

## Grades for Steel

Steel	P	P05	P10	P15	P20	P25	P30	P35	P40	P45	P50	
		C8	C7 (Light Finishing)			C6 (Semi-Finishing)			C5 (General)			
		BC75										
						BC20N						
						BP93						
							BC30					
							BC20					

### CVD Coated Grades

### ISO

### Machining Condition/Application

BC75	P05 ~ P15	<ul style="list-style-type: none"> <li>For high speed machining of steel.</li> <li>Optimal for high speed machining of steel due to the combination of high hardness substrate and CVD coating.</li> </ul>
BC20N	P15 ~ P30	<ul style="list-style-type: none"> <li>Medium to roughing for steel.</li> <li>Combining excellent fracture resistance substrate with chipping resistance and heat resistance increased stability.</li> </ul>
BC30	P25 ~ P35	<ul style="list-style-type: none"> <li>For medium to roughing, intermittent cutting of steel and stainless steel.</li> <li>Combination of toughest substrate and coating having superior chipping resistance provide wide coverage.</li> </ul>
BC20	P25 ~ P40	<ul style="list-style-type: none"> <li>For high speed machining of steel.</li> <li>Optimal for high speed machining of steel due to the combination of high hardness substrate and CVD coating.</li> </ul>

### PVD Coated Grades

### ISO

### Machining Condition/Application

BP93	P20 ~ P30	<ul style="list-style-type: none"> <li>For medium to roughing, interrupted turning of steel.</li> <li>Toughest sub-micron substrate with PVD TiAlN guarantee superior property of prevent build-up edge, thus extending and consistent tool life can be acquired.</li> </ul>
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## Grades for Stainless Steel

Stainless Steel	M	M05	M10	M15	M20	M25	M30	M35	M40	M45	M50
		BP90									
		BC92									
		BC30					BP93				

### CVD Coated Grades

### ISO

### Machining Condition/Application

BC92

M10 ~ M20

- For high speed cutting of stainless steel.
- Matching of special substrate having excellent thermal stability and CVD coating having superior chipping resistance provide longer tool life.

BC30

M15 ~ M25

- For medium to roughing, intermittent cutting of steel and stainless steel.
- Combination of toughest substrate and coating having superior chipping resistance provide wide coverage.

### PVD Coated Grades

### ISO

### Machining Condition/Application

BP90

M01 ~ M10

- For high speed machining of difficult-to-cut material and stainless steel.
- Hard coating guarantees pro-longed tool life at difficult-to-cut material cutting.
- K-Gold coating.

BP93

M25 ~ M40

- For medium to roughing, interrupted turning of stainless steel.
- Toughest sub-micron substrate with PVD TiAlN guarantee superior property of prevent build-up edge, thus extending and consistent tool life can be acquired.

## Grades for Cast Iron

Cast Iron	K	K05	K10	K15	K20	K25	K30	K35	K40	K45	K50	
		C4	C3 (Semi-Finishing)			C2 (General)		C1 (Roughing)				
		BCK35										
		BCK65										
			BCK55									
			BCK45									

### CVD Coated Grades

### ISO

### Machining Condition/Application

BCK35	K01 ~ K10	<ul style="list-style-type: none"> <li>• For high speed cutting of cast iron.</li> <li>• Combination of hard substrate and thick CVD provide excellent wear resistance.</li> </ul>
BCK65	K05 ~ K15	<ul style="list-style-type: none"> <li>• For general cutting for gray cast iron &amp; ductile cast iron.</li> <li>• Tough substrate and improved adhesion of thick coating show superior wear resistance.</li> </ul>
BCK55	K10 ~ K15	<ul style="list-style-type: none"> <li>• For general, high effective cutting of gray cast iron and ductile cast iron.</li> <li>• Combination of tough substrate and thick CVD coating provide wide coverage of cast iron machining.</li> </ul>
BCK45	K10 ~ K20	<ul style="list-style-type: none"> <li>• For effective cutting of cast iron at interrupted cutting.</li> <li>• Combination of soft substrate and thick CVD coating provide stable cutting without breakage.</li> </ul>