

Carbide Grades

BLU

PVD triple layer coated Sub-Micron grade for Steel, Stainless Steels, Titanium and hard materials.

K20

Uncoated Sub-Micron carbide grade for Aluminum and non-ferrous materials, Stainless Steels and Titanium.

ISO Standard	Materials	Cutting Speed m/min	
		K20	BLU
P	Low & Medium Carbon Steels <0.55%C	-	80-150
	High Carbon Steels ≥0.55%C	-	70-120
	Alloy Steels, Treated Steels	-	40- 80
M	Stainless Steel-Free Cutting	30- 80	60-120
	Stainless Steel-Austenitic	20- 70	30- 90
	Cast Steels	30- 80	50-120
K	Cast Iron	50-120	-
N	Aluminum ≤12%Si, Copper	120-250	-
	Aluminum >12%Si	90-200	-
	Synthetics, Duroplastics, Thermoplastics	70-150	-
S	Nickel Alloys, Titanium Alloys	20- 50	30- 70
H	Hardened Steel, 45-50HRc	-	20- 50