

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"> • 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	<ul style="list-style-type: none"> • Medium to roughing for steel. • Combining excellent fracture resistance substrate with chipping resistance and heat resistance increased stability.
BC30	P25 ~ P35	<ul style="list-style-type: none"> • 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	<ul style="list-style-type: none"> • 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	<ul style="list-style-type: none"> • For medium to roughing, interrupted turning of 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.
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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"> • For high speed cutting of cast iron. • Combination of hard substrate and thick CVD provide excellent wear resistance.
BCK65	K05 ~ K15	<ul style="list-style-type: none"> • 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	<ul style="list-style-type: none"> • 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	<ul style="list-style-type: none"> • For effective cutting of cast iron at interrupted cutting. • Combination of soft substrate and thick CVD coating provide stable cutting without breakage.