CARBIDE COMPARISON

CARBIDE GRADE INFORMATION/COMPARISON

GRADE	MITSUBISHI	SANDVIK	SECO	KENNAMETAL	VALENITE	KORLOY	WALTER	TaeguTec
XAB849	UE6005/UE6010	GC4015	TX110	KC9110/KC935			WTL41/WTA33	
XAB848	F7010	GC4215	TX110	KC9010/KC910	SV305	NC310	WTA21	TT1500
XAB749	UC6010/EU6020	GC4020	TP200	KC725M/KC9125	SV410		WTA31/WXK15/WQM25/WTL82	TT3500
XAB748	UC6025/F620	GC4025	T250M/T25M	KC9040/KC625M	SV325	NC310	WAP20/WTN43	
XAB699	UP20M/AP20M	GC4030/GC4035	CP20TP200	KC850/CM4KC7025/KC7215	SV935	NC320/NC330	WXM15/WTA41	TT7200
XAB698								
XAB649	UE6035	GC4125	CP30	CD4/KC7020	SV330	NC320	WXP25/WTA61/WTL71/WTL14	
XAB599	UE6035	GC1120	TP40	CS3(KC7030)	SM245	NC330	WQM35/WTP30	TT8020
XAC849	UC6010/EU6020	GC3015/GC3115	TP100	KC625M/KC631M	SV305		WAK15	
XAF799	UP10H	GC1020/GC1120	TX150	KC992M/KC7215/KC9315/KC7225	SV415	NC315K	WAK20/WTA43/WTA33/WTA/41	
XAF798	AP20M	GC3040	F25M	KC9025/KC631M		NCM325	WXP20/WTP20	
XAF797								
XAF960	AP15TF	GC3040		CS3(KC7030)	SV515		WAP35	TT8020
XAL849		GC2015		KC510M			WAM10/WAP10	TT9030
XAL749	F620	GC2025	CP50	KC9225/KC7020	SV415	NC325S	WAM20/WTA43	TT5100
XAL748	F620	GC2025	CP50	KC9225/KC7020	SV415	NC325S	WAM20/WTA43	TT5100
XAL649	F730	GC2035	CP50	KC9040/KC7020		NCM335	WTP35/WTA51	TT8020
XB970R								
XMF849								

CHIP-BREAKER INFORMATION

Characteristics	Description
-DF	**Recommended for finishing steel materials.** With a satisfactory flow of chips and an excellent surface quality.
-DM	**Recommended for semi-finishing steel materials.** With a light cutting force and a wide range of chipping, it can achieve better results in machining alloyed steel with a high adhesiveness.
-DR	**Recommended for quasi-roughing steel materials.** It is the first option for roughing operations under general working conditions. It can achieve a high rate of metal removal and economy.
-EF	**Recommended for finishing materials heat-resistant steel.** A specially designed rake angle and an inclined edge angle aimed at machining highly adhesive and plastic material hard to machine, like stainless steel. The edges are sharp making the cutting light and smooth, getting a good control of the chips and obtaining an excellent surface quality, which makes it most suitable for ultra fine and fine machining of such materials.
-EM	**Recommended for 300 series stainless steels.** Impact resistance of the cutting edge is strengthened for interrupted cutting. The sharp cutting edges function to shear low machinability rated metals while resisting edge-build-up.
-HF	**Recommended for finishing of universal applications.** Suitable for finishing internal and peripheric operations in machining steel and cast iron. Fine finishing of surface can be achieved with a slow feed rate.
-HM	**Recommended for semi-finishing of universal applications.** With sharp wave cutting edges to reduce cutting force. Suitable for semi-finishing internal and peripheric operations of steel and cast iron. It is the first choice for semi-finishing of internal holes and allows chips to flow smoothly.
-HR	**Recommended for roughing operations.** With tough cutting edge. Suitable for internal and peripheric machining of steel, stainless steel and cast iron with irregular surface.
-LH	**Recommended for aluminum alloy.** Suitable maching aluminum alloy with larger cutting depth and higher feed rate.
-PF	**Recommended for finishing steel materials.** Suitable for finishing operations under unstable cutting conditions with a light cutting force.
-PM	**Recommended for semi-finishing steel materials.** With a stronger edge than -DM. Suitable for semi-finishing operations under unstable cutting conditions and for machining cast iron as well with a light cutting force.
-PR	**Recommended for roughing of steel.** With a high safety of cutting edges. It can achieve a high rate of metal removal with a low cutting force under working conditions of deep cuts and fast feed rates.