

Grade Selection

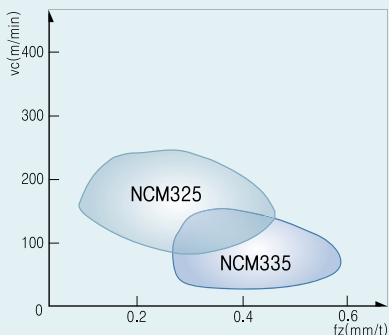
Grade	ISO	Features	Coating Type	Coating
H01	K10	Uncoated grade for machining of aluminium & non-ferrous metals	Uncoated	-
NCM325	P20~P30 M20~M30	For high speed milling of steels & stainless	CVD	TiN
NCM335	P30~P40 M30~M40	Suitable for interrupted and rough milling of steels & stainless	CVD	TiN
PC230	P20~P30 M20~M30	For high speed milling of steels & stainless	PVD	TiAlN
PC240	P30~P50	Extremely tough grade for interrupted and rough milling of steels	PVD	TiAlN
PC3500	P20~P35	Super Universal milling grade. Covering the same application area as old grades PC3525 & PC3535	PVD	K-Gold
PC3545	P30~P50	Medium and rough milling of steels	PVD	K-Gold
PC6510	K01~K15	High speed milling of cast iron	PVD	K-Gold
PC8520	S20~S30	For medium and rough milling of exotics & difficult to machine stainless	PVD	K-Gold
PC9530	M20~M35	Medium and rough milling of stainless	PVD	TiAlN

Selection System

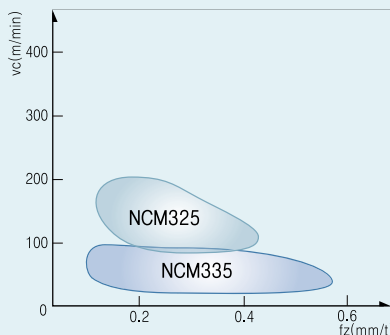
P						M				K				S			
P01	P10	P20	P30	P40	P50	M10	M20	M30	M40	K01	K10	K20	K30	S01	S10	S20	S30
		NCM325					NCM325			H01							PC8520
		NCM335					NCM325			PC3500							
		PC3500					PC9530			PC6510							
		PC3545					PC230										
		PC230															
		PC240															

Application Range

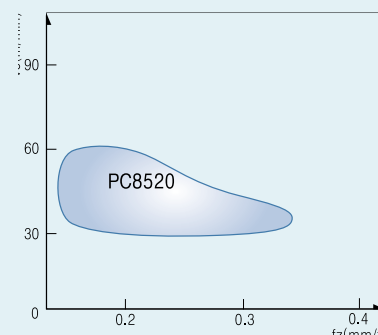
1) P: Steel (CVD)



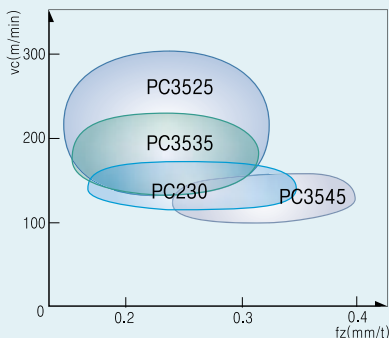
2) M: Stainless (CVD)



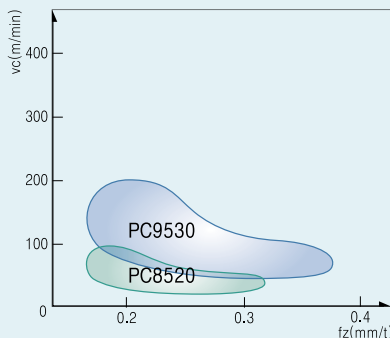
3) S: Heat resistant steel (PVD)



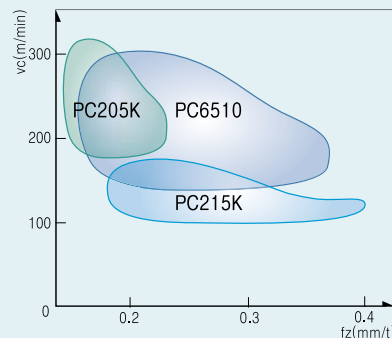
4) P: Steel (PVD)



5) M: Stainless (PVD)



6) K: Cast iron (PVD)



Selection System

Grade	Recommended Cutting Speed (m/min)	ISO
H01	500 (300~1,200)	K10
NCM325	250 (150~300)	P20~P30 M20~M30
NCM335	200 (150~250)	P30~P40 M30~M40
PC230	200 (150~250)	P20~P30 M20~M30
PC240	120 (100~150)	P30~P50
PC3500	200 (150~250)	P20~P35
PC3545	120 (100~150)	P30~P50
PC6510	200 (150~250)	K01~K15
PC8520	50 (30~100)	S20~S30
PC9530	130 (50~200)	M20~M35