

PHG & PHS New Turning Grades

The best grades for machining Steels and Stainless Steels

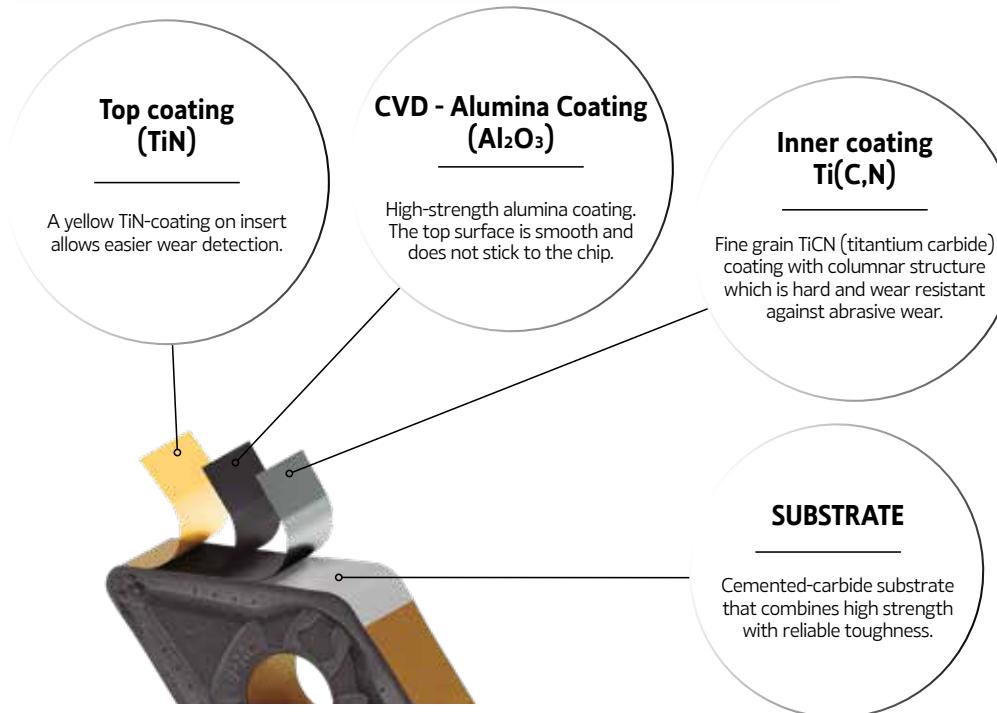


PHG & PHS

NEW

New Turning Grades

Cosmic Technology **for better Productivity**



PHG105
P05-P10 NEW

First choice for continuous cut with hardness higher than 38HRC

New CVD coating with Al₂O₃+TiN combined with a very hard substrate.

PHG115
P10-P25

Suitable for high to medium cutting speeds on steels

New CVD coating with Al₂O₃+TiN.

PHG125
P20-P35

Ideal for general application in all kind of steels

Carbide grade suitable for medium machining of steels at medium cutting speeds.

PHG140
P25-P45 NEW

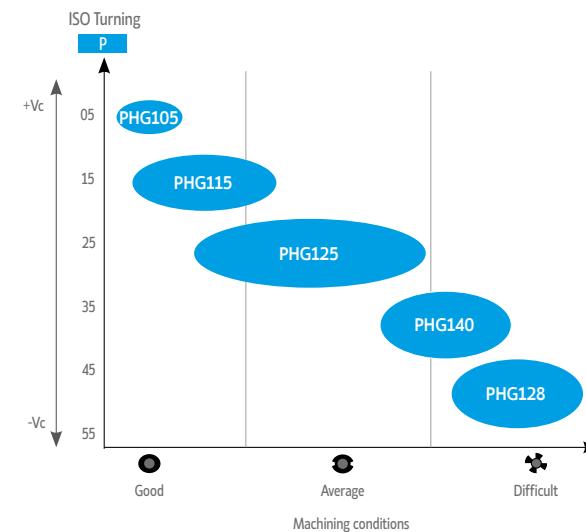
First choice for roughing to heavy roughing operations with interrupted cut at medium to low cutting speeds

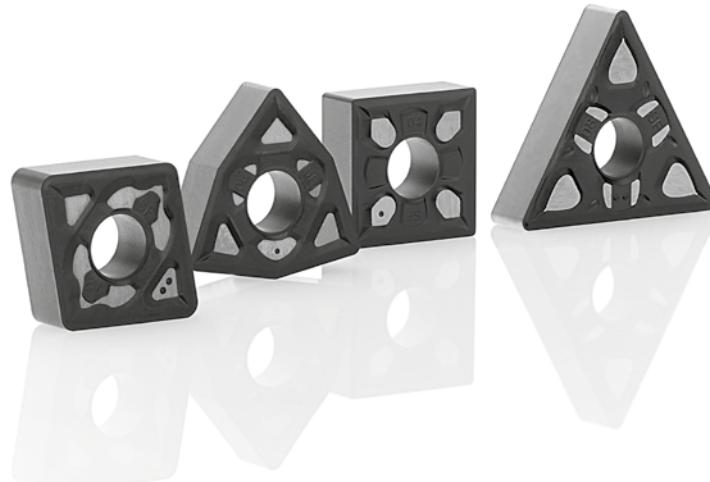
Binary substrate grade (Wc - Co) with medium grain size combined with a medium temperature CVD coating.

PHG128
P40-P50 NEW

A very high toughness grade ideal for heavy roughing applications while using on large I.C inserts

New CVD coating with Al₂O₃+TiN.





PHS215
M10-M25

Suitable for high to medium cutting speeds in stainless steel. Ideal for turning on good condition of cut (continuous cut)

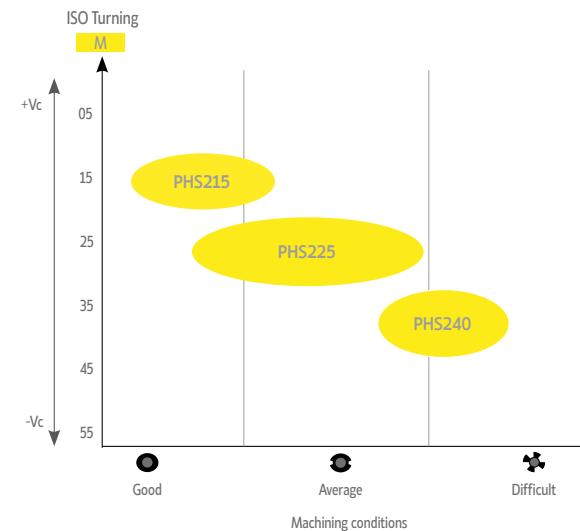
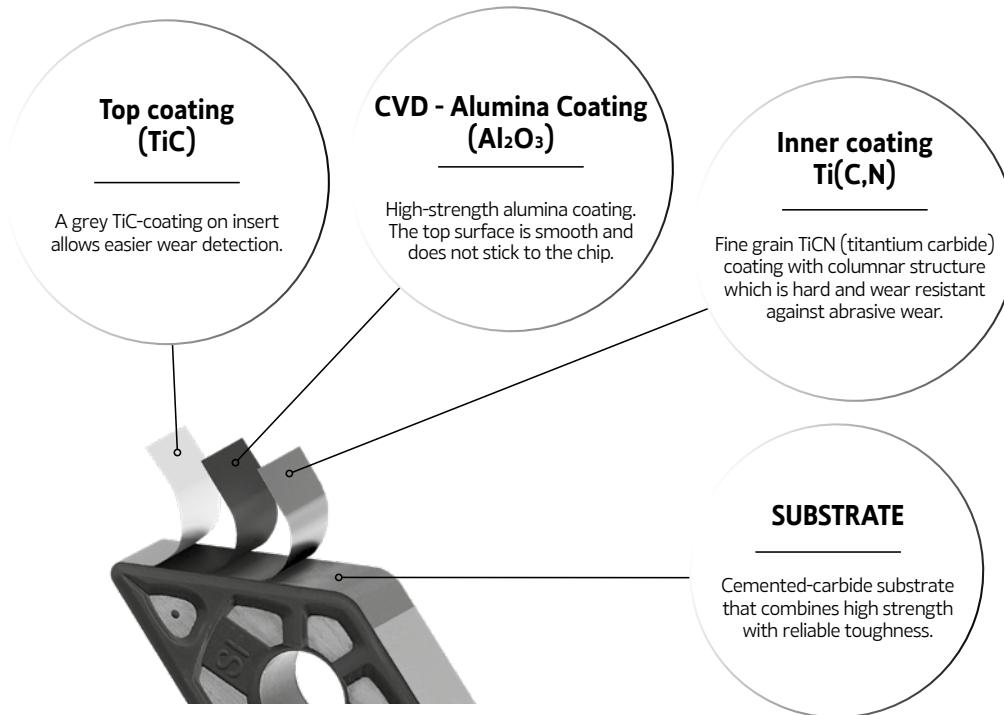
PHS225
M15-M30

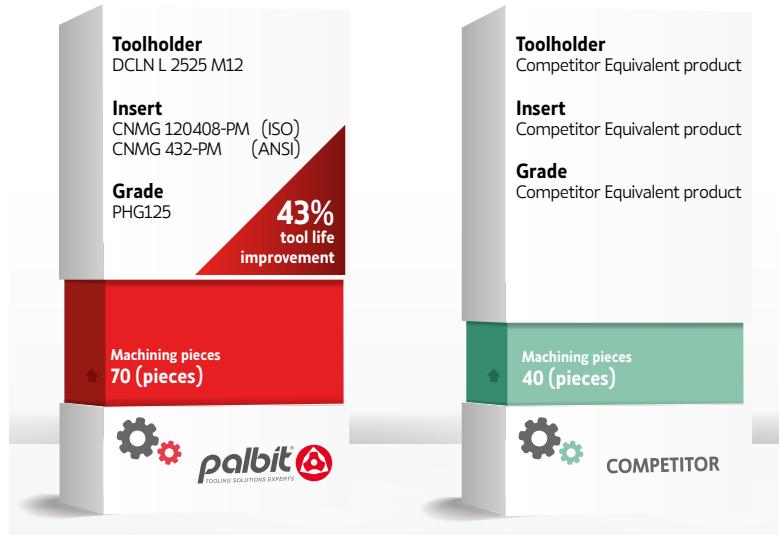
First choice for general application on turning of stainless steels

PHS240
M25-M45

Carbide grade suitable for medium machining of stainless steels and super alloys at medium cutting speeds.

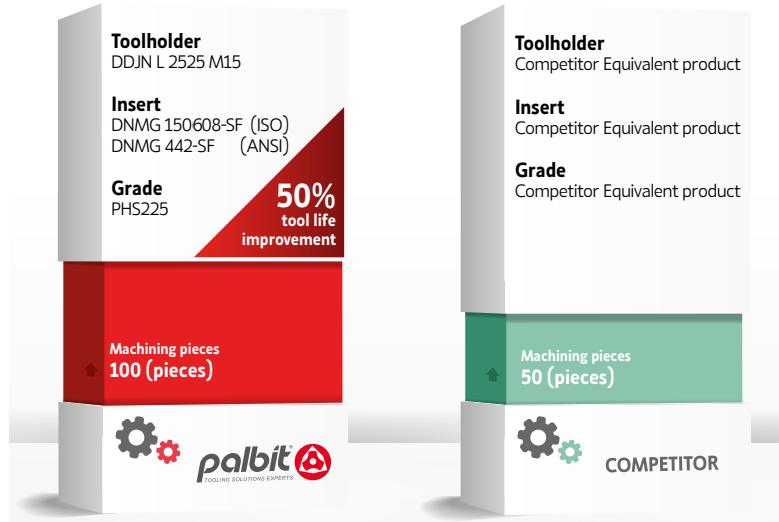
First choice for roughing to heavy roughing operations with interrupted cut at medium to low cutting speeds on stainless steel.





Workpiece material: Low-alloy steel, Ck45 (200 HB)

Cutting speed: Vc	200 m/min	656 sfm
Feed per tooth: fn	0,30 mm/r	0.012 in/r
Depth of cut: ap	3,00 mm	0.118 in
Operation	External turning	
Coolant	Emulsion	



Workpiece material: stainless steel, AISI 316

Cutting speed: Vc	180 m/min	590 sfm
Feed per tooth: fn	0,30 mm/r	0.012 in/r
Depth of cut: ap	2,00 mm	0.078 in
Operation	External turning	
Coolant	Emulsion	