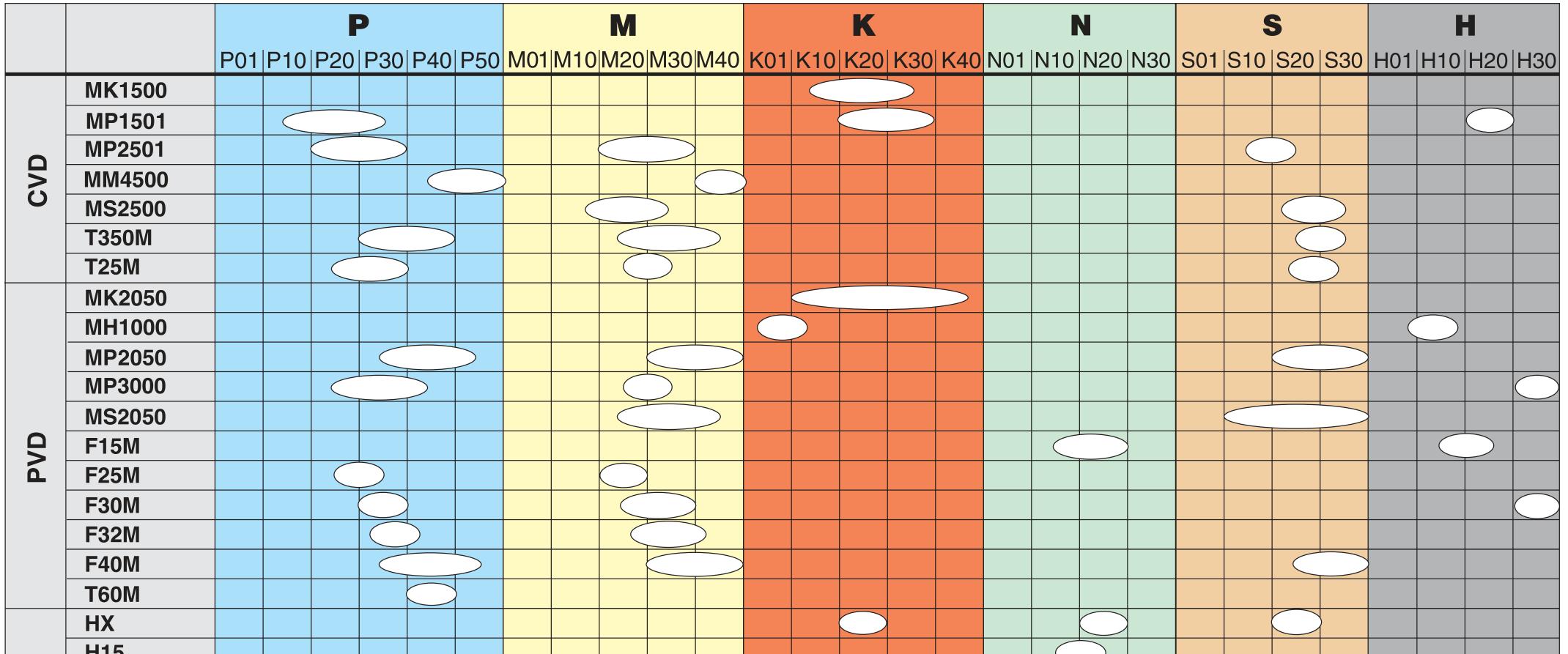
INDICATIVE ISO CLASSIFICATION OF THE GRADES



	H15										
	H25										
CBN	CBN150										>
	CBN200										
	CBN300						>				\geq
	CBN500										
CBN PVD	CBN160C										>
	CBN300P						>				\geq
	CBN400C						>				\geq
	PCD05										
Q	PCD20										
PCD	PCD30										
	PCD30M										
	CS100										
	CS300										
	CW100										

HX, H15, and H25 = uncoated CBN300P = PVD coating CS100/CS300/CW100 = ceramic

BASIC GRADES

DASIC GRADES		
	F40M	PVD-coated grade for fine to medium rough milling. First choice for milling with small feeds and/or low cutting speeds. Excellent for milling when there is a risk of vibrations and when coolant is used. Recommended for machining superalloys. (Ti, Al) $N - TiN$
	MP2501	CVD-coated grade based on Duratomic coating. Basic grade for milling steel and easy/medium difficult stainless steel, with or without coolant.
Centre Parts	Duratomic [®]	Ti (C, N) $- AI_2O_3$
	MK1500	CVD-coated grade based on Duratomic coating. Basic grade for milling cast iron and nodular cast iron, with or without coolant.
	Duratomic®	Ti (C, N) $- AI_2O_3$
	MK2050	PVD-coated grade for cast iron, Improved edge integrity. First choice in all cast iron materials. Excellent for milling with and without coolant. (Ti,Si)N/(Ti,AI)N

COMPLEMENTARY CVD COATED GRADES

	MP1501	Grade for medium rough milling under stable conditions at high cutting speeds and for milling hardened steel. Excellent grade for roughing grey and nodular cast iron.
El Carto	Duratomic ®	$Ti (C, N) - Al_2O_3$

UNCOATED GRADES

НХ	Wear resistant grade for milling in cast iron and non-ferrous alloys.
H15	Hard, wear resistant grade for milling in aluminum.
H25	Tough micro-grain carbide grade for milling in superalloys and aluminum.

GRADES

Most modern grades are coated with either CVD (Chemical Vapor Deposition) or PVD (Physical Vapor Deposition) technique. The coating improves the wear resistance of the grade.

GRADE

MS2500	Optimization grade for superalloy materials, also suitable for rough milling in tool steel. Ti (C, N) – AI_2O_3
MM4500	Extremely tough grade for duplex stainless steel. Can also be used for a wide range of materials when cutting conditions are unstable. Ti (C, N) $- Al_2O_3$
T350M	CVD-coated grade as basic choice for difficult stainless steel and an alternative in difficult operations in steel. Ti (C, N) $- AI_2O_3$

COMPLEMENTARY PVD COATED GRADES

CUMPLEMENIARY	PVD CUAIED 6	IRADES
	MH1000	Extremely hard grade for milling hard steel but also favorable in finishing operations in cast iron. (Ti, Al) N
	MS2050	PVD-coated grade first choice for machining titanium alloys. Can also be used as a complementary grade for milling stainless steels when increased toughness is needed. (Ti, Al) N – NbN
	MP3000	Highly wear resistant optimized grade for milling in steel. (Ti, Al) N
	F15M	Hard and wear resistant grade for milling in aluminum and non-ferrous alloys. Excellent grade, in combination with protected cutting edges, for high speed machining in hardened steel. (Ti, AI) $N - TiN$
	F25M	Tough grade for rough milling in tool steel. (Ti, Al) N – TiN
	F30M	Basic grade for Minimaster inserts and thread milling inserts. Also suitable for milling stainless steel, hardened steel, and superalloys. (Ti, AI) N – TiN
	TGOM	Tough grade for Minimaster inserts. Suitable for milling in soft and medium hard steel. (Ti, AI) N $-$ TiN

CVD-coated grades are suitable for wear resistance in demanding applications with high feed rates and intermediate to high cutting speed. PVD-coated grades are recommended for applications with low feed rate where high edge toughness is required. PVD-coated grades are suitable for applications with low to intermediate cutting speed.







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