

NEW-GRADE

PVD Coated Grade for Milling Stainless Steel.

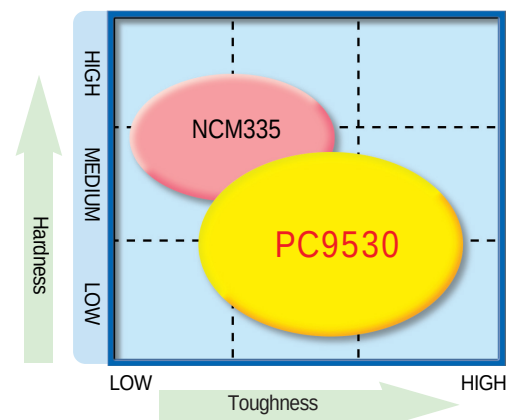
PC9530



PC9530 Features

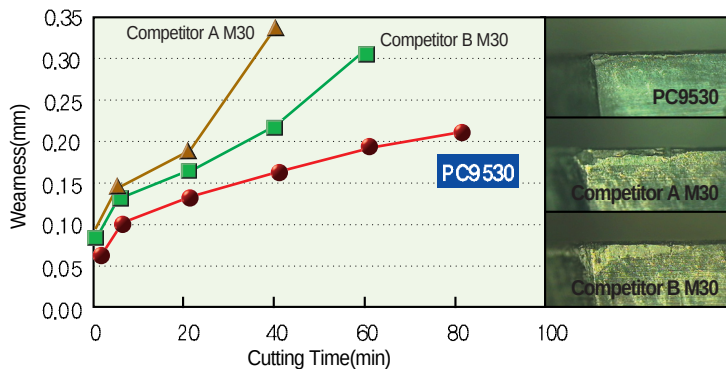
1. Ultra fine substrate for medium and roughing in Stainless Steel milling operation.
2. PVD film for the process of difficult to cut material such as Stainless Steel and Cr-Ni Steel.
3. Ultra fine grade and PVD coated layer avoid built up edge and burr.
4. Excellent toughness and cutting performance at a high rate of feed.

PC9530 Application



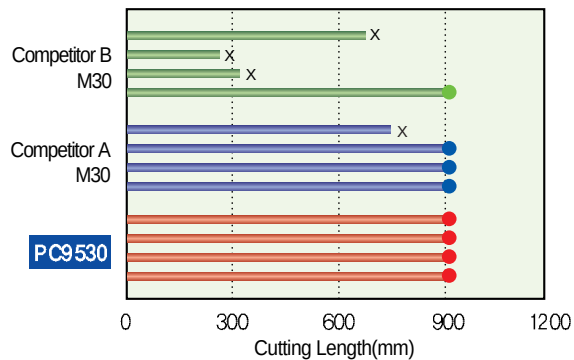
PC9530 Performance

Wear-resistance



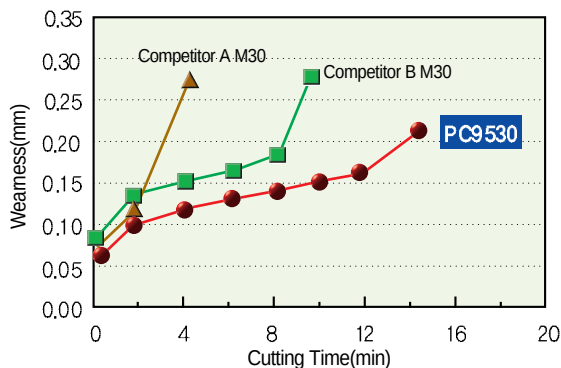
1. Work-piece : STS304(DIN X5CrNi89)
2. Description : SPCN1203EDTR-S20
3. Condition : V=200m/min, f=0.20mm/tooth, d=2.0mm, Dry

Anti-Vibration



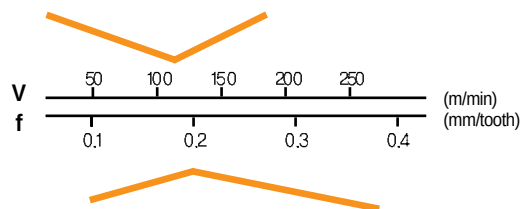
1. Work-piece : STS316(DIN X5CrNiMo1810)
2. Description : SPCN1203EDTR-S20
3. Condition : V=125m/min, f=0.36mm/tooth, d=2.0mm, Dry

Intermittent Wear-resistance



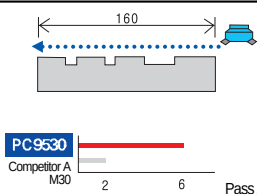
1. Work-piece : STS304(DIN X5CrNi89)
2. Description : SECN1203AFTN-S20
3. Condition : V=120m/min, f=0.167mm/tooth, d=2.0mm, Dry

PC9530 Recommended Cutting Condition

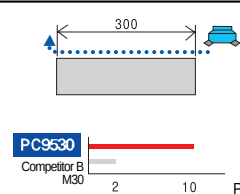


PC9530 Application Example

Description	SPCN1203EDTR-S20
Work-piece	STS316(DIN X5CrNiMo1810)
V(m/min)	166
f(mm/rev)	0.125
d(mm)	3.0
Coolant	Dry



Description	SECN1203AFTN-S20
Work-piece	STS304(DIN X5CrNi89)
V(m/min)	220
f(mm/rev)	0.07
d(mm)	1.0
Coolant	Dry



PC9530 Stocked Standard Items

APKT1604PDSR-MM	SPCN1203EDTR-S20	SEKR1203AFSN-MX	OFKR0704SN-MM	SDCN42MT-S20	TPCN1603PDR-S20
	SPCN1504EDTR-S20	SECN1203AFTN-S20		SDCN53MT-S20	TPCN2204PDR-S20
Cutter : AMS3000type	Cutter : EP4000type EP5000type	Cutter : AE4000type	Cutter : AFO5000type	Cutter : AD4000type	Cutter : PP4000type