

ROTATING TOOL INSERTS

COATED CARBIDE (CVD&PVD)

<CVD>

- Special tough fibrous structure improves wear and fracture resistance.
- It covers a wide application range and reduces the number of tools required.

<PVD>

- PVD coating prolongs tool life when compared to cemented carbide under the same cutting conditions.
- Coating of tools with sharp edges is possible without softening or changing the quality of the substrate.

SELECTION STANDARD

● MILLING

Work Material	Recommended Grade	Recommended Cutting Speed (m/min)	ISO	Application Range
P Steel	F7030	200 (150 – 250)	P10	
	MP6120	150 (100 – 200)	P20	 
	MP6130	150 (100 – 200)	P30	 
	VP15TF	150 (100 – 200)	P40	   
M Stainless Steel	F7030	200 (150 – 250)	M10	
	MP7030	150 (100 – 200)	M20	
	MP7130	150 (100 – 200)	M30	
	MP7140	150 (100 – 200)	M40	  
	VP15TF	150 (100 – 200)	M40	 
K Cast Iron	MC5020	180 (100 – 250)	K01	
			K10	
	VP15TF	150 (100 – 200)	K20	
			K30	
N Aluminium Alloy	LC15TF	1000 (200 – 3000)	N10	
			N20	
			N30	
S Heat Resistant Alloy Ti Alloy	MP9120	30 (20 – 40)	S01	
	VP15TF	30 (20 – 40)	S10	
	MP9130	40 (25 – 60)	S20	
	MP9030	40 (25 – 60)	S30	
H Hardened Materials	MP8010	80 (50 – 120)	H01	
			H10	
	VP15TF	80 (50 – 120)	H20	
			H30	

