

NEW

CORUN

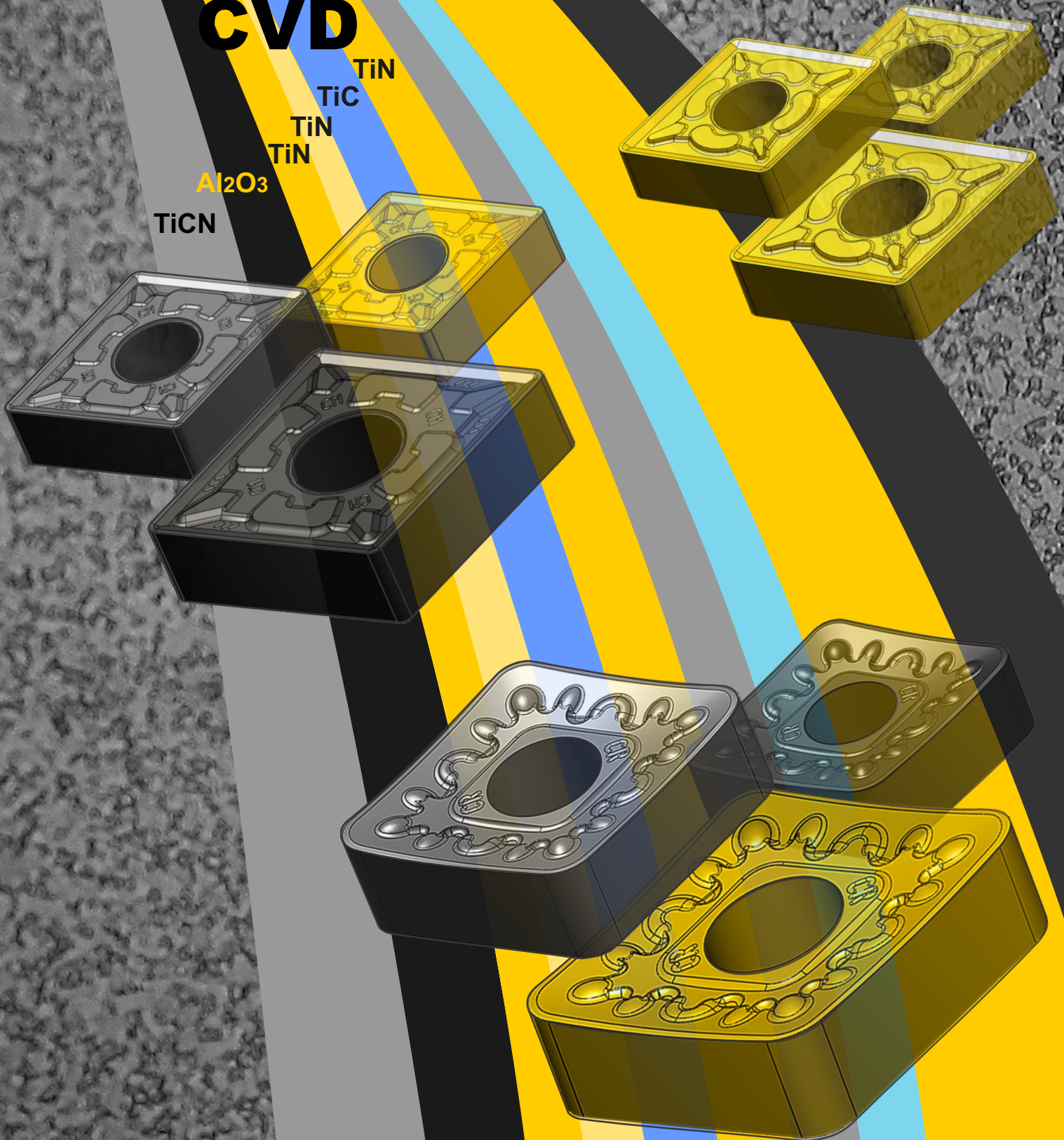
COATINGS CVD, PVD

PVD

TiAlN
TiN
TiCN+TiN
TiAlN+TiN
TiCN

CVD

TiN
TiC
TiN
TiN
Al₂O₃
TiCN



Područje Primerne Application area	UPOREDNA TABELA SORTI TVRDOG METALA UKOPAVANJE COMPARISON TABLE OF HARD METAL GRADES GROOVING						UPOREDNA TABELA SORTI TVRDOG METALA NAVOJ COMPARISON TABLE OF HARD METAL GRADES THREADING						UPOREDNA TABELA SORTI TVRDOG METALA BUŠENJE COMPARISON TABLE OF HARD METAL GRADES BORING					
	CORUN		SANDVIK		ISCAR		CORUN		SANDVIK		ISCAR		CORUN		SANDVIK		ISCAR	
	Nepresv. Uncoat.	CVD	PVD	Nepresv. Uncoat.	CVD	PVD	Nepresv. Uncoat.	CVD	PVD	Nepresv. Uncoat.	CVD	PVD	Nepresv. Uncoat.	CVD	PVD	Nepresv. Uncoat.	CVD	PVD
P	01																	
	10	2C15	GC3115		IC428	IC570		715 7520			GC4125						IC9080	
	20	4C25	GC3020 GC4225 GC4025		IC9015 IC9025	IC528 IC907		515 520			GC1020			2C25	720			IC908 IC328 IC528
	30	2C35	GC2135	GC4125	IC9054 IC1008	IC908 IC354 IC1008								2C40	515 520 7535	GC1020 GC1120		IC1008
	40	2C40		GC2125		IC328		6535										
M	10	K13A		H13A		IC20												
	20				IC08	IC570		715 7520 520			GC4125 GC1020			2C25	720		GC3040	IC28
	30	2C35	GC2135	GC4125		IC1008 IC1028 IC328		6535						7520				IC1008 IC328
	40													2C40	515 520 620	GC1020 GC1120		
K	01																	
	10	2C15	GC3020 GC3115		IC428 IC418			715 7520			GC1020 GC4125							IC9080
	20	K13A	H13A		IC9015	IC1008		515 520	K13A					2C25	620		GC3040	IC1008 IC350 IC908
	30					IC908 IC228		6535							7535			
N	40																	
		K13A		H10 H13A		IC20 IC08		715 515 520	K13A									IC908
S		2C35	GC2135	GC4125		IC908 IC228 IC328		715 515 520 7520 6535	K13A									IC908 IC328
		K13A	H10 H13A			IC20 IC08												
H								715 7520 520						2C25	515 520 620 720	GC1020 GC1120		IC908 IC328
																		IC908 IC1008

CORUN Coatings

Thin multilayer coatings

Layer thickness 5-6µm

CVD

CODE	ISO	COATING LAYERS	RECOMMENDED APPLICATION	Turning	Milling	Parting	Grooving	Threading	Boring
2C15	K20,M25		Machining of gray and nodular cast iron at medium and high cutting speed	●	●	○	○		
2C20	P20,M25		For medium roughing and finishing of carbonated steel, gray cast iron and stainless steel	○	●				
2C25	P25,M25		For finishing and medium rough machining of austenite and stainless steel, at medium cutting speed. Grade is resistant to thermal and mechanical shocks as well as interrupted cutting	●	●				●
2C35	P35,M25		For finishing and medium rough machining of tough materials at medium cutting speed. Grade is resistant to thermal and mechanical shocks as well as for interrupted cutting	●	●	●	●		
2C40	P40,M40		Very tough grade for machining of abrasive stainless steel	●	●	●	●		○

Thick multilayer coatings

Layer thickness 12-18µm

CVD

3C15	P10,K15		Best choice for machining of all types of cast iron at low and medium cutting speed. Especially good for interrupted cutting	●	○				
4C15	P15,K15		For finishing and medium machining of: steel, cast steel, gray and nodular cast iron under all conditions of operation. Perfect for usage with cooling emulsion in P15 application field	●					
4C25	P25,K25		For medium and rough machining of steel and cast steel with large chips and unfavorable cutting conditions. Very good for use in P25 application field as well for stainless steel and gray cast iron	●		○	○		
4C35	P35		For medium and finishing of cast stainless steel. Good resistance against heating and interrupted cutting. High toughness and resistance against plastic deformation. Excellent for work under the hard conditions in P35 application field	●					
4C40	P40		For machining of stainless steel at low cutting speed under the hard machining conditions	●					

PVD

CODE	ISO	COATING LAYERS	LAYER THICKNESS	RECOMMENDED APPLICATION	Turning	Milling	Parting	Grooving	Threading	Boring
515	P15,M15 K15		1-2µm	Universal grade for different materials					○	○
520	P20,M20 K15		1-2µm	For low carbonated steel with medium cutting speed		○			●	●
620	P40,M20		2-3µm	For boring of wide range of materials						●
635	P25,M25		2-3µm	For machining of stainless steel and heavy turning at high cutting speed. For milling of wide range of materials	●	○				
715	P15,K15 M15		2-3µm	For turning of austenite stainless steel at high cutting speed	●	●			○	
720	P15,M20 K25,N		2-3µm	For machining of heat resistant alloys and austenite stainless steel at medium and high speed under unfavorable work conditions		○	●			○
735	P40		2-3µm	For milling of stainless steel under the hard work conditions		●				
6515	M25,S15		4µm	For stainless steel, heat resistant alloys and hard materials				●		
6520	P20,M20 N,S,H		4µm	For milling of steel and cast steel		○	●			
6535	P35,M35 K35		4µm	For all types of materials at mild operation conditions					●	
7515	M15		4µm	For machining of stainless steel at medium cutting speed			○	○		
7520	P30,M25 K30,S,H		4µm	Universal grade for many kind of materials	○	○	●	●	●	○
7535	P45,M40		4µm	For hard operating conditions at lower speed	○	○	○	○		●

● First priority ○ Second priority

CORUN Presvlake

Tanke multilayer presvlake

Debljina sloja 5-6µm

CVD

OZNAKA	ISO	SLOJEVI PRESVLAKE	PREPORUČENA PRIMENA	Struganje	Glodanje	Odsecanje	Ukopavanje	Navoj	Bušenje
2C15	K20,M25		Za obradu sivog i nodularnog liva, pri srednjim i velikim brzinama rezanja	●	●	○	○		
2C20	P20,M25		Za srednje grubu i finu obradu ugljeničnog čelika, sivog liva i nerđajućeg čelika	○	●				
2C25	P25,M25		Za finu do srednje grubu obradu austenitnog i nerđajućeg čelika, sa umerenim brzinama rezanja. Sorta dobro otporna na termičke i mehaničke šokove i prekidno rezanje	●	●				●
2C35	P35,M25		Za finu do srednje grubu obradu žilavih materijala, sa umerenim brzinama rezanja. Sorta dobro otporna na termičke i mehaničke šokove i prekidno rezanje	●	●	●	●		
2C40	P40,M40		Veoma žilava sorta za obradu abrazivnog nerđajućeg čelika	●	●	●	●		○

Debele multilayer presvlake

Debljina sloja 12-18µm

CVD

3C15	P10,K15		Najbolji izbor za obradu svih vrsta livenog gvožđa, pri malim i srednjim brzinama rezanja. Posebno dobro podnosi prekidno rezanje	●	○				
4C15	P15,K15		Za finu i srednje grubu obradu: čelika, čeličnog liva, sivog i nodularnog livenog gvožđa u svim uslovima rada. Idealan uz upotrebu emulzije za hlađenje u P15 području	●					
4C25	P25,K25		Za srednje do grube obrade čelika i čeličnog liva sa velikom strugotinom i nepovoljnim uslovima rezanja. Veoma dobar u P25 području kao i za nerđajući čelik i sivi liv	●		○	○		
4C35	P35		Za srednje do fine obrade livenog nerđajućeg čelika. Dobra otpornost na termalne šokove i prekidno rezanje. Velika žilavost i otpornost na plastičnu deformaciju. Odličan za teške režime rada u P35 području	●					
4C40	P40		Za obradu nerđajućih čelika sa manjim brzinama u teškim uslovima obrade	●					

PVD

OZNAKA	ISO	SLOJEVI PRESVLAKE	DEBLJINA SLOJA	PREPORUČENA PRIMENA	Struganje	Glodanje	Odsecanje	Ukopavanje	Navoj	Bušenje
515	P15,M15 K15		1-2µm	Univerzalna sorta za različite materijale					○	○
520	P20,M20 K15		1-2µm	Za niskougljenične čelike sa srednjom brzinom rezanja		○			●	●
620	P40,M20		2-3µm	Za bušenje kao periferna pločica u širokoj lepezi materijala						●
635	P25,M25		2-3µm	Za struganje nerđajućeg čelika i teško struganje sa velikom brzinom rezanja. Za glodanje široke lepeze materijala	●	○				
715	P15,K15 M15		2-3µm	Za struganje austenitnog nerđajućeg čelika sa velikom brzinom rezanja	●	●			○	
720	P15,M20 K25,N		2-3µm	Za obradu toplootpornih legura i austenitnog nerđajućeg čelika pri srednjim i velikim brzinama uz nepovoljne uslove rada	○	●	●			○
735	P40		2-3µm	Za glodanje nerđajućeg čelika pri teškim uslovima rada		●				
6515	M25,S15		4µm	Za nerđajući čelik, toplo otporne legure i tvrde materijale					●	
6520	P20,M20 N,S,H		4µm	Za glodanje čelika i čeličnog liva	○	●				
6535	P35,M35 K35		4µm	Za sve vrste materijala uz lakše uslove rada						●
7515	M15		4µm	Za obradu nerđajućeg čelika uz srednje brzine rezanja			○	○		
7520	P30,M25 K30,S,H		4µm	Univerzalna sorta za mnoge vrste materijala.	○	○	●	●	●	○
7535	P45,M40		4µm	Za teške uslove rada pri manjim brzinama	○	○	○	○		●

● Prvi prioritet ○ Drugi prioritet