

Technical Information

Comparison table materials	D2-D8
Comparison table hardness and tensile strength	D9-D10
Conversion table chip breaker – turning	D11-D12
Conversion table chip breaker – milling/turning	D13-D21
Example of materials for machining groups	D22
Form test protocol	D23
Torque for screw	D24



A

Turning

B

Milling

C

Drilling

D

Technical
Information

E

Index

Comparison table materials

ISO	Country and standard											
	China	USA	Germany		Great Britain		Sweden	France	Italy	Spain	Japan	Russia
	GB	AISI/SAE	W.-nr	DIN	BS	EN	SS	AFNOR	UNI	UNE	JIS	GOST
P	Alloy steel											
	15	1015	1.0401	C15	080M15	-	1350	CC12	C15C16	F.111	-	-
	20	1020	1.0402	C22	050A20	2C	1450	CC20	C20C21	F.112	-	20
	35	1035	1.0501	C35	060A35	-	1550	CC35	C35	F.113	-	35
	45	1045	1.0503	C45	080M40	-	1650	CC45	C45	F.114	-	45
	55	1055	1.0535	C55	070M55	-	1655	-	C55	-	-	55
	60	1060	1.0601	C60	080A62	43D	-	CC55	C60	-	-	60
	Y15	1213	1.7015	9SMn28	230M07	-	1912	S250	CF9SMn28	11SMn28	SUM22	15Ch
	-	12L13	1.0718	9SMnPb28	-	-	1914	S250Pb	CF9MnPb28	11SMnPb28	SUM22L	-
	-	-	1.0722	10SPb20	-	-	-	10PbF2	CF10Pb20	10SPb20	-	-
	-	1140	1.0726	35S20	212M36	8M	1957	35MF4	-	F210G	-	-
	Y13	1215	1.0736	9SMn36	240M07	1B	-	S300	CF9SMn36	12SMn35	-	-
	-	12L14	1.0737	9SMnPb36	-	-	1926	S300Pb	CF9SMnPb36	12SMnP35	-	-
	55Si2Mn	9255	1.0904	55Si9	250A53	45	2085	55S7	55Si8	56Si7	-	-
	-	9262	1.0961	60SiCr7	-	-	-	60SC7	60SiCr8	60SiCr8	-	-
	15	1015	1.1141	Ck15	080M15	32C	1370	XC12	C16	C15K	S15C	15
	40Mn	1039	1.1157	40Mn4	150M36	15	-	35M5	-	-	-	40G
	25	1025	1.1158	Ck25	-	-	-	-	-	-	S25C	25
	35Mn2	1335	1.1167	36Mn5	-	-	2120	40Mn5	-	36Mn5	SMn438(H)	35G2,35GL
	30Mn	1330	1.1170	28Mn6	150M28	14A	-	20M5	C28Mn	-	SCMn1	30G
	35Mn	1035	1.1183	Cf35	060A35	-	1572	XS38TS	C36	-	S35C	-
	Ck45	1045	1.1191	45	080M46	-	1672	XC42	C45	C45K	S45C	-
	55	1055	1.1203	Ck55	070M55	-	-	XC45	C50	C55K	S55C	55
	50	1050	1.1213	Cf53	060A52	-	1674	XC48TS	C53	-	S50C	-
	60Mn	1060	1.1221	Ck60	080A62	43D	1678	XC60	C60	-	S58C	60,60G
	-	1095	1.1274	Ck101	060A96	-	1870	-	-	-	SUP4	-
	-	-	1.3401	X120Mn12	Z120M12	-	-	X120M12	XG120Mn12	X120Mn12	SCMnH/1	110G13L
	Gr15;45Gr	52100	1.3505	100Cr6	534A99	31	2258	100C6	100Cr6	F.131	SUJ2	SchCh 15
	-	ASTM A204Gr.A	1.5415	15Mo3	1501-240	-	2912	15D3	16Mo3KW	16Mo3	-	-
	-	4520	1.5426	16Mo5	1503-245-420	-	-	-	16Mo5	16Mo5	-	-
-	ASTM A350LF5	1.5622	14Ni6	-	-	-	16N6	14Ni6	15Ni6	-	-	
-	ASTM A353	1.5662	X8Ni9	1501-509;510	-	-	-	X10Ni9	XBNI09	-	-	

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Comparison table materials

ISO	Country and standard											
	China	USA	Germany		Great Britain		Sweden	France	Italy	Spain	Japan	Russia
	GB	AISI/SAE	W.-nr	DIN	BS	EN	SS	AFNOR	UNI	UNE	JIS	GOST
P	Alloy steel											
	-	2515	1.5680	12Ni19	-	-	-	Z18N5	-	-	-	-
	-	3135	1.5710	36NiCr6	640A35	111A	-	35NC6	-	-	SNC236	-
	-	3415	1.5732	14NiCr10	-	-	-	14NC11	16NiCr11	15NiCr11	SNC415(H)	-
	-	3415 3310	1.5752	14NiCr14	655M13 655A12	36A	-	12NC15	-	-	SNC815(H)	-
	-	9840	1.6511	36CrNiMo4	816M40	110	-	40NCD3	38CrNiMo4(KB)	35CrNiMo4	-	40 ChN2MA
	-	8620	1.6523	21NiCrMo2	850M20	362	2503	20NCD2	20NiCrMo2	20NiCrMo2	SNCCM220(H)	-
	-	8740	1.6546	40NiCrMo2	311-Type7	-	-	-	40NiCrMo2(KB)	40NiCrMo2	SNC240	38ChGNM
	40CrNiMoA	4340	1.6582	34CrNiMo6	817M40	24	2541	35NCD6	35CrNiMo6(KB)	-	-	38Ch2N2MA
	-	-	1.6587	17CrNiMo6	820A16	-	-	18NCD6	-	14CrNiMo13	-	-
	15Cr	5015	1.7015	15Cr3	523M15	-	-	12C3	-	-	SCr415(H)	15Ch
	35Cr	5132	1.7033	34Cr4	530A32	18B	-	32C4	34Cr4(KB)	35Cr4	SCr430(H)	35Ch
	40Cr	5140	1.7035	41Cr4	530M40	18	-	42C4	41Cr4	42Cr4	SCr440(H)	40Ch
	40Cr	5140	1.7045	42Cr4	-	-	2245	-	-	42Cr4	SCr440	40Ch
	18CrMn	5115	1.7131	16MnCr15	(527M20)	-	2511	16MC5	16MnCr15	16MnCr15	-	18ChG
	20CrMn	5155	1.7176	55Cr3	527A60	48	-	55C3	-	-	SUP9(A)	50ChGA
	30CrMn	4130	1.7218	25CrMo4	1717CDS110	-	2225	25CD4	25CrMo4(KB)	55Cr3	SCM420; SCM430	30ChM
	35CrMo	4137;4135	1.7220	34CrMo4	708A37	19B	2234	35CD4	35CrMo4	34CrMo4	SCM432; SCRMM3	AS38ChGM
	40CrMoA	4140;4142	1.7223	41CrMo4	708M40	19A	2244	42CD4TS	41CrMo4	41CrMo4	SCM440	40 ChFA
	42CrMo 42CrMnMo	4140	1.7225	42CrMo4	708M40	19A	2244	42CD4	42CrMo4	42CrMo4	SCM440(H)	-
	-	-	1.7262	15CrMo5	-	-	2216	12CD4	-	12CrMo4	SCM415(H)	-
	-	ASTM A182 F11;F12	1.7335	13CrMo44	1501- 620Gr.27	-	-	15CD3.5; 15CD4.5	14CrMo44	14CrMo45	-	12ChM, 15ChM
	-	-	1.7361	32CrMo12	722M24	40B	2240	30CD12	32CrMo12	F.124.A	-	-
-	ASTM A182 F.22	1.7380	10CrMo910	1501- 622Gr.31;45	-	2218	12CD9;10	12CrMo9,10	TU.H	-	-	
-	-	1.7715	14MoV63	1503-660-440	-	-	-	-	13MoCrV6	-	-	
50CrVA	6150	1.8159	50CrV4	735A50	47	2230	50CV4	50CrV4	51CrV4	SUP10	50ChGFA	
-	-	1.8509	41CrAlMo7	905M39	41B	2940	40CAD6,12	41CrAlMo7	41CrAlMo7	-	38ChMJuA	
-	-	1.8523	39CrMoV139	897M39	40C	-	-	36CrMoV12	-	-	-	

A

Turning

B

Milling

C

Drilling

D

Technical
Information

E

Index

Comparison table materials

ISO	Country and standard											
	China	USA	Germany		Great Britain		Sweden	France	Italy	Spain	Japan	Russia
	GB	AISI/SAE	W.-nr	DIN	BS	EN	SS	AFNOR	UNI	UNE	JIS	GOST
P	Alloy steel											
	T10	W.110	1.1545	C105W1	-	-	1880	Y1105	C98KU C100KU	F.515 F.516	-	U10A
	T12A	W.112	1.1663	C125W	-	-	-	Y2120	C120KU	(C120)	SK2	U13
	CrV;9SiCr	L3	1.2067	100Cr6	BL3	-	-	Y100C6	-	100Cr6	-	-
	Cr12	D3	1.2080	X210Cr12	BD3	-	-	Z200Cr12	X210Cr13KU X250Cr12KU	X210Cr12	SKD1	Ch12
	4Cr5MoVSi	H13	1.2344	X40CrMoV5 1	BH13	-	2242	Z40CDV5	X35CrMoV05KU X40CrMoV51KU	X40CrMoV5	SKD61	4Ch5MF1S
	Cr6WV	A2	1.2363	X100CrMoV5 1	BA2	-	2260	Z100CDV5	X100CrMoV51KU	X100CrMoV5	SKD12	-
	CrWMo	-	1.2419	105WCr6	-	-	2140	105WC13	10WCr6 107WCr5KU	105WCr5	SKS31 SKS2 SKS3	ChWG
	Cr12W	-	1.2436	X210CrW12	-	-	2312	-	X215CrW12 1KU	X210CrW12	SKD2	-
	5CrNiMo	S1	1.2542	45WCrV7	BS1	-	2710	-	45WCrV8KU	45WCrS18	-	-
	3Cr2W8V	H21	1.2581	X30WCrV9 3 X30WCrV93KU	BH21	-	-	Z30WCV9	X28W09KU X30WCrV9 3KU	X30WCrV9	SKD5	3Ch2W8F
	Cr12MoV	-	1.2601	X165CrMoV 12	-	-	2310	-	X165CrMoW12KU	X160CrMoV12	SKD11	-
	5CrNiMo	L6	1.2713	55NiCrMoV6	-	-	-	55NCDV7	-	F.250.S	SKT4	5ChNM
	V	W210	1.2833	100V1	BW2	-	-	Y1105V	-	-	SKS43	-
	W6Mo5Cr4V2Co5	-	1.3243	S6-5-2-5	-	-	2723	Z85WDKCV	HS6-5-2-5	HS6-5-2-5	SKH55	R6M5K5
	W18Cr4VCo5	T4	1.3255	S18-1-2-5	BT4	-	-	Z80WKC 10-05-04-01	X78WCo1805KU	HS18-1-1-5	SKH3	-
	W6Mo5Cr4V2	M2	1.3343	S6-5-2	BM2	-	2722	Z85WDCV 06-05-04-02	X82WMo0605KU	HS6-5-2	SKH9	R6M5
	-	M7	1.3348	S2-9-2	-	-Z-	2782	Z100WCWV 09-02-04-02	HS2-9-2	HS2-9-2	-	-
	W18Cr4V	T1	1.3355	S18-0-1	BT1	-	-	Z80WCV 18-04-01	X75W18KU	HS18-0-1	SKH2	-
	W6Mo5Cr4V3	M3	-	S6-5-3	-	-	-	-	-	-	SKH52	-
-	M42	-	-	BM42	-	-	-	-	-	SKH59	-	

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Comparison table materials

ISO	Country and standard						Main application
	China	USA	Germany	Japan	Daido Steel Co., Ltd (Japan)	Russia	
	GB	AISI/SAE	DIN	JIS	DAIDO	GOST	
P	Plastic die steel						
	-	P20 mod.		-	PX5N		For mass production of large mirror dies. Automobile tail light, front fender of car, video camera, household electrical appliances etc
	-	-		-	NAK55		High precision mirror die. Video camera, music disc, Cosmetic Containers, transparent covers, transparent films etc
	-	-		-	NAK80		High precision mirror die. Video camera, music disc, Cosmetic Containers, transparent covers, transparent films etc
	3Cr13	420 mod.		SUS420J2 mod.	S-STAR		For ultra-mirror corrosion resistant precise dies. Accessories of camera, CD, lens, watch case.
	Cold-working die steel						
	-	O2	-	SKS93	YK30		Stamping die, gauge calipers, paper cutter, auxiliary tools
	9CrWMn	O1 mod.	-	SKS3 mod.	GOA		Blanking die, gauge calipers, drawing die, taps, Perforated punch.
	Cr12MoV	D2	X165CrMoV12	SKD11	DC11		Blanking die, cold forming die, cold drawing die, forming roller, punch
	-	D2 mod.	-	SKD11 mod.	DC53		Blanking die, cold forming die, cold drawing die, forming roll, punch
	Hot-working die steel						
	4Cr5MoSiV1	H13	X40CrMoV51	SKD61	DHA1		Aluminum-compression die, connecting parts of compression die, hot stamping die, hot extrusion die, thermal shear cutting blade
	-	-	-	-	DH21		Long life Aluminum compression die
	-	-	-	-	DH31-S		Compression die
	-	-	-	-	DH2F		Compression die, plastic die

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Comparison table materials

ISO	Country and standard											
	China	USA	Germany		Great Britain		Sweden	France	Italy	Spain	Japan	Russia
	GB	AISI/ SAE	W.-nr	DIN	BS	EN	SS	AFNOR	UNI	UNE	JIS	GOST
M	Stainless steel											
	0Cr13; 1Cr12	403	1.4000	X6Cr13	403S17	-	2301	Z6C13	X6Cr13	F.3110	SUS403	08Ch13
	-	-	1.4001	X7Cr14	-	-	-	-	-	F.8401	-	-
	1Cr13	410	1.4006	X10Cr13	410S21	56A	2302	Z10C14	X12Cr13	F.3401	SUS410	12Ch13
	1Cr17	430	1.4016	X6Cr17	430S15	60	220	Z8C17	X8Cr17	F.3113	SUS430	12Ch17
	2Cr13	410	1.4021	X20Cr13	562	56B; 56C	-	Z20C13	X20C13	F.3401	SUS410	20Ch13
	-	-	1.4027	G-X20Cr14	420C29	56B	-	Z20C13M	-	-	SCS2	20Ch13L
	4Cr13	-	1.4034	X46Cr13	420S45	56D	2304	Z40CM Z38C13M	X40Cr14	F.3405	SUS420J2	40Ch13
	1Cr17Ni2	431	1.4057	X20CrNi172	431S29	57	2321	Z15CNi6.02	X16CNi16	F.3427	SUS431	20Ch17N2
	Y1Cr17	430F	1.4104	X12CrMoS17	-	-	2383	Z10CF17	X10CrS17	F.3117	SUS430F	-
	1Cr17Mo	434	1.4113	X6CrMo171	434S17	-	2325	Z8CD17.01	X8CrMo17	-	SUS434	-
	-	-	1.4313	X5CrNi134	425C11	-	-	Z4CND13.4M	-	-	SCS5	-
	-	-	1.4408	G-X6CrNiMo1810	316C16	-	-	-	-	F.8414	SCS14	07Ch18N10G2S2M2L
	4Cr9Si2	HW3	1.4718	X45CrSi93	401S45	52	-	Z45CS9	X45CrSi8	F.322	SUH1	40Ch9S2
	0Cr13Al	405	1.4724	X10CrAl13	403S17	-	-	Z10C13	X10CrAl12	F.311	SUS405	10Ch13SJu
	Cr17	430	1.4742	X10CrAl18	430S15	60	-	Z10CAS18	X8Cr17	F.3113	SUS430	15Ch18SJu
	8Cr20Si2Ni	HNV6	1.4757	X80CrNiSi20	443S65	59	-	Z80CSN20.02	X80CrSiNi20	F.320V	SUH4	-
	2Cr25N	446	1.4762	X10CrAl24	-	-	2322	Z10CAS24	X16Cr26	-	SUH446	-
	Austenitic stainless steel											
	0Cr18Ni9	304	1.4301	X5CrNi1810	304S15	58E	2332	Z6CN18.09	X5CrNi1810	F.3551; F.3541; F.3504	SUS304	08Ch18N10
	1Cr18Ni9MoZr	303	1.4305	X10CrNiS189	303S21	58M	2346	Z10CNF18.09	X10CrNiS18.09	F.3508	SUS303	-
	0Cr19Ni10	304L	1.4306	X2CrNi1911	304S12	-	2352	Z2CN18.10	X2CrNi18.11	F.3503	SCS19	03Ch18N11
	-	-	1.4308	G-X6CrNi189	304C15	-	-	Z6CN18.10M	-	-	SCS13	07Ch18N9L
	Cr17Ni7	301	1.4310	X12CrNi177	-	-	2331	Z12CN17.07	X12CrNi1707	F.3517	SUS301	-
	-	304LN	1.4311	X2CrNi1810	304S62	-	2371	Z2CN18.10	-	-	SUS304LN	-
	0Cr19Ni9	304	1.4350	X5CrNi189	304S31	58E	-	Z6CN18.09	X5CrNi1810	-	SUS304	-
	0Cr17Ni11Mo2	316	1.4401	X5CrNiMo1712	316S16	Z6CND17.11	2347	1.4401	X5CrNiMo1712	F.3543	SUS316	-
	00Cr17Ni13Mo2	316LN	1.4429	X2CrNiMo17133	-	-	2375	Z2CND17.13	-	-	SUS316LN	-
0Cr27Ni12Mo3	316L	1.4435	X2CrNiMo18143	316S12	-	2353	Z2CDN17.13	X2CrNiMo1713	-	SCS16,	03Ch17N14M2	
00Cr19Ni13Mo3	317L	1.4438	X2CrNiMo17133	317S12	-	2367	Z2CND19.15	X2CrNiMo18.16	-	SUS317L	-	
-	329L	1.4460	X8CrNiMo275	-	-	2324	-	-	-	SUS329L; SCH11; SCS11	-	
1Cr18Ni9Ti	321	1.4541	X6CrNiTi1810	2337	321S12	58B	Z6CNT18.10	X6CrNiTi1811	F.3553	SUS321	12Ch18N10T	
1Cr18Ni11Nb	347	1.4550	X6CrNiNb1810	347S17	58F	2338	Z6CNNb18.1	X6CrNiTi1811	F.3552	SUS347	08Ch18N12B	
Cr18Ni12Mo2Ti	316Ti	1.4571	X6CrNiMoTi17122	320S17	58J	2350	Z6NDT17.12	X6CrNiMoTi17	F.3535	-	10Ch17N13M2T	

Comparison table materials

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M	Austenitic stainless steel											
	-	-	1.4581	G-X5CrNiMoNb1810	318C7	-	-	Z4CNDNb1812M	XG8CrNiMo18	-	SCS22	-
	Cr17Ni12Mo3Nb	318	1.4583	X10CrNiMoNb1812	-	-	-	Z6CNDNb1713B	X6CrNiMoTiNb17	-	-	-
	1Cr23Ni13	309	1.4828	X15CrNiSi2012	309S24	-	-	Z15CNS20.1	-	-	SUH309	20Ch20N14S2
	0Cr25Ni20	310S	1.4845	X12CrNi2521	310S24	-	2361	Z12CN2520	X6CrNi2520	F.331	SUH310	20Ch23N18
	Cr15Ni36W3Ti	330	1.4864	X12NiCrSi3616	-	-	-	Z12CNS35.1	-	-	SUH330	-
	-	-	1.4865	G-X40NiCrSi3818	330C11	-	-	-	XG50NiCr3919	-	SCH15	-
	5Cr2Mn9Ni4N	EV8	1.4871	X53CrMnNiN219	349S54; 321S12	-	58B	-	Z52CMN21.0	X53CrMnNiN219	-	SUH35
1Cr18Ni9Ti	321	1.4878	X12CrNiTi189	321S320	58C	-	Z6CNT18.12	X6CrNiTi1811	F.3523	SU321	09Ch18N10T	

ISO	Country and standard									
	China	USA	Germany	Great Britain	Sweden	France	Italy	Spain	Japan	Russia
K	Nodular cast iron									
	QT400-18	60-40-18	GGG40	400/17	0717-02	FGS370-17	GS370-17	FGE38-17	FCD400	VC 42-12
	QT450-10	65-45-12	--	420/12	--	FGS400-12	GS400-12	FGE42-12	FCD450	-
	QT500-7	70-50-05	GGG50	500/7	0727-02	FGS500-7	GS500-7	FGE50-7	FCD500	VC 50-2
	QT600-3	80-60-03	GGG60	600/7	0732-03	FGS600-2	GS600-2	FGE60-2	FCD600	VC 60-2
	QT700-2	100-70-03	GGG70	700/2	0737-01	FGS700-2	GS700-2	FGE70-2	FCD700	VC 70-2
	QT800-2	120-90-02	GGG80	800/2	0864-03	FGS800-2	GS800-2	FGE80-2	FCD800	VC 80-2
	QT900-2	--	--	900/2	--	--	--	--	--	-
	Nodular cast iron									
	--	NO.60	GG40	--	0140	FGL400	--	--	--	Sc 40
	HT350	NO.50	GG35	350	0135	FGL350	G35	FG35	FC350	Sc 35
	HT300	NO.45	GG30	300	0130	FGL300	G30	FG30	FC300	Sc 30
	HT250	NO.35	GG25	250	0125	FGL250	G25	FG25	FC250	Sc 25
	HT200	NO.30	GG20	200	0120	FGL200	G20	FG20	FC200	Sc 20
	HT150	NO.20	GG15	150	0115	FGL150	G15	FG15	FC150	Sc 15
HT100	--	--	100	0110	--	G10	--	FC100	-	

ISO	Country and standard											
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	GB	AISI/SAE	W.-nr	DIN	BS	EN	SS	AFNOR	UNI	UNE	JIS	GOST
H	Hardened materials											
	-	440A	1.4108	X100CrMo03	-	-	2258 08	-	-	-	C4BS	-
	-	610	1.4111	X100CrMoV15	-	-	2534 05	-	-	-	AC4A	-
	-	0-2	-	X65CrMo14	-	-	2541 06	-	-	-	AC4A	-

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Comparison table materials

ISO	Country and standard											
	China	USA	Germany		Great Britain		Sweden	France	Italy	Spain	Japan	Russia
	GB	AISI/SAE	W.-nr	DIN	BS	EN	SS	AFNOR	UNI	UNE	JIS	GOST
N	Aluminium-based alloys											
	-	SC64D	3.2373	G-AISI9MGWA			4251	A-57G			C4BS	-
	-	DG-AISI12		G-ALMG5	LM5		4252	A-SU12			AC4A	
	-	356.1			LM25		4244				A5052	
	-	A413.0		GD-AISI12			4247				A6061	
	-	A380.1		GD-AISI8Cu3	LM24		4250				A7075	
	-	A413.1		G-AISI12(Cu)	LM20		4260				ADC12	
	-	A413.2		G-AISI12	LM6		4261					
-	A360.2		G-AISI10Mg(Cu)	LM9		4253						

ISO	Country and standard											
	China	USA	Germany		Great Britain		Sweden	France	Italy	Spain	Japan	Russia
	GB	AISI/SAE	W.-nr	DIN	BS	EN	SS	AFNOR	UNI	UNE	JIS	GOST
S	Nickel based alloys											
	-	5391	LW2 4670	S-NiCr13A16MoNb	mar-46	-	-	NC12AD	-	-		
	-	AMS 5397	LW2 4674	NiCo15Cr10MoAlTi	-	-	-	-	-	-		
	-	5660	LW2.4662	NiFe35Cr14MoTi	-	-	-	ZSNCDT42	-	-		
	-	5383	LW2.4668	NiCr19Fe19NbMo	HR8	-	-	NC19eNB	-	-		
	-	-	2.4631	NiCr20TiAk	Hr401.601	-	-	NC20TA	-	-		-
	-	AMS 5399	2.4973	NiCr19Co11MoTi	-	-	-	NC19KDT	-	-		-
	-	AMS 5544	LW2.4668	NiCr19Fe19NbMo	-	-	-	NC20K14	-	-		
	-	5390A	2.4603	-	-	-	-	NC22FeD	-	-		-
	-	5666	2.4856	NiCr22Mo9Nb	-	-	-	NC22FeDNB	-	-		-
	-	-	2.4630	NiCr20Ti	HR5.2034	-	-	NC20T	-	-		-
	-	4676	2.4375	NiCu30AL3Ti	3072-76	-	-	-	-	-		-
	Cobalt based alloys											
	-	5537C AMS		CoCr20W15Ni	-	-	-	KC20WN	-	-		
	-	5772	LW2.4964	CoCr20W14Ni				KC22WN				
	Titanium alloys											
	-	UNS R54520	3.7115.1	TiAl5Sn2.5	TA14/17	-	-	T-A5E	-	-		
	-							UNS R56400				
-	-	3.7165.1	TiAl6V4	TA10-13/ TA28		-	UNS R56401	T-A6V	-	-		
-			TiAl5V5Mo5Cr3									
-	-	3.7185	TiAl4Mo4Sn4Si0.5	-	-	-	-	-	-			

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Comparison table hardness and tensile strength

Hardness				Tensile strength N/mm ²	Hardness				Tensile strength N/mm ²
Rockwell Hardness		Vickers Hardness	Brinell Hardness		Rockwell Hardness		Vickers Hardness	Brinell Hardness	
HRC	HRA	HV	HB		HRC	HRA	HV	HB	
70.0	86.6	1037	—	—	51.0	76.3	525	501	1780
69.5	86.3	1017	—	—	50.5	76.1	517	494	1750
69.0	86.1	997	—	—	50.0	75.8	509	488	1720
68.5	85.8	978	—	—	49.5	75.5	501	481	1690
68.0	85.5	959	—	—	49.0	75.3	493	474	1660
67.5	85.2	941	—	—	48.5	75.0	485	468	1630
67.0	85.0	923	—	—	48.0	74.7	478	461	1605
66.5	84.7	906	—	—	47.5	74.5	470	455	1575
66.0	84.4	889	—	—	47.0	74.2	463	449	1550
65.5	84.1	872	—	—	46.5	73.9	456	442	1525
65.0	83.9	856	—	—	46.0	73.7	449	436	1500
64.5	83.6	840	—	—	45.5	73.4	443	430	1475
64.0	83.3	825	—	—	45.0	73.2	436	424	1450
63.5	83.1	810	—	—	44.5	72.9	429	418	1430
63.0	82.8	795	—	—	44.0	72.6	423	413	1405
62.5	82.5	780	—	—	43.5	72.4	417	407	1385
62.0	82.2	766	—	—	43.0	72.1	411	401	1360
61.5	82.0	752	—	—	42.5	71.8	405	396	1340
61.0	81.7	739	—	—	42.0	71.6	399	391	1320
60.5	81.4	726	—	—	41.5	71.3	393	385	1300
60.0	81.2	713	—	2555	41.0	71.1	388	380	1280
59.5	80.9	700	—	2500	40.0	70.8	382	375	1260
59.0	80.6	688	—	2450	40.0	70.5	377	370	1245
58.5	80.3	676	—	2395	39.5	70.3	372	365	1225
58.0	80.1	664	—	2345	39.0	70.0	367	360	1210
57.5	79.8	653	—	2295	38.5	—	362	355	1190
57.0	79.5	642	—	2250	38.0	—	357	350	1175
56.5	79.3	631	—	2205	37.5	—	352	345	1160
56.0	79.0	620	—	2160	37.0	—	347	341	1140
55.5	78.7	609	—	2115	36.5	—	342	336	1125
55.0	78.5	599	—	2075	36.0	—	338	332	1110
54.5	78.2	589	—	2035	35.5	—	333	327	1095
54.0	77.9	579	—	1995	35.0	—	329	323	1080
53.5	77.7	570	—	1955	34.5	—	324	318	1065
53.0	77.4	561	—	1920	34.0	—	320	314	1050
52.5	77.1	551	—	1885	33.5	—	316	310	1035
52.0	76.9	543	—	1850	33.0	—	312	306	1020
51.5	76.6	534	—	1815	32.5	—	308	302	1010

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Comparison table hardness and tensile strength

Hardness					Tensile strength N/mm ²	Hardness					Tensile strength N/mm ²
Rockwell Hardness		Vickers Hardness	Brinell Hardness			Rockwell Hardness		Vickers Hardness	Brinell Hardness		
HRC	HRA	HV	HB			HRC	HRA	HV	HB		
32.0	—	304	298		995	24.0	—	249	245		820
31.5	—	300	294		980	23.5	—	246	242		810
31.0	—	296	291		970	23.0	—	243	240		800
30.5	—	292	287		960	22.5	—	240	237		790
30.0	—	289	283		950	22.0	—	237	234		785
29.5	—	285	280		935	21.5	—	234	232		775
29.0	—	281	276		920	21.0	—	231	229		765
28.5	—	278	273		910	20.5	—	229	227		760
28.0	—	274	269		900	20.0	—	226	225		750
27.5	—	271	266		890	19.5	—	223	222		745
27.0	—	268	263		880	19.0	—	221	220		735
26.5	—	264	260		870	18.5	—	218	218		730
26.0	—	261	257		860	18.0	—	216	216		725
25.5	—	258	254		850	17.5	—	214	214		715
25.0	—	255	251		835	17.0	—	211	211		710
24.5	—	252	248		830						

Note: The conversion values for steel in the table are commonly applicable for the steels with carbon from low to high.

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Conversion table chip breakers – turning

ISO	Anwendung	ZCC-CT		Sandvik		Seco		Kennametal		ISCAR		Walter		Mitsubishi		Sumitomo		Tungaloy		Kyocera		Korloy		Ingersoll Tague Tec				
		Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos			
P	Wiper-finishing	WG		WF WL	WF WK	W-MF2	W-F1	FW MW	FW MW	WF		NF	PF	SW	FW	NLU-W	NLU-W	ASW		WP		VW LW		WS				
	Finishing	DFEF	SF HF	PF QF	PF UF 23	FF1 MF1	FF1 F1	FF FN	11 UF LF	SF		NF3 NS6	PF4 PF5	FH FS	FJ FV	NLU NFP	NLU NFA NLF	TF TS 17	PF 01	DP GP	VF	VG VF	VL	FG FC	VF	FA SA FG		
	Semi-finishing	DM EM	HM	PM QM	PM UM	MF2	F2	FN	MF		NF TF	14 16	17 19	SH SA	SW SV	NSX	NSU NSC	TSTMA S	PS	HQ CQ	CJ	VQ VC	VB	WT ML	WT			
	Medium machining to light roughing	DM PM	HR	PM QM	PR UR	M3 MF3	F2	MN	MF		GN PP	17 19		MV MZ	MM	NMU NSF	NMU NUX	TM DM	PM	GS CS	HS PS	HO XQ	GK G	PC MC	MT MG	PMR		
	Wiper-medium			WR WM	WM	W-M3	W-R4	W-R7	MW RW	MW	WG		NM	PM	MW	NGU-W				WQ								
	Roughing	DR		PR QR 31		M5 MR5	MR7	RP UN	RN		TNM GN	19		GH MAT	MT	NMU NMX				PT GT	HT	G	St-form	HR	RT			
	Single side roughing	HDR	31 HPR	HR QR		R8 RR9	-56	-57	RH RM	RP		NR6 NR8		HA HZ	HH HV	NMP NHG	NHP	NHU NHW		HX			GH VH	VT	HT HD	HY HZ	RX RH	CMX
	Wiper-finishing	WG		WF WL	WMX	W-MF2		FW MW	FW MW	WF			PF	SW	FW	NLU-W												
	Finishing	EF DF	EF HF	MF	MF UF	FF F2	MF1	F1	FF FP	11 UF LF	NF VL	PF SM	NF4	PF4 PF5	FJ FV	NSU NLU	NSU NLU	SS	SS	GU				VF	FG			
	Semi-finishing	EF EM	EF EM	MF MM	MF UM	MF3	MF3	F2	FP	MF	PP TF	14 16	17 19	SH MS	MV	NEX NUP	NSU	SS SM	PS	MS			CK DP	GP VF	XP			
Medium machining to light roughing	EM DM	EM HM	MM	MM UM	R6 S6	F2	F2	MP	HP	PP TF	17 19		MS ES	MM	NGU	NMU	SA S	PM	MS			HO XQ	GK G	EM SU	MT PMR	WT		
Wiper-medium			WR WM	WM	W-M3			MW RW	MW	WG		PM	MW		NGU -W													
Roughing	ER DR	HR	MR QR	PR	R7 R8			MP-P		HTW NR	19	NR4	GH HZ		NMU NMX	NHG						VM	ET	CMX				
Single side roughing	ER DR	HDR LR	HR QR		-56			RP																				



Conversion table chip breakers – turning

ISO	Application	ZCC-CT		Sandvik		Seco		Kennametal		ISCAR		Walter		Mitsubishi		Sumitomo		Tungaloy		Kyocera		Korloy		Ingersoll Tague Tec		
		Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	Neg	Pos	
K	Wiper-Finishing	WG		WF-WM	WF	W-MF2	W-F1	FW-MW	WF								NLU-W									
		DF	HF	KF	KF	F1	F1	FF-FN	11 UF-LF	NF-SM	14 19	P55					NSU	NLU					VM			
	Semi-finishing	PM	HM	KF-KM	KF-KM	M3	F2	FN	MF	GN	14 19	NM5	P55	GH		NUX-NGU	NSU									
		DR	HM-HR	KM-QM	KM	M3	F2	UN	HP	GN-NR		NM6	PM5			NUZ-NGU-NMU	NMU	CM								
Cast Iron	Medium machining to light roughing					W-M3 W-R4 W-R7		MW	MW	WG		NM				NGU-W										
		DR *NMA	HR	KR-QR	KR-UR	M5				NR		NR6		GH												
	Wiper medium		LC		AL			LF	LF	NF			PM2													
			LC		AL		AL	GP		NF-PP	AS															
Non-ferrous metals	Medium machining to light roughing		LH		AL		AL	GG-FS MS	HP	NMS																
		NF-EF	NF	NGP	MF	MF1		FS	GT-HP	SF-PF	PF-SM															
	Finishing	NF-NM-EM	NF	23	MM	MF1-M1		FS-MS	GT-MF	SF-PF	PF-SM															
		NM-EM		MF	MM-LUM	M1		MS	MT-LF	PP-TF																
S	Medium machining to light roughing																									
		ER		SR		MP3-MR4		RP		TF-HTW-NR																
	Roughing																									

Conversion table grades – turning

Coated cemented carbide CVD

ISO	ZCC-CT	Sandvik	Kennametal	Sumitomo	Mitsubishi	Toshiba Tungaloy	Kyocera	Walter	Iscar	SECO	Korloy	Ingersoll Tague Tec	Widia		
P	Steel	P01-05	GC4205 GC4305	KCP05 KC9105	AC805P	UE6005 UE6105	T9005 T9105	CA5505	WPP01 WPP05	IC8150 IC9150 IC428	TP0500 TP0501				
		P10-15	GC4315 GC4215	KCP10 KC9110	AC810P AC700G	UC6110 MY5015	T9015 T9115	CA510 CA5515 CA510	WPP10 WPP10S	IC8150 IC8250 IC9150 IC9250 IC9015	TP1500 TP1501	NC3010	TT8115 TT8125	WP15CT	
		P20-25	GC4325 GC4225 GC4025	KCP25 KC9125	AC820P AC8020P AC900G AC2000	UE6020 MC6025	T9025 T9125	CA5525 CA525 CR9025	WPP20 WPP20S	IC8150 IC8250 IC9250 IC9025	TP2501 TP2500 TP200	NC3220 NC3120	TT8125 TT3500	WP25CT	
		P30-35	GC4335 GC4235 GC4035	KCP30 KC8050	AC830P AC3000	UE6035 UE6400	T903 T9135	CA530 CA5535 CA535	WPP30 WPP30S	IC8250 IC8350 IC9350	TP3500	NC3030 NC5330 NC500H	TT5100 TT8135	WP35CT	
		M10	GC2015 GC1515	KCM15	AC610M	MC7015	T9115			IC8250 IC9250 IC6015			TT9215	WM15CT	
		M20	GC2015 GC2025	KCM25 KC9225	AC610M AC630M	US7020 MC7015 MC7025	T6020 T6120 T9125	CA6515	WAM20	IC8250 IC9350 IC6025 IC6025	TM 2000 TP200 TP2500	NC9025	TT5100 TT9225	WM25CT	
		M30	GC2025 GC2035	KCM25 KCM35 KC9225	AC630M AC6030M AC830P AC3000	US735 US7025	T6030 T6130	CA6525	WAM30	IC8350 IC9350 IC9025	TP3500 TM4000		TT5100 TT7100 TT9235	WM35CT	
		M40	GC2035	KCM35 KC9240 KC9245	AC630M AC6030M AC830P AC3000	US735	T6030 T6130	CA6525		IC6025 IC9350	TP40				
		K01-05	GC3005 GC3205	KCK05	AC405K AC410K	UC5005 UC5105	T5105	CA4505		IC5005 IC9007		NC6205	TT1300 TT7005	WK05CT	
		K10-15	GC3215	KCK15 KC9315	AC410K AC415K AC420K AC700G	MC5015 UC5115 MY5015	T5105 T5115	CA4010 CA4515 CA4115	WAK10 WAK10S	IC9015 IC9007 IC8150 IC5010 IC428 IC4028 IC9150	TK1001 TK1000	NC6210	TT1300 TT7310 T7015	WK20CT	
K20-25	GC3225	KCK20 KC9320	AC420K AC900G	MC5015 UC5115 UE6110 MY5015	T5125 T9125	CA4125	WAK20 WKK20S	IC5010 IC428 IC4028 C9150	TK2000 TK2001	NC5330		WK20CT			
K	Cast iron														

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index



Conversion table grades – turning

Coated cemented carbide PVD

ISO	ZCC-CT	Sandvik	Kennametal	Sumitomo	Mitsubishi	Toshiba Tungaloy	Kyocera	Walter	Iscar	SECO	Korloy	Ingersoll Tague Tec	Widia	
P01-05		GC1105					PR1005							
P10-15	YBG101 YBG102 YBG105	GC1515 GC1115 GC1025	KC5010 KC5510 KC7215 KC7315	AC510U	VP10MF VP15TF	AH710	PR930 PR1005 PR930 PR1115	WSM10 WXN10	IC520N IC507 IC570 IC807 IC907 IC908					
P20-25	YB9320 YBG205 YBG202	GC1515 GC1125 GC1025	KC5025 KC5525 KU25T	AC520U	VP20RT VP20MF	AH725 AH120	PR930 PR1025 PR1225	WSM20 WMP20S WSM21	IC228 IC250 IC308 IC828 IC350 IC354 IC507 IC807 IC808 IC907 IC908 IC928 IC1008 IC1028 IC3028	CP200 CP250 TP2000 TS2500	TT8020 TT9020			
P30-35	YBG302	GC1125 GC2035	KC7335	AC530U		SH730 J740 GH130 AH740	PR660	WSM30	IC228 IC250 IC328 IC330 IC354 IC528 IC1008 IC1028 IC3028	CP500	PC5300		WS10PT	
M10	YBG101 YBG102 YBG105	GC1105 GC1115 GC1025 GC1125 GC1515	KCU10 KC5010 KC5510 KC6005 KC6015	EH10Z AC510U AC530U	VP10MF	AH710	PR915 PR1005	WSM10	IC330 IC354 IC507 IC520 IC570 IC807 IC1028 IC3028	CP500 TS2000	PC8110	TT5080		
M20	YB9320 YBG205 YBG202	GC1025 GC1125	KC501 KCU25	AC520U AC530U	VP10RT VP15TF VP20RT VP20MF	AH120 AH725 SH730 AH710 AH630 GH330 J740	PR1025 PR1125 PR1225	WSM10 WMP20S WSM20 WSM21	IC228 IC250 IC354 IC808 IC908 IC1008 IC1028 IC3028	TS2000 TS2500 CP200 CP250	PC5300 PC9030	TT8020 TT9020 TT9080	WS25PT	
M30	YBG302	GC2035	KC5025 KCU25		VP10RT VP15TF VP20RT VP20MF MP7035	AH12 AH725 SH730 AH710 AH630 GH330 J740	PR1025 PR1125	WSM20 WSM21 WSM30	IC228 IC250 IC328 IC330 IC1008 IC1028 IC3028	CP500 TS2500				
S05		S05F			MP9005	AH905			IC507 IC907					
S10	YBG102 YBG105 YBG202 YBG205	GC1105 GC1115	KC5010 KCU10 KC5510 KC510	AC510U EH510Z	MP9015 VP10RT	AH905 SH730 AH110 AH120		WSM10	IC507 IC807 IC808 IC907	CP200 CP250 TS2000 TS2500	PC8110	TT5080	WS10PT	
S20	YB9320 YBG205 YBG202	GC1025 GC1125 GC1515	KC5010 KCU10 KC5025 KCU25 KC5525	AC520U EH520Z	MP9015 VP20RT MT9015	AH120 AH725	PR1125	WSM20 WSM21 WSM30	IC507 IC807 IC907	CP250 TS2500 CP500	PC5300	TT5080 TT8020 TT9080	WS25PT	
S30	YBG302			AC520U	VP15TF	AH725	PR1125	WSM30	IC3028 IC808 IC830		PC5400	TT8020		
N10	YBG101 YBG102 YBG105	GC1515	KC5410					WXN10	IC520					

Conversion table grades – turning

Cermet

ISO	ZCC-CT	Sandvik	Kennametal	Sumitomo	Mitsubishi	Toshiba Tunggaloy	Kyocera	Walter	Iscar	SECO	Korloy	Ingersoll Tague Tec	Widia	
P	Steel	P01-05	CT5005	T110A T1000A	AP25N VP25N	NS520 AT520 GT520 GT720	TN30 TN6010 PV30 PV7010		IC20N IC520N		CN1000 CC105	CT3000 PV3010		
		P10-15	CT5015 CT530	KT315 KT125	T1200A T2000Z T1500A T1500Z	NX2525 AP25N VP25N	NS520 NS730 GT730 NS9530 GT9530	TN60 TN6010 PV60 PV6010		IC20N IC520N IC530N	CM TP1020 TP1030 CMP	CN1000 CT10 CN2000 CC115	CT3000 PV3010	TT115
		P20-25	GC1525	KT325 KT1120 KT5020	T1200A T2000Z T1500A T1500Z	NX2525 NX3035 AP25N VP25N MP3025	NS530 NS730 GT730 NS9530 GT9530	TN60 TN6020 PV60 PV7020 PV7025		IC20N IC30N IC75T IC520N IC530N	CM TP1020 TP1030 CMP	CN20 CN2000 CC115		
P30-35			T3000Z	MP3025 VP45N		PV7025 PV90		IC75T						
M	Stainless steel	M10	GC1525	T110A T1000A T1500Z T2000Z	NX2525 AP25N VP25N	NS520 AT530 GT530 GT720	TN60 TN6020 PV60 PV7020			CM TP1020 TP1030 CMP		CT3000 PV3010	TT115	
		M20	CT5015 CT530	HT2	T110A T1000A T1500Z T2000Z	NX2525 AP25N VP25N	NS530 GT730 NS730	TN90 TN6020 PV90 PV7020 PV7025				CT3000 PV3010	TT115	
		M30			T3000Z									
		M40												
K	Cast iron	K01-05		T110A T1000A T2000Z T1500Z	NX2525 AP25N	NS520 GT730 NS730	TN30 TN6010 PV30 PV7005 PV7010				CN1000	CT3000 PV3010		
		K10-15	CT5015	KT325 KT125	T1200A T1500A T2000Z T1500Z	NX2525 AP25N	NS520 GT730 NS730	TN60 TN6020 PV60 PV7020 PV7025				CN1000	CT3000 PV3010	
		K20-25	CT5015		T3000Z	NX2525 AP25N								

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Conversion table grades – turning

Uncoated carbide

ISO	ZCC-CT	Sandvik	Kennametal	Sumitomo	Mitsubishi	Toshiba Tungaloy	Kyocera	Walter	Iscar	SECO	Korloy	Ingersoll Tague Tec	Widia
N Non-ferrous metals	N01	H10 H13A	KF1	H1		KS05F				883 890			
	N10	H10 H13A	K313 KF1 THM-F	H1	HT110	KS15F	KW10	WK01 WK10	IC20	890 KX HX	H01	K10	THM
	N20	H10 H13A	K313 KF1 THM-F			KS15F	KW15		IC20	KX HX			

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Conversion table grades – milling

CVD milling grades

Material / Class	ZCC-CT	Sandvik	Kenametal	Sumitomo	Mitsubishi	Toshiba Tunggaloy	Kyocera	Walter	Iscar	SECO	Korloy	Ingersoll Tague Tec
P	P05	K20W GC4220		F7010								
	P10	K20W GC3040 GC4220 GC4230		ACP100	F7010				IC4100 IC5100	MP1500	NC5330 NCM325	IN6505 IN6520
	P20	GC3040 GC4230		CS3000	FH7020	T3130		WKP25 WKP255	IC4050 IC4100 IC5100 IC5400	MP1500 MP2500 MS2500 T25M	NC5330 NCM325	IN6505 IN6520 IN7035
	P30	GC2040 GC4240		CS3000	F7030	T3130		WKP35 WKP355 WTP35	IC4050 IC5400	MK3000 T25M T350M	NCM325	IN7035 IN6530
	P40	GC2040 GC4240								T350M		IN6530
	M10	GC4230			F7010					MP1500	NCM325 NC5330	IN6520
	M20	GC4230			F7020	T3130			IC4050	MP1500 MP2500 MS2500 T25M	NCM325 NCM335	IN7035 IN6520 IN6505
	M30	GC2040 GC4240			F7030	T3130		WTP35		MP2500 MS2500 T25M T350M	NCM335	IN6530 IN7035 IN6505
	M40	GC2040 GC4240								T350M		IN6530
	K	K05				F7010 MC5020				DT7150 IC4100		
K10		K20W		ACK200	F7010 MC5020	T1115		WAK15	DT7150 IC4100 IC4010	MP1500 MK1500	NC5330	IN6520
K20		K20W		ACK200		T1115		WKP25 WKP255	DT7150 IC4100	MP1500 MP2500 MS2500 T25M MK1500	NC5330	IN6530 IN6515 IN6520
K30								WKP35 WKP355	IC4050	MK3000 MP2500 MS2500		IN6530 IN6515

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Conversion table grades – milling

CVD milling grades

Material / Class	ZCC-CT	Sandvik	Kennametal	Sumitomo	Mitsubishi	Toshiba Tungaloy	Kyocera	Walter	Iscar	SECO	Korloy	Ingersoll Tague Tec
S Heat-resistant alloys	S05									MK3000		
	S10											
	S20									MP2500 MS2500 T25M		IN7035 IN6520
	S30		GC2040					WTP35		MM4500 T350M		
N Non-ferrous metals	N05											
	N10											
	N20									MP2500 25M		
H Hardened materials	H05											
	H10		K20W									
	H20		K20W GC3040									

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Conversion table grades – milling

PVD milling grades

Material / Class	ZCC-CT	Sandvik	Kennametal	Sumitomo	Mitsubishi	Toshiba Tungaloy	Kyocera	Walter	Iscar	SECO	Korloy	Ingersoll Tague Tec
P Steel	P05			ACZ120	VP05HT	GH130			IC903			
	P10	GC1010 GC1025 GC1020	KC522M KC525M KC610M KC643M KC715M	ACZ10M ACZ20W	VP10H	AH120 GH130	PR730 PRI225 PRI525	WHX15 WHH15 WXM15	IC903 IC950 IC1008	F15M		IN2004 IN2006
	P20	GC1020 GC1025 GC1010 GC2030	KC522M KC525M KC643M KC715M KC725M	ACP200 ACZ330 ACX70 ACW30 AC350 ACZ50M	VP15TF VP20M VP20RT	AH725 AH120 AH130 AH330 AH725 AH730 GH330	PR630 PR830 PR730 PRI225 PRI230 PRI525	WXM15	IC810 IC380 IC830 IC900 IC908 IC910 IC950 IC1008	F25M MP3000	PC3500 PC3600	IN2006 IN1030 IN2004 IN2005 IN2015 IN2030 IN2505 IN2540
	P30	GC1030 GC2030	KC530M KC725M KC735M	ACP200 ACP300 ACZ50M ACZ330 ACZ350 ACX70 ACW30 AC350	VP30RT	AH740 AH130 AH140	PR630 PR660 PR830 PRI230	WXM35	IC300 IC328 IC830 IC900 IC928 IC350 IC808 IC908	F30M MP3000	PC3500 PC3600 PC5300 PC3545 PC9570T	IN1030 IN2005 IN2015 IN2030 IN2035 IN2040 IN2505 IN2530 IN4035
P40	GC1030	KC735M	ACP300 ACZ350		AH140 AH750		WXP45 WSP45 WSP46	IC300 IC328 IC928	F40M	PC5300 PC3545	IN2035 IN2040	
M Stainless steel	M10	GC1020	KC522M KC610M KC643M KC715M	ACZ20W ACZ350 EH20Z	AH330 GH110 GH130	PR730 PRI1225 PR660 PRI1525		PR730 PR660 PRI1025 PRI1225 PRI1525	F15M	PC8110		IN2505
	M20	GC1020 GC1025 GC1030 GC203	KC522M KC525M KC610M KC715M KC725M	ACP200 ACZ50M ACZ20M ACZ350 EH20Z AC350	VP15TF VP20RT	AH725 AH730 GH110	PR730 PRI1025 PR660 PRI1225 PRI1525	WXM15	F25M MP3000	PC5300 PC8110 PC9530		IN2005 IN2015 IN2505
	M30	GC1040 GC203	KC525M KC530M KC725M KC735M	ACP300 ACZ50M ACX80 AC350	VP30RT	AH740 AH120 AH130 GH330 GH340		W5M35 W5M36 WXM35	F30M MP3000	PC9530 PC3545 PC9570T		IN1030 IN2015 IN2030 IN2035 IN2530 IN4035
	M40	GC1040	KC530M KC735M	ACP300 ACX80		AH140 AH750 GH330 GH340			F40M	PC3545		IN1030 IN2030 IN2035 IN2530 IN4035
K Cast iron	K05	GC1010	KC510M	ACZ10M ACZ120 ACZ310	AH330		PR905 PRI1210 PRI1510		MH1000		PC8110	IN2510
	K10	GC1010	KC510M KC520M KC620M KC643M	EH20Z ACZ310	AH120 AH330 AH725	PR905 PRI1210 PRI1510	WXM15 WHH15 WXM15	IC810 IC950 IC1008	F15M MK2000	PC6510		IN2004 IN2010 IN2510
	K20	GC1020	KC520M KC620M KC725M	ACK300 EH20Z ACX80 ACW30	VP15TF	GH130		WKK25	IC328 IC830 IC950 IC350 IC808 IC908 IC1008	F25M MK2000 MO3000	PC6510 PC5300	IN1030 IN2004 IN2010 IN2015 IN2030 IN2505
K30	GC1020	KC620M KC725M	ACK300 ACZ50M					IC328 IC830 IC900 IC908 IC350 IC808 IC908	F30M F40M MP3000	PC5300 PC9570T	IN2005 IN2015 IN2030 IN2505	

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index



Conversion table grades – milling

PVD milling grades

Material / Class	ZCC-CT	Sandvik	Kennametal	Sumitomo	Mitsubishi	Toshiba Tunggaloy	Kyocera	Walter	Iscar	SECO	Korloy	Ingersoll Tague Tec
S Heat-resistant alloys	S05									MH1000 F15M	PC8110	
	S10	YBG102 YBG202 YBG205		KC525M KC643M	ACZ20W VP15TF		PR905 PR1210 PR1510		IC808	NH1000 F15M F25M	PC5300	
	S20		S30T GC1025 GC1030 GC2030	KC525M KC643M	ACZ20W		PR905 PR1210 PR1510		IC908 IC380 IC900 IC903 IC908 IC928 IC830 IC808	F25M F30M	PC5300 PC3545	IN2005 IN2505
	S30		GC2030	KC725M KC735M	ACZ50M			WSM35 WSM36 WSP45 WSP46 WXM35 WXP45	IC328 IC928 IC830	F40M	PC3545	IN1030 IN2030 IN2035 IN2530 IN4035
N Non-ferrous metals	N05									MH1000 F15M		
	N10	YBG202		KC510M				WXN15		MH1000 F15M		
	N20		GC1025 GC1030	KC620M KC522M KC651M	EH20Z					F25M F30M F40M MP3000		
H Hadeded materiels	H05				VP05HT				IC903	MH1000 F15M	PC210F	IN2004 IN2006
	H10	YBG102		KC643M	VP10MF			WXH15 WHH15	IC900 IC808	MK2000 F30M MP3000	PC210F	IN2004 IN2005 IN2006
	H20	YBG202	GC1010 GC1025 GC1030		VP15TF				IC810 IC908	F30M F40M MK2000 MP3000		

Conversion table grades – milling

Uncoated milling grades

ISO	ZCC-CT	Sandvik	Kennametal	Sumitomo	Mitsubishi	Toshiba Tungaloy	Walter	Kyocera	Iscar	SECO	Korloy	Ingersoll Tague Tec
N	Non-ferrous metals	N01	K115M K110M				WK10		IC20N		H01	IN04S
		N10		K313	EH520	HT10	WKM	GW25	IC08	H15	G10	IN10K IN05S
		N20		KMF	EH520	TF15	KMG40			IC28	H25	

A

Turning

B

Milling

C

Drilling

D

Technical
Information

E

Index

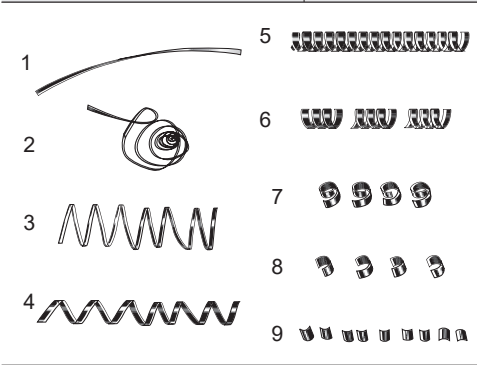
Examples of materials for machining groups

Material No.	Material	Machining group	Material No.	Material	Machining group	Material No.	Material	Machining group
1.0722	10SPb20	1	1.1203	Ck55	4 / 5	1.4429	X2CrNiMoN 17-13-3	14
1.0715	9SMn28	1	1.1221	Ck60	4 / 5	1.4311	X2CrNiN 18 10	14
1.0736	9SMn36	1	1.5710	36NiCr9	5 / 9	1.4301	X5CrNi 18-10	14
1.0718	9SMnPb28	1	1.5120	38MnSi 7	5 / 9	1.4401	X5CrNiMo 17-12-2	14
1.0737	9SMnPb36	1	1.1545	C 105 W5	4 / 5	0.6010	GG10	16
1.0401	C15	1	1.1663	C 125 W	4 / 5	0.6015	GG15	16
1.0402	C22	1	1.0535	C95	4 / 5	0.6020	GG20	16
1.1141	Ck15	1	1.0601	C100	4 / 5	0.6025	GG25	16 / 17
1.1170	28Mn6	2	1.1274	Ck101	4 / 5	0.6030	GG30	17
1.0726	35S20	2 / 3	1.1203	Ck55	4 / 5	0.6035	GG35	17
1.1167	36Mn5	2 / 3	1.1221	Ck60	4 / 5	0.6040	GG40	17
1.1157	40Mn4	2 / 3	1.5710	36NiCr10	5 / 9	1.4829	X12NiCrSi 22-12	17
1.0501	C35	2 / 3	1.5120	38MnSi 8	5 / 9	1.4828	X15CrNiSi20-12	17
1.0503	C45	2 / 3	1.5680	12Ni19	10 / 11	0.7033	GGG35.3	18
1.1191	Ck45	2 / 3	1.3255	S 18-1-2-5	10 / 11	0.7040	GGG40	18
1.1183	Cf35	2 / 3	1.3348	S 2-9-2	10 / 11	0.7043	GGG40.3	18
1.1213	Cf53	2 / 3	1.3343	S 6-5-2	10 / 11	0.8135	GTS-35	18
1.1545	C 105 W1	4 / 5	1.3243	S 6-5-2-5	10 / 11	0.7050	GGG50	19
1.1663	C 125 W	4 / 5	1.2363	X 100 CrMoV 5-1	10 / 11	0.7060	GGG60	19
1.0535	C55	4 / 5	1.2601	X165CrMoV12	10 / 11	0.7070	GGG70	19
1.0601	C60	4 / 5	1.2080	X210 Cr 12	10 / 11	0.7660	GGGNiCr 20-2	19
1.1274	Ck101	4 / 5	1.2581	X30WCrV 9-3	10 / 11	0.7652	GGGNiMn 13-7	19
1.1203	Ck55	4 / 5	1.2344	X40CrMoV 5-1	10 / 11	0.8155	GTS-55	21
1.1221	Ck60	4 / 5	1.4718	X45CrSi9-3	10 / 11	0.8165	GTS-65	21
1.5710	36NiCr6	5 / 9	1.3355	S 18-0-1	10 / 11	0.8170	GTS-70	21
1.5120	38MnSi 4	5 / 9	1.4027	G-X20Cr14	12 / 13	0.8145	GTS-45	21
1.1545	C 105 W2	4 / 5	1.4006	X12 Cr 13	12 / 13	3.0205	Al99	22
1.1663	C 125 W	4 / 5	1.4104	X12CrMoS 17	12 / 13	3.3315	AlMg 1	22
1.0535	C65	4 / 5	1.4057	X19CrNi 17-2	12 / 13	3.1325	AlCuMg 1	23
1.0601	C70	4 / 5	1.4034	X46Cr 13	12 / 13	3.2315	AlMgSi 1	23
1.1274	Ck101	4 / 5	1.4871	X53 CrMnNiN 21-9	12 / 13	3.2581	G-AlSi12	24
1.1203	Ck55	4 / 5	1.4113	X6CrMo 17	12 / 13	3.2163	G-AlSi9Cu3	24
1.1221	Ck60	4 / 5	1.4000	X6CR 13	12 / 13	3.2381	G-AlSi10Mg	25
1.5710	36NiCr7	5 / 9	1.4001	X7Cr14	12 / 13	2.0375	CuZn36Pb 3	27
1.5120	38MnSi 5	5 / 9	1.4016	X6Cr17	12 / 13	2.1096	G-CuSn5ZnPb	27
1.1545	C 105 W3	4 / 5	1.4581	G-X5CrNiMoNb 18	14	2.0590	G-CuZn40Fe	27
1.1663	C 125 W	4 / 5	1.4308	G-X6CrNi 18-9	14	2.0240	CuZn15	28
1.0535	C75	4 / 5	1.4408	G-X6CrNiMo 18-10	14	2.0060	E-Cu 57	29
1.0601	C80	4 / 5	1.4583	X6CrNiMoNb 18-12	14	1.4865	G-X40NiCrSi 38-18	30
1.1274	Ck101	4 / 5	1.4571	X6CrNiMoTi 17-12-2	14	1.4864	X12NiCrSi 36-16	30
1.1203	Ck55	4 / 5	1.4550	X6CrNiNb 18-10	14	2.4631	NiCr20TiAl	32
1.1221	Ck60	4 / 5	1.4541	X14CrNiTi 18-10	14	2.4856	NiCr22Mo9Nb	32
1.5710	36NiCr8	5 / 9	1.4845	X12CrNi 25-21	14	2.4375	NiCu30Al	33
1.5120	38MnSi 6	5 / 9	1.4310	X10CrNi 18-8	14	2.4955	NiFe25Cr20NbTi	33
1.1545	C 105 W4	4 / 5	1.4305	X10CrNiS 18-10	14	2.4764	CoCr20W15Ni	34
1.1663	C 125 W	4 / 5	1.4878	X12CrNiTi 18-9	14	1.3401	G-X120Mn12	34
1.0535	C85	4 / 5	1.4317	X2CrNi 18-8	14	3.7165	TiAl6V4	36
1.0601	C90	4 / 5	1.4436	X3CrNiMo 17-13-3	14			
1.1274	Ck101	4 / 5	1.4440	X2CrNiMo 18-16	14			

Test protocol

ZCC Cutting Tools Europe GmbH

Date:			
General	End User	Distributor	
Company			
Contact person			
Machine			
Type			
Producer			
Power [kW]			
Tooling system			
Work piece			
Material			
Hardness/Tensile strength [N/mm ²]			
Heat treatment/Surface			
Interrupt cutting			
Cutting tools			
Producer (holder)			
Toolholder (name)			
Teeth Z			
Producer/Supplier			
Insert type/Tool number			
Grade			
Solid carbide tools number			
Cooling			
Cutting Data			
RPM n [U/min]			
Cutting speed Vc [m/min]			
Feed rate f [mm/rpm]			
Feed rate Vf [mm/min]			
Depth of cut a _p [mm]			
Width of cut a _e [mm]			
Machining length [mm]			
Cutting time T [min]			
Results			
Machined pieces/Edges			
Surface quality			
Flankwear VB			
Criteria			
Notch wear			
Crater wear			
Plastic deformation			
Built-up edge			
Insert breakage			
Cutting edge breakage			



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Conclusion:

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Signature:

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Torque for screw

Thread	M1,6	M1,8	M2	M2,2	M2,5	M3	M3,5	M4	M4,5	M5	M6	M7	M8	M10	M12
Torque [Nm]	0,2	0,3	0,4	0,7	0,8	1,5	2,3	3,4	5,0	6,7	11,4	19,2	27,0	55,8	85

A

Turning

B

Milling

C

Drilling

DTechnical
Information**E**

Index

Index

Inserts

E2-E5

Tools

E6-E8

E

A

Turning

B

Milling

C

Drilling

D

Technical
Information

E

Index

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

1

175.32-22	A101
175.32-24	A101
175.32-25	A101
175.32-28	A101
175.32-31	A101

A

ANGX*PNR-GM	B127
	B129
	B131
	B133
	B135
ANGX*PNR-LH	B127
	B129
	B131
	B133
	B135

APKT-ALH	B105
	B108
	B111
	B114
	B116
	B205
APKT-APF	B105
	B108
	B111
	B114
	B116

APKT-APM	B105
	B108
	B111
	B114
	B116
	B205
APKT-KM	B179
	B181
	B183

APKT-LH	B105
	B108
	B111
	B114
	B116
	B205

APKT-PF	B105
	B108
	B111
	B114
	B116
	B205

APKT-PM	B105
	B108
	B111
	B114
	B116
	B205

APKT-PR	B105
	B108
	B111
	B114
	B116
	B205

APMT	B118
------	------

C

CCGT (PCD)	A163
CCGT-SF	A102
CCGT-USF	A102
CCGW (PCBN)	A154
CCGX-LC	A108
CCGX-LH	A108
CCMT-AHF	A103
CCMT-EF	A105
CCMT-EM	A105
CCMT-HF	A103
CCMT-HM	A106
CCMT-HR	A107
CCMT-TC	A107
CCMW	A107
CNE-A/B	B175
CNEG-NF	A46
CNGA (PCBN)	A148
CNGN (PCBN)	A159
CNGX (Ceramic)	A178
CNMA	A54
CNMG	A54
CNMG-ADF	A45
CNMG-DF	A45
CNMG-DM	A47
CNMG-DR	A49
CNMG-EF	A45
CNMG-EG	A47
CNMG-EM	A47
CNMG-ER	A51

CNMG-NM	A49
CNMG-PM	A46
CNMG-SF	A45
CNMG-SNR	A50
CNMG-TC	A49
CNMG-WG	A45
CNMG-ZM	A48
CNMM	A53
CNMM-DR	A51
CNMM-ER	A51
CNMM-HDR	A53
CNMM-HPR	A53
CNMM-LR	A52
CPGT	A104
CPGT-SF	A110
CPGW	A110
CPMT-HF	A110
CPMT-HM	A110

D

DCGT (PCD)	A165
DCGT-SF	A111
DCGT-USF	A112
DCGW (PCBN)	A155
DCGX-LC	A115
DCGX-LH	A116
DCMT-AHF	A111
DCMT-EF	A113
DCMT-EM	A113
DCMT-HF	A113
DCMT-HM	A114
DCMT-HR	A115
DCMW	A115
DNEG-NF	A58
DNEG-NGF	A58
DNGA (PCBN)	A149
DNGN (Ceramic)	A180
DNGX (Ceramic)	A181
DNMA	A61
DNMG-ADF	A55
DNMG-DF	A55
DNMG-DM	A56
DNMG-DR	A60
DNMG-EF	A58
DNMG-EG	A59
DNMG-EM	A59
DNMG-ER	A61
DNMG-FM	A58
DNMG-NM	A59
DNMG-PM	A56

DNMG-SF A55
 DNMG-SNR A60
 DNMG-TC A59
 DNMG-ZM A57
 DNMM-DR A62
 DNMM-ER A62
 DNMM-HDR A62
 DNMM-LR A62
 DNMX-WG A55
 DPGT-SF A117

H

HNEX-DM B67
 HNEX-DR B67
 HNGX-HDR B212
 HNGX-MR B212

K

KNUX A100

L

LNCX B214
 LNE32.534 B213
 LNKT-GM B121
 B123
 LNKT-ZR B69
 B76
 B83

M

MPHT-DM B158
 B160
 B177

O

OFKR-DF B43
 OFKR-DM B43
 OFKT-DF B41
 OFKT-DM B41
 OFKT-LH B41
 ONHU-GM B57
 ONHU-PF B47
 B49

ONHU-PM B47
 B49

P

PNEG-CF B61
 B64
 PNEG-CM B61
 B64
 PNEG-CR B61
 B64
 PNEG-PF B62
 B64
 PNEG-PM B62
 B64
 PNEG-PR B62
 B64

Q

QC**R/L A369
 QC**R/L***R A372

R

R/LT****N-A(G) A415
 R/LT****N-A(G)B A432
 R/LT****N-AC A426
 R/LT****N-AP A428
 R/LT****N-BPTB A437
 R/LT****N-BSPT A419
 R/LT****N-BSPTB A436
 R/LT****N-BUT A430
 R/LT****N-GM A413
 R/LT****N-GMB A431
 R/LT****N-NPT A420
 R/LT****N-NPTF A421
 R/LT****N-R A422
 R/LT****N-RT A429
 R/LT****N-STAC A427
 R/LT****N-TR A425
 R/LT****N-UN A418
 R/LT****N-UNB A435
 R/LT****N-W A417
 R/LT****N-WB A434
 R/LT****W-A(G) A416
 R/LT****W-A(G)B A432
 R/LT****W-AC A426
 R/LT****W-AP A428
 R/LT****W-BPTB A437

R/LT****W-BSPT A419
 R/LT****W-BSPTB A436
 R/LT****W-BUT A430
 R/LT****W-GM A413
 R/LT****W-GMB A431
 R/LT****W-MJ A423
 R/LT****W-NPT A420
 R/LT****W-NPTF A421
 R/LT****W-R A422
 R/LT****W-RT A429
 R/LT****W-STAC A427
 R/LT****W-TR A425
 R/LT****W-UN A418
 R/LT****W-UNB A435
 R/LT****W-UNJ A424
 R/LT****W-W A417
 R/LT****W-WB A434
 RCGT A118
 RCGX-LH A118
 RCKT-DM B91
 B95

RCKT-DR B91
 B95
 RCKT-ER B91
 B95
 RCKT-NM B91
 B95

RCMT A118
 RCMW (PCBN) B92
 B95
 RCMX A119
 RDKW B97
 B101
 B207
 RNGN (PCBN) A162
 RNMG A99
 ROHX B140

S

SCGX-LC A122
 SCGX-LH A123
 SCMT-AHF A120
 SCMT-EF A120
 SCMT-EM A120
 SCMT-HF A121
 SCMT-HM A121
 SCMT-HR A122
 SDMT B138

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

A Turning	SDMT-DM	B167	SNMG-ER	A69	TCMT-AHF	A127
		B169	SNMG-NM	A68	TCMT-EF	A128
		B201	SNMG-PM	A65	TCMT-EM	A128
	SDMT-PM	B167	SNMG-SF	A63	TCMT-HF	A127
		B169	SNMG-TC	A67	TCMT-HM	A129
		B201	SNMM	A74	TCMT-HR	A129
	SEEN	B38	SNMM-DR	A70	TCMW	A129
	SEET-APF	B80	SNMM-ER		TNGA (PCBN)	A151
	SEET-APM	B80	SNMM-HDR	A72	TNGN (Ceramic)	A186
	SEET-APR	B80	SNMM-HPR	A73	TNMA	A89
B Milling	SEET-CF	B32	SNMM-LR	A71	TNMG	A88
		B35	SNUN	A77	TNMG-ADF	A78
	SEET-CM	B32	SPCN	B216	TNMG-DF	A78
		B35	SPGN	B219	TNMG-DM	A81
	SEET-CR	B32	SPGT-EM	C19	TNMG-DR	A84
		B35	SPGT-PM	C19	TNMG-EF	A80
	SEET-DF	B32	SPKN	B73	TNMG-EG	A83
		B35	SPKR	B74	TNMG-EM	A83
	SEET-DM	B32	SPKR-GM	B74	TNMG-ER	A85
		B35	SPKT	B71	TNMG-FM	A80
C Drilling	SEET-DR	B32	SPKW	B71	TNMG-PM	A81
		B35	SPMR	B217	TNMG-SF	A79
	SEET-EF	B32	SPMT	B138	TNMG-TC	A83
		B35		B185	TNMG-TM	A82
	SEET-EM	B32		B187	TNMM	A89
		B35		B189	TNMM-DR	A85
	SEET-LH	B32		B191	TNMM-HDR	A87
		B35		B193	TNMM-LR	A85
	SEET-PF	B80		B195	TNMX-WG	A78
	SEET-PM	B80	SPMT-HT	B218	TPCN	B220
D Technical Information	SEET-PR	B80	SPMT-KM	B179	TPGH	A132
	SEET-W	B33		B181	TPGT-SF	A133
		B36		B183	TPKN	B78
	SEKN	B39	SPMT-KT	B138		B221
	SEKR	B39		B218	TPMR	B222
	SNEG-E	B53	SPMT-PM	B179	TPUN	B222
	SNEG-GM	B53		B181		
	SNEG-GR	B53		B183		
	SNEG-W	B54	SPMW	A124		
	SNGA (PCBN)	A150	SPUN	B219		
E Index	SNGN (PCBN)	A160				
	SNGX (Ceramic)	A183				
	SNKN	B215	T			
	SNMA	A75	TBGH	A125	VBET-NF	A140
	SNMG	A74	TCGT (PCD)	A167	VBET-NGF	A142
	SNMG-ADF	A63	TCGT-SF	A126	VBGT (PCD)	A169
	SNMG-DF	A63	TCGT-USF	A126	VBGT-SF	A141
	SNMG-DM	A66	TCGW (PCBN)	A156	VBGW (PCBN)	A157
	SNMG-DR	A68	TCGX-LC	A131	VBMT-AHF	A140
	SNMG-EF	A64	TCGX-LH	A131	VBMT-EF	A140
SNMG-EG	A66	TCMT	A130	VBMT-EM	A142	
SNMG-EM	A67			VBMT-HF	A140	
				VBMT-HM	A142	
				VBMT-HR	A143	
				VBMT-SNR	A143	

VCGT	A135
VCGT-HF	A134
VCGT-NF	A134
VCGT-SF	A134
VCGT-USF	A135
VCGW (PCBN)	A158
VCGX-LC	A136
VCGX-LH	A137
VCMT-EF	A138
VCMT-EM	A138
VNEG-NF	A90
VNEG-NGF	A91
VNGA (PCBN)	A152
VNMG	A92
VNMG-ADF	A90
VNMG-DF	A90
VNMG-DM	A92
VNMG-EF	A90
VNMG-EM	A92
VNMG-NM	A92
VNMG-PM	A93
VNMG-SF	A91
VNMG-SNR	A93
VNMG-TC	A93
VNMG-ZM	A93
VPGT-USF	A139

W

WCMX-53	C20
	A144
WCMX-D	C20
WCMX-PG	C20
WNEG-NF	A95
WNGA (PCBN)	A153
WNGN (PCBN)	A161
WNHU-GM	B87
	B89
WNMA	A98
WNMG-ADF	A94
WNMG-DF	A94
WNMG-DM	A96
WNMG-DR	A98
WNMG-EF	A95
WNMG-EG	A96
WNMG-EM	A96
WNMG-NF	A95
WNMG-NM	A98
WNMG-PM	A97
WNMG-SF	A94
WNMG-TC	A98

WNMG-WG	A95
WNMG-ZM	A97
WPGT	B171
	B173
	B203
WPGT-PM	B171
	B173
	B203

X

XPHT-GM	B142
	B144
	B146
	B148
	B199
XSEQ	B154
	B156

Z

ZDET	B137
ZDET-PM	B137
ZIGQ-NM	A365
ZILD-LC	A367
ZIMF-NM	A364
ZOHX-GF	B150
	B152
	B211
ZOHX-GM	B150
	B152
	B211
ZP*D-MG-R/L	A356
ZP*S-MG	A355
ZPD-MG	A354
ZPNT	B137
ZR*D-EG	A363
ZR*D-LH	A366
ZR*D-MG	A362
ZT*D-EG	A359
ZT*D-MG	A357
ZT*D-MM	A353
ZT*S-MG	A358

A

Turning

B

Milling

C

Drilling

D

Technical
Information

E

Index

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

1

1101SC05	C110
1105SC03	C107
1143SC120	C120
1143SC90	C119
1165PA03	C111
1534SH03	C106
1534SP03C	C89
1534ST03C	C94
1534SU03	C32
1534SU03C	C32
1536ST05C	C98
1536SU05	C43
1536SU05C	C43
1538SU08C	C53
1557SU03	C72
1576PC05	C116
1576PC05C	C116
1579PC15C	C118
1588SL10C	C74
1588SL12C	C77
1588SL15C	C81
1588SL20C	C84
1588SL30C	C87
1634SU03C	C56
1636ST05C	C102
1636SU05C	C60
1734SU03C	C64
1736SU05C	C68

3

3101H7	C131
3102H7	C132
3103H7	C134
3112H7	C133

4

4111	C159
4122A	C145
4122M	C148
4201A	C155
4201C	C151
4202A	C157
4202C	C153
4222A	C146
4222M	C149

5

5501/5601	B432
5501R302GM	B272
5501R303GM	B287
5501R304GF	B301
5501R38414GM	B408
5502R302GM	B274
5502R303GM	B289
5502R304GF	B303
5502R38414GM	B409
5502R38414GM-R	B412
5502R402NM	B378
5502R453GM	B291
5502R55MHH	B362
5508R454GM	B305
5565R302GF	B310
5565R302NH	B398
5566R302GF	B312
5566R302NH	B399
5589R45MGF	B307
5601	B434
5601R302GM	B273
5601R303GM	B288
5601R304GF	B302
5601R38414GM	B410
5602R302GM	B275
5602R303GM	B290
5602R303GR	B324
5602R304GF	B304
5602R304GR	B325
5602R305GR	B326
5602R38414GM	B411
5602R38414GM-R	B413
5602R453GM	B292
5602R454GM	B306
5665R202GM	B311

A

A***-PCLNR/L	A284
A***-PDSNR/L	A286
A***-PDUNR/L	A287
A***-PSKNR/L	A289
A***-PTFNR/L	A290
A***-SCLCR/L	A293
A***-SDQCR/L	A295
A***-SDUCR/L	A296
A***-SDZCR/L	A297
A***-SSKCR/L	A298
A***-STFCR/L	A300

A***-SVQBR/L	A304
A***-SVUBR/L	A305
AL-2B	B400
AL-2E	B386
AL-2EL	B387
AL-2R-AIR	B401
AL-2RL-AIR	B402
AL-3E	B389
AL-3EL	B390
AL-3R-AIR	B405
AL-3RL-AIR	B406
AL-3W	B397
ALG-2E	B388
ALG-2R	B403
ALG-2R-W	B404
ALG-3E	B391
ALG-3E-W	B392
ALP-3E	B393
ALP-3E-W	B394
ALP-4E	B395
ALP-4E-W	B396

B

BMR01	B136
BMR02	B139
BMR03	B141
BMR04	B149

C

C***-SCLPR/L	A312
C***-SDQPR/L	A314
C***-SDUPR/L	A316
C***-STUPR/L	A318
C***-SVQCR/L	A321
C***-SVUCR/L	A322
C40X-Q*DR/L	A394
CCLNR/L	A258
CDJNR/L	A260
CKJNR/L	A256
CKNNR/L	A257
CMA01	B188
CMD01	B192
CMZ01	B184
CRDNN	A264
CSDNN	A265
CSKNR/L	A262
CSRNR/L	A263
CTJNR/L	A259
CTUNR/L	A261

D

DCLNR/L	A197
DDJNR/L	A198
DSBNR/L	A199
DTGNR/L	A200
DVJNR/L	A202
DVVNN	A201
DWLNR/L	A203

E

E***-SCLCR/L	A313
E***-SCLPR/L	A312
E***-SDQCR/L	A315
E***-SDUCR/L	A317
E***-STFCR/L	A319
E***-STFPR/L	A320
E***-SVUCR/L	A322
EMP01	B104
EMP02	B110
EMP03	B113
EMP04	B115
EMP05	B117
EMP09	B120
EMP13	B126

F

FMA01	B31
FMA02	B34
FMA03	B37
FMA04	B40
FMA07	B48
FMA11	B52
FMA12	B56
FMD02	B60
FMD03	B68
FME02	B70
FME03	B72
FME04	B75
FMP01	B77
FMP02	B79
FMP03	B82
FMP12	B86
FMR01	B90
FMR02	B93
FMR03	B96
FMR04	B100

G

G*-QCH	
GM-2B	B313
GM-2BFP	B315
GM-2BL	B314
GM-2BP	B317
GM-2BS	B316
GM-2E	B276
GM-2EFP	B279
GM-2EL	B277
GM-2EP	B282
GM-2ES	B284
GM-2EX	B278
GM-2F	B280
GM-2FL	B281
GM-2R	B321
GM-3E	B285
GM-3EL	B286
GM-4B	B319
GM-4BL	B320
GM-4E	B297
GM-4E-G	B298
GM-4EFP	B300
GM-4EL	B299
GM-4EL-G	B294
GM-4EX-G	B296
GM-4F-G	B293
GM-4FL-G	B295
GM-4R	B322
GM-4RL	B323
GM-4W	B327
GM-6E	B308
GM-6EL	B309
GQC**R/L	A399

H

HM-2B	B365
HM-2BFP	B367
HM-2BL	B366
HM-2BP	B369
HM-2BS	B368
HM-2E	B354
HM-2EFP	B355
HM-2EP	B356
HM-2ES	B358
HM-4B	B371
HM-4BL	B372
HM-4E	B359
HM-4EFP	B361

HM-4EL	B360
HM-4R	B373
HM-4RF	B374
HM-4RP	B375
HM-6E	B363
HM-6EL	B364
HMP01	B178
HMP01-EC	B182

J

JCLNR/L	A266
JDJNR/L	A267
JSDNN	A268

M

MCBNR/L	A218
MCLNR/L	A219
MDJNR/L	A220
MDPNN	A221
MRDNN	A233
MRGNR/L	A234
MSBNR/L	A222
MSDNN	A225
MSKNR/L	A224
MSRNR/L	A223
MTFNR/L	A229
MTGNR/L	A226
MTJNR/L	A227
MVJNR/L	A231
MVVNN	A230
MWLNR/L	A232

N

NM-2B	B382
NM-2BP	B383
NM-2E	B379
NM-2EP	B380
NM-4E	B381

P

PCBNR/L	A204
PCLNR/L	A205
PDJNR/L	A206
PDNNR/L	A207
PM-2B	B339
PM-2BC	B342

A

Turning

B

Milling

C

Drilling

DTechnical
Information**E**

Index

A

Turning

PM-2BFP	B341
PM-2BL	B340
PM-2E	B330
PM-2EL	B331
PM-2R	B347
PM-4B	B345
PM-4BL	B346
PM-4E	B335
PM-4E-G	B332
PM-4EL	B336

B

Milling

PM-4EL-G	B333
PM-4EX-G	B334
PM-4H	B348
PM-4HL	B349
PM-4R	B350
PM-4RL	B351
PM-6E	B337
PM-6EL	B338
PSBNR/L	A208
PSDNN	A210
PSKNR/L	A211

C

Drilling

PSSNR/L	A212
PTFNR/L	A213
PTGNR/L	A215
PTTNR/L	A214
PWLNR/L	A217

D

Technical Information

Q

Q*DR/L	A395
QCH-APKT	B204
QCH-RD	B206
QCH-SDMT	B200
QCH-WPGT	B202
QCH-XPHT	B198
QCH-ZOHX	B210
QE**R/L	A377
QE*S**N	A383
QE*SN30	A379
QE*SR/L	A382
QEBDR/L	A377
QECDR/L	A380
QF**R/L	A385
QF**RR/LL	A387
QF*DRR/LL	A390
QX**R/L	A381
QZS*	A384

E

Index

S

S***-PCLNR/L	A284
--------------	------

S***-PDSNR/L	A286
S***-PDUNR/L	A287
S***-PSKNR/L	A289
S***-PTFNR/L	A290
S***-PWLNR/L	A291
S***-SCFCR/L	A310
S***-SCLCR	A311
S***-SCLCR/L	A293
S***-SCLPR/L	A306
S***-SDQCR/L	A295
S***-SDQPR/L	A307
S***-SDUCR/L	A296
S***-SDUPR/L	A308
S***-SDZCR/L	A297
S***-SSKCR/L	A298
S***-STFCR/L	A300
S***-STUPR/L	A309
S***-SVQBR/L	A304
S***-SVQCR/L	A302
S***-SVUBR/L	A305
S***-SVUCR/L	A303
S**_QC**R/L	A400
SCACR/L	A235
SCACR/L-SC	A272
SCLCR/L	A236
SCLCR/L-SC	A273
SDACR/L	A237
SDACR/L-SC	A274
SDHCR/L-SC	A275
SDJCR/L	A238
SDJCR/L-SC	A276
SDNCN	A239
SDNCN-SC	A277
SMP01	B153
SMP03	B157
SMP05	B161
SNL	A442
SNR	A441
SRDCN	A254
SRGCR/L	A255
SSBCR/L	A245
SSDCN	A246
SSKCR/L	A247
SSSCR/L	A248
STACR/L	A249
STFCR/L	A250
STGCR/L	A251
STTCR/L	A252
SVABR/L	A241
SVACR/L-SC	A278
SVJBR/L	A240
SVJCR/L	A244

SVJCR/L-SC	A279
SVVBN	A242
SVVCN	A243
SWACR/L	A253
SWL	A440
SWR	A439

T

TMP01	B176
-------	------

U

UM-4E	B416
UM-4E-W	B417
UM-4EFP	B421
UM-4EL	B418
UM-4EL-W	B419
UM-4ELP-W	B420
UM-4R	B422
UM-4RFP	B424
UM-4RL	B423

V

VSM-4E	B426
VSM-4E-C	B427
VSM-4R	B428

X

XMP01	B174
XMR01	B168

Z

ZD03	C16
ZTD02	C8
ZTD03	C10
ZTD04	C12
ZTD05	C14