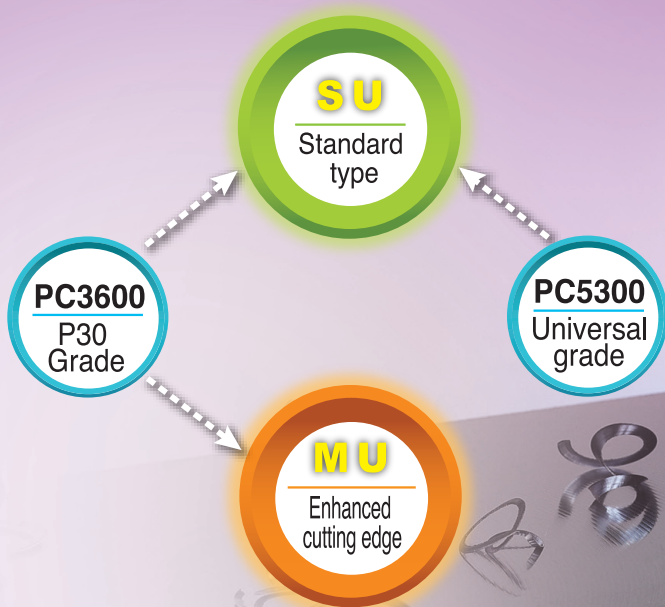
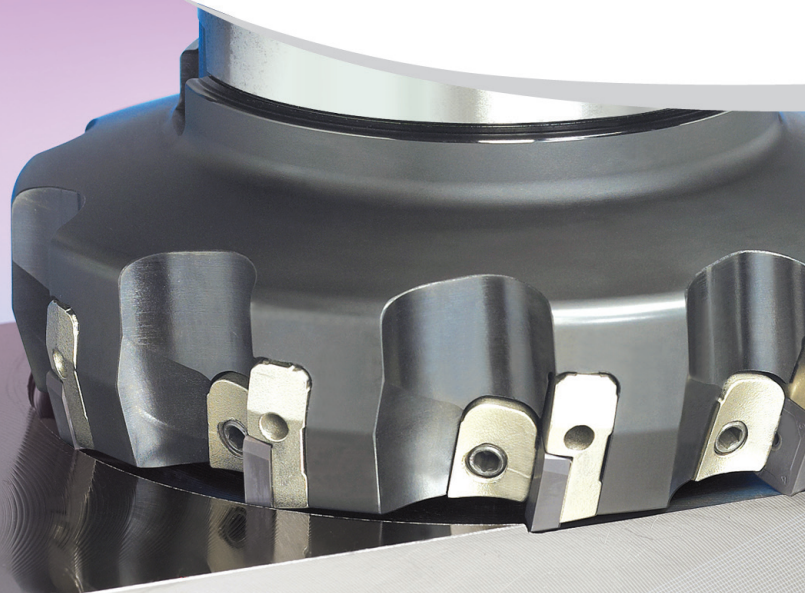


ISO Milling Insert

PC3600-SU/MU
PC5300-SU



ISO Milling Insert



Features of grade

• PC3600 : New PVD coated milling grade(P30)

- Coating layer with high hardness and oxidation resistance at high temperature ensures stable tool life.
- Improved wear resistance and impact resistance in high speed machining for all steels.
- PC3600 Application chip breaker
 - SU : Improved cutting edge for chipping resistance during intermittent cutting. Standard type.
 - MU : Enhanced cutting edge.

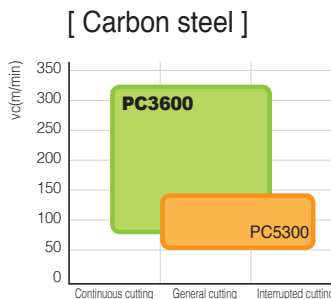
• PC5300 : Universal milling grade(M30, P40, K20)

- High toughness substrate with a superior coating layer.
- Universal grade for various materials.(Steel, Cast iron, Stainless steel)
- Stable machining due to a strong cutting edge and high hardness coating that prevents fracture from chipping.
- Superior performance in low and intermittent conditions.
- PC5300 Application chip breaker
 - SU : Improved cutting edge for chipping resistance during intermittent cutting. Application for high-hardened steels and gummy steels.

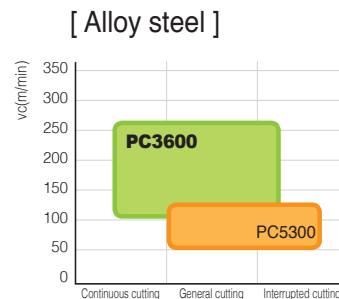
02

KORLOY
TECH-NEWSPC3600 -SU/MU
PC5300 -SU

Grade line-up

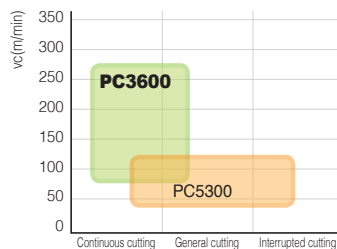


- Improved performance of PC3600 for machining carbon steel with high speed.
- Improved crater wear and chipping of the flank of the insert.
- PC3600 for continuous and slight interruption.
- PC5300 for interruption and low speed machining.



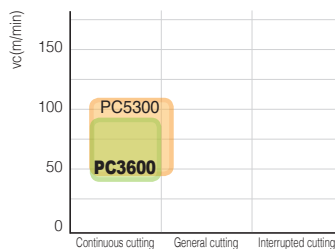
- Improved performance of PC3600 for machining alloy steel with high speed.
- Improved thermal cracking resistance and crater wear resistance.
- PC3600 for continuous and slight interruption.
- PC5300 for interruption and low speed machining.

[Die steel]



- Improved performance with new coating technology for mold and die steels.
- PC3600 for continuous machining, PC5300 for interrupted machining.

[High hardened steel / Deposited steel]



- PC5300 for hardened steel and deposited hardened steel.

Recommendation

Workpiece			Hardness (HRC)	Grade		Vc (m/min)	Feed (mm/tooth)
				Recommendation	Grade		
P	Carbon steel	Low-carbon steel	10 Below	1 st	PC3600	100~300	0.1~0.25
				2 nd	PC5300	50~150	0.15~0.30
		High-carbon steel	10~30	1 st	PC3600	100~300	0.1~0.25
				2 nd	PC5300	50~50	0.15~0.30
	Alloy steel	Low-alloy steel	27 Below	1 st	PC3600	100~250	0.1~0.25
				2 nd	PC5300	50~125	0.15~0.30
		Heat-low alloy steel	20~50	1 st	PC5300	50~100	0.05~0.10
		High-alloy steel	27 Below	1 st	PC3600	100~250	0.1~0.25
				2 nd	PC5300	50~125	0.15~0.30
		Heat-high alloy steel	20~48	1 st	PC5300	50~100	0.05~0.10
	Die steel	Mold and die steel	40 Below	1 st	PC3600	100~250	0.1~0.25
				2 nd	PC5300	50~125	0.05~0.15
		Deposited hardened steel	40 Below	1 st	PC5300	50~100	0.05~0.10
				2 nd	PC3600	50~100	0.05~0.10

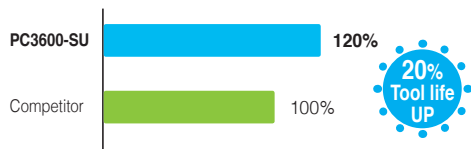
03

KORLOY
TECH-NEWS

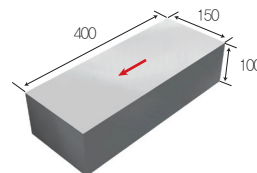
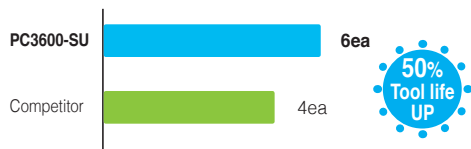
PC3600 -SU/MU
PC5300 -SU

Cutting performance

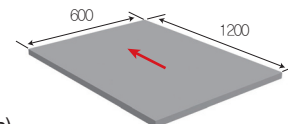
PC3600-SU



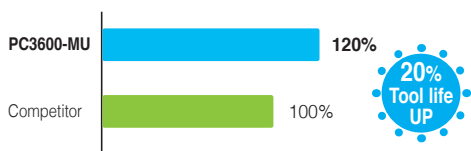
- **Workpiece** SS41(KS)
- **Cutting condition** $vc(m/min)=216$
 $fz(mm/tooth)=0.39$
 $ap(mm)=1$, Dry
Cutter PPN4125R(6 Inserts)
Insert TPKN2204PDSR-SU(PC3600)
- **Tools**



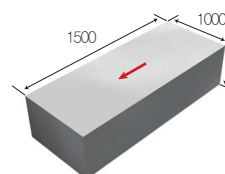
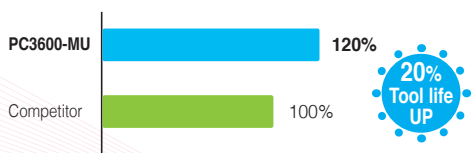
- **Workpiece** C45
- **Cutting condition** $vc(m/min)=306$
 $fz(mm/tooth)=0.13$
 $ap(inch)=2$, Dry
Cutter ADN4315R(7 Inserts)
Insert SDKN1203AESN-SU
- **Tools**



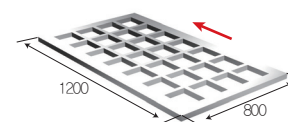
PC3600-MU



- **Workpiece** X40CrMoV5-1
- **Cutting condition** $vc(m/min)=113$
 $fz(mm/tooth)=0.3$
 $ap(mm)=5$, Dry
Cutter EPN5200R(12 Inserts)
Insert SPKN1504EDSR-MU(PC3600)
- **Tools**



- **Workpiece** KP4M(KS)
- **Cutting condition** $vc(m/min)=126$
 $fz(mm/tooth)=0.2$
 $ap(mm)=3\sim3.5$, Dry
Cutter ADN5200R(10 Inserts)
Insert SDKN1504AESN-MU
- **Tools**



Insert designation

• PC3600-SU, PC5300-SU

Shape	Designation	Stock	
		PC3600	PC5300
	SDKN1203AESN-SU	●	●
	SDKN1504AESN-SU	●	●
	SEKN1203AFSN-SU	●	
	SEKN1504AFSN-SU	●	

Shape	Designation	Stock	
		PC3600	PC5300
	SPKN1203EDSR/L-SU	●	●
	SPKN1504EDSR/L-SU	●	●
	TPKN1603PDSR/L-SU	●	
	TPKN2204PDSR/L-SU	●	●

• PC3600-MU

Shape	Designation	Stock
		PC3600
	SDKN1203AESN-MU	●
	SDKN1504AESN-MU	●
	SPKN1203EDSR-MU	●
	SPKN1504EDSR-MU	●

Shape	Designation	Stock
		PC3600
	TPKN2204PDSR-MU	●

KORLOY Inc.

Holystar B/D, 953-1, Doksanbon-Dong, Geumcheon-Gu, Seoul, 153-823, Korea
 Tel : +82-2-522-3181 Fax : +82-2-522-3184, +82-2-3474-4744
 Web : www.korloy.com E-mail : export@korloy.com

KORLOY EUROPE GmbH

Heinrich-Lanz-Allee 12, 60437 Frankfurt am Main, Germany
 Tel : +49-69-5069-887-0 Fax : +49-69-5069-887-29
 Web : www.korloyeurope.com E-mail : europe@korloy.com

KORLOY AMERICA Inc.

620 Maple Avenue, Torrance, CA 90503, USA
 Tel : +1-310-782-3800 Toll Free : +1-888-711-0001 Fax : +1-310-782-3885
 Web : www.korloyamerica.com E-mail : sales@korloy.us

KORLOY INDIA TOOLING Pvt.Ltd.

Ground Floor, Property No. 217, Udyog Vihar Phase 4,
 Gurgaon 122016, Haryana, INDIA
 Tel : +91-124-4050030 Fax : +91-124-4050032
 Web : www.korloyindia.com E-mail : sales.kip@korloy.com