

Comparison table for turning insert chipbreaker

Negative inserts

ISO	Machining range	ZCC.CT	SANDVIK	KORLOY	TaeguTec	WALTER	SECO	mitsubishi	sumitomo	KENNAMETAL	DIJET	HITACHI	TUNGALOY	KYOCERA	VALANTTE	
P	For extra finishing		QF	HU	FA, EA	NF3	FF1	PK※ FH, FY	FA, FL	UF, FF	F1, FA	FE	01※, TF, ZF	DP※, GP, VF XP, XP-T	F1	
	For finishing	DF	PF MF	HF	FG, SF	NS6	MF2	C, SA, SH	SU, LU, SX	LF, FN	PF, UR UA, UT	BE, CE	NS, 27 TS, AS	HQ, CQ	F2(2B), F5(5C)	
	For finishing (Soft steel)	SF		HF				SY					17	XQ, XS		
	For finishing (Wiper)	WGF	WP WF	HW		NF	W-MF2	SW	LUW	FW			AFW, ASW	WP, WQ		
	For semi-finishing	DM PM	PM QM SM	HA HC HM	MC ML MP	NM4 NM6	MF3 M3 M5	MV MA MH	GU UG UX	MG MN	PG UB	AB AY AE	NM ZM TM DM 37	CJ, GS PS, HS PT, CS	F3, F4(8A), M2(2C), M3 M4, M5(5B), M6, M7, 55, M8	
	For semi-finishing	WGM	WM		WS, WT	NM	W-M3	MW	GUW	MW						
	(Wiper)	DR (Double-side)	PR		MT, MG	NM9	MR7	GH	MU, MX	RN	UD, GG	AR, RE	TH	GT, HT		
	For light roughing	LR, DR (Single-side) HDR, HPR	QR PR HR	HR HH	HT, RH	NR6	R4, R6 R7, PR9	HZ, HX HV	MP, HG HP	MR, RM RH	UC	HX HE	57, 65, TU	HX	R3, R4, R6(9A) R7(9B), R9(9C)	

※ Periphery grinding type

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Negative inserts

ISO	Machining range	ZCC:CT	SANDVIK	KORLOY	TaeguTec	WALTER	SECO	MITSUBISHI	SUMITOMO	KENNAMETAL	DIJET	HITACHI	TUNGALOY	KYOCERA	VALANTE
M	For finishing	EF	MF	HA	FG, SF	NF4		FS	SU	K, FP		SE	SS	GU	F1, F2(2B), F5(5C)
	For semi-finishing	EM	MM	HS	ML, MP	NM4		MS, ES	EX, UP	P, MP	SF, SG	DE	SA, SM, S	SU, HU, ST	F3, F4(8A), M2(2C), M3, M4, M5(5B), M6, M7, 55, M8
	For roughing	ER	MR	GS, HM	MT, RH	NR4	M5, MR7 56, R6	GH, HZ	MP	RP					R3, R4, R6(9A) R7(9B), R9(9C)
K	For finishing	PM	KF	Without chip-breaker Through	FG	MA		Through chip-breaker,	UZ	FN		Y	CM	Through chip-breaker, C	F2(2B)
	For Semi-Finishing	PM	KM	chip-breaker, HM	MC, MT, MG	MA, NM5		Through chip-breaker,	UX	Through chip-breaker, UN		V	33, through chip-breaker	ZS, GC	M5(5B), M6, M8
S	For roughing	Without chip-breaker	KR	GR, HR, GH	RT, RH	MA		Without chip-breaker	Without chip-breaker					Without chip-breaker	R3, R4, R7(9B)
	For finishing	NF			SF	NF4	MF1※	FJ※		FS※, K※					F5(5C), M2(2C)
	For semi-finishing	NM	NGP※, 23			NM4	M1	MJ※	SU※	NGP※			SA		M4, M5(5B), M7, 55
	For roughing		SR			NR4		GJ		MS					

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Positive inserts

ISO	Machining range	ZCC-CT	SANDVIK	KORLOY	TaeguTec	WALTER	SECO	mitsubishi	sumitomo	KENAMETAL	DIJET	HITACHI	TUNGALOY	KYOCERA	VALANTTE
P	For finishing	USF, SF, HF	UF, PF	HFP	FA, FG	PF4	FF1 F1	FV, SV	FP, LU SU, SK	11, UF LF		JQ	01※, PF FS	GP, XP VF	PF4 JQ, JZ
	For finishing (Wiper)		WK※, W WP			PF	W-F1	SW	LUW	FW					
	For semi-finishing	HM	UM PM	HMP C25	MT, CMX	PS5 PM5	F2	MV, through chip-breaker	MU	MF	FT	JE	PM 23, 24	HQ, XQ GK	PM2 PM4
For semi-finishing (Wiper)		WM			PM		MW		MW						
M	For finishing	EF	MF	HFP	FA, FG	PF4		SV					SS※		1A, 2A
	For semi-finishing	EM	MM	HMP C25	MT CMX	PS5 PM5		Through chip-breaker, MV							PM2 PM4
K	For semi-finishing	HM, HR without chip-breaker	KF KM KR	HMP C25	MT CMX	MW PS5 PM5		Without chip-breaker	Without chip-breaker※		FT		Without chip-breaker	Without chip-breaker※	PM2 PM4
	For finishing/ For semi-					PF4 PS5 PM5		FJ※	SC※	LF※ HP※					PM2, 1A 2A
N	For general turning	LC, LH	AL	TAAK MA	FL	PM2			AG	HP	ALU ACB		PP	A3	1L, 1A 2A

※ Periphery grinding type