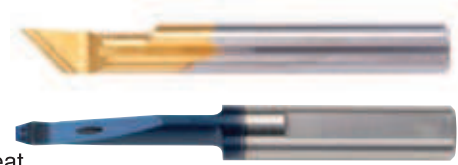


Technical Section

Carbide Grade: **BXC (P30 - P50, K25 - K40)**
 PVD TiN coated grade for low cutting speed.
 Works well with a wide range of stainless steels.

Carbide Grade: **BMK (K10 - K20)**

Sub-micron grade with advanced PVD triple blue coating. Extremely high heat resistant and smooth cutting operation, for high performance, and normal machining conditions.
 General purpose for all materials.



Cutting speed for Tiny Tools

ISO Standard	Material		Condition	Cutting Speed m/min	
				BXC	BMK
P	Non-Alloy steel and cast steel, free cutting steel	<0.25%C	Annealed	25-50	30-60
		≥0.25%C	Annealed		
		< 0.55%C	Quenched and tempered		
		≥0.55%C	Annealed		
	Low alloy steel and cast steel (less than 5% alloying elements)		Quenched and tempered	20-25	24-30
			Annealed		
High alloy steel, cast steel, and tool steel		Annealed	18-20	22-24	
		Quenched and empered			
M	Stainless steel and cast steel		Ferritic/martensitic	25-30	30-42
			Martensitic		
			Austenitic		
K	Cast iron nodular (GGG)		Ferritic/pearlitic	17-23	20-28
			Pearlitic		
	Grey cast iron (GG)		Ferritic	17-23	20-28
			Pearlitic		
	Malleable cast iron		Ferritic	17-23	20-28
			Pearlitic		
N	Aluminum-wrought alloy		Not cureable	50-70	60-84
			Cured		
	Aluminum-cast, alloyed	≤12% Si	Not cureable	30-40	36-48
			Cured		
	Copper alloys	>12% Si	High temperature	22-25	24-30
		>1% Pb	Free cutting		
			Brass		
Non metallic		Duroplastics, fiber plastics	35-45		
		Hard rubber			
S	High temp. alloys, Super alloys	Fe based	Annealed	15-20	18-24
		Ni or Co based	Annealed		
			Cast		
	Titanium alloys		Alpha+beta alloys cured	12-18	15-20
H	Hardened steel		Hardened 45-50 HRc	15-20	18-24
			Hardened 51-55 HRc		
			Hardened 56-62 HRc		
	Chilled cast iron		cast	10-14	12-16
Cast iron		Hardened	8-12	10-14	

Threading Passes

Recommended Feed Rate: 0.01 - 0.03 mm/rev

Pitch:	mm	0.5	0.7	0.8	1.0	1.25	1.5	2-5
	TPI	48	36	32	24	20	16	
Number of Passes		6-12	7-14	7-16	8-18	8-20	10-22	20-38