

3 Cutting Edges Swiss Line Inserts (19,20mm)

Carbide Grades

BLU

PVD triple layer coated Sub-Micron grade for , steel, Stainless Steels, Titanium and hard materials.

K20

Uncoated Sub-Micron carbide grade for Aluminium and non-ferrous materials,
Stainless Steels and Titanium

Cutting Data

Iso Standard	Materials	Cutting Speed m / min	
		K20	BLU
P	Low & Medium Carbon Steels <0.55%C	-	80-150
	High Carbon Steels ≥0.55%C	-	70-120
	Alloy Steels, Treated Steels	-	40-80
M	Stainless Steel-Free Cutting	30-80	60-120
	Stainless Steel-Austenitic	20-70	30-90
	Cast Steels	30-80	50-120
K	Cast Iron	50-120	-
N	Aluminum ≤12% Si, Copper	120-250	-
	Aluminium >12%Si	90-200	-
	Synthetics, Duroplastics, Thermoplastics	70-150	-
S	Nickel Alloys, Titanium Alloys	20-50	30-70
H	Hardened Steel, 45-50HRc	-	20-50