

# PVD Coating Selection Guide for Turning

Coating Grade

CP11xxTM CP26xxTN CP26xxTM CP24xxFS CP62xxMS CP11xxFH CP62xxFAN

Insert example  
for Turning



	CP11xxTM	CP26xxTN	CP26xxTM	CP24xxFS	CP62xxMS	CP11xxFH	CP62xxFAN
Steel	■	□	□	□			
Stainless Steel		■	■	■	■	■	■
Superalloy		■		■	■	■	■
Titanium Alloy		■		■	■	■	■
Roughing	■	□	□				
Semi-finishing	□	■	■	■	■	□	□
Finishing		□	□	■	■	■	■
Continuous	□	■	■	■	■	■	■
Intermittent	■	■	■	□			
Recommended Chipbreaker for Turning	R/L	CM,CF	CM,CF	CF	CM,CF	AL,CF	AL
Vc Range (m/min)	<80	50-180	50-180	100-180	50-180	100-200	70-150

■ Main Application

□ Extended Application

# Features of the latest developed PVD coating



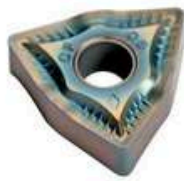
**CP11xxTM: Artifact for small parts machining**  
Particularly designed for free cutting steel as 12L14



**CP26xxTN (TM): Versatile, general purpose machining**

TN - Adhesion-reducing layer for stainless steel, titanium alloy and superalloy

TM - Strong impact resistance layer for steel and stainless steel



**CP24xxFS: Dry machining of hard-to-machine material**

Excellent balance between impact and wear resistance



**CP62xxMS: Ultra abrasion-resistant composite coating**

Finishing and semi-finishing of hard-to-machine materials



**CP11xxFH: Extremely great wear resistance**

Specialized for finishing



**CP62xxFAN: High lustre surface effect**

Especially for small parts finishing

Toughness increase from bottom to top

Graphs on this page specify chipbreaker code for turning inserts to match illustration, including CF, CM and AL.

For other machining process such as milling and threading, coating selections comply with similar principles but different parameters.



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### Machined Materials

- 1 : Steel
- 2 : Stainless Steel and  
Difficult-to-machine Materials
- 3 : Cast Iron
- 6 : Titanium Alloy

### Machined Materials

- M&N : General machining of  
difficult-to-machine materials
- S : Titanium Alloys and Superalloy
- H : Hardened Steel and Finishing
- G : Steel and Cast Iron
- L : General Low-speed Machining

