

# ISO Turning Insert Selection Guide

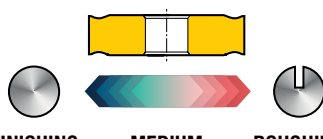
GENERAL AND SMALL PART MACHINING

  = 1<sup>st</sup> Recommended

(Feed rate: ipr)

**NEGATIVE**

**POSITIVE**



FINISHING

MEDIUM

ROUGHING

FINISHING

MEDIUM

ROUGHING

Material	Chip breaker	NEGATIVE			POSITIVE		
		FINISHING	MEDIUM	ROUGHING	FINISHING	MEDIUM	ROUGHING
<b>P</b> Steel	Chip breaker	WS (.002-.014) FA (.002-.010) FLP(.003-.012) FC (.003-.014) FG (.003-.014) <b>MLP (.004-.016)</b> PC (.005-.019) <b>MGP (.006-.022)</b> MT (.007-.022) RGP (.010-.028)			FA (.002-.010) FG (.003-.010) <b>PC (.003-.010)</b> FM (.003-.010) MT (.004-.010)		
	Grade	TT8105B TT8115B <b>TT8125B</b> TT8135B Low Carbon TT5100 Low Carbon TT7100			TT8105B TT8115B <b>TT8125B</b> Low Carbon TT5100		TT4410 <b>TT4430</b> TT9020
<b>M</b> Stainless Steel	Chip breaker	EA (.003-.016) ML (.006-.016) <b>EM (.005-.020)</b> ET (.007-.020)			FA (.002-.010) FG (.003-.010) <b>PC (.003-.010)</b> SL (.0008-.004) <b>SM (.0012-.0067)</b> SA (.002-.006) GW/GF (.002-.007) SH (.0025-.008)		
	Grade	TT9215 <b>TT9225</b> TT9235 TT8080			TT9215 <b>TT9225</b> TT9235 TT8080		TT4410 <b>TT4430</b> TT9020
<b>K</b> Cast Iron	Chip breaker	FG (.003-.014) MT (.007-.022) -MG (.009-.024) <b>KT (.007-.021)</b> <b>-MA (.006-.024)</b> RT (.010-.026)			FG (.003-.010) <b>MT (.004-.010)</b>		
	Grade	TB7015 CBN AS500 Ceramic <b>AS10</b> Ceramic AB30 Ceramic TT7005 <b>TT7015</b> TT7025			TB7015 CBN TT7005 <b>TT7015</b> TT7025		
<b>S</b> High Temp. Alloys	Chip breaker	EA (.003-.016) ML (.005-.014) <b>MGS (.006-.016)</b> MP (.005-.016) ET (.007-.022)			-GT FGS (.002-.008) <b>FG (.003-.010)</b> PC (.003-.010) MT (.004-.010)		
	Grade	TC430 Ceramic TC3020 Ceramic <b>TC3030</b> Ceramic TT3005 TT3010 TT5080 <b>TT3020</b> TT9080 TT8020			TT3005 TT3010 TT5080 <b>TT3020</b> TT9080 TT8020		TT5080 TT4410 TT4430 TT9020
<b>N</b> Non-Ferrous	Chip breaker	<b>-GG ML (.005-.014)</b>			-GW CB -GT FL		
	Grade	TD1010 PCD TD1020 PCD <b>K10</b>			TD1010 PCD TD1020 PCD <b>K10</b>		
<b>H</b> Hardened Steel	Chip breaker	<b>-GA</b>			<b>-GW</b>		
	Grade	TB610 CBN <b>TB650</b> CBN TB2030 CBN TB670 CBN AB2010 Ceramic <b>AB20</b> Ceramic AB30 Ceramic			TB610 CBN <b>TB650</b> CBN TB670 CBN		