

Step 3 • Select chipbreaker style and feed rate
Chipbreaker and Feed Rates • in/rev (mm/rev)


workpiece material and application	P	M	K	N	S	H
first choice	NG-K .003-.011 (0,08-0,28)	NG-K .0025-.008 (0,07-0,20)	NG .004-.012 (0,01-0,30)	NGP .004-.012 (0,01-0,30)	NG-K .0025-.008 (0,07-0,20)	NG-ST CBN tipped .002-.004 (0,05-0,10)
alternate choice	NG .004-.012 (0,10-0,30)	NGP .004-.009 (0,10-0,23)	NG-K .003-.011 (0,08-0,28)	NG-K .003-.012 (0,08-0,30)	NGP .004-.008 (0,10-0,20)	—

-K chipbreaker inserts



flat-top inserts



positive rake inserts


Step 4 • Select grade and speed
Recommendations for Grade and Speed Selection • SFM (m/min)

machining condition	workpiece material					
	P	M	K	N	S	H
high-performance for optimal conditions (clean cuts, good machine condition, higher speed capability)	KC9110 400-1200 (120-370)	KCU10/KC5010 250-750 (80-230)	KD9320 400-1200 (120-370)	KD1425 800-10000 (240-3050)	KCU10/KC5010 50-400 (20-120)	KB5625 250-500 (80-150)
	KT315 330-750 (100-230)	KT315 230-650 (70-200)	KD5010 250-750 (80-230)	—	—	—
general purpose (first choice for general machining)	KC9110 400-1000 (120-300)	KCU25/KC5025 160-400 (50-120)	KD9110 400-1000 (120-300)	KC5410 500-3000 (150-910)	KCU25/KC5025 35-200 (10-60)	KB5625 250-500 (80-150)
unfavorable conditions (roughing, poor machine condition, interrupted cuts, low speed, I.D. grooving)	KCU25/KC5025 180-450 (50-140)	KCU25/KC5025 130-300 (40-90)	KD5025 200-500 (60-300)	KCU25/KC5025 200-1000 (60-300)	KCU25/KC5025 35-150 (10-50)	KB1630 200-350 (60-110)

Step 5 • Select insert and holder from catalog page

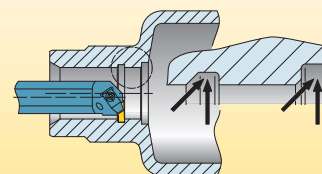
NOTE: The insert size must match the gage insert size of your toolholder selection.

Example for Top Notch • Grooving

Material low-alloyed steel
 Groove depth079" (2mm)
 Groove width118" (3mm)
 Operation I.D. cut, limited speed capability,
 plunge groove and chamfer

Recommendation

Insert NG2M300RK
 Grade KC5025
 Insert width118" (3mm)
 Insert size 2
 Toolholder A20QNTOL2 (metric)
 A12NEL2 (inch)
 Gage insert N.2R



Speed: 400 SFM (120 m/min)
 Feed: .006 in/rev (0,15 mm/rev)

Congratulations!

You have successfully maximized your productivity by selecting the best Top Notch insert geometry, grade, and cutting specifications for your application!