

Inserts precision ground for fineboring tools and cartridges



Grade matrix
Grade selection
Chipbreaker recommendation

Carbide / carbide coated / PCD / PCBN



Cutting material	Grade composition		Workpiece material						
			Steel	Stainless steel	Cast iron	Nonferrous materials	Heavy machinable materials	Hardened steels	
Grade code	Substrat	Coating							
P10	P10	uncoated	● n	—	—	—	—	—	—
Chipbreaker			→ -1000 -1011						
P40	P40	uncoated	● n	—	—	—	—	—	—
Chipbreaker			→ -1000 -1011						
K10	K10	uncoated	—	—	● n	▲ n	● n	—	—
Chipbreaker				→	-1000 -1011	-1620 -1611	-1620* -1611		
G12	K10	TiAlN Multilayer PVD	—	● n	t ▲ n	t ● n	—	—	—
Chipbreaker				→ -1620 -1611	-1000 -1011	-1620 -1611			
G16	P40	TiAlN Multilayer PVD	▲ n	▲ n	t ▲ n	—	● n	—	—
Chipbreaker			→ -1000 -1011		-1000 -1011		-1000 -1011		
G26	P40	TiN PVD	● n	●	—	—	▲ n	—	—
Chipbreaker			→ -1000 -1011	-1620 -1611					
PCD	Grain size 10 µm		—	—	—	▲	—	—	—
Spanleitstufe						→ -0000 -0011			
PCBN			—	—	t ● n	—	—	t ▲ n	—
Chipbreaker					→ -0000 -0011				-0000 -0011

▲ = very good applicable ● = applicable — = not applicable * = for Titanium t = dry n = wet
Further cutting materials, coatings and geometries on request.