

Coated cermet grades

Coated cermet for machining carbon steel, alloy steel and sintered ferrous components

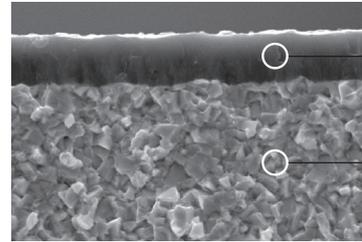
CC1500 **new**

- Maximized resistance to built-up edge and oxidation in continuous cutting at high speeds and low depth of cuts
- Superior wear resistance vs. existing tools in continuous cutting of carbon steel and alloy steel

CC2500 **new**

- Maximized resistance to built-up edge and oxidation in interrupted cutting at high feeds and high depth of cuts
- Superior impact resistance vs. existing tools in interrupted cutting of carbon steel and alloy steel

Features



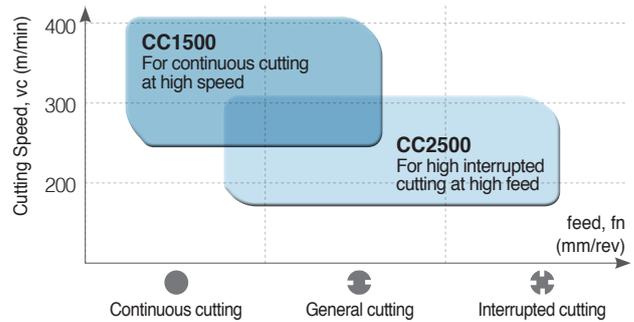
PVD layer with high hardness and lubrication

Exclusive substrate for super-high hardness coating

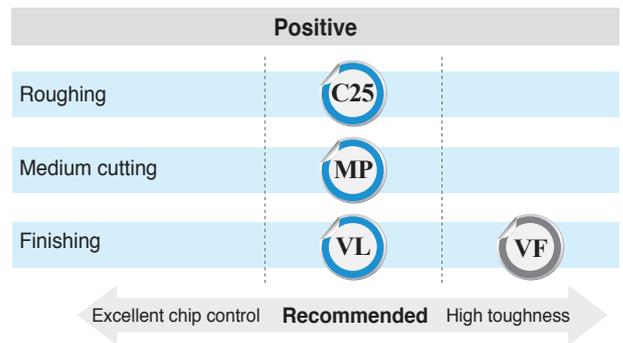
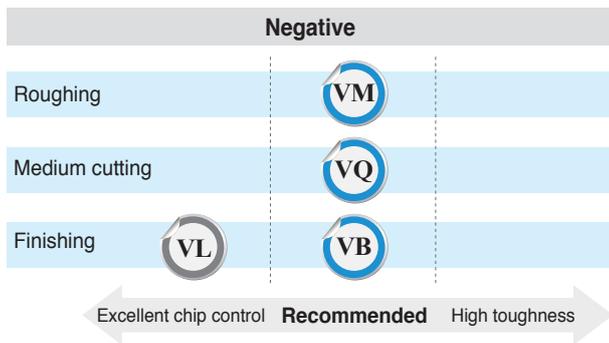
Recommended cutting condition

Division	Workpiece	Grade	Recommended cutting speed (m/min)		
			Minimum	Recommended	Maximum
Turning	SM10C, SS440	CN1500	200	350	450
		CN2500	180	290	400
	SM45C	CN1500	200	300	400
		CN2500	180	270	350
	SCM440, Sintered fe ferrous alloy	CN1500	180	270	350
		CN2500	150	250	300

Grades line up



Chip breakers line up



Selection system of coated cermet grades

Workpiece	Machining types	Recommended grade	Recommended cutting speed (m/min)	ISO	Application range
P Steel	Continuous cutting	CC1500	325 (200 ~ 450)	P10	← CC1500
	Interrupted cutting	CC2500	265 (180 ~ 350)	P20, P30	← CC2500
K Cast iron	Continuous cutting	CC1500	270 (180 ~ 350)	K10	← CC1500
	Interrupted cutting	CC2500	250 (150 ~ 300)	K20	← CC2500

The features of coated cermet grade

Coated cermet	ISO	Features
CC1500	P10 ~ P20 / K05 ~ K15	• PVD coated Cermet • Light cutting for steel and cast iron in high speed machining • Optimized for precision boring
CC2500	P20 ~ P30 / K10 ~ K20	• PVD coated Cermet • Light cutting for steel and cast iron in medium or high speed machining • Dry and wet cutting are available

