

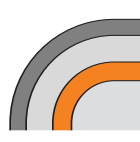









First Choice Grade Descriptions



	cutting material	coating	composition and application
Inserts	K600	 uncoated carbide	Carbide grade made from high-quality, micro-grain materials for cutting all types of material. Extreme toughness guarantees a controlled wear rate. The micro-grain structure permits extremely sharp cutting edges.
Face Mills	KC610M (KC610)	 TiN TiCN TiN	Coated carbide grade with PVD multi-layer coating (TiN/TiCN/TiN). An excellent grade for milling steel, stainless steel, and nodular graphite iron. Because of the resistance to thermal shocks of its substrate, this grade is an excellent choice for wet as well as dry machining.
End Mills	KC625M	 TiC(N) TiCN TiN	Coated carbide grade with a PVD multi-layer coat [TiN/TiCN/TiC(N)]. KC625M is a high-performance grade for milling all types of material. Good hardness and wear resistance characterizes this grade. It provides outstanding protection for solid carbide tools against cratering and abrasion. This grade is ideally used with cooling or minimal lubrication.
Die and Mold	KC635M (KC7215)	 TiAlN	PVD TiAlN coated carbide on a deformation resistant substrate. Exceptional heat and wear resistance qualities make this grade an excellent choice for milling aluminum, cast iron, heat resistant alloys, steels, and stainless steels.
Slotting	KC631M	 TiAlN	PVD TiAlN coated carbide on a deformation resistant substrate. It's a very thin and smooth coating that is suitable for milling aluminum. The coating keeps the necessarily sharp edge and protects against abrasion and edge build-up.
Thread Milling	KC633M	 TiAlN TiN TiAlN	Coated carbide grade with a PVD multi-layer coating (TiAlN, TiN, TiAlN). KC633M is a high-performance grade for dry milling of all material types. This grade is extremely hard and wear resistant. It provides outstanding protection for solid carbide tools against cratering and abrasion.
Widia Cutters	KC651M	 TiB ₂	The coating on KC651M inserts is extremely hard providing very good wear characteristics at high cutting speeds. KC651M resists built-up edge, can help reduce burring, and generates excellent surface finish. KC651M is best suited for aluminum with <10% silicon and non-ferrous metals.
Vintage Cutters	KC637M	 TiAlN	PVD TiAlN coated carbide on a "new" sub-micron carbide substrate. It's a very thin and hard coating that provides outstanding performance in milling hardened materials (50-65 HRC).
Accessories	KT605M	 cermet	The high edge strength permits sharp cutting edges and exhibits virtually no edge build-up during machining. This results in excellent surface finishes. Recommended for fine finishing of <32 HRC, characterized by high feed/high speed.
Technical Data	KP525M	 TiCN	Powdered metal grade with a TiCN coating. The KP525M grade is a universal grade for end milling aluminum, steels, heat-resistant alloys, and stainless steel.
Mat'l Database	KH110M	 high speed steel	Uncoated M42 (8%) cobalt grade for use in hard-to-machine materials. This grade includes a special heat treating process to assure optimized hardness.
Index	KDF300	 diamond coated	The KDF300 grade is a pure, diamond coated carbide grade for milling aluminum, graphite, and other non-metals. It is an extremely tough and wear resistant grade.