

Polygon Swiss Line

Carbide Grades

BLU

PVD triple layer coated Sub-Micron grade for Steel, Stainless Steels, Titanium and hard materials.

GX7

New generation of PVD triple layer coated Sub-Micron grade for wide range of materials as: Steel, Stainless Steels, Titanium and hard materials up to 58 HRc. With high toughness for optimized performance.

K20

Uncoated Sub-Micron carbide grade for Aluminum and non-ferrous materials, Stainless Steels and Titanium.

Cutting Data

ISO Standard	Materials	Cutting Speed m/min		
		K20	BLU	GX7*
P	Low & Medium Carbon Steels <0.55%C	-	80-150	70-160
	High Carbon Steels ≥0.55%C	-	70-120	60-130
	Alloy Steels, Treated Steels	-	40-80	40-100
M	Stainless Steel-Free Cutting	30-80	60-120	60-140
	Stainless Steel-Austenitic	20-70	30-90	30-120
	Cast Steels	30-80	50-120	50-140
K	Cast Iron	50-120	60-130	60-140
N	Aluminum ≤12%Si, Copper	120-250	-	-
	Aluminum >12%Si	90-200	-	-
	Synthetics, Duroplastics, Thermoplastics	70-150	-	-
S	Nickel Alloys, Titanium Alloys	20-50	30-70	30-90
H	Hardened Steel, 45-50HRc	-	20-50	20-70
	Hardened Steel, 50-58HRc	-	-	20-60

* Available for grooving and parting off, with G25 insert size