



Carbide Grades for CVD coating of Inserts

January 1, 2017

<p>Recommended Grades for Inserts and Flat Tools</p>	<p>Carboly - 883/HX Circle - C25 Dapra - F1 Duramet - DU2/DU22 Firth Sterling H21/HA Greenleaf - GO2 Iscar - IC20/IC28 Everede - CS2</p>	<p>Ingersoll - ICT205/ICT 111 Kaiser Thinbit - D5 Kennametal - K68 Millstar Mitsubishi - HTi20T/HTi10 Newcomer - 22 Sandvik - H10/H13A Sumitomo -G10E Taegu Tec - K10</p>	<p>Teledyne - H21/HA Tool Flo - C25 Toshiba - Th10 Ultra-met - Z22, Z86 Valenite - VC2/VC3 Walmet - WA2 Widia - THM</p>
<p>Acceptable Grades for Inserts and Flat Tools</p>	<p>Fansteel/VWR - 2A5 General Carbide - GC106 Ingersoll - ICT111 Ultra-met - Z23</p>		



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Category	Manufacturer	Carbide Grade	Composition	Grain Size	TRS 1000 psi	ISO Code
6% Co, Fine Grain	Ceratizit	CTF12A	WC 94% Co 6%	Fine 1.3 to 1.6um	380	K15
	Hydro Carbide Inc.	HC292	WC 95% Co 5%	Fine 0.9 to 2.2um	340	
	Sandvik	H6N	WC 94% Co 6%	Medium 1.7um avg	319	K20
	CB Carbide (Ceratizit Chinese subsidiary)	K100L	WC 94% Co 6%	Fine 0.8 - 1.3u	300	K10
	HB Carbide	HB-2	WC 94% Co 6%	Fine 1.0 - 1.5u	440	K20, K30, K40
	General Carbide	GC-206	WC 94% Co 6%	Medium 1.0 to 4.0um	480	
	Guhring	DK120	WC 94% Co 6%	1.3um avg	450	K15
	TechMet	TMK22D	WC 94% Co 6%	Medium 1.3 - 2.5u	400	K20, K30
6% Co, micrograin	Ceratizit	CTS12D (was MG12)	WC 93.4% Co 6%	Submicron 0.5 - 1.0um	520	K05, K10
	Extramet	EMT 100	WC 93% Co 6%	0.8um avg >0.5 - 0.8um	566	
	Techmet	TMK326	WC 94% Co 6%	Micrograin	410	K10
	Iljin	TH608	WC 94% Co 6%	Micrograin 0.8um avg	>435	
	Kennametal	2506	WC 94% Co 6%	Micrograin	450	K5, K10
	Kennametal	K313	WC 94% Co 6%	Micrograin	500	K5, K10
	Mitsubishi	HTi10	WC 94% Co 6%	Micrograin <1.0um avg	464	K10
10% Co, micrograin	Hydro Carbide Inc.	HCUS10	WC 90% Co 10%	Micrograin 0.6 to 1.2um	450	
	Ceratizit	CTS20D (was MG18)	WC 90% Co 10%	Submicron	580	K20-K40
	TechMet	TMK320	WC 89.5% Co 10%	Submicron 0.8 to 1.0um	700	
	Tungsten Carbide MFG	TCM2210	WC 90% Co 10%		500	K20, K25
	Mitsubishi	TF15	WC 90% Co 10%	Micrograin <0.9um avg	580	K20