

Technical Section

Cutting Speeds for Grooving Tools

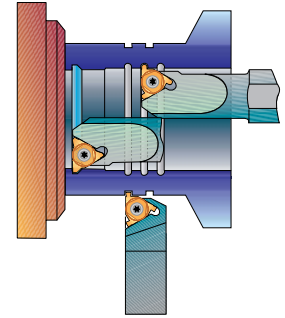
Carbide Grades:

BXC (P30 - P50, K25 - K40)

PVD TiN coated grade for low cutting speed. Works well with a wide range of stainless steels.

BMA (P20 - P40, K20 - K30)

PVD TiAlN coated sub-micrograin grade for stainless steels and exotic materials at medium to high cutting speeds.



ISO Standard	Materials	Cutting Speed ft/min
P	Low & Medium Carbon Steel	65-330
	High Carbon Steel	100-260
	Alloy Steels and Treated Steels	130-300
M	Stainless Steels	100-260
	Cast Steels	100-300
K	Cast Iron	100-300
N	Non-Ferrous & Aluminum	65-660

For grooving small bores see pages 191-196

