

Dual Edge Insert Grades for Steel

Steel	P	P05	P10	P15	P20	P25	P30	P35	P40	P45	P50	
		C8	C7 (Light Finishing)			C6 (Semi-Finishing)			C5 (General)			
		BK19				BK65						

Grade	ISO	Machining Condition/Application
BK19	P10 ~ P15	<ul style="list-style-type: none"> • Excellent combination of toughness and hardness. • Micro-grained tungsten carbide and special processing enable this grade to exhibit high edge strength and wear properties. • Excellent choice for low speeds and feeds when machining steel, high temperature alloys, nodular iron and cast iron.
BK65	P30	<ul style="list-style-type: none"> • General purpose, turning, boring and grooving on steel and alloyed cast iron at moderate cutting speeds.

Dual Edge Insert 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)				
		BK26				BK20							
		BK19											

Grade	ISO	Machining Condition/Application
BK26	K15 ~ K30	<ul style="list-style-type: none"> • Excellent combination of impact and wear properties for moderate to heavy milling at high speeds and feeds on low alloyed cast irons.
BK20	K20	<ul style="list-style-type: none"> • Roughing and general purpose machining of cast iron high temperature alloys and non-ferrous materials. • Also utilized in wear applications.
BK19	K20 ~ K30	<ul style="list-style-type: none"> • Excellent combination of toughness and hardness. • Micro-grained tungsten carbide and special processing enable this grade to exhibit high edge strength and wear properties. • Excellent choice for low speeds and feeds when machining steel, high temperature alloys, nodular iron and cast iron.

Ex-Celler-8 Insert Grades for Steel

Steel	P	P05	P10	P15	P20	P25	P30	P35	P40	P45	P50	
		C8	C7 (Light Finishing)			C6 (Semi-Finishing)			C5 (General)			
							BK21					
					BK60							

Grade	ISO	Coating	Machining Condition/Application
BK21	P20	Multi-Layered ALTiN	<ul style="list-style-type: none"> • Is suitable for milling nodular and also milling of steel at high speeds.
BK60	P20	Tin/TiALN	<ul style="list-style-type: none"> • High speed steel milling grade have superior wear resistance.

Ex-Celler-8 Insert 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)			
		BK26										

Grade	ISO	Coating	Machining Condition/Application
BK26	K40	Multi-Layered ALTiN	<ul style="list-style-type: none"> • Excellent wear resistance and tough substrate. • Is suitable for milling nodular and also milling of steel at high speeds.