

■ **Insert Selection Guide**

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←————→		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	.E..GE	KCPM40	.E..GE	KCPM40	.S..GE	KCPM40
P3-P4	.E..GE	KC522M	.S..GE	KCPM40	.S..GE	KCPM40
P5-P6	.S..GE	KC522M	.S..GE	KCPK30	.S..GE	KCPM40
M1-M2	.E..GE	KC725M	.E..GE	KC725M	.S..GE	KC725M
M3	.E..GE	KC522M	.E..GE	KC725M	.S..GE	KC725M
K1-K2	.S..GE	KCK15	.S..GEM	KCK15	.S..GEM	KCPK30
K3	.S..GE	KC520M	.S..GEM	KC520M	.S..GEM	KCPM40
N1-N2	.E..LEJ	KC422M	.E..LEJ	KC422M	.E..LEJ	KC422M
N3	.E..LEJ	KC422M	.E..LEJ	KC422M	.E..LEJ	KC422M
S1-S2	.E..GE	KC522M	.E..GE	KC725M	.S..GE	KC725M
S3	.E..GE	KCSM30	.E..GE	KC725M	.S..GE	KC725M
S4	.E..GE	KCSM30	.S..GE	KCSM40	.S..GE	KCSM40
H1	-	-	-	-	-	-