HPMT End Mill - Description of Coating Types

Coating Code	Type of Coating	Hardness	Oxidation Resistance Temperature	Coefficient of Friction	Standard Thickness	Application Area	Coating Colour
B0819	AlTiN	(HV 0.05) 3,300	≥ 900°C ≤ 1,000°C	0,3	3 µm	Suitable for medium and high speed, wet and dry machining and good for machining steel with hardness up to HRC 52.	 Blue-Black
B0909	TiSi based	(HV 0.05) 3,600	≤ 1,200°C	0,3	2,5 - 3,5 µm	Suitable for high speed (dry) and hard machining for difficult materials above HRC 52. Suitable for high-speed machining with hardened steels above HRC 60	 Copper
B0909+	AlTiSiN	3,800	>1,100 °C	0,5	2,5 - 3,5µm	Suitable for high speed (dry) and hard machining for difficult material above HRC 50. Suitable for high-speed machining with hardened steels above HRC60. Vc & Vf = +30%	 Copper to Brown
G6110	AlCrN	(HV 0.05) 3,200	≤ 1,100°C	0,35	2,5 - 3,5 µm	Suitable for low to medium speed, wet and dry machining and good for machining steel with hardness and high temperature alloy up to HRC 52.	 Blue-Grey
DCT01	Diamond	(GPA) 40 -90	≤ 600°C	0,15-0,2	1,2 µm	Suitable for machining graphite and composite reinforced plastic fiberglass (e.g. graphite electrodes, crucibles, boats)	 Dark Grey
H2600	H2600	2,600	600°C	0.35	1 - 3 µm	Suitable for aluminium.	 Barley
D0120	TiSi based	(HV 0.05) 3,600	≤ 1,200°C	0.3	2 - 3 µm	Suitable for high performance drilling in difficult machining material.	 Copper
T8090	TiALN	(HV 0.05) 3,300	≤ '900°C	0.3-0.35	3 µm	Suitable for low and medium cutting speed under wet machining.	 Blue-Black

Subject to errors and misprints.

Fraisa End Mill - Description of Coating Types

Coating Code	Type of Coating	Hardness	Oxidation Resistance Temperature	Coefficient of Friction	Standard Thickness	Application Area	Coating Colour
UNICUT-4A	**TiALCN**	HV 3200	650°C	0,25	1 - 5 µm	High toughness, hardness and thermal resistance. Low friction coefficient. For milling, tapping, hobbling, punching and stamping.	 Copper
CELERO	**TiB2**	HV 4000	700°C	0,4	0,5 - 1,5 µm	To avoid built-up edges when machining sticky materials. For aluminium injection moulding and impact extrusion. Very low roughness	 Guld
POLYCHROM	**TiAlCrN**	HV 3000	1000°C	0,45	3 µm	Excellent suitability for wet machining. Particularly suitable for roughing and high dynamic cutting.	 Blue-Black

Subject to errors and misprints.