



DATUM



Metalcutting Answers™

Stellram, a globally integrated technology leader in the development of carbide metal cutting answers for turning, milling, threading, drilling and grooving applications. The company is recognized for powder technology, innovative chip groove design and superior coating technology. Stellram is a wholly owned subsidiary of Metal Working Products an Allegheny Technologies Company, one of the world's leading producers of tungsten-based products. It is also one of only a few companies in the industry that is truly integrated from raw material through to the various finished products



Geometry 2N

Positive rake angle provides a positive cutting action and reduced cutting pressure, this makes 2N a good starting geometry for a wide range of application / materials.

Geometry 4T

New designed version of 4T with improved surface contact, a good all round negative roughing geometry for a wide range of applications.



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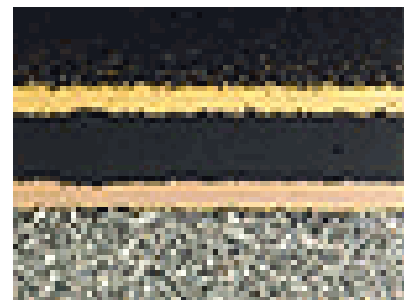


| | |
|---|---|
| MF | MR |
| Medium Finishing | Medium Roughing |
| 2N | 4T |
|  |  |

| Negative Inserts | | | |
|-------------------------|--------------|--------------------|--------------------|
| | Grade | NL25 | NL25 |
| Smooth Cut | DOC | 0.75-4.0 | 1.2-6.0 |
| (Metric) | Feed | 0.125-0.400 | 0.200-0.500 |
| | SFM | 60-240 | 60-240 |
| Smooth Cut | DOC | 0.030-0.155 | 0.047-0.250 |
| (Imperial) | Feed | 0.005-0.016 | 0.009-0.020 |
| | SFM | 190-770 | 190-770 |

Grade NL25

Coated grade TiN-TiCN-Al₂O₃-TiN by CVD for all finishing operations. Layers thickness 10—17 microns. NL25 is usually recommended for semi-finishing and finishing if wear resistance is required instead of toughness.



Nitro-lok®

All NL grades use Stellram's patented Nitro-lok® coating. This provides improved adhesion by altering the structure of the intermediate coated layers. The improved bond increases the strength of the aluminium oxide layer, resulting in greater wear and crater resistance, thus increasing tool life.