

Technical Section

Cutting Speeds for Grooving Tools

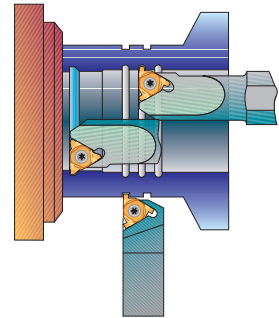
Carbide Grade:

BXC (P30 - P50, K25 - K40)

PVD TiN coated grade for low cutting speed. Works well with a wide range of stainless steels.

BMA (P20 - P40, K20 - K30)

PVD TiAlN coated sub-micrograin grade for stainless steels and exotic materials at medium to high cutting speeds.



ISO Standard	Materials	Cutting Speed m/min
P	Low & Medium Carbon Steel	20-100
	High Carbon Steel	30-80
	Alloy Steels and Treated Steels	40-90
M	Stainless Steels	30-80
	Cast Steels	30-90
K	Cast Iron	30-90
N	Non-Ferrous & Aluminium	20-200

For grooving small bores see pages 183-188

