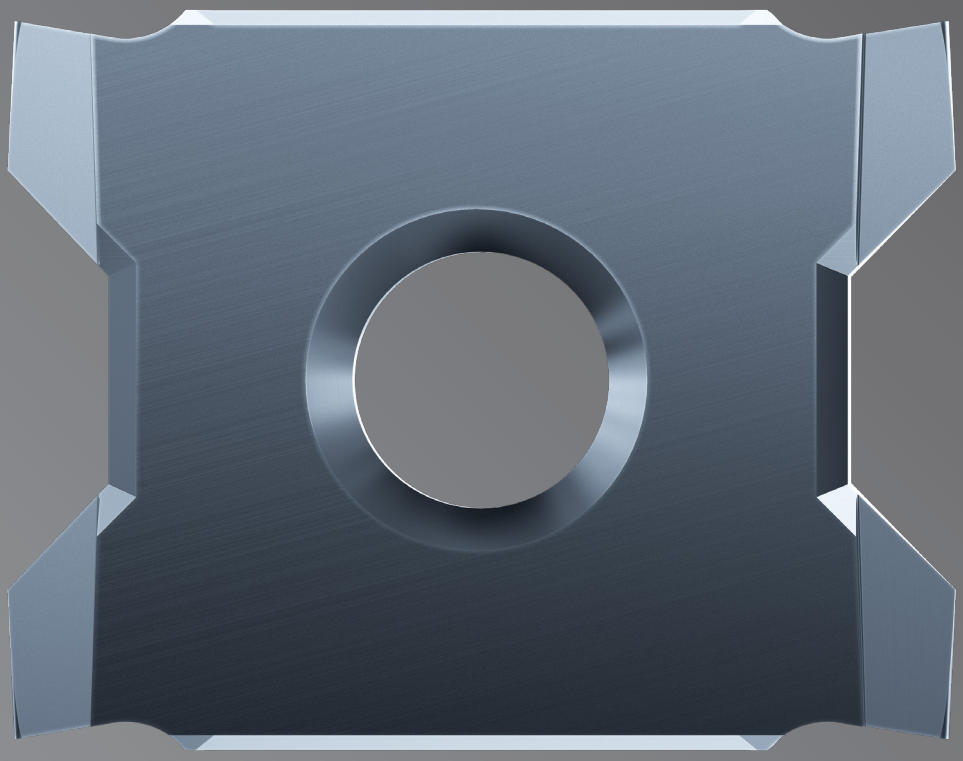
SmiCut™ STS

NEWS 2024

FourCut



LC

New Grade for Steel and Cast Iron

THREAD TURNING

Carbide Grades

NEW GRADE

FourCut

LC is a new standard grade. We recommend this grade as the first choice for many different materials such as steel, cast iron and aluminium.

HC is best for harder materials and high-heat applications, while LC offers a good balance of toughness and heat resistance.

LC Micrograin Carbide with AlCrN coating.
All-round grade, combination of toughness and heat resistance. Use cutting data according to the tables.

HC Micrograin Carbide with AlTiSiN coating.
All-round grade, high hardness and heat resistance. Use cutting data according to the tables.

HC
AlTiSiN coating

LC
AlCrN coating

Choose between the grades HC and LC for maximal productivity.

Select Grade

MATERIAL		Hardness HB	Tensile Strenght N/mm²	FourCut First Choice	FourCut Second Choice
Steel	Low carbon, C < 0,25%	< 120	< 400	LC	HC
	Medium carbon, C < 0,55%	< 200	< 700	LC	HC
	High carbon, C < 0,85%	< 250	< 850	LC	HC
	Low alloy	< 250	< 850	LC	HC
	High alloy	< 350	< 1200	HC	LC
	Hardened, HRC < 45			HC	LC
	Hardened, HRC < 55			HC	LC
	Hardened, HRC < 65			HC	LC
Cast iron	Lamellar graphite	< 150	< 500	LC	HC
	Lamellar graphite	< 300	< 1000	LC	HC
	Nodular graphite, malleable	< 200	< 700	LC	HC
	Nodular graphite, malleable	< 300	< 1000	LC	HC
Stainless steel	Free machining	< 250	< 850	HC	LC
	Austenitic	< 250	< 850	HC	LC
	Ferritic and austenitic	< 300	< 1000	HC	LC
Titanium	Unalloyed	< 200	< 700	HC	LC
	Alloyed	< 270	< 900	HC	LC
	Alloyed	< 350	< 1250	HC	LC
Nickel	Unalloyed	< 150	< 500	LC	HC
	Alloyed	< 270	< 900	HC	LC
	Alloyed	< 350	< 1250	HC	LC
Copper	Unalloyed	< 100	< 350	LC	HC
	Brass, bronze	< 200	< 700	LC	HC
	High strength bronze	< 470	< 1500	HC	LC
Aluminium	Unalloyed	< 100	< 350	LC	HC
	Alloyed, Si < 0.5%	< 150	< 500	LC	HC
	Alloyed, Si < 10%	< 120	< 400	LC	HC
	Alloyed, Si > 10%	< 120	< 400	LC	HC
Inconel	718	< 370		HC	LC
Graphite				LC	HC