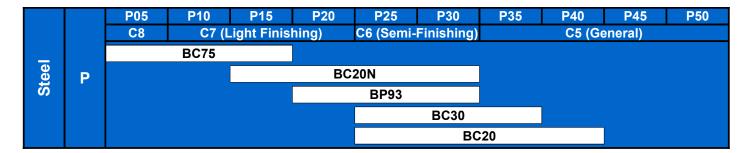
Grades for Steel



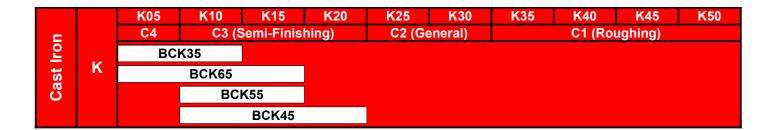
CVD Coated Grades	ISO	Machining Condition/Application
BC75	P05 ~ P15	 For high speed machining of steel. Optimal for high speed machining of steel due to the combination of high hardness substrate and CVD coating.
BC20N	P15 ~ P30	 Medium to roughing for steel. Combining excellent fracture resistance substrate with chipping resistance and heat resistance increased stability.
BC30	P25 ~ P35	 For medium to roughing, intermittent cutting of steel and stainless steel. Combination of toughest substrate and coating having superior chipping resistance provide wide coverage.
BC20	P25 ~ P40	 For high speed machining of steel. Optimal for high speed machining of steel due to the combination of high hardness substrate and CVD coating.
PVD Coated Grades	ISO	Machining Condition/Application
BP93	P20 ~ P30	 For medium to roughing, interrupted turning of steel. Toughest sub-micron substrate with PVD TiAIN guarantee superior property of prevent build-up edge, thus extending and consistent tool life can be acquired.

Grades for Stainless Steel

		M05	M10	M15	M20	M25	M30	M35	M40	M45	M50
ess el		BP90									
te in	M			BC92							
ta S					BC30						
S							ВР	93			

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 stainlees 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 maching 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



CVD Coated Grades	ISO	Machining Condition/Application
BCK35	K01 ~ K10	 For high speed cutting of cast iron. Combination of hard substrate and thick CVD provide excellent wear resistance.
BCK65	K05 ~ K15	 For general cutting for gray cast iron & ductile cast iron. Tough substrate and improved adhesion of thick coating show superior wear resistance.
BCK55	K10 ~ K15	 For general, high effective cutting of gray cast iron and ductile cast iron. Combination of tough substrate and thick CVD coating provide wide coverage of cast iron machining.
BCK45	K10 ~ K20	 For effective cutting of cast iron at interupted cutting. Combination of soft substrate and thick CVD coating provide stable cutting without breakage.