

Schnittdaten

Polygon Swiss Line

Carbide grades:

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

K20 Uncoated Sub-Micron carbide grade for Aluminum and non-ferrous materials, Stainless Steels and Titanium.

ISO Standard	Material	Cutting Speed m/min	
		K20	BLU
P	Low and Medium Carbon Steels <0.55%C	-	80-150
	High Carbon Steels ≥0.55%C	-	70-120
	Alloy Steels, Treated Steels	-	40-80
M	Stainless Steel-Free Cutting	30-80	60-120
	Stainless Steel-Austenitic	20-70	30-90
	Cast Steels	30-80	50-120
K	Cast Iron	50-120	60-130
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
H	Hardened Steel, ≤45 HRc	-	20-50

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