

GROOVING Grade table

ISO 513	CARBIDE			PCBN	DIAMOND		
	CVD COATED	PVD COATED	UNCOATED	UNCOATED	PCD		
A - TURNING	P	P01					
		P10	JC8025	JP5120			
		P20		JP5125	JP5130		
		P30					
		P40					
B - THREADING	Steel	M01					
		M10		JP5120			
		M20		JP5125	JP5130		
		M30					
		M40					
C - GROOVING	Stainless steel	K01					
		K10	JG7010	JP5120			
		K20		JP5125			
		K30					
		K40					
D - MILLING	Cast iron	N01					
		N10			JG6015		
		N20					
		N30					
		N40					
E - DRILLING	Non-ferrous materials	H01					
		H10					
		H20					
		H30					
		H40					
F - ACCESSORIES	Hardened steel						
G - SPARE PARTS							

GRADE	SUBSTRATE	HARDNESS HV	COATING		APPLICATION	FEATURES
			TECHNOLOGY	COMPOSITION		
JC7010	carbide	1.830	CVD	TiCN+Al ₂ O ₃	K K05 K25	High wear resistance. First choice for grey cast iron general machining.
JC8025	carbide	1.700	CVD	TiCN+Al ₂ O ₃ +TiN	P P20 P30	All around grade suitable for a wide range of applications. Excellent reliability even on medium interrupted cut.
JP5120	micrograin carbide	1.830	PVD	TiAlN	P P10 P20	Special coating technology balances wear resistance and toughness. The post-coating surface treatment effectively prevents built-up edge.
					M M10 M20	
					K K10 K20	
JP5125	micrograin carbide	1.830	PVD	TiAlN	P P20 P30	High Co micrograin carbide substrate with high toughness and latest coating technology. Universal use with great reliability and long tool life.
					M M20 M30	
					K K20 K30	
JP5130	micrograin carbide	1.830	PVD	TiAlN	P P20 P35	High toughness substrate combined with super-smooth coating designed for precision applications.
					M M20 M35	
JU6015	micrograin carbide	1.950	-	-	N N10 N20	Uncoated carbide for universal use, from finishing to roughing, on non-ferrous materials.
NB350	Low volume CBN 75%	3.400	-	-	H H20 H35	Hardened steel machining with a perfect combination between toughness and wear resistance. Available only for BGF system.
NBH450U	High volume CBN 95%	4.400	-	-	K K01 K20	Gray cast iron machining at very high cutting condition and with great wear resistance. Available only for BGF system.
ND120	diamond 95%	6.000	-	-	N N10 N30	High productivity grooving of non-ferrous materials. Available only for BGF system.

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	NDB	NCG	BGF
	<input type="checkbox"/> C5	<input type="checkbox"/> C13	<input type="checkbox"/> C15
	 EXTERNAL  INTERNAL	 EXTERNAL  INTERNAL	 EXTERNAL
Pressed type inserts	✓	✗	✗
Ground type inserts	✓	✓	✓
Available sizes (CW)	2.00 / 3.00 / 4.00 / 5.00 / 6.00 / 8.00 mm	1.10 ÷ 2.15 mm	1.00 ÷ 4.00 mm
Maximum depth (CDX)	14 / 20 / 25 / 25 / 30 / 30 mm	1.30 ÷ 1.85 mm	1.80 ÷ 4.50 mm
Coolant holes	✓	✗	✗
Workpiece material	P M K N	P M	K N H
No. of cutting edges	2	3	1
No. of geometries	6	1	2
Special features	All-around system	Can be installed on threading tool holders	Easy tailor-made
Grooving 	✓	✓	✓
Turning 	✓	✗	✗
Profiling 	✓	✗	✗
Cut-off 	✓	✗	✗
Versatility	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ □
Strength	■ ■ ■ ■ □	■ ■ ■ □ □	■ ■ ■ ■ ■
Precision	■ ■ ■ □ □	■ ■ ■ ■ ■	■ ■ ■ ■ □
Finishing	■ ■ ■ ■ □	■ ■ ■ ■ □	■ ■ ■ ■ □
Range	■ ■ ■ ■ □	■ ■ ■ □ □	■ ■ ■ □ □