

First Choice Grade Descriptions



- Inserts
- Face Mills
- End Mills
- Die and Mold
- Slotting
- Thread Milling
- Widia Cutters
- Vintage Cutters
- Accessories
- Technical Data
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Materials	Code	Grade												
		wet/dry K313	wet/dry K110M	dry K125M	dry KB1340	wet/dry KC410M	wet/dry KC510M	wet/dry KC520M	wet/dry KC522M	wet/dry KC525M	dry KC715M	wet/dry KC725M		
Unalloyed and Alloyed Steel	<increasing feed increasing speed>	P05												
		P10												
		C7	P15											
		P20												
		C6	P25											
		P30												
		C5	P35											
		P40												
Stainless Steel	<increasing feed increasing speed>	P45												
		M05												
		M10												
		M15												
		M20												
		M25												
		M30												
		M35												
Cast Iron	<increasing feed increasing speed>	M40												
		M45												
		C3	K05											
		K10												
		C2	K15											
		K20												
		C1	K25											
		K30												
Non-Ferrous Materials	<increasing feed increasing speed>	K35												
		K40												
		K45												
		N05												
		N10												
		N15												
		N20												
		N25												
High-Temperature Alloys	<increasing feed increasing speed>	N30												
		N35												
		N40												
		N45												
		S01												
		S05												
		S10												
		S15												
Hard Materials: Hardened Steel Hardened Cast Iron Chilled Cast Iron	<increasing feed increasing speed>	S20												
		S25												
		S30												
		S35												
		S40												
		S45												
		H05												
		H10												

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Materials	Code	Grade											
		wet/dry KC735M	dry KC792M	wet/dry KC915M	wet/dry KC935M	wet/dry KD1405	wet/dry KD1410	wet/dry KD1415	dry KT530M	dry KY3500			
Unalloyed and Alloyed Steel	<increasing feed increasing speed>	P05											Face Mills
		P10											
		C7 P15											
		P20											
		P25											
		C6 P30											
		P35											
		C5 P40											
P45													
Stainless Steel	<increasing feed increasing speed>	M05										Die and Mold	
		M10											
		M15											
		M20											
		M25											
		M30											
		M35											
		M40											
M45													
Cast Iron	<increasing feed increasing speed>	K05										Thread Milling	
		C3 K10											
		K15											
		C2 K20											
		K25											
		C1 K30											
		K35											
		K40											
K45													
Non-Ferrous Materials	<increasing feed increasing speed>	N05										Vintage Cutters	
		N10											
		N15											
		N20											
		N25											
		N30											
		N35											
		N40											
N45													
High-Temperature Alloys	<increasing feed increasing speed>	S01										Technical Data	
		S05											
		S10											
		S15											
		S20											
		S25											
		S30											
		S35											
S40													
S45													
Hard Materials: Hardened Steel Hardened Cast Iron Chilled Cast Iron	<increasing feed increasing speed>	H05										Mat'l Database	
		H10											
		H15											
		H20											
		H25											
		H30											
		H35											
		H40											
H45													

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grades	coating composition	recommended use
K110M 	 uncoated carbide	Uncoated carbide grade. K110M is a universal grade for machining non-ferrous metals. For use in light and general machining. K110M can be used with or without coolant.
K125M 	 uncoated carbide	Uncoated carbide grade. K125M is particularly suitable for dry machining of steel. Primarily for use in light general machining of steel. K125M is intended for dry machining.
 KC410M 	 advanced PVD carbide	The coating on KC410M inserts is extremely hard providing very good wear characteristics at high cutting speeds. KC410M resists built-up edge, can help reduce burring, and generates excellent surface finish. KC410M is best suited for aluminum with <10% silicon and non-ferrous metals.
KC510M 	 TiAlN carbide	Coated carbide grade with a TiAlN coating (PVD). KC510M is a highly wear-resistant carbide grade. Primarily for use in milling aluminum and high-temp alloys in light machining applications.
KC520M 	 TiAlN carbide	Coated carbide grade with a TiAlN coating (PVD). KC520M is a carbide grade developed specifically for general machining of ductile cast iron. KC520M can be used dry or wet.
 KC522M 	 TiAlN carbide	Coated carbide with a TiAlN (PVD) coating. KC522M is engineered to provide better performance in general machining of high-temperature alloys. KC522M resists breakage, offers improved wear resistance, and increased strength.
KC525M 	 TiAlN carbide	Coated carbide grade with a TiAlN coating (PVD). New universal carbide grade for milling steel, stainless steel, and high-temperature alloys. KC525M can be used with or without coolant. Primarily for use in light and general machining.
KC715M 	 TiN TiCN TiN carbide	KC715M is ideal for dry machining. The wear-resistant substrate has a high resistance to heat exchange. It is primarily for use in light and general machining of steels, stainless steels, and cast steel.
KC725M 	 TiN TiCN TiN carbide	Coated carbide grade with a thick PVD multi-layer coating (TiN/TiCN/TiN). KC725M is a high-performance grade for milling steel, stainless steel, and ductile cast iron. The good thermal shock resistance of the substrate makes this grade ideal for both wet and dry machining. Primarily for use in general heavy machining.

