The best way to choose KORLOY Milling inserts

Selection system

Workpiece	P	Steel					M	Stainless steel			K	Cast iron				N	Nonferrous		S	HRSA		H	Hardened		
ISO	P01	P10	P20	P30	P40	P50	M10	M20	M30	M40	K01	K10	K20	K30	K40	N01	N10	N20	S10	S20	S30	H01	H10	H020	H30
Coated carbide	NC5330 NC5340 New NCM325 PC3500 PC3600 PC5300 NC5350 New NCM335 PC5400 New PC3545						NC5330 NC5340 New NCM325 PC5300 PC9530 NC5350 New NCM335 PC5400 New				PC8110 PC6510 NC5330 PC5300 NC5340 New PC5400 New					ND2000 PD2000			PC5300 PC5400 New			PC2005 New PC2010 New PC2015 New PC210F		

Geometry	Cutting edge	Application range feed rate fn(ipr) 0.002 0.003 0.004 0.006 0.010 0.016 0.025 0.039 0.063 0.098 0.157 0.248 depth of cut ap(inch) 0.004 0.006 0.010 0.016 0.025 0.039 0.063 0.098 0.157 0.248 0.394 0.457 0.512	Features
MR		0.002~0.014 0.059~0.197	**For Roughing of Milling** • Strongest cutting edge strength provide stable tool life even in case of severe cutting with heavy intermittent and heavy roughing
MA		0.004~0.014 0.020~0.197	**For Aluminum** • Sharp cutting edge and lubricated top face show excellent chip flow and welding resistance in aluminum machining
MA		0.004~0.016 0.020~0.630	**For Aluminum** • Sharp cutting edge and lubricated top face show excellent chip flow and welding resistance in aluminum machining
MM		0.004~0.016 0.020~0.236	**For Medium to Roughing of Milling** • Suitable geometry design for general milling has wider ranges of machining
MM		0.004~0.010 0.020~0.630	**For Medium to Roughing of Milling** • Suitable geometry design for general milling has wider ranges of machining
ML		0.002~0.006 0.020~0.630	**For hard-to-cut material machining** • The chip breaker with low cutting resistance ensures superior machinability in hard-to-cut materials
MF		0.002~0.008 0.020~0.197	**For Finishing of Milling** • Special design for light cutting of gummy materials like stainless steel and hard to machine material provide fine surface finish and longer tool life
MM		0.002~0.012 0.039~0.197	**For Medium cutting of Milling** • Chip breaker design to cover general cutting condition provides wide available application range • Ground type and as sintered type is available
MX		0.004~0.012 0.039~0.197	**For General Milling** • Possible to increase productivity through increase feed and depth • Excellent heat resistance due to the special chip breaker design of top face of insert