

ISO	General turning									Threading	Parting and grooving				
	Code	Coating				Cermet	Coated cermet	Ceramic	Cemented carbide		PCBN	PCD	Coating		Cemented carbide
		CVD		PVD									PVD	CVD	
P Steel	01														
	10	YBC151													
	20	YBC251	YBC152												
	30	YBC252													
	40	YBC351													
M Stainless steel	01														
	10	YBM151													
	20	YBM251													
	30														
	40														
K Cast iron	01														
	10	YBD052	YBD102	YBD152	YBD151										
	20														
	30	YBD252													
	40														
N Non ferrous metal	01														
	10														
	20														
	30														
	40														
S Heat resistant alloy & Ti alloy	01														
	10														
	20														
	30														
	40														
H Super hard material	01														
	10														
	20														
	30														
	40														

A
General turning
Recommended grade overview
for turning inserts