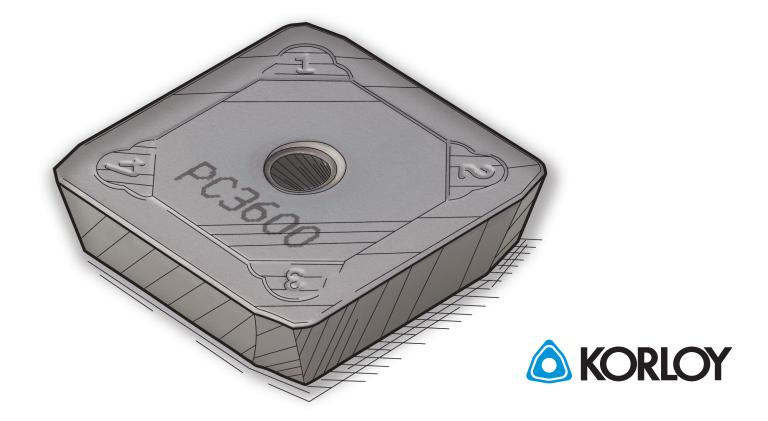
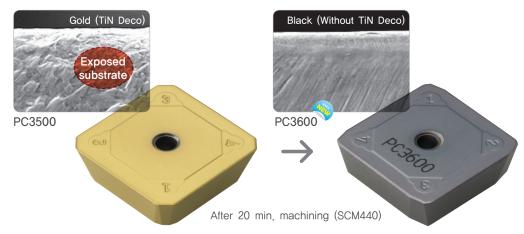


- · Improved wear and chipping resistance
- · New PVD coating with high toughness and oxidation resistance at high temperature
- · Optimum properties with fine-grained substrate

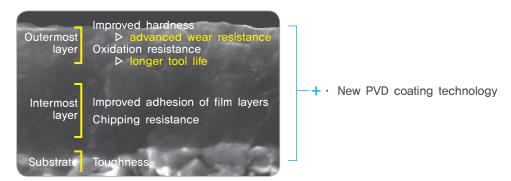


Black Power Coating

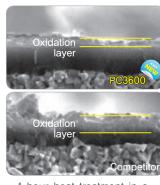


TiN deco layer reduced the tool life due to built up edge which made the outermost layer and even main layer broken away. However, TiN deco layer is removed from the new grade, PC3600 but a new layer which has more oxidation resistance and higher hardness is applied for longer tool life.

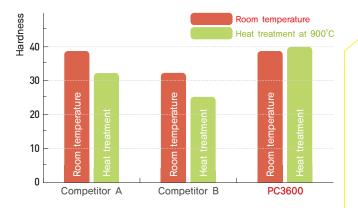
Features



Improved Features



1 hour heat treatment in a vacuum at 900°C





PC3600 Performance

Improved chipping on the cutting edge



SM45C vc=300m/min fz=0.2mm/tooth ap=2mm

· KORLOY special treatment for longer tool life.

Improved crater wear



SCM440 vc=250m/min fz=0,2mm,tooth ap=2mm

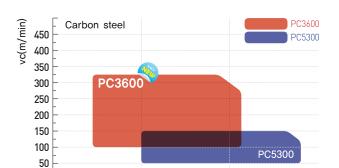
· KORLOY special treatment for longer tool life.

Recommended PVD grades

| Workpiece | | | | | Grade | | vc | Feed |
|-------------------|------------------------------|--|---------|----------|--------|-----------------|---------|------------|
| ISO | KS | Materials | НВ | HRC | 1st | 2 _{nd} | (m/min) | (mm/tooth) |
| P Carbon Steel | SM15C SM25C SM35C | Low carbon steel | 80~180 | Below 10 | PC3600 | PC5300 | 100~300 | 0.1~0.25 |
| | SM45C SM58C SCMn1 | High carbon steel | 180~280 | 10~30 | PC3600 | PC5300 | 100~300 | 0.1~0.25 |
| | SMn438(H) SUM22 SNC236 | | | | | | | |
| P Alloy Steel | SCM4105 SCM440 SCMnH1 | Low hardened steel | 140~260 | Below 27 | PC3600 | PC5300 | 100~250 | 0.1~0.25 |
| | SCr440 SNCM220 SNCM240 | Low alloy steel (pre-heat treatment) | 220~450 | 20~50 | PC5300 | DBN500 | 50~100 | 0.05~0.1 |
| | STD1 STD61 STS43 | High hardened steel | 50~260 | Below 27 | PC3600 | PC5300 | 100~200 | 0.1~0.25 |
| | SKH55 SKH3 SKH51 | High alloy steel (pre-heat treatment) | 220~450 | 20~48 | PC5300 | DBN500 | 50~100 | 0.05~0.1 |
| Hardened Steel | KP1 KP4 KP4M SKD61 | Hardened steel | 190~380 | Below 40 | PC3600 | PC5300 | 100~250 | 0.1~0.25 |
| | SKD11 NAK80 STAVAX | Sticky hardened steel | 210~370 | Below 40 | PC5300 | PC3600 | 50~100 | 0.05~0.1 |

Line up

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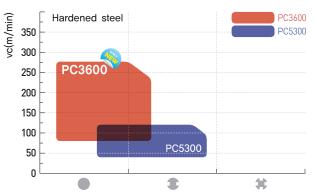
- Continuous cutting
- General cutting
- Interrupted cutting
- · Improved performance in carbon steel cutting
- Improved crater wear and fracture

 Heavy interrupted cutting: Use PC5300



- · Improved performance in alloy steel cutting
- Improved heat crack

 Heavy interrupted cutting: Use PC5300



Improved performance

Heavy interrupted cutting: Use PC5300



Use PC5300 with SDKN1203AESN-SU or SDKN1504AESN-SU