



Solution of Super alloy & Heat Resistant Ti-alloy TURNING!

PC8010

New
PVD Coating

Fono: 055 787169
www.itachile.com

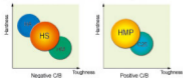


Features of PC8010

- PVD coated S10 grade
- Heat Resistant Super Alloy (HRSA) turning grade
- Good wear resistance and anti-adhesion of new coating layer
- Prolonged tool life



C/B line-up



Application area

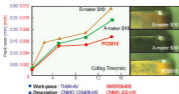


© KW8010 - Uncoated grade for HRSA TURNING.

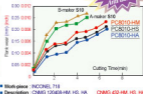


Excellent
Wear-resistance &
Anti-adhesion

Wear resistance of PC8010



V	f	d	Coolant
50 m/min	0.1 mm/rev	1.0 mm	Dry
195 sfm	0.004 ipr	0.04 inch	




V	f	d	Coolant
50 m/min	0.15 mm/rev	1.0 mm	Wet
195 sfm	0.0064 ipr	0.04 inch	

Machining Examples of PC8010

www.itachile.com

Description	CHMG 12048-HS	CHMG 432-HS
Work-piece	Ti-6Al-4V (Ship Engine Part)	
V	60 m/min	300 sfm
f	0.1 mm/rev	0.004 ipr
d	1.0 mm	0.04 inch
Coolant	Dry	



Description	CHMG 12048-HS	CHMG 432-HS
Work-piece	Ti-6Al-4V (Ship Engine Part)	
V	50 m/min	195 sfm
f	0.15 mm/rev	0.0064 ipr
d	1.0 mm	0.04 inch
Coolant	Wet	



Recommended cutting condition of PC8010

Work piece	Cutting condition		V		d		f	
	m/min	sfm	mm	inch	mm/rev	ipr		
Ni-based alloy(Inconel, Hastelloy)	30	100	0.1	0.004	0.1	0.004		
	~ 60	~ 200	~ 2.0	~ 0.080	~ 0.3	~ 0.012		
Fe-based alloy(MA-956, Incoloy909)	30	100	0.1	0.004	0.1	0.004		
	~ 70	~ 230	~ 2.0	~ 0.080	~ 0.3	~ 0.012		
Co-based alloy(Stellite, Haynes25)	25	85	0.1	0.004	0.1	0.004		
	~ 70	~ 230	~ 2.0	~ 0.080	~ 0.3	~ 0.012		
Ti-alloy(Ti-6Al-4V.)	30	100	0.1	0.004	0.1	0.004		
	~ 60	~ 265	~ 2.0	~ 0.080	~ 0.3	~ 0.012		

Coating film of PC8010

KORLOY grade code



- TiN/AlTiN film: Good anti-oxidation and anti-adhesion.
- CrAlN film: Better wear resistance, shock resistance and anti-oxidation than conventional TiAlN coating layer.
- Free gas TiCo: Substrate with high hardness and toughness.

