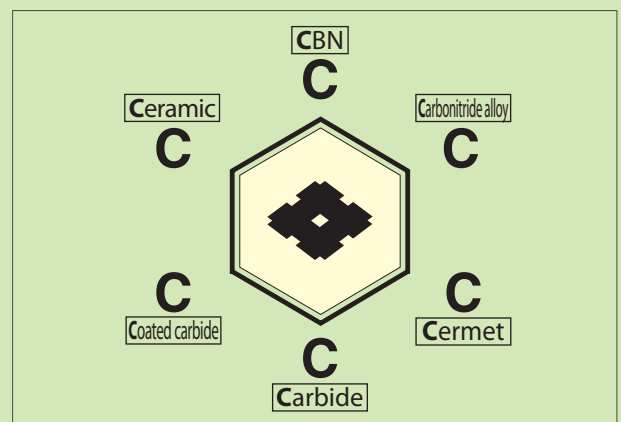
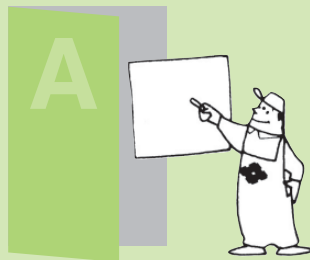


Grades A1 to A35

A

A
Grades



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Application-Specific Chipbreaker & Grade Selection Guide

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Selection of Sumitomo Grades (Turning)

Selection Guide by Work Material and Cutting Process



A
Grades

Cutting Process	P General Steel (Carbon Steel, Alloy Steel), Soft Steel					M Stainless Steel					K Cast Iron						
	Wear Resistance ← Fracture Resistance					Wear Resistance ← Fracture Resistance					Wear Resistance ← Fracture Resistance						
ISO Classification	-	P01	P10	P20	P30	P40	-	M01	M10	M20	M30	M40	-	K01	K10	K20	K30
Coated Carbide		AC810P ^C	AC825P ^C	AC820P ^C	AC830P ^C		AC6020M ^{New}		AC6030M	AC6040M			AC405K ^C		AC415K ^C		AC420K ^C
Small Product Machining A24 A22			AC1030U ^{New}						AC1030U ^{New}						AC1030U ^{New}		
Coated Cermet		T1500Z	T3000Z														
Cermet		T1000A	T1500A				T1000A	T1500A					T1000A				
Carbide		ST10P	ST20E	A30										G10E			
Ceramic													NB90S				
Uncoated CBN Coated CBN													BNS800				
													BN7000				
													BN500				
													BNC500 ^P				

Cutting Process	S Exotic Alloy				H Hardened Steel				N Non-Ferrous Metal				Sintered Components							
	Wear Resistance ← Fracture Resistance				Wear Resistance ← Fracture Resistance				Wear Resistance ← Fracture Resistance				Wear Resistance ← Fracture Resistance							
ISO Classification	-	S01	S10	S20	S30	-	H01	H10	H20	H30	-	N01	N10	N20	N30	-	01	10	20	30
Coated Carbide		AC510U	AC520U			AC503U										AC510U				
Cermet																T1000A				
Carbide		EH510	EH520										H1							
Ceramic		WX120				NB100C														
Coated CBN						BNC2010	BNC2020		BNC300											
						BNC100	BNC160	BNC200												
Uncoated CBN		BN7000	BNS800			BN1000	BN2000	BNX20	BN350							BN7500				
						BNX10			BNX25							BN7000				
PCD											DA1000	DA150								



Selection of Sumitomo Grades (Milling)

A
Grades

Cutting Process	P General Steel (Carbon Steel, Alloy Steel), Soft Steel						M Stainless Steel					K Cast Iron					
	Wear Resistance ← Fracture Resistance →						Wear Resistance ← Fracture Resistance →					Wear Resistance ← Fracture Resistance →					
ISO Classification	-	P01	P10	P20	P30	P40	-	M01	M10	M20	M30	M40	-	K01	K10	K20	K30
Coated Carbide <small>ISO A24</small>			ACP100					ACM100		ACM200		ACM300		ACK100			
				ACP200										ACK200			
					ACP300											ACK300	
Cermet <small>ISO A27</small>			T250A						T250A								
					T4500A					T4500A							
Carbide <small>ISO A28</small>					A30N						A30N				G10E		
Ceramic <small>ISO A34</small>														NB90M			
Uncoated CBN Coated CBN <small>ISO A30</small>																BNS800	
																BN7000	

Cutting Process	S Exotic Alloy						H Hardened Steel				N Non-Ferrous Metal					
	Wear Resistance ← Fracture Resistance →						Wear Resistance ← Fracture Resistance →				Wear Resistance ← Fracture Resistance →					
ISO Classification	-	S01	S10	S20	S30	S40	-	H01	H10	H20	H30	-	N01	N10	N20	N30
Coated Carbide <small>ISO A24</small>		ACM100														
			ACM200											DL1000		
Carbide <small>ISO A28</small>				EH520												H1
Uncoated CBN <small>ISO A30</small>										BN7000						
									BN350							
PCD <small>ISO A32</small>																DA1000

█ █ █ █ █ █ : 1st Recommendation
 : 2nd Recommendation
 ▽ : CVD Coating
 ▲ : PVD Coating
 Blank: Uncoated

Grade Comparison Chart

Coated Carbide

A
Grades

Application	Work Materials	Classification	Sumitomo Electric	Mitsubishi	Tungaloy	Kyocera	Mitsubishi Hitachi	NTK	Sandvik	Kennametal	SECO Tools	WALTER	ISCAR	TaeguTec	
Turning	Steel	P05	AC810P	UE6105	T9105	CA510	HG8010		GC4305 GC4205	KCP05 KC9105	TP0501 TP0500	WPP05S WPP05	IC8005 IC428	TT8115	
		P10	AC810P	MC6015 UE6110	T9115	CA515	HG8010	TM1.VM1 CP7.DT4 DM4	GC4315 GC4215	KCP10 KC9110	TP1501 TP1500	WPP10S WPP10	IC8150 IC9015	TT8115	
		P20	AC8025P AC820P	MC6025 UE6020	T9125	CA525	IP2000 HG8025 GM25	TM1.VM1 CP7.QM3	GC4325 GC4225	KCP25 KC9125	TP2501 TP2500	WPP20S WPP20	IC8250 IC9015	TT8125 TT5100	
		P30	AC830P AC630M	MC6035 UE6035 VP15TF	T9135	CA530	IP3000 GM8035	TM4 QM3	GC4235	KCP30 KC9140	TP3500	WPP30S WPP30	IC8350 IC8025	TT8135 TT7100	
		P40	AC830P AC630M	UE6035 UH6400	T9135	PR660	IP3000 GM8035	QM3	GC4235	KC9140	TP3500	WTN53	IC8350 IC8025	TT8135 TT7100	
	Stainless Steel	M10 S10	AC610M AC6020M AC510U	MC7015 US7020 MP9005 US905 VP05RT VP10RT	T9115 AH110 AH905 AH8005	CA6515 PR915 PR1025 PR1215 PR1225 PR1305 PR1310	IP050S IP100S	TM1 VM1 DT4 DM4 ZM3	GC2015 GC1105 GC1115	KCM15 KC5510 KCU10	TS2000	WSM10 WSM10S	IC807 IC8025 IC907	TT9215 TT5080	
		M20 S20	AC6020M AC6030M AC610M AC520U	MC7025 US7020 MP9015 VP20MF UP20M	T6120 T6020 T9125 AH630 AH120 AH725 AH8015	CA6525 PR915 PR930 PR1025 PR1125 PR1215 PR1225 PR1325	IP100S HG8025	DT4 DM4 ZM3 TM4	GC2025 GC1125	KCM25 KC5525 KCU25 KC5020	TP2501 TP2500 TM2000 TS2500	WMP20S WSM20 WSM20S	IC808 IC8080 IC908	TT9225 TT9080 TT9020	
		M30	AC6030M AC6040M AC630M AC830P AC1030U	MC7025 MP7035 US735 VP15TF VP20MF MS6015	AH725 T6130 T6030 AH630 AH645	CA6525 PR1125 PR1535	GM8035 GX30	QM3 TM4 DT4 DM4	GC2035	KCM35 KC9240	TP3500 TM4000	WSM30 WSM30S	IC8080 IC830	TT9235 TT8020	
		M40	AC6040M AC530U	MP7035 US735 VP15TF MS6015	AH645	PR1125 PR1535	GX30	QM3.TM4 DT4.DM4	GC235		TM4000		IC830 IC928	TT8020	
	Cast Iron	K05	AC405K	MC5005 UC5105 UC5115	T5105 T5115	CA4505 CA4010	HG3305 HX3305			GC3205	KCK05	TK1001 TK1000	WKK10S WAK10	IC5005	TT7005
		K10	AC415K	MC5005 UC5015 UC5105 UC5115	T515 T5115 T5125	CA4505 CA4515 CA4115	HX3305 HG3305 HG3315 HX3315	CP1	GC3210	KCK15	TK1001 TK1000	WKK10S WKK20S WAK10 WAK20	IC5010 IC5100	TT7015 TT7310	
		K20	AC420K	MC5015 UC5115 VP15TF UE6110	T5125 T9125	CA4515 CA4120 CA4115	HX3315 HG3315 HG8010		GC3215	KCK20	TK2001 TK2000	WKK20S WAK20 WAK30	IC8150		
	Milling	Steel	P10	ACP100	FH7020 F7030	T3130 T3030		JP4005 JP4105 JP4020 JP4115 JP4120		GC4220 GC4230	KC715M KC930M KC935M KCPK10	T250M T350M MP1500 MP2500	WKP25S WKP25 WPP20 WKP35S	IC4100 IC520M IC4050 DT7150 IC903	TT7080 TT7030
			P20	ACP200	MV1020 VP15TF VP20RT MP6120	AH9030 AH120 AH725	PR1525 PR1225 PR830	JS4045 GX2140	TM1 DT4 DM4	GC1010 GC1025 GC2040 GC4240	KTPK20 KCPM20 KCU25	MP3000 F25M F30M	WSM20	IC808 IC810 IC380	TT9080 TT9030
			P30	ACP300	VP30RT MP6130	AH3035 AH130 AH140 SH730	PR1525 PR1230	JS4060 JX1045 JX1060 CY150 CY250	ZM3	GC1030 GC1130 GC2030	KCPK30 KCMF30 KC725 KC730 KC735 KC7140 KCU40	MM4500 F40M	WSM30 WSM35 WSP45S WSP45	IC830 IC928 IC330	TT8080 TT8020 TT7800
		Stainless Steel	M10	ACM100 ACK300				PR1025 PR1225	JX1020 CY9020 JP4020 JP4120		GC1025 GC1030 GC1130	KC522M			IC903
M20			ACM200	F7030 VP15TF VP20RT MP7130 MP9120	GH330 AH330 AH120 AH130	PR1525 PR1025 PR1225	JX1015 CY150 CY15	DT4 DM4	GC2030	KC730M KC525M KCU25	F25M F30M MS2050	WSM35 WSM35S WXM35	IC908 IC928	TT9080 TT9030	
M30			ACM300	F7030 VP30RT MP7030 MP7140 MP9130	AH130 AH140	CA6535 PR1535	JX1045 JX1060 GX2160 JM4060 JM4160	ZM3	GC2040	KC994M KC725M KC7140 KCU40	F30M F40M	WSM35 WSM35S WXM35	IC328 IC330 IC830	TT8080 TT8020	
K20			ACK200	MV1020 MC5020 F5010 F5020	T1115	PR905	JP4020 JP4120			GC3330 GC3220 GC3020 GC3040 K15W K20D K20W GC3330	KCK15 KCK20 KC915M KC930M KC935M KCPK10	MK1500 MK3000 T150M	WAK15 WKK25 WKP25S	IC5100 DT7150	TT6800
K30	ACK300	VP15TF VP20RT	AH725 AH120 AH110 AH330 GH110 GH130	PR1510 PR1210	GX2140 JS4045 JX1045 CY150 CY250			GC1010 GC1020 GC1025 GC1030 GC1130	KTPK20 KCPK30 KC510M KC520M KC525M KCU40	MK2500 MK2000 MK2050 MH1000	WKP35S WPP20	IC830 IC810 IC908 IC910 IC928 IC950	TT6080		

Grade Comparison Chart

Cermet

Application	Work Materials	Classification	Sumitomo Electric	Mitsubishi	Tungaloy	Kyocera	Mitsubishi Hitachi	NTK	Sandvik	Kennametal	SECO Tools	WALTER	ISCAR	TaeguTec
Turning		P10	T1000A T110A	AP25N* NX2525	GT720* NS520	TN30,PV30* TN6010,TN610 PV710*,PV7005* PV7010*	CZ25*	Q15* Z15* T15 C7Z*	CT5015	KT125 HTX KT1120			IC20N IC520N	PV3030 PV3010 CT3000
		P20	T1500A T1500Z* T2000Z*	AP25N* NX2525 NX3035	NS530 GT530* NS730 GT730* NS9530 GT9530*	TN60 TN6020 PV60* PV7020* PV7025*	CH550	T15 C7Z* C7X	GC1525*	KT6215 KT315* KT175 KT5020*	CM CMP C15M TP1020		IC30N IC530N	CT7000
		P30	T3000Z*	NX3035 MP3025*		PV7025* PV90*		N40 C7X						
Milling		K10	T1000A T110A	AP25N* NX2525	GT720* NS520	TN30 PV30* TN6010, PV7010*			CT5015	KT125 HTX				PV3030 CT3000
			T250A T4500A	NX4545 VP45N*	NS540 NS740	TC60M TN100M	MZ1000* MZ2000* MZ3000* CH7030 CH7035		CT530	KT530M*	C15M			IC30N

★ Coated Cermet

Carbide

Work Materials	Classification	Sumitomo Electric	Mitsubishi	Tungaloy	Kyocera	Mitsubishi Hitachi	NTK	Sandvik	Kennametal	SECO Tools	WALTER	ISCAR	TaeguTec	
	P10	ST10P				WS10		S1P						
	P20	ST20E	UTi20T	UX30		EX35		SMA	K125M			IC07 IC50M		
	P30	A30 A30N	UTi20T	UX30	PW30	EX40		SM30				IC54 IC28		
	P40	ST40E				EX45		S6				IC54 IC28		
	M10	U10E EH510				WA10B		H10A	KU10,K313 K68,KYSM10	890		IC07,IC20 IC08		
	M20	U2 EH520	UTi20T	UX30				H13A	K313 K68	HX 883		IC07,IC20 IC08		
	M30	A30 A30N	UTi20T	UX30				H10F SM30				IC28		
	K01	H2 H1	HTi05T			WH01 WH05			KU10,K313 K68,K115M			IB50,IB85 IS8		
	K10	H1 EH10 EH510	HTi10	TH10	KW10 GW15	WH10	KM1	H13A	KU10,K313 K68,K115M K110M KY3500	890		IB50,IB85 IB55,IB90 IC20,IS8		
	K20	G10E EH20 EH520	UTi20T	UX30	GW25	WH20	KM3	H13A	KMF KY3500 KYHS10	890 883 HX		IC20 IS8		
	K30	G10E	UTi20T			WH30			KY3500	883				
	—	EH510 EH520	RT9005 RT9010 MT9015 TF15	TH10 KS20	SW05,SW10 SW25,KW10 GW15	WH10		H10A H10F H13A	KU10,K313 K68,KMF K110M,KYHS10 K1025(KMF)	HX H25		ID5,IB85 IC20,IC07 IC08,IC28		
	Fine-grained Carbide	F0	SF10,MF07 MF10	F,MD1508 MD08F			NM08						IC07	
		F1,AFU XF1	HTi10 MF20	M,MD10 MD05F,MD07F	FW30		NM15		6UF,8UF PN90,H6FF		890		IC07	
		AF0,AF1 SF2	TF15 MF30	EM10,MD20 MD15			BRM20 EF20N		12UF		890 883		IC08	
		A1		UM			NM25		N6F H10F		883		IC08	

Ceramic

Work Materials	Sumitomo Electric	Tungaloy	Kyocera	NTK	Sandvik	Kennametal	TaeguTec
	NB100C	WG300 LX11	A66N A65 KT66	HC4,HC7 ZC7,WA1	GC6050 CC650 CC670	KY1615 KY4300	AB20 AB2010
	WX120	WG300	CF1	WA1 SX9	CC6060 CC6065 CC670	KY4300 KY1540	TC430 AS20
	NB90S	LX11,LX21 CXC73,FX105 CX710	A65,A66N KA30,KS500 KS6000,KT66	HC1,HW2,HC2,HC6 HC7,WA1,SX1,SX2 SP2,SX9,SX8	CC620,CC650 CC6090 GC1690	KY1615,KY1310 KY1320,KY3500 KY4300	AW120,AB30 AS500,AS10 SC10

(Note) The data on pages A4 and A5 was collected from the various published catalogues therefore the information may not be updated.




A

Grades

Grade Comparison Chart


A
Grades

■ CBN

Work Materials	Classification	Sumitomo Electric	Mitsubishi	Tungaloy	Kyocera	NTK	Chukyo	Sandvik	Kennametal	SECO Tools
	K01	BNC500* BN7000 BN500	MB710 MB5015	BX910 BX930 BX870	KBN475 KBN60M	B30 B16		CB50 CB7525	KB1340	
	K10	BN7000 BN500	MB710,MB5015 MB4020	BX470,BX480 BX950	KBN60M KBN900	B23 B16	HB55,HB569 HB580,HB57	CB7925		CBN200,CBN300 CBN300P,CBN400C
	K20	BN7000 BNS800	MB730,MB4020 MBS140	BX470,BX480 BXC90,BX90S	KBN900		HB56,HB569 HB580,HB57			
	K30	BNS800	MBS140	BXC90 BX90S			HB57		KB5630	CBN500
	S01	BN7000	MB730 MB4020	BX940 BX950 BX470 BX480			HB55 HB580 HB52		KB5630 KB1340	
	H01	BNC2010 BNC100 BN1000 BN2000 BNX10	BC8105 BC8110 MBC010 MB810	BXM10 BX310	KBN05M KBN10M KBN510	B5K B52	HB55 HB550 HB580		KB5610	CH0550 CBN10 CBN100 CBN100 CBN060K
	H10	BNC2010 BNC2020 BNC160 BNC200 BN2000	BC8110 BC8120 MBC020 MB8025 MB825	BXM10 BX330	KBN05M KBN25M KBN525	B5K B6K B52 B36	HB55 HB59 HB550 HB580 HB52	CB7015 CB20	KBH20 KB5610 KB5625	CBN10 CBN100 CBN150 CBN060K CBN160C
	H20	BNC2020 BNC200 BNX20	BC8120,BC8020 MBC020 MB8025	BXA20 BXM20 BX360	KBN30M KBN35M KBN900	B36 B40 B6K	HB57,HB59 HB590 HB580	CB7025 CB50	KBH20 KB5625 KB5630	CH2540 CBN150 CBN160C
	H30	BNC300 BN350 BNX25	BC8130 MB835	BXM20 BXC50 BX380		B40	HB57 HB580	CB7525	KB5630	CH3515

* For cutting ductile cast iron

■ Polycrystalline Diamond

Work Materials	Classification	Sumitomo Electric	Mitsubishi	Tungaloy	Kyocera	NTK	Chukyo	Sandvik	Kennametal	SECO Tools
	N01	DA1000 DA90	MD205	DX180 DX160	KPD001	PD1		CD05 CD10	KD1400	
	N10	DA1000 DA150	MD205 MD220	DX140 DX110	KPD001 KPD010 KPD230	PD2	HD100 HD30 HD60	CD1810	KD1400 KD1425	PCD05 PCD10
	N20	DA1000 DA2200	MD220 MD230	DX120 DX110	KPD230	PD2	HD100,HD30 HD50		KD1400 KD1425	PCD05 PCD20
	N30	DA1000 DA2200	MD2030 MD230	DX110			HD30,HD50 HD700 HD100		KD1400	PCD05 PCD30 PCD30M

(Note) The above data was collected from the various published catalogues therefore the information may not be updated.

Chipbreaker Comparison Chart

A
Grades

Negative

Work Materials	Application	Sumitomo Electric	Mitsubishi	Tungaloy	Kyocera	Mitsubishi Hitachi	NTK	Sandvik	Kennametal	SECO Tools	WALTER	ISCAR	TaeguTec	
P Steel	Fine Finishing	FA	FH	TF	GP			QF	FF	FF1		SF		
		FL,FB	FS,FY	NS,ZF	XP,XF,VF	FE	WM			FF2	FP5		FA	
	Finishing	LU,FE	SA,SY	NM	PP,XQ,CQ	BE	ZF1	LC	FN		NF3		FG	
		SU	SH	TS,TSF	HQ	CE,B,BH	UL, WV	XF,MF	CT	MF2		NF	FC	
	Wiper Edge	LUW		AFW,FW	WP			WL,WP		W-FF2				
		SEW	SW	ASW,SW	WQ			WF,WMX	FW	W-MF2	NF	WF	WS	
	Finishing to Light	SE,SX	LP	AS,ZM	CJ,XS	AB,CT	ZW1, WR	PF,KF	LF,33		MP3,NS6	F3P,TF		
	Medium	GU(UG)	MA,MV	TM,TQ	HS,PS	AH	ZP	XM,QM,PMC	P,MG	M3			GN	ML,MP,MC
		GE,UX	MH,MP	DM,AM	PQ,GS,PT,PG	AE,AY	Z5	PM,SM,KM,HM	MN,MP1		MP5,NM4,NM6	RF,LF	PC,MT	
	Wiper Edge	GUW	MW					WM	MW,RW	W-M3,W-M3	NM	WG	WT	
	Rough	MU,ME	RP,GH	TH,S	HT,GT,PH	RE,AR	G	PR,XMR,KR	RP	M5,MR7	RP5,NM9,RP7	M3P,NR	RT	
		MX	HAS,MT	CH					RN	MR6				
	Heavy	HG	HZ,HX,HL	THS,TRS	PX,Standard	TE,UE		QR	RM,MR	R4,R5,M6	NR6,NRF	NM	RX	
		HP	HH,HXD,HR	65				HR,SR	RH	R7,MR7	NR8	TNM	RH	
		HU,HW	HV			H							HT,HD,HY	
		HF	HCS	TUS		HX,HE		MR		RR9	NRR	R3P	HZ	
M Stainless Steel	Finishing	SU,EF	LM,SH	SS	MQ,GU	SE,MP	ZF1	MF	FP,FS,LF	MF2	NF4		EA,SF	
	Light to Medium	EX,EG	GM,MS	SF,SA	MS,MU	PV	ZP	23	MS	MF1,M1		TF,VL	EM	
	Medium	GU	MM	SM		DE		MM,MMC,SMR	MP	MF3,M3	NM4	M3M,PP	ET	
	Rough	HM	ES,1M,2M,HL	S					UP	MF4,MF5	NR4,RM5		VF	
EM,MU		RM,GH,HM	SH	TK			MR,MRR		M5,MR3,MR4		MR	SU		
K Cast Iron	Light	UZ	LK,MA,MK	CM,CF	Standard,C	V,VA		KF	UN	M4	NM5	GN	MT	
	Medium	GZ(UX)	GK,RK,GH	Standard,CH,33	ZS,GC	Y,RE		KM,KR,KRR		MR7	RK5,RK7		RT	
N Non-Ferrous Metal	Finishing	AX		P	AH			MS						
S Exotic Alloy	Finishing	EF	LS,FJ	HRF				SF,SGF			NFT			
	Medium	EG,EX	MS,MJ	HMM,SA,HRM		VI		SM,SMC			NMT			
	Rough	MU	RS,GJ					SMR			NRT			
H Hardened Steel	Finishing	GH,FV*												
	Light	LV*												
	Carburized Layer Removal	SV*												

() indicates a discontinued item. ★ CBN/PCD tool chipbreakers

Positive

Work Materials	Application	Sumitomo Electric	Mitsubishi	Tungaloy	Kyocera	Mitsubishi Hitachi	NTK	Sandvik	Kennametal	SECO Tools	WALTER	ISCAR	TaeguTec
P Steel	Finishing	FC	FJ,AM	01,JRP,JTS	CF,GF,VF		AZ7, AMX	UM		GT-F1	FM4		
		FB,LU(FP,FK)	FP,FM,FV,SQ	PSF,PF,23,SS,JSS	GP,XP,MP,PP,DP	JQ,MP	ZR	PF,UF,MF,KF,XF	11,UF,FP	FF1	FP4	PF	FA
	Wiper Edge	LUW	SW					WF	FW	W-F1	PF	WF	WT
M Stainless Steel		SDW						WK,WM	MW	W-F2		WG	
	Finishing to Light	SI	SMG	JS	CK		YL, 1L						SA
K Cast Iron	Light	LB,SU(SK,SF)	LP,LM,SV,MQ	PSS,PS,TS,TJS,CM	HQ,XQ,GK	JE	AZ8,AM3,AM5	PM,UM,MM,XM	LF	F1	MP4,MM4,FK6	SM,14	FG, PC
		SC			GQ,SK,Standard		AF1, CL		MP	MF2			
N Non-Ferrous Metal	Light to Medium	MU	MP,MM,MK,MV	PM				PR,UR,MR,KR,MMC,MPC,XR	MF	F2,M3,M5	PM5,RP4,RM4	19	MT
	Finishing	AG,AW,AY	AZ	AL,PP	AH			AL	HP	AL	PM2	AS,AF	FL
H Hardened Steel	Finishing to Light	LD*,GD*											
	Finishing	FV*											
	Light	LV*											

() indicates a discontinued item. ★ CBN/PCD tool chipbreakers

(Note) The above data was collected from the various published catalogues therefore the information may not be updated.