

# Technical Details



## Selection system of coated cermet grades

Workpiece	Machining types	Recommended grade	Recommended cutting speed (sfm)	ISO	Application range
<b>P</b>	<b>Steel</b>	Continuous cutting	HCP10C	1066 (656 ~ 1476)	P10
					P20
<b>K</b>	<b>Cast iron</b>	Continuous cutting	HCP10C	886 (591 ~ 1148)	K10

## The features of coated cermet grade

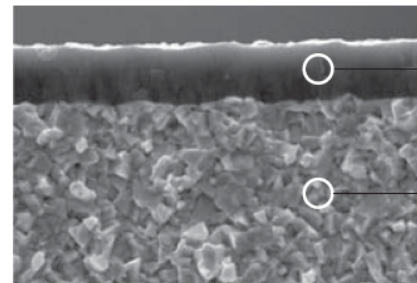
Coated cermet	ISO	Features
HCP10C	P10 ~ P20 / K05 ~ K15	<ul style="list-style-type: none"> <li>• PVD coated Cermet</li> <li>• Light cutting for steel and cast iron in high speed machining</li> <li>• Optimized for precision boring</li> </ul>

Coated cermet for machining carbon steel, alloy steel and sintered ferrous components

## HCP10C

- Maximized resistance to built-up edge and oxidation in continuous cutting at high speeds and low depth of cuts
- Superior wear resistance vs. existing tools in continuous cutting of carbon steel and alloy steel

### Features





PVD layer with high hardness and lubrication

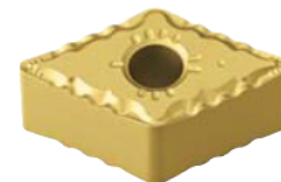
Exclusive substrate for super-high hardness coating



## Chip breaker for turning

Geometry	Cutting edge	Features
<div>HF</div> 		<div>For Finishing</div> <ul style="list-style-type: none"><li>• Improved chip control for smaller depth of cuts</li><li>• Excellent chip control in copying, corner R machining</li></ul>

## HF Chip Breaker [For finishing]



- Excellent chip evacuation in continuous and high speed machining of various workpieces
- 3-dimensional chip breaker achieves lower cutting resistance, high rigidity of the cutting edge, and longer tool life
- Stable chip control in copying and internal machining

### Features of HF chip breaker

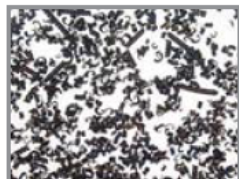
- **6 bumps on the insert corner** - Superior chip control and chip cutting in copying with various depths of cut
- **Side rake angle** - Superb chip cutting in facing and copying. Superior tool life due to improved surface roughness and lower cutting resistance
- **Cutting edge on 100° part for medium machining (For CNMG)** - Excellent chip evacuation and toughness in machining with high depth of cut

### Performance

Better machining



Better Chip control



Longer tool life



HF Chip Breakers



Conventional chip breaker