

## MILL 4-15 • INSERT SELECTION GUIDE

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