

Machining Gray / Ductile Cast Iron with Ceramics

SX6 Silicon Nitride Ceramic



■ Features

- 1st choice for roughing gray cast iron
- Applicable for wet cutting
- Excellent thermal shock resistance makes high speed milling possible

■ Recommended Applications

- Gray cast iron - Rough - Turning and milling

SP9 CVD Coated Silicon Nitride Ceramic



■ Features

- Extremely tough - Tough enough to rough cast iron with T0420 (.004" x 20) edge preparation
- Small edge preparation - low tool pressure for stable precision machining
- SP9's toughness makes higher feed rates possible
- Dramatically reduced flank wear due to CVD coating

■ Recommended Applications

- Gray cast iron - Rough - Turning and milling
- Ductile cast iron - Rough - Turning and milling

HC1, HW2 Alumina Oxide Ceramic



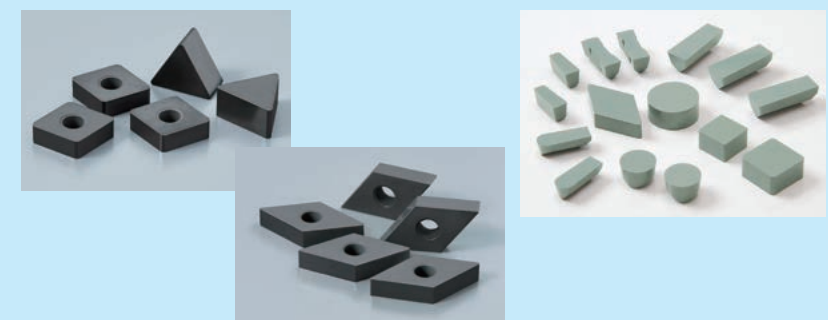
■ Features

- 1st choice for finishing gray cast iron with no coolant
- Excellent wear resistance makes high speed finishing possible

■ Recommended Applications

- Gray cast iron - Finish - Turning
- Chilled liners - Rough/Finish - Turning (HW2)

HC2, HC6 TiC Ceramic **WA1** Whisker Reinforced Ceramic



■ Features

- All grades make high speed finishing of cast iron possible
- Applicable for wet cutting conditions
- HC6 - Optimized for finishing ductile cast iron

■ Recommended Applications

- Gray cast iron - Finish - Turning (HC2 HC6 WA1)
- Ductile cast iron - Finish - Turning (HC6)

