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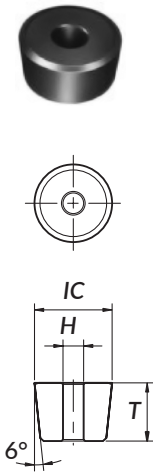
Turning Solutions for the Steel Mill

Ceramic Inserts

www.ntkcuttingtools.com

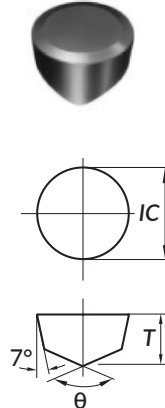


CDH



Item	IC	T	H	HC2	HC5	HC7
CDH 22 P2810	1/2	0.250	0.125	\$26.78	\$30.80	\$30.80
CDH 33 P6015	3/4	0.375	0.250	CALL	-	-
CDH 33 Q6010	3/4	0.375	0.250	\$40.09	-	-
CDH 33 Q6010B	3/4	0.375	0.250	-	CALL	CALL
CDH 42 P8015	1	0.500	0.266	-	-	\$50.60
CDH 42 P12010	1	0.500	0.266	\$44.00	\$50.60	-
CDH 43 P6010	1	0.750	0.266	\$53.71	-	-
CDH 515 P7110B	1 1/4	0.375	0.391	\$49.79	-	-
CDH 515 P7110	1 1/4	0.375	0.391	\$49.79	-	-
CDH 515 P8015	1 1/4	0.375	0.391	-	-	\$57.27
CDH 515 Q7110	1 1/4	0.375	0.391	\$49.79	\$57.27	CALL
CDH 53 P8015	1 1/4	0.750	0.391	-	-	\$70.83
CDH 53 Q9515	1 1/4	0.750	0.391	\$61.59	\$70.83	-

RCGX



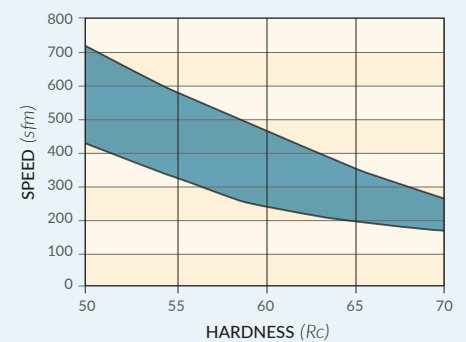
Item	IC	T	θ	HC2	HC5	HC7	ZC4	WA1
RCGX 104 P6015	1/2	0.312	120	\$21.14	\$24.31	\$24.32	-	-
RCGX 104 P8015	1/2	0.312	120	-	-	\$24.32	-	-
RCGX 104 T0820	1/2	0.312	120	\$21.14	-	-	-	-
RCGX 104 T1625	1/2	0.312	120	-	-	-	\$25.37	-
RCGX 45 E02	1/2	0.312	120	-	-	-	-	\$30.84
RCGX 45 T0220	1/2	0.312	120	-	-	-	-	\$30.84
RCGX 45 T0320	1/2	0.312	120	-	-	-	-	\$30.84
RCGX 45 T0420	1/2	0.312	120	-	-	-	-	\$30.84
RCGX 45 Z0620	1/2	0.312	120	-	-	-	-	\$30.84
RCGX 45 Z0820	1/2	0.312	120	-	-	-	-	\$30.84
RCGX 105 P4815	5/8	0.388	120	\$29.91	\$38.78	-	-	-
RCGX 105 P8015	5/8	0.388	120	-	-	\$34.40	-	-
RCGX 105 S8020	5/8	0.388	120	\$29.91	-	\$34.40	-	-
RCGX 106 P4815	3/4	0.388	120	\$33.72	-	-	-	-
RCGX 106 P8015	3/4	0.388	120	\$33.72	\$38.78	\$38.77	-	-
RCGX 108 P8015	1	0.461	140	\$50.35	-	-	-	-

Grade

Material Properties and Conditions

Grade	Work Materials	Purpose	Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (Inch)
Black Ceramics (Alumina+TiC)	HC2	Gray cast iron	1200-2100	.004-.016	.020-.060
		Mill rolls (Cast iron)	150-500	.003-.008	.020-.140
	HC5	Mill roll (Cast iron)	450-600	.004-.012	.025-.075
	Mill roll (Steel)	450-600	.004-.012	.025-.075	
HC7	Hardened material (HRC30-62)	Finish	130-700	.003-.008	.005-.030
	Mill roll (Steel / Cast iron)	Rough - Finish	450-600	.004-.012	.025-.075
TIN Coated Black Ceramics	ZC7	Hardened material (HRC30-62)	130-700	.003-.008	.005-.030
		Mill roll (Steel / Cast iron)	450-600	.004-.012	.025-.075
	ZC4	Hardened material (HRC55-70)	130-700	.003-.008	.005-.030
Whisker (Al₂O₃+SiC)	WA1	Heat resistant alloy	Rough no scale	600-1000	.005-.010
			Semi finish Profiling	600-1100	.004-.010
			Grooving	600-1100	.002-.004
		Gray cast iron	Semi finish Finish	1200-2100	.004-.016
		Mill roll Carbide	Rough-Semi finish	150-500	.003-.008
CBN (Cubic Boron Nitride)	B99	Cast Iron	2000-4500	.006-.020	.020-.140
		Mill Rolls	100-200	.004-.012	0.01

Recommended Speeds



Recommended Feeds

Nose Radius	Depth of Cut (Inch)	Feed (IPR)	
		30 micro	60 micro
1/64	-.007	.002-.003	.003-.004
1/32	-.015	.003-.004	.004-.005
3/64	-.020	.004-.005	.005-.0065
1/16	-.030	.004-.0055	.006-.0075
1/4	-.080	.007-.010	.010-.014

- General purpose ceramic **HC2** grade; **HC5** and **HC7** for higher productivity
- **WA1**'s wear resistance is perfect for roughing carbide and hardened rolls
- **ZC7** covers applications such as carburized or induction hardened steels.
- **ZC4** performs best in hardened material from 55-70 Hc