

THREAD TURNING

Carbide Grades



FourCut

With FourCut you choose between two different grades for best performance.

HC is best for harder materials and high-heat applications, while LC offers a balance of toughness and heat resistance, ideal for a wide range of applications and materials.



Micrograin Carbide with AlTiSiN coating. All-round grade, high hardness and heat resistance. Use cutting data according to the tables.



Micrograin Carbide with AlCrN coating. All-round grade, combination of toughness and heat resistance. Use cutting data according to the tables.

Triangular Insert

You don't need to choose a grade for our triangular inserts. We use FC as our all-round grade, which performs great in most applications.

For internal thread turning of small dimensions, we utilize the BC grade.



Micrograin Carbide with TiAlN coating. All-round grade with high heat resistance. Use cutting data according to the tables.



Micrograin Carbide with TiN coating. Suitable for internal thread turning of small dimensions. Cutting speed 40% less than FC.

Select Grade

MATERIAL	Hardness HB	Tensile Strength N/mm ²	FourCut		Triangular	
			First Choice	Second Choice	First Choice	
Steel	Low carbon, C < 0,25%	< 120	< 400	LC	HC	FC
	Medium carbon, C < 0,55%	< 200	< 700	LC	HC	FC
	High carbon, C < 0,85%	< 250	< 850	LC	HC	FC
	Low alloy	< 250	< 850	LC	HC	FC
	High alloy	< 350	< 1200	HC	LC	FC
	Hardened, HRC < 45			HC	LC	FC
	Hardened, HRC < 55			HC	LC	FC
	Hardened, HRC < 65			HC	LC	FC
Cast iron	Lamellar graphite	< 150	< 500	LC	HC	FC
	Lamellar graphite	< 300	< 1000	LC	HC	FC
	Nodular graphite, malleable	< 200	< 700	LC	HC	FC
	Nodular graphite, malleable	< 300	< 1000	LC	HC	FC
Stainless steel	Free machining	< 250	< 850	HC	LC	FC
	Austenitic	< 250	< 850	HC	LC	FC
	Ferritic and austenitic	< 300	< 1000	HC	LC	FC
Titanium	Unalloyed	< 200	< 700	HC	LC	FC
	Alloyed	< 270	< 900	HC	LC	FC
	Alloyed	< 350	< 1250	HC	LC	FC
Nickel	Unalloyed	< 150	< 500	LC	HC	FC
	Alloyed	< 270	< 900	HC	LC	FC
	Alloyed	< 350	< 1250	HC	LC	FC
Copper	Unalloyed	< 100	< 350	LC	HC	FC
	Brass, bronze	< 200	< 700	LC	HC	FC
	High strength bronze	< 470	< 1500	HC	LC	FC
Aluminium	Unalloyed	< 100	< 350	LC	HC	FC
	Alloyed, Si < 0.5%	< 150	< 500	LC	HC	FC
	Alloyed, Si < 10%	< 120	< 400	LC	HC	FC
	Alloyed, Si > 10%	< 120	< 400	LC	HC	FC
Inconel	718	< 370		HC	LC	FC
Graphite				LC	HC	FC