

The best solution for the machining various kinds of materials

PC5300 / PC5400



Series of Universal Grades

- Superior and universal grade for machining various kinds of materials
- The new PVD coating layer ensures excellent performance and stability in machining



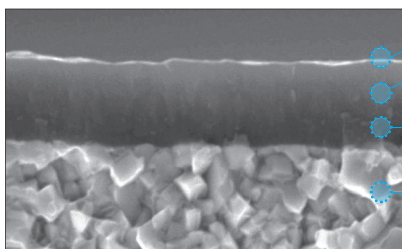
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Universal Grade Series

PVD PC 5300

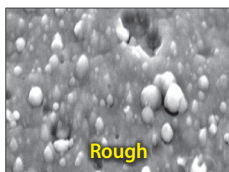
- PVD coating layer with high hardness and oxidation resistance during machining at high temperature
→ Superior oxidation resistance during machining of steel, cast iron, stainless steel, and heat-resistant alloys
- Ultra fine grain substrate with high toughness and special treatment on the surface
→ Improved welding resistance and chipping resistance

Features

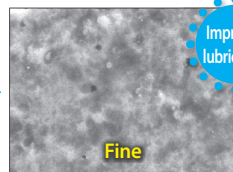


- ① Coating layer with high surface finish → Superior welding resistance
- ② Coating layer with high hardness and oxidation resistance during machining at high temperature → Superb wear resistance during machining at high speeds
- ③ Coating layer with high toughness and high adhesive strength
→ Excellent chipping resistance
- ④ Ultra fine grain substrate with high toughness
→ Great fracture resistance and stability in machining

- Special treatment on the surface



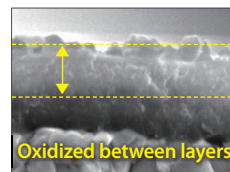
[Existing coating layer]



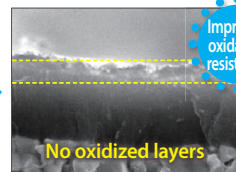
[PC5300]



- Coating layer with oxidation resistance during machining at high temperature (after 900°C heat treatment)



[Competitor's layer]



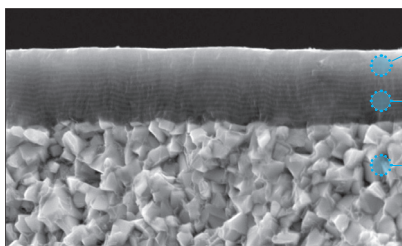
[PC5300]



PVD PC 5400

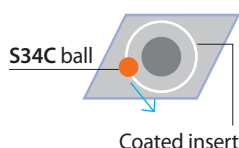
- Coating layer with excellent lubrication → Improved wear resistance and surface roughness at low speed machining or machining of deposited materials and mild steel
- Ultra fine grain substrate with high toughness and special treatment on the surface
→ chipping resistance and fracture resistance ensures stability in machining

Features



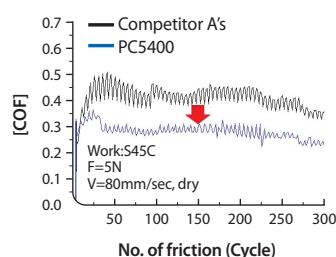
- ① Coating layer with superior lubrication → Welding resistance ensures excellent machining of carbon steel and mild steel
- ② Coating layer with high toughness and high adhesive strength
→ Superior chipping resistance
- ③ Ultra fine grain substrate with high toughness
→ Fracture resistance and high stability at machining

- Evaluation of measuring Coefficient of Friction

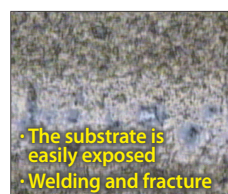


Coated insert

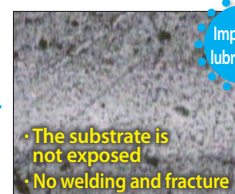
- Layer with high lubrication (Evaluation of measuring Coefficient of Friction)



- Surface of the layer rubbed with S34C ball



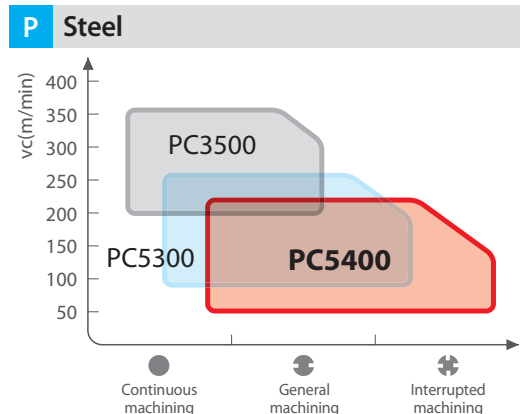
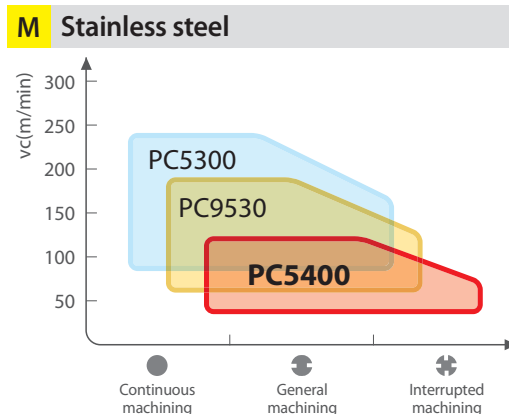
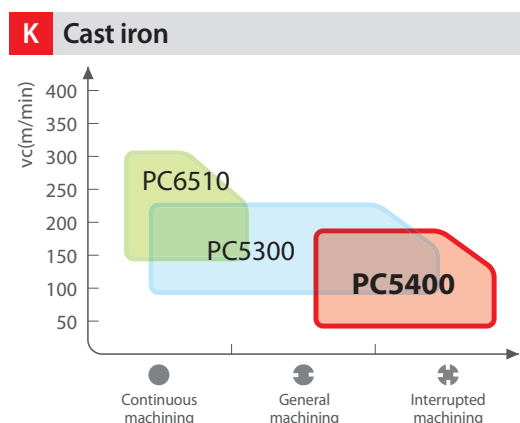
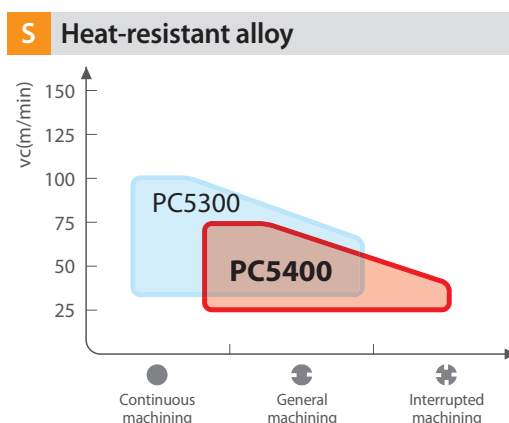
[Competitor A]



[PC5400]



Milling Grades Line-up



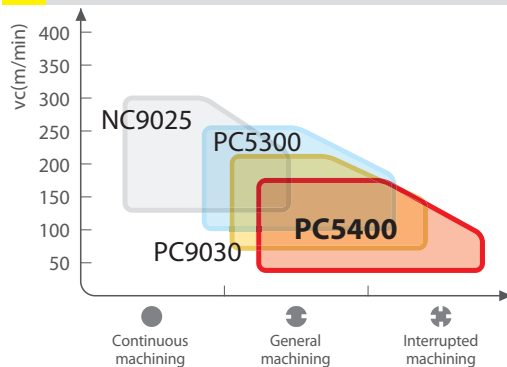
Milling Insert

Chip breaker	Cutting edge	Applications	Features
MA		Aluminum	Optimally buffed cutting edge for machining of aluminum ensures excellent performance
ML		Hard-to-cut materials	Chip breaker designed for low cutting load ensures superb performance in machining of hard-to-cut materials
MF		For finishing	Chip breaker having stronger cutting edge than ML is optimal for finishing with low cutting load
MM		Universal	Optimal for universal milling

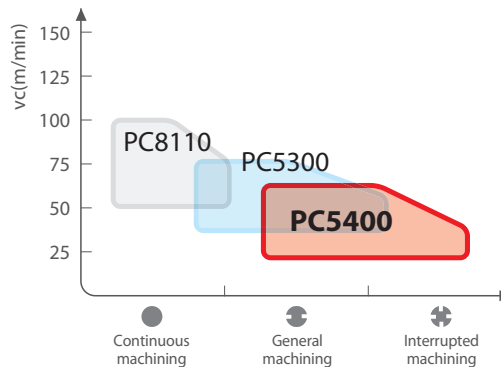
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Turning grades Line-up

M Stainless steel



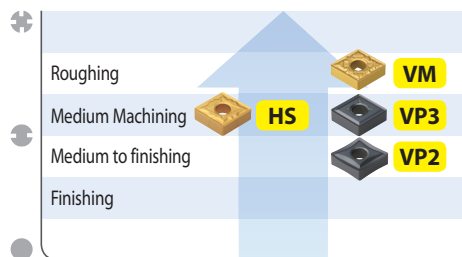
S Heat-resistant alloy



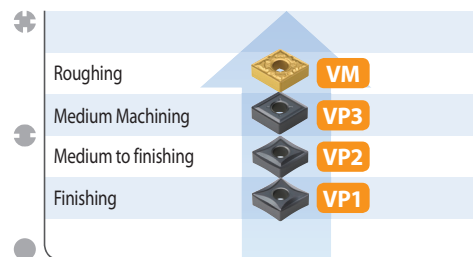
Chip breakers for turning inserts

• Negative insert

M Stainless steel

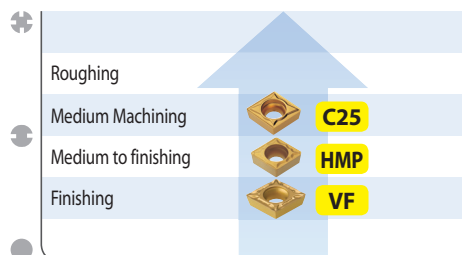


S Heat-resistant alloy

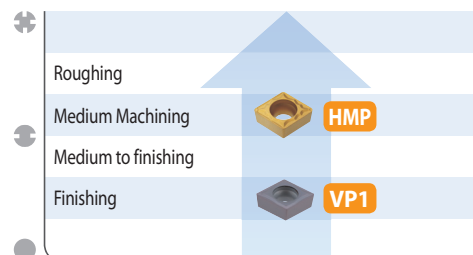


• Positive insert

M Stainless steel



S Heat-resistant alloy



Comparison for universal grades

Grade	Korloy	MMC	Sandvik	Iscar	Kyocera	KTT	Seco
S15-25 M20-35	PC5300	VP15TF	GC1025 GC1030	IC908	PR1125 PR1225 PR630	TT9030 TT9080	CP500
S25-35 M35-45	PC5400	VP30RT	GC1040 GC2040	IC328	PR660	TT8020 TT8080	F40M

Recommended Cutting Conditions

Workpiece					vc(m/min)			
ISO	KS	Workpiece	HB	HrC	Turning		Milling	
					PC5300	PC5400	PC5300	PC5400
P Carbon steel	SM15C SM25C SM35C	Low carbon steel	80~180	10below	100~170	80~150	140~270	100~250
	SM45C SM58C SCMn1 SMn438(H) SUM22 SNC236	High carbon steel	180~280	10~30	80~160	70~140	90~220	80~220
P Alloy steel	SCM410S SCM440 SCMnH1	Low alloy steel	140~260	27below	80~150	70~130	100~200	80~200
	SCr440 SNCM220 SNCM240	Low alloy pre-hardened steel	220~450	20~50	60~130	50~110	70~140	60~120
	STD1 STD61 STS43	High alloy steel	50~260	27below	80~130	70~110	70~150	60~150
	SKH55 SKH3 SKH51	High alloy pre-hardened steel	220~450	20~48	50~100	40~100	40~110	30~90
M Stainless steel	STS304 STR31 STR316	Austenite Series	135~275 Ni>8%	29below	120~220	100~200	100~230	80~180
	STS316 B11SSC16 STS321 STS12	Cast steel Austenite	150~250	25below	100~200	80~180	90~190	50~170
	STS403 STS410 STS420 STS430 STR446 STR36	Ferrite series Martensite series	135~275	29below	120~280	100~250	110~240	80~200
	Incoloy800	Fe base	200~280	29below	50~80	40~60	40~65	30~60
S Heat-resistant alloy	Hastelloy C Inconel718 Nimonic901	Ni base	250~320	34below	20~55	20~50	35~60	30~60
	Stellite	Co base	200~320	34below			10~25	10~25
	TA14/17	Ti alloy steel	400	43below	110~160	80~140	100~120	80~100
		Ti High hardness alloy steel	4000이상	43above	40~65	30~60	45~65	30~60
K Cast iron	GC100 GC150 GC200	Low tensile strength	180	18below	110~180	80~150	200~210	150~180
	GC250 GC350	High tensile strength	220	23below	95~140	80~110	150~230	120~200
	GCD400 GCD500	Ferrite series	160	10below	95~135	80~110	110~180	80~150
	GCD600 GCD700	Ferrite series	250	24below	90~130	70~110	100~160	70~130
		Martensite series	380	41below	65~100	50~90	60~120	50~100
N Aluminum Copper alloy	Aluminum	Aluminum alloy	30~150	-	40~400	40~400	250~400	250~400
	Copper, copper alloy		150~160	-	20~250	20~250	300~500	300~500

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Application Examples(PC5300)

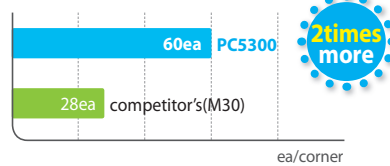
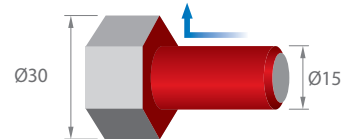
• Turning

M Stainless steel (STS304)

- Cutting conditions $vc(m/min) = 282$
 $fn(mm/rev) = 0.2$
 $ap(mm) = 3.0$
wet

- Tool Insert CNMG120408-HS
Holder DCLNL2525-M12

• Result

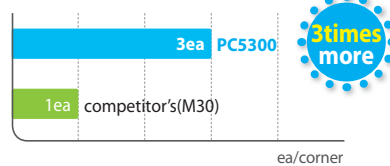
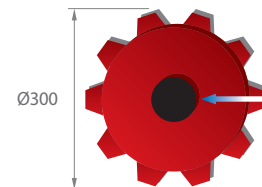


M Stainless steel (STS316)

- Cutting conditions $vc(m/min) = 120$
 $fn(mm/rev) = 0.2$
 $ap(mm) = 0.5 \sim 1.5$
wet

- Tool Insert SNMG120408-GS
Holder DSBNL2525-M12

• Result



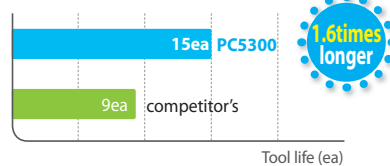
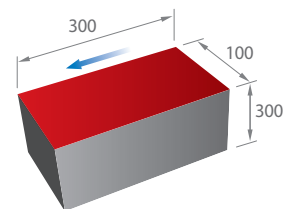
• Milling

P Carbon Steel (SM45C)

- Cutting conditions $vc(m/min) = 250$
 $fz(mm/t) = 0.3$
 $ap(mm) = 2.0$
dry

- Tool Insert SPKN1504EDSR-SU
Cutter EPN5160R

• Result

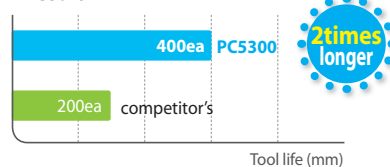
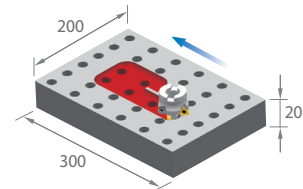


P Alloy steel (KP4M)

- Cutting conditions $vc(m/min) = 250$
 $fz(mm/t) = 1.0$
 $ap(mm) = 1.0$
dry

- Tool Insert WNMX130520ZNN-MM
Cutter HRMDCM13050HR-3

• Result

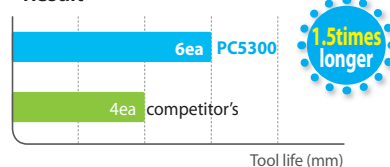
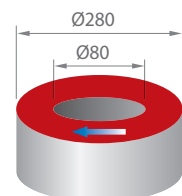


M Stainless steel (STS316)

- Cutting conditions $vc(m/min) = 65$
 $fz(mm/t) = 0.14$
 $ap(mm) = 3.0$
wet

- Tool Insert SEET14M4AGSN-MM
Cutter FMACM4100HR

• Result



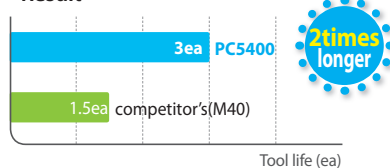
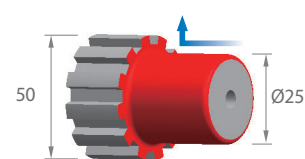
Application Examples(PC5400)

• Turning

M Stainless steel (STS304)

- Cutting conditions $vc(m/min) = 110$
 $fn(mm/rev) = 0.25$
 $ap(mm) = 1.0 \sim 2.0$
 wet
- Tool Insert CNMG120408-VP3
 Holder DCLNL2525-M12

• Result

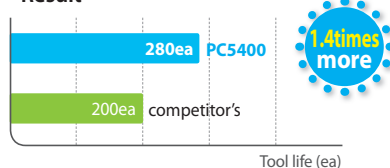
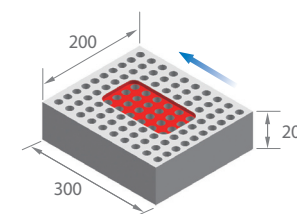


• Milling

P Carbon steel (SM45C)

- Cutting conditions $vc(m/min) = 250$
 $fz(mm/t) = 1.2$
 $ap(mm) = 1.0$
 dry
- Tool Insert WNMX130520ZNN-MM
 Cutter HRMDCM13050HR-4

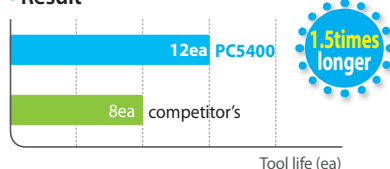
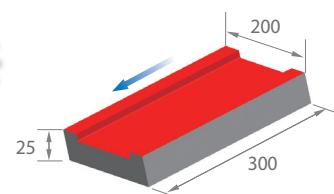
• Result



P Alloy steel (SCR440)

- Cutting conditions $vc(m/min) = 180$
 $fz(mm/t) = 0.2$
 $ap(mm) = 2.0$
 dry
- Tool Insert RDKT1605M0-MM
 Cutter FMRC5063HRD-H

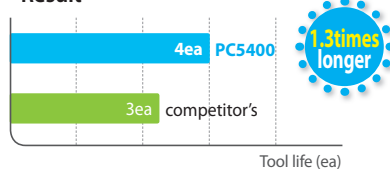
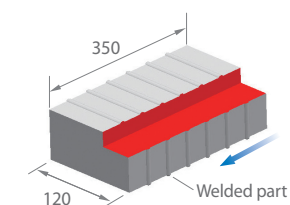
• Result



M Stainless steel (STS316)

- Cutting conditions $vc(m/min) = 50$
 $fz(mm/t) = 0.1$
 $ap(mm) = 4.0$
 $ae(mm) = 15.0$
 dry
- Tool Insert APMT1604PDSR-MM
 Cutter AMC3063HS

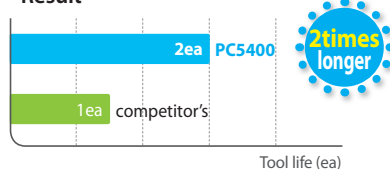
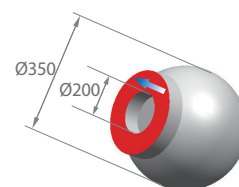
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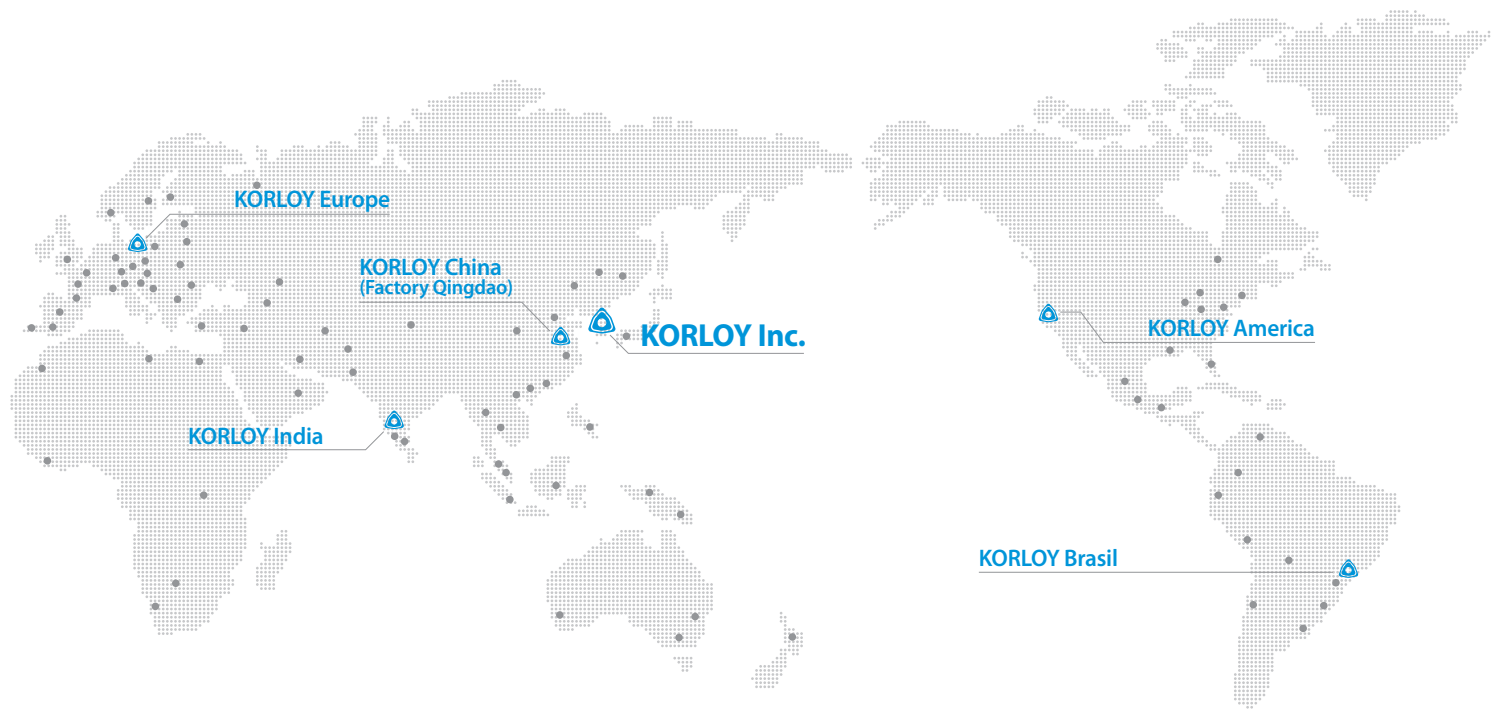


S Heat-resisting alloy (INCONEL718)

- Cutting conditions $vc(m/min) = 60$
 $fz(mm/t) = 0.1$
 $ap(mm) = 2.5$
 wet
- Tool Insert SNMX1206ANN-MM
 Cutter RM8AC4080HR

• Result





Head Office

Holystar B/D, 1350, Nambusunhwan-ro, 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

Cheongju Factory

55, Sandan-ro, Heungdeok-gu, Cheongju-si,
Chungcheongbuk-do, 361-290, Korea
Tel : +82-43-262-0141 Fax : +82-43-262-0146

Jincheon Factory

54, Gwanghyewonsandan 2-gil, Gwanghyewon-myeon, Jincheon-gun,
Chungcheongbuk-do, 365-831, Korea
Tel : +82-43-535-0141 Fax : +82-43-535-0144

R & D Institute

55, Sandan-ro, Heungdeok-gu, Cheongju-si,
Chungcheongbuk-do, 361-290, Korea
Tel : +82-43-262-0141 Fax : +82-43-262-0711



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



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



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



Av. Aruana 280, conj.12, WLC, Alphaville, Barueri, CEP06460-010, SP, Brazil
Tel : +55-11-4193-3810
E-mail : vendas@korloy.com



Ground Dongjing Road 56 District Free Trade Zone. Qingdao, China
Tel : +86-532-86959880 Fax : +86-532-86760651
E-mail : kimyc@korloy.com

- Please refer to stock management of cutters and detail dimensions in the 2014 catalogue



Seoul Headquarter



KORLOY Engineering Center



Cheongju
Research & Development



Jincheon Factory Office



Jincheon Factory