Grades

Carbide grades

Grades	ISO	Characteristics & applications
TT7005 CVD coated	K05 - K15	High speed turning of gray cast iron in continuous conditions
TT7015 CVD coated	K10 - K25	General turning of gray and ductile cast iron in continuous and interrupted conditions
TT7025 CVD coated	K20 - K35	Interrupted turning of gray and ductile cast iron especially good in ductile cast iron
TT8105B CVD coated	P05 - P15	High speed turning of steel in continuous conditions
TT8115B CVD coated	P05 - P20	General turning of steel in high speed conditions
TT3005 CVD coated	S05 - S15	Finish turning of heat resistant super alloys in high speed and low depth of conditions
TT9215 CVD coated	M05 - M20 S05 - S20	High speed turning of stainless steel and heat resistant super alloys in continuous conditions
TT4410 PVD coated	M05 - M25 P05 - P25 S05 - S25	High speed turning of small parts for stainless steel, steel and titanium alloys in continuous conditions
TT3010 PVD coated	S05 - S20	High speed turning of heat resistant super alloys in continuous conditions
TT5080 PVD coated	M05 - M25 S05 - S25	Wide range of turning for stainless steel and heat resistant super alloy
TT3020 PVD coated	S10 - S30	General turning of heat resistant super alloy
TT8125B CVD coated	P15 - P30	General turning of steel in wide range of conditions
TT5100 CVD coated	P20 - P35 M20 - M35	Wide range of turning for mild steel, low carbon steel, low carbon alloy steel and stainless steel
TT9225 CVD coated	M15 - M30 S15 - S30	General turning of stainless steel and heat resistant super alloy
TT9020 PVD coated	P20 - P40 M20 - M40	General turning of small parts for steel and stainless steel

Grades

Carbide grades

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Grades	ISO	Characteristics & applications
TT4430 PVD coated	M20 - M40 P20 - P40 S20 - S40	General turning of small parts for stainless steel, steel and titanum alloy
TT9080 PVD coated	M20 - M40 P20 - P40 S20 - S40	General turning of stainless steel, steel and heat resistant super alloy
TT8135B CVD coated	P25 - P40	Interrupted turning of steel in low speed conditions
TT7100 CVD coated	P30 - P45	Heavy intrrupted turning of steel
TT9235 CVD coated	M25 - M40 S25 - S40	Interrupted turning of stainless steel and heat resistant super alloy in low speed conditions
TT8080 PVD coated	M30 - M50 P30 - P50 S30 - S50	Interrupted and rough turning of stainless steel and steel Interrupted turning of heat resistant super alloys in low speed conditions
TT8020 PVD coated	M30 - M50 P30 - P50 S30 - S50	Low speed turning of stainless steel, heat reisitant super alloys and low carbon steel
PV3010 Cermet PVD coated	P05 - P20 M05 - M20 K05 - K20	Good surface finish turning of steel, stainless steel and cast iron in high speed conditions
CT3000 Cermet uncoated	P10 - P20 M10 - M20 K10 - K20	Excellent surface finish turning of steel, stainless steel and cast iron
K10 Carbide	K05 - K15 N05 - N15 S05 - S15	General turning of cast iron, non-ferrous materials of aluminum and titanum alloy

Grades

CBN, PCD, Ceramic grades

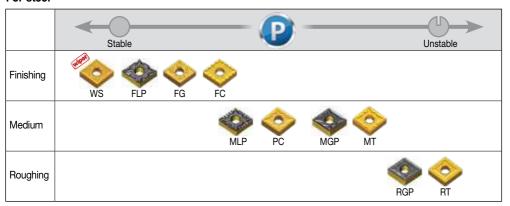
Grades	ISO	Characteristics & applications
TB610 CBN	H05 - H10	High speed continuous turning of hardened steel
TB2015 CBN	H10 - H20	Light interrupted turning of hardened steel
TB650 CBN	H10 - H20	General turning of hardened steel
TB670 CBN	H20 - H30	Medium interrupted turning of hardened steel
TB7015 CBN	H25 - H35 K10 - K20	High speed turning of cast iron and general turning of carbide roll
TB7020 Solid CBN	K10 - K25	High speed and light interrupted turning of cast iron. Solid CBN insert
TB730 CBN	K05 - K10 P10 - P20	General turning of sintered or powder metals
AW120 Ceramic, Al ₂ O ₃ +Z _r O ₂	K05 - K15	High speed continuous turning of white cast iron
AB2010 Ceramic, PVD coated	H05 - H10	High speed finish turning of hardened steel
AB20 Ceramic, Al ₂ O ₃	H05 - H15	Continuous and finish turning of hardened steel
AB30 Ceramic, Al ₂ O ₃	H10 - H15 K05 - K15	General turning of hardened steel under HRC 55 and cast iron
TC430 Ceramic, Whisker	S05 - S15	High speed turning of super alloys especially for Ni-based super alloy
TC3020 Ceramic, SiAION	S15 - S25	General turning and milling of super alloy
TC3030 Ceramic, SiAION	S25 - S35	Rough turning and milling of super alloy
AS500 Ceramic, SiAlON	K15 - K25	General and light interrupted turning of gray cast iron
SC10 Ceramic, CVD coated	K25 - K35	General turning of ductile cast iron
AS10 Ceramic, Si ₃ N ₄	K25 – K35	Interrupted turning of gray cast iron
TD1010 PCD	N05 - N15	Bi-modal composition for high speed turning of non-ferrous materials, high Si aluminum alloy, ceramic and sintered tungsten carbide
TD1020 PCD	N10 - N25	General turning of non-ferrous materials and finish turning of carbide roll
TD1030 PCD	N20 - N35	Low Si aluminum alloys and composite plastics (CFRP, GFRP)

Recommendations for Chip Breakers

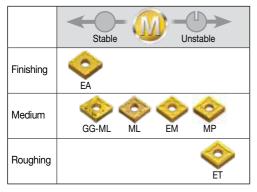


ISO Negative inserts

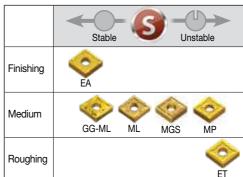
For steel



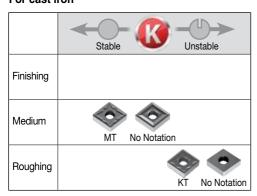
For stainless steel



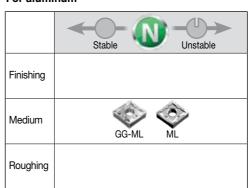
For super alloys



For cast iron



For aluminum

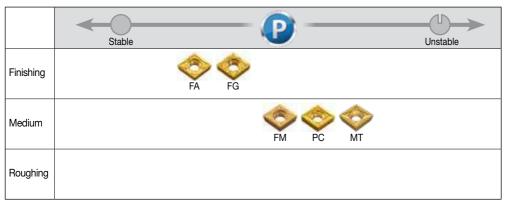


Recommendations for Chip Breakers

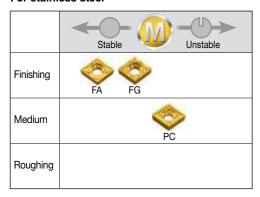


ISO Positive inserts

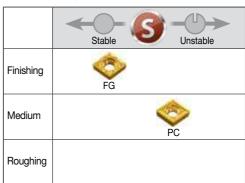
For steel



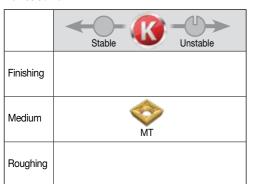
For stainless steel



For super alloys



For cast iron



For aluminum

	Stable Unstable
Finishing	
Medium	GT-FL
Roughing	



Recommendations for Chip Breakers



Chip breakers for Swiss turn (Ground type)

ISO Positive inserts

	Stable D W O Unstable
Finishing	SL
Finishing-Medium	SA SM
Roughing	SH ST