

## Technical Section

### Cutting Speeds for Grooving Tools

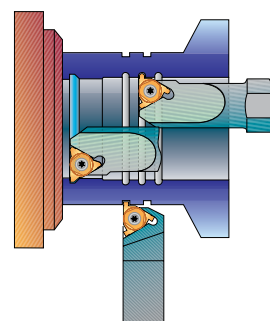
#### Carbide Grades:

**BXC** (P30 - P50, K25 - K40)

PVD TiN coated grade for low cutting speed. Works well with a wide range of stainless steels.

**BMA** (P20 - P40, K20 - K30)

PVD TiAlN coated sub-micrograin grade for stainless steels and exotic materials at medium to high cutting speeds.



ISO Standard	Materials	Cutting Speed m/min
<b>P</b>	Low & Medium Carbon Steel	20-100
	High Carbon Steel	30- 80
	Alloy Steels and Treated Steels	40- 90
<b>M</b>	Stainless Steels	30- 80
	Cast Steels	30- 90
<b>K</b>	Cast Iron	30- 90
<b>N</b>	Non-Ferrous and Aluminum	20-200

For grooving small bores see pages 89-95

