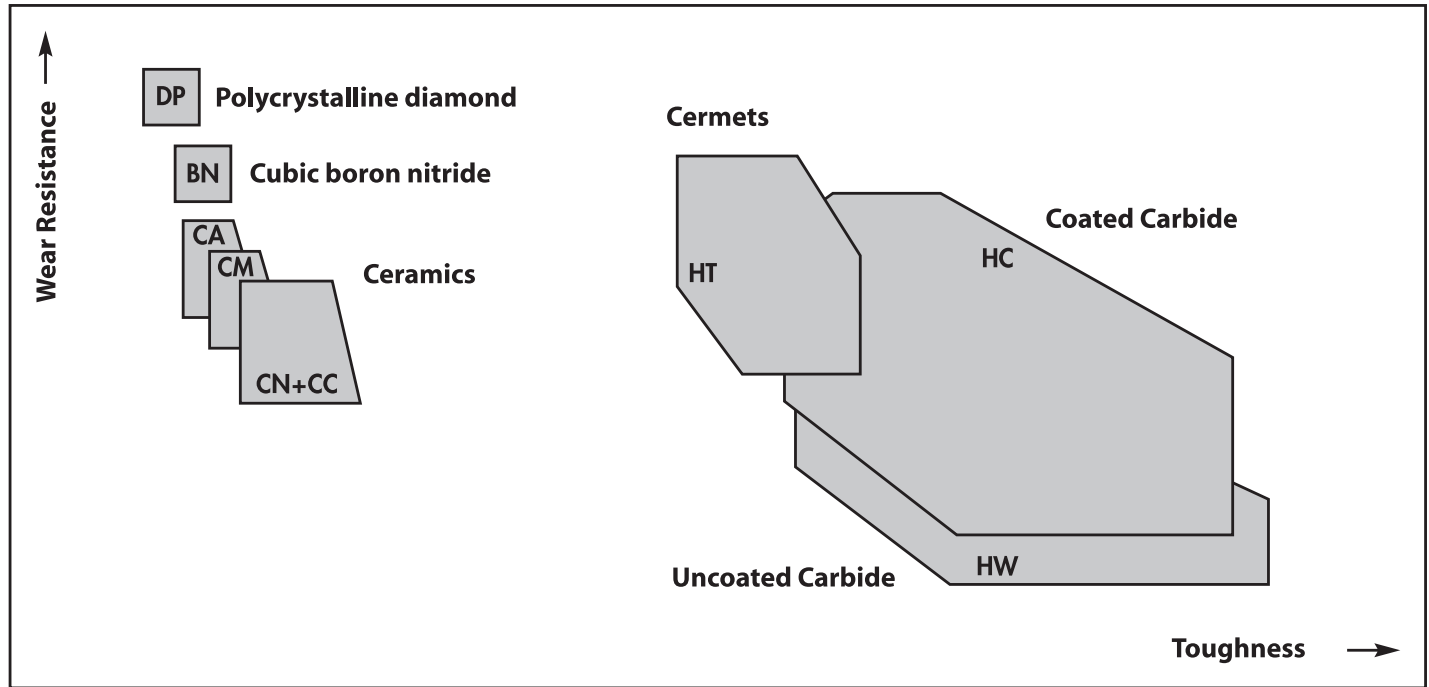


Technical Information - Turning

Cutting Material Chart / ISO Application Range

As well as carbides, the extended standard ANSI ISO 513 also includes ceramic cutting materials and the superhard polycrystalline materials boron nitride and diamond, specifying additional identification symbols for these cutting material groups.

Cutting Material Chart



ISO Application Ranges

Main Group	Sub Group	
	Symbol	Feature
Carbide	HW	uncoated WC-base carbide
	HT	uncoated TiC/TiN-base carbide (cermets)
	HC	Coated carbide
Ceramics	CA	Al ₂ O ₃ -base oxide ceramics
	CM	Composite ceramics Al ₂ O ₃ + metal carbide
	CN	Si ₃ N ₄ -base nitride ceramics
	CC	coated ceramics
Cubic Boron Nitride	BL	Polycrystalline cubic boron nitride (CBN) with low content of CBN
	BH	Polycrystalline cubic boron nitride (CBN) with high content of CBN
Diamond	DP	Polycrystalline diamond (PCD)