



Application recommendations

Inserts precision ground

Grade matrix
Grade selection

Carbide / carbide coated / PCD / CBN

Chipbreaker recommendation

Chipbreaker

for boring bars starting from 5 mm working diameter

Cutting material	Grade composition		Workpiece material					
	Substrat	Coating	Steel	Stainless steel	Cast iron	Nonferrous materials	Heavy machinable materials	Hardened steel
P10	P10	uncoated	● n	—	—	—	—	—
Chipbreaker			-1000 -1020					
P40	P40	uncoated	● n	—	—	—	—	—
Chipbreaker			-1000 -1020					
K10	K10	uncoated	—	—	● n	▲ n	● n	—
Chipbreaker			—	→	-1000 -1020	-1620 -2420	-1620* -2420	
H02	K10	TiAlN PVD	—	● n	t▲ n	t● n	—	—
Chipbreaker			→	-1620 -2420	-1000 -1020	-1620 -2420		
H06	P40	TiAlN PVD	▲ n	▲ n	t▲ n	—	● n	—
Chipbreaker			-1000 -1020		-1000 -1020		-1000 -1020	
H25	P40	TiN CVD	▲ n	—	—	—	●	—
Chipbreaker			-1000 -1020				-1000 -1020	
H26	P40	TiN PVD	t● n	●	—	—	▲ n	—
Chipbreaker			-1000 -1020	-1620 -2420				
PCD10	Grainsize 10µm		—	—	—	▲	—	—
Chipbreaker			—	—	→	-0000		
CBN			—	—	t● n	—	—	t▲ n
Chipbreaker			—	→	-0000			-0000

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