

MILLING CVD

Turning PVD micrograin carbide









● stock standard

MILLING

- New grades with latest MT-CVD technology
- **JC8520** grade: fine grain carbide substrate with perfect balancing between toughness and wear resistance.
The alumina coating creates a thermal barrier that allows machining at higher cutting speed compared to PVD technology.
Main application area: ISO P materials, but it is also suitable to nodular cast iron machining.
- **JC9540** grade: high-toughness substrate, designed for difficult applications with heavy impacts.
The black alumina coating guarantees great stability against thermal cracks, showing excellent performance on high-temperature alloys and stainless steels.

HC	HC
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JC8520

Stable machining, light cut	 1 st choice	 suitable
General machining, medium cut	 1 st choice	 suitable
Unstable machining, heavy cut	 1 st choice	 suitable

ISO

Vc(m/min) - suggested cutting speed range (bold: 1st choice)



M

AND HOLE

H

D1

5.90

5.90

10

4.00

[illegible]

● stock standard

HF4PLUS

GP

a_e 40÷100% DC	a_p	0.50	1.00	1.50
	f_z	0.80	1.00	1.20
a_e 10÷30% DC	a_p	0.60	1.30	2.00
	f_z	1.00	1.20	1.40
a_e <10% DC	a_p	0.60	1.30	2.00
	f_z	1.20	1.50	1.80

SS

a_e 40÷100% DC	a_p	0.40	0.70	1.00
	f_z	0.40	0.70	1.00
a_e 10÷30% DC	a_p	0.40	0.70	1.00
	f_z	0.50	0.80	1.10
a_e <10% DC	a_p	0.40	0.70	1.00
	f_z	0.60	1.00	1.40

TE

a_e 40÷100% DC	a_p	0.50	1.00	1.50
	f_z	0.90	1.10	1.30
a_e 10÷30% DC	a_p	0.60	1.30	2.00
	f_z	1.00	1.30	1.60
a_e <10% DC	a_p	0.60	1.30	2.00
	f_z	1.40	1.70	2.00

4FACEPLUS

GP

a_e 40÷100% DC	a_p	1.00	2.50	4.00
	f_z	0.08	0.16	0.24
a_e 10÷30% DC	a_p	1.00	2.50	4.00
	f_z	0.10	0.20	0.30
a_e <10% DC	a_p	1.00	2.50	4.00
	f_z	0.12	0.24	0.36

SC

a_e 40÷100% DC	a_p	0.50	2.00	3.50
	f_z	0.06	0.11	0.16
a_e 10÷30% DC	a_p	0.50	2.00	3.50
	f_z	0.08	0.14	0.20
a_e <10% DC	a_p	0.50	2.00	3.50
	f_z	0.10	0.17	0.24

TE

a_e 40÷100% DC	a_p	1.50	3.00	4.50
	f_z	0.12	0.15	0.28
a_e 10÷30% DC	a_p	1.50	3.00	4.50
	f_z	0.14	0.24	0.34
a_e <10% DC	a_p	1.50	3.00	4.50
	f_z	0.18	0.30	0.42

DOUBLE4FACE

GP

a_e 40÷100% DC	a_p	1.00	2.50	4.00
	f_z	0.14	0.20	0.26
a_e 10÷30% DC	a_p	1.00	2.50	4.00
	f_z	0.16	0.23	0.30
a_e <10% DC	a_p	1.00	2.50	4.00
	f_z	0.20	0.30	0.40

SC

a_e 40÷100% DC	a_p	0.50	2.00	3.50
	f_z	0.10	0.14	0.18
a_e 10÷30% DC	a_p	0.50	2.00	3.50
	f_z	0.12	0.17	0.22
a_e <10% DC	a_p	0.50	2.00	3.50
	f_z	0.14	0.20	0.26

TE

a_e 40÷100% DC	a_p	1.50	3.00	4.50
	f_z	0.20	0.25	0.30
a_e 10÷30% DC	a_p	1.50	3.00	4.50
	f_z	0.24	0.30	0.36
a_e <10% DC	a_p	1.50	3.00	4.50
	f_z	0.28	0.36	0.44

DOUBLE3GON

GP

a_e 40÷100% DC	a_p	1.00	2.50	4.00
	f_z	0.08	0.12	0.16
a_e 10÷30% DC	a_p	1.00	4.00	7.00
	f_z	0.10	0.15	0.20
a_e <10% DC	a_p	1.00	4.00	7.00
	f_z	0.12	0.18	0.24

a_e : radial depth of cut (mm)

a_p : axial depth of cut (mm)

f_z : feed per tooth (mm)

DC: milling cutter diameter (mm)

