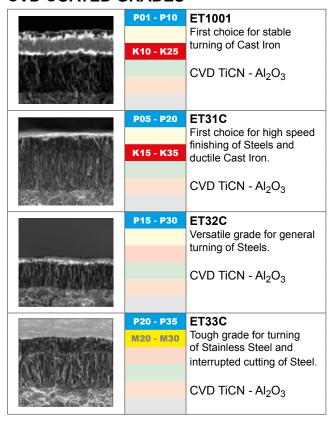






INSERT GRADES

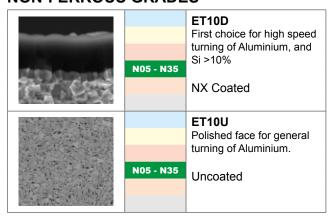
CVD COATED GRADES

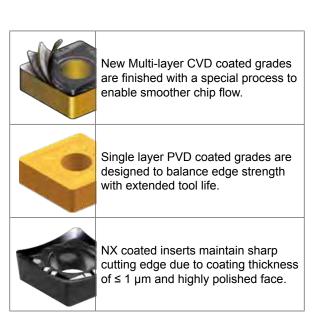


PVD COATED GRADES

M05 - M20	ET21P First choice for stable turning of Stainless Steel and HRSA. PVD Coated	
M20 - M35 S15 - S25	ET23P Optimised grade for cutting of Stainless Steel and HRSA at low cutting speeds. PVD Coated	
M30 - M40 S25 - S30	ET24P Optimised grade for interrupted cutting of Stainless Steel and HRSA. PVD Coated	
P10 - P30 K20 - K30 H20 - H30	ET801 Turning grade for mid and low cutting conditions in most steels and cast iron PVD Coated	

NON-FERROUS GRADES



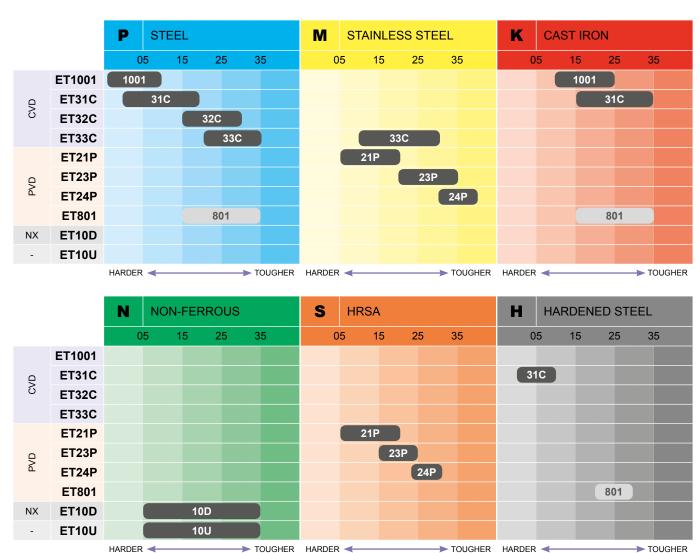








INSERT GRADE GUIDE



THEORETICAL SURFACE ROUGHNESS BY INSERT RADIUS

R _a (R _{z)} μm	Insert corner radius							
	0.2	0.4	0.8	1.2	1.6	2.4		
μ	fn (mm/rev)							
0.4 (1.6)	0.05	0.07	0.10	0.12	0.14	0.18		
1.6 (6.3)	0.10	0.14	0.20	.025	0.28	0.35		
3.2 (12.5)	0.14	0.20	0.28	0.35	0.40	0.49		
6.3 (25)	-	0.28	0.40	0.49	0.57	0.69		
8 (32)	-	-	0.45	0.55	0.64	0.78		







INSERT GRADE APPLICATION AREA

The charts below indicate grade selection in relation to cutting speed and feed rate

