

PC6510 ^{New}



Milling Inserts for Cast Iron

The specialized grade for multi-purpose milling applications of cast iron

Excellent Surface Finish

Specially prepared surface provides mirror like finish on workpieces

Stable Tool Life

Optimized PVD coating for cast iron minimizes tool life deviation

High Speed and Feed Capability for Higher Productivity



PVD-coated Insert Specialized for Milling Applications of Cast Iron

New PC6510



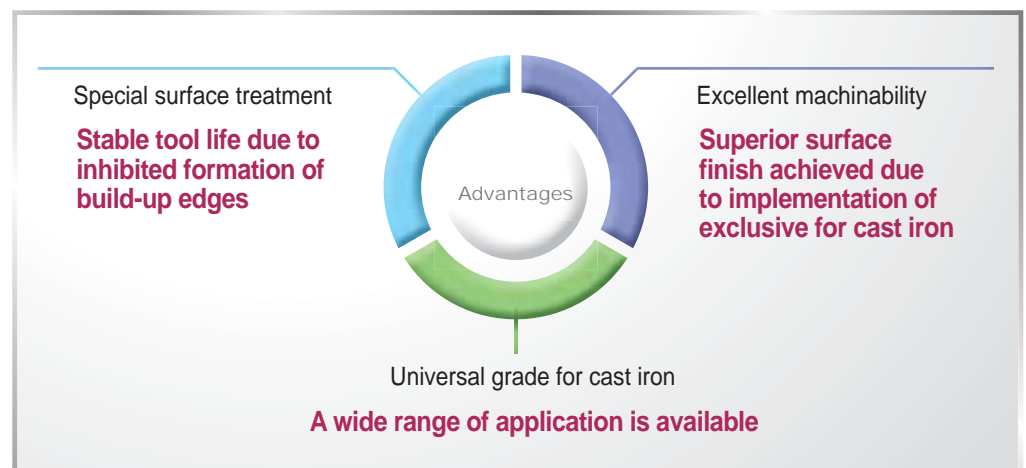
New PC6510

For multi-purpose cutting of cast iron

Cast iron is characterized by heavy chip breaking during milling. Wear is more rapid on the relief surface where the contact time with the workpiece is relatively long while the cutting load on the flank surface is low. In addition, graphite contained in cast iron causes a lot of dust during cutting. To prevent dust, the machining process is mainly done wet, however, there are still chances of thermal cracking on cutting edges due to the thermal impact of the cutting fluids to the inserts. Melted and compressed chips on the surface of inserts create uneven chipping, making the tool life unstable.

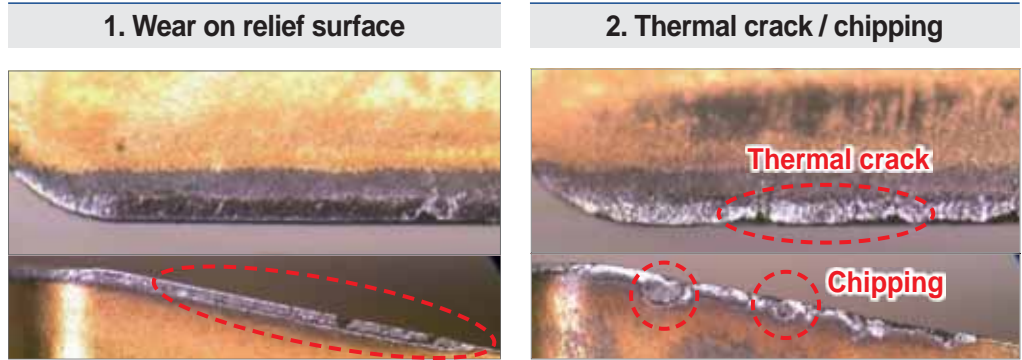
Now KORLOY offers a new milling grade to provide more stable machining for cast iron.

The **NEW PC6510** has PVD coating optimized for multi-purpose machining of cast iron, which also can be used to inhibit heat cracks. Special surface treatment also prevents chips from melting or compressing onto inserts, providing mirror-like surface finish and stable tool life.



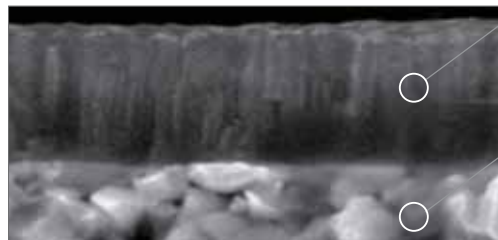
⇒ Problems When Machining Cast Iron

- Excessive wear on relief surface due to friction between graphite particles and cutting edge.



⇒ Development of New PC6510

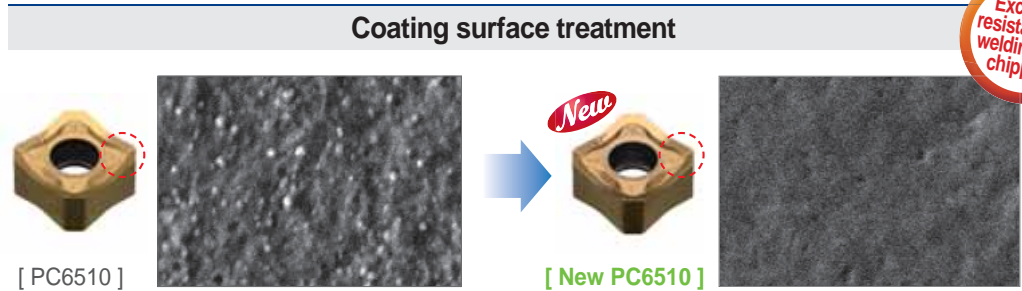
PVD coatings specialized for cast iron



- Stable machinability due to the highly wear-resistant TiAlN coating of toughness
- Minimized life deviation due to the thermal crack-resistant material optimized for cast iron

Excellent wear resistance and stable tool life

- Improved surface finish due to coating surface treatment
Stronger resistance to welding and chipping



Excellent resistance to welding and chipping

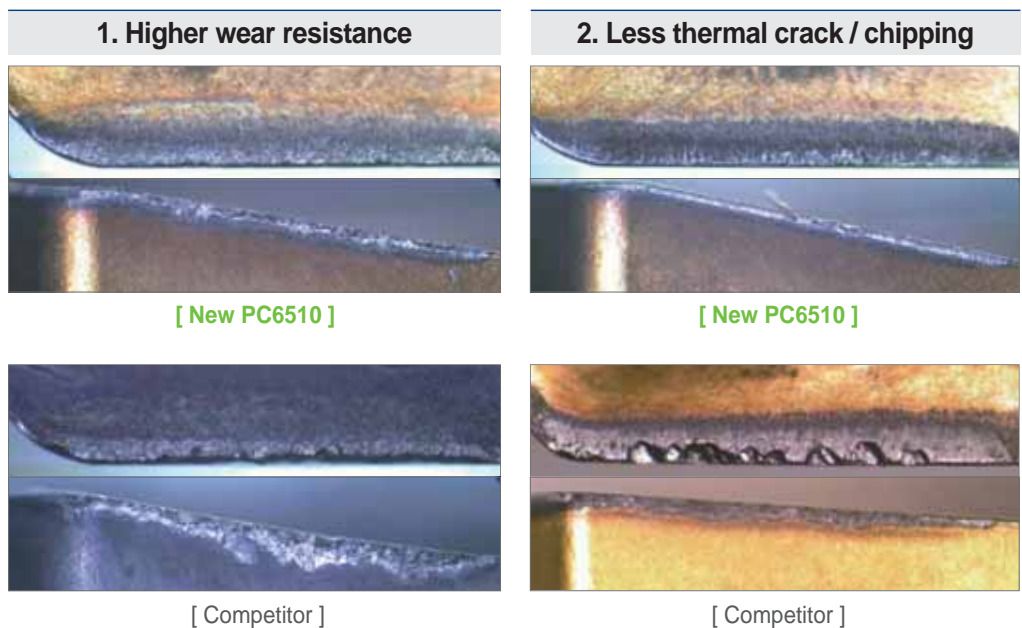
⇒ Development Effects

[Evaluation of wear resistance]

Workpiece
500-7
Cutting conditions
vc(m/min) = 200
fz(mm/t) = 0.2
ap(mm) = 1.0
ae(mm) = 120, wet
Tools
SNMX1206ANN-MF
RM8ACM4125HR-M

[Evaluation of thermal crack]

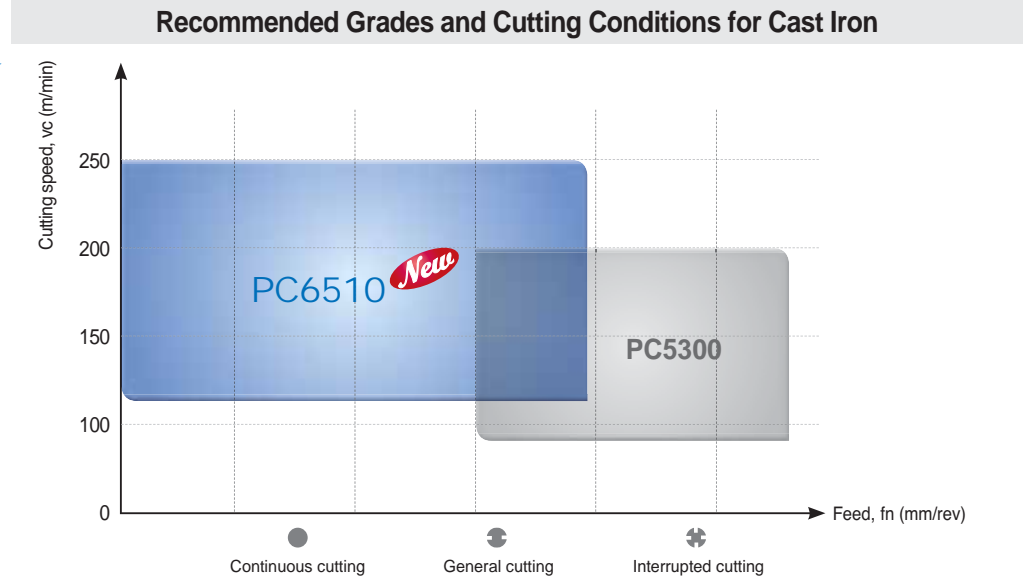
Workpiece
600-3
Cutting conditions
vc(m/min) = 180
fz(mm/t) = 0.2
ap(mm) = 1.0
ae(mm) = 20, wet
Tools
SNMX1206ANN-MF
RM8ACM4063HR-M



⇒ Grades Application Range

• New PC6510

- Surface treatment on the rake surface of insert
- Excellent resistance to thermal cracks
- High speeds and interrupted machining available
- Reduced fine chipping from compression






⇒ Grade Guideline by Workpiece Type for Cylinder Blocks

• New PC6510



- For multi-purpose machining of cast iron
- For general cutting

• PC5300

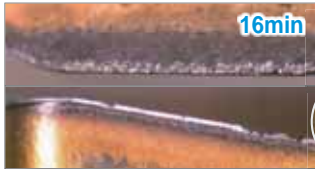
- For interrupted machining
- For unstable machining

Specification	General cutting	Multi-purpose	High interruptions
Grade	New PC6510	New PC6510	PC5300
Workpiece material	Gray cast iron, ductile cast iron	Gray cast iron, ductile cast iron	Gray cast iron, ductile cast iron
Machining type	General cutting for wide areas	Multi-purpose cutting for various shapes	Highly interrupted and unstable cutting
Workpiece type	Top & Bottom face 	Front & Rear face 	Bosses 

⇒ Grade Guideline by Workpiece Type for Crank Shafts

Specification	Roughing (pin miller)		Finishing (pin miller)	
	New PC6510	PC5300	New PC6510	PC5300
Workpiece material	Cast iron	Cast iron, steel	Cast iron, steel	Steel
Wear type	Wear on relief surface, thermal crack, chipping	Edge chipping, thermal crack, breakage	Wear on relief surface	Wear on relief surface, chipping
Workpiece type	Pin & Journal 		Pin-Grooving 	

⇒ Cutting Performance



[New PC6510]

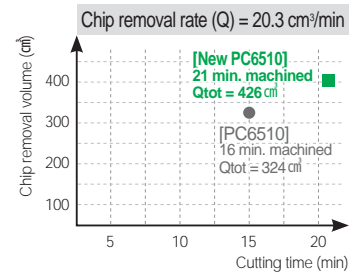


[PC6510]



Performance Evaluation of New PC6510 (Rich Mill)

Workpiece 600-3
 Cutting conditions vc (m/min) = 200
 fz (mm/t) = 0.2
 ap (mm) = 2.0
 ae (mm) = 100
 Tools Insert : SNMX1206ANN-MF
 Holder : RM8AC4125HR-M



➔ 30% more cutting volume compared to the existing PC6510



[New PC6510]

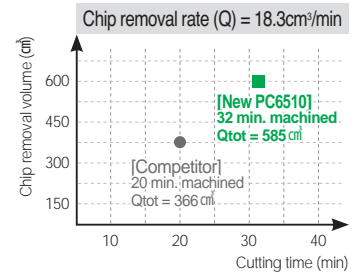


[Competitor]



Performance Evaluation of New PC6510 (Rich Mill)

Workpiece 700-2
 Cutting conditions vc (m/min) = 180
 fz (mm/t) = 0.2
 ap (mm) = 2.0
 ae (mm) = 100
 Tools Insert : SNMX1206ANN-MF
 Holder : RM8ACM4063HR-H



➔ 60% more cutting volume compared to the competitor



[New PC6510]

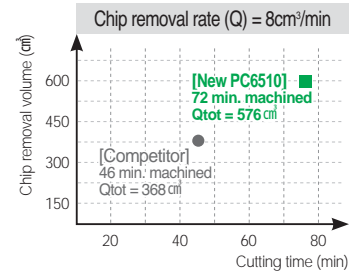


[Competitor]



Performance Evaluation of New PC6510 (Rich Mill)

Workpiece 700-2
 Cutting conditions vc (m/min) = 200
 fz (mm/t) = 0.2
 ap (mm) = 2.0
 ae (mm) = 20
 Tools Insert : SNMX1206ANN-MF
 Holder : RM8ACM4063HR-H



➔ 56% more cutting volume compared to the competitor



[New PC6510]

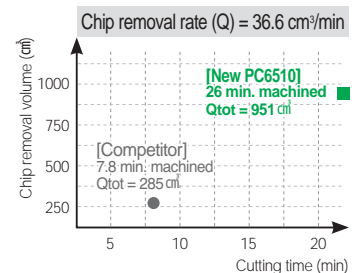


[Competitor]



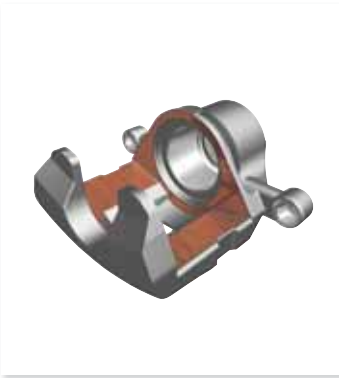
Performance Evaluation of New PC6510 (ISO)

Workpiece 250
 Cutting conditions vc (m/min) = 200
 fz (mm/t) = 0.2
 ap (mm) = 3.0
 ae (mm) = 120
 Tools Insert : SPCN1203EDSR-RH
 Holder : EPNM4125R



➔ 233% more cutting volume compared to the competitor

➔ Application Examples



Automotive components (Brake Housing)

Workpiece	Cast iron (500-7)
Cutting conditions	vc (m/min) = 238, fz (mm/t) = 0.1, ap (mm) = 2.0, ae (mm) = 100, wet
Tool	Insert : CNHQ1305-C1.0-HG (NEW PC6510) Holder : HSG300R-T62.5R3.5-MDL

New PC6510	3000ea/corner
Competitor	2400ea/corner



➔ 25% longer tool life compared to the competitor



Automotive components (knuckle)

Workpiece	Cast iron (700-2)
Cutting conditions	vc (m/min) = 210, fz (mm/t) = 0.16, ap (mm) = 2.5, ae (mm) = 100, wet
Tool	Insert : SNEX150712N (NEW PC6510) Holder : KSFCB1303R-D31.75-D46

New PC6510	200ea/corner
Competitor	160ea/corner



➔ 25% longer tool life compared to the competitor



Automotive components (exhaust manifold)

Workpiece	Cast iron (400-18)
Cutting conditions	vc (m/min) = 188, fz (mm/t) = 0.2, ap (mm) = 2.0, ae (mm) = 20, wet
Tool	Insert : SDXT09M405R-MM (NEW PC6510) Holder : FMPCM3100HS

New PC6510	190ea/corner
Competitor	150ea/corner



➔ 26% longer tool life compared to the competitor



Automotive components (bearing cap)


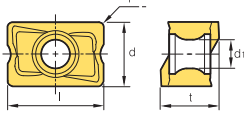

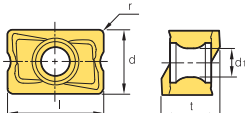

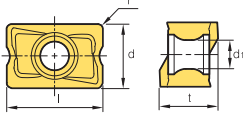

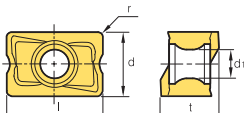

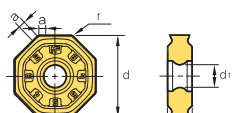

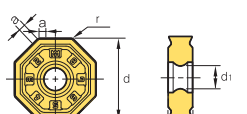

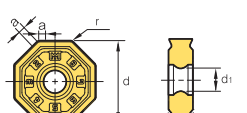

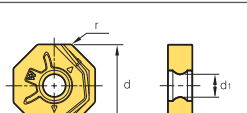

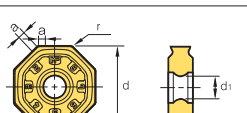
Workpiece	Cast iron (500-7)
Cutting conditions	vc (m/min) = 250, fz (mm/t) = 0.15, ap (mm) = 1.0, ae (mm) = 120, wet
Tool	Insert : SNCF1206QNN-MF (NEW PC6510) Holder : RMT8Q4100R-M

New PC6510	200ea/corner
Competitor	160ea/corner




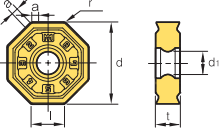

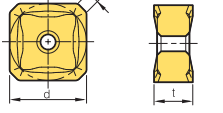

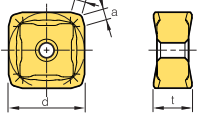

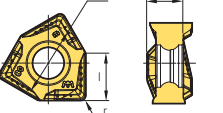

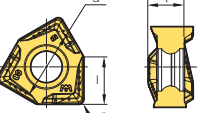

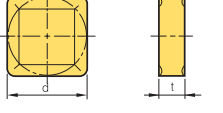

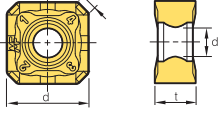

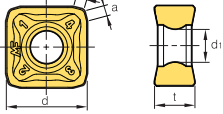

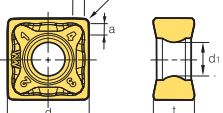

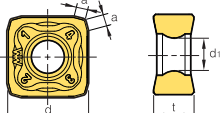

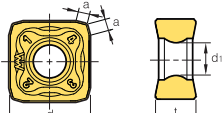
➔ 25% longer tool life compared to the competitor

 Available Stock

Type	Shape	Designation		Grade	Dimensions (mm)						Figure			
				PC6510 <small>New</small>	l	d	t	r	d ₁	a				
Rich Mill		LNM(E)X	LNMX	100605PNR-MF	●	10.0	6.5	6.5	0.5	3.5	-			
				100608PNR-MF	●	10.0	6.5	6.5	0.8	3.5	-			
		LNEX	100605PNR-MF	●	10.0	6.5	6.5	0.5	3.5	-				
			100608PNR-MF	●	10.0	6.5	6.5	0.8	3.5	-				
		LNM(E)X	LNMX	151004PNR-MF	●	15.0	10.0	10.0	0.4	4.5	-			
					151008PNR-MF	●	15.0	10.0	10.0	0.8	4.5			-
					151016PNR-MF	●	15.0	10.0	10.0	1.6	4.5			-
			LNEX	151004PNR-MF	●	15.0	10.0	10.0	0.4	4.5	-			
151008PNR-MF				●	15.0	10.0	10.0	0.8	4.5	-				
151016PNR-MF				●	15.0	10.0	10.0	1.6	4.5	-				
	LNM(E)X	LNMX	100605PNR-MM	●	10.0	6.5	6.5	0.5	3.5	-				
				100608PNR-MM	●	10.0	6.5	6.5	0.8	3.5		-		
				100605PNL-MM	●	10.0	6.5	6.5	0.5	3.5		-		
		LNEX	100605PNR-MM	●	10.0	6.5	6.5	0.5	3.5	-				
			100608PNR-MM	●	10.0	6.5	6.5	0.8	3.5	-				
			100605PNL-MM	●	10.0	6.5	6.5	0.5	3.5	-				
	LNM(E)X	LNMX	151004PNR-MM	●	15.0	10.0	10.0	0.4	4.5	-				
				151008PNR-MM	●	15.0	10.0	10.0	0.8	4.5		-		
				151016PNR-MM	●	15.0	10.0	10.0	1.6	4.5		-		
		LNEX	151004PNR-MM	●	15.0	10.0	10.0	0.4	4.5	-				
			151008PNR-MM	●	15.0	10.0	10.0	0.8	4.5	-				
			151016PNR-MM	●	15.0	10.0	10.0	1.6	4.5	-				
			151008PNL-MM	●	15.0	10.0	10.0	0.8	4.5	-				
	ONHX	060608-MF	●	6.6	16.0	6.0	0.8	5.6	-					
		080608-MF	●	8.4	20.2	6.0	0.8	5.6	-					
		0606ANN-MF	●	6.6	16.0	6.0	0.8	5.6	1.03					
		0806ANN-MF	●	8.4	20.2	6.0	0.8	5.6	1.53					
	ONHX	060608-MM	●	6.6	16.0	6.0	0.8	5.6	-					
		080608-MM	●	8.4	20.2	6.0	0.8	5.6	-					
		0606ANN-MM	●	6.6	16.0	6.0	0.8	5.6	1.03					
		0806ANN-MM	●	8.4	20.2	6.0	0.8	5.6	1.53					
	ONHX	060608-MA	●	6.6	16.0	6.0	0.8	5.6	-					
		080608-MA	●	8.4	20.2	6.0	0.8	5.6	-					
	ONHX	060608-W	●	6.5	16.0	6.0	0.8	5.6	-					
		080608-W	●	8.2	20.2	6.0	0.8	5.6	-					
	ONMX	060608-MF	●	6.6	16.0	6.0	0.8	5.6	-					
		080608-MF	●	8.4	20.2	6.0	0.8	5.6	-					
		0606ANN-MF	●	6.6	16.0	6.0	0.8	5.6	1.03					
		0806ANN-MF	●	8.4	20.2	6.0	0.8	5.6	1.53					


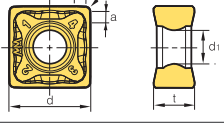

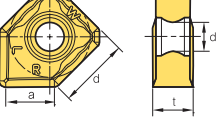

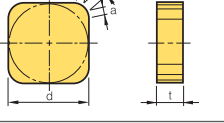

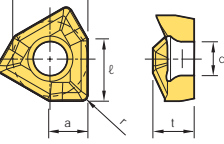

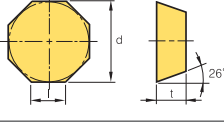

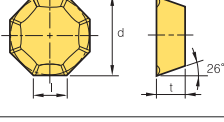

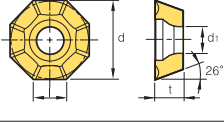

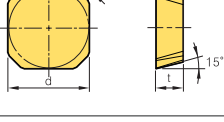
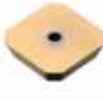
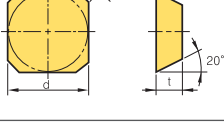

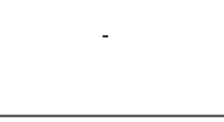
: Stock item

Available Stock

Type	Shape	Designation		Grade	Dimensions (mm)						Figure	
				PC6510	l	d	t	r	d ₁	a		
Rich Mill		ONMX	060608-MM	●	6.6	16.0	6.0	0.8	5.6	-		
			080608-MM	●	8.4	20.2	6.0	0.8	5.6	-		
		0606ANN-MM	●	6.6	16.0	6.0	0.8	5.6	1.03			
		0806ANN-MM	●	8.4	20.2	6.0	0.8	5.6	1.53			
		SNCF	1507ANN-MF	●	-	15.875	7.35	-	-	2.1		
			1206ENN-MF	●	-	12.7	6.6	-	-	1.8		
			1507ENN-MF	●	-	15.875	7.35	-	-	1.8		
			1206QNN-MF	●	-	12.7	6.6	0.8	-	1		
		SNCF	1206QNN-MM	●	-	12.7	6.6	0.8	-	1		
		WNGX	040304PNER-ML		4.3	7.0	3.46	0.4	-	-		
			040308PNER-ML		4.3	7.0	3.46	0.8	-	-		
			080604PNER-ML		8.2	13.0	6.4	0.4	-	-		
			080608PNER-ML		8.2	13.0	6.4	0.8	-	-		
		WNGX	040304PNSR-MM		4.3	7.0	3.46	0.4	-	-		
			040308PNSR-MM		4.3	7.0	3.46	0.8	-	-		
			080604PNSR-MM		8.2	13.0	6.4	0.4	-	-		
			080608PNSR-MM		8.2	13.0	6.4	0.8	-	-		
		SNEF	435	●	-	12.7	4.76	2.0	-	-		
		SNM(E)X	SNMX	1206ANN-MF	●	-	12.7	6.35	-	4.5	2.36	
				1507ANN-MF	●	-	15.875	7.94	-	5.6	3.15	
			SNEX	1206ANN-MF	●	-	12.7	6.35	-	4.5	2.36	
				1507ANN-MF	●	-	15.875	7.94	-	5.6	3.15	
		SNM(E)X	SNMX	1206ENN-MF	●	-	12.7	6.35	-	4.5	1.82	
				1507ENN-MF	●	-	15.875	7.94	-	5.6	2.66	
			SNEX	1206ENN-MF	●	-	12.7	6.35	-	4.5	1.82	
				1507ENN-MF	●	-	15.875	7.94	-	5.6	2.66	
		SNM(E)X	SNMX	1206QNN-MF	●	-	12.7	6.35	-	5.2	2.36	
				120612-MF	●	-	12.7	6.35	1.2	5.2	-	
			SNEX	1206QNN-MF	●	-	12.7	6.35	-	5.2	2.36	
				120612-MF	●	-	12.7	6.35	1.2	5.2	-	
		SNM(E)X	SNMX	1206ANN-MM	●	-	12.7	6.35	-	4.5	2.36	
				1507ANN-MM	●	-	15.875	7.94	-	5.6	3.15	
SNEX			1206ANN-MM	●	-	12.7	6.35	-	4.5	2.36		
			1507ANN-MM	●	-	15.875	7.94	-	5.6	3.15		
	SNM(E)X	SNMX	1206ENN-MM	●	-	12.7	6.35	-	5.2	1.82		
			1507ENN-MM	●	-	15.875	7.94	-	5.6	2.66		
		SNEX	1206ENN-MM	●	-	12.7	6.35	-	5.2	1.82		
			1507ENN-MM	●	-	15.875	7.94	-	5.6	2.66		


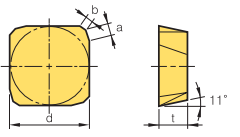


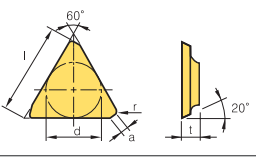

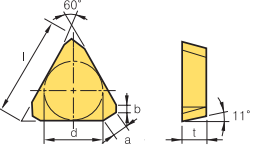

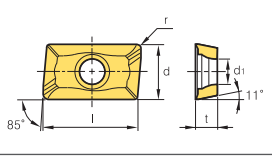

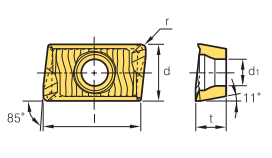

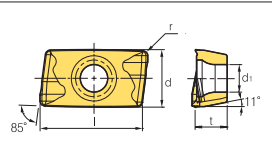

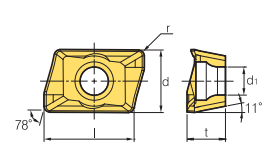

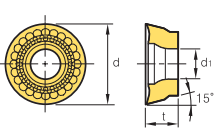

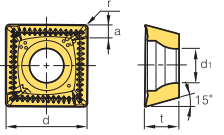
: Stock item

➔ Available Stock

Type	Shape	Designation		Grade	Dimensions (mm)							Figure	
				PC6510	l	d	t	r	d ₁	a	b		
Rich Mill		SNM(E)X	SNMX 1206QNN-MM	●	-	12.7	6.35	-	4.5	2.36	-		
			120612-MM	●	-	12.7	6.35	1.2	4.5	-	-		
		SNEX	1206QNN-MM	●	-	12.7	6.35	-	4.5	2.36	-		
			120612-MM	●	-	12.7	6.35	1.2	4.5	-	-		
		SNEX	1206ANN-W	●	-	12.7	6.35	-	4.5	7.6	-		
		SNKN	1204ENN	●	-	12.7	4.76	-	-	1.4	1.0		
		XNKT	060405PNER-ML	●	5.7	6.5	4.0	0.5	3.4	1.8	-		
			060408PNER-ML	●	5.7	6.5	4.0	0.8	3.4	1.8	-		
080508PNER-ML			●	8.2	10.0	5.5	0.8	4.5	2.9	-			
120608PNER-ML			●	12.0	13.0	6.5	0.8	5.5	3.5	-			
XNKT		060405PNSR-MM	●	5.7	6.5	4.0	0.5	3.4	1.8	-			
		060408PNSR-MM	●	5.7	6.5	4.0	0.8	3.4	1.8	-			
		080508PNSR-MM	●	8.2	10.0	5.5	0.8	4.5	2.9	-			
		120608PNSR-MM	●	12.0	13.0	6.5	0.8	5.5	3.5	-			
	OFCN	0704SN	●	7.4	18	4.86	0.5	-	-	-			
		OFKR	0704SN-MM	●	19/64	45/64	3/16	3/128	-	-		-	
		OFKT	05T3SN-MF	●	5.2	12.7	3.97	0.5	4.4	-		-	
	SDCN	1504AEEN-RH	●	-	15.875	4.76	-	-	1.5	-			
		1504AESN-RH	●	-	15.875	4.76	-	-	1.43	-			
	SECN	1203AFEN-RH	●	-	12.7	3.18	-	-	2.36	-			
		1504AFSN-RH	●	-	15.875	4.76	-	-	2.4	-			
	SFKN	12T3AZEN	●	-	12.7	3.97	-	-	2.2	-			


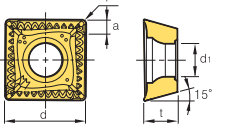

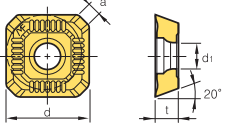

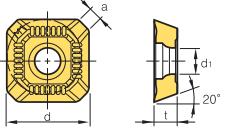

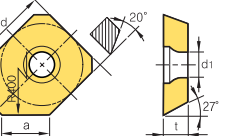

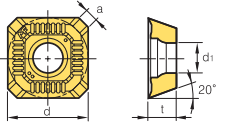

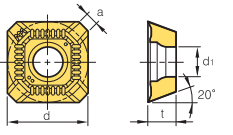

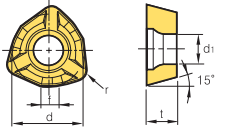

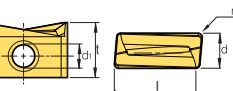
: Stock item

Available Stock

Type	Shape	Designation		Grade	Dimensions (mm)						Figure		
					PC6510	l	d	t	r	d ₁		a	b
ISO		SPCN	1203EDER-RH	●	-	12.7	3.18	-	-	1.63	0.8		
			1203EDSR-RH	●	-	12.7	3.18	-	-	1.63	0.8		
			1504EDL	●	-	15.875	4.76	-	-	1.4	1.0		
			1504EDER-RH	●	-	15.875	4.76	-	-	1.64	0.8		
			1504EDSR-RH	●	-	15.875	4.76	-	-	1.64	0.8		
		SPGN	090308	●	-	9.525	3.18	0.8	-	-	-	-	
		TEEN	43TR	●	22.0	12.7	4.76	0.8	-	1.5	-		
		TPCN	1603PPN	●	16.5	9.525	3.18	-	-	1.2	1.2		
			1603PDER-RH	●	16.5	9.525	3.18	0.8	-	1.5	-		
			1603PDSR-RH	●	16.5	9.525	3.18	0.8	-	1.5	-		
2204PDER-RH			●	22.0	12.7	4.76	0.8	-	1.8	-			
2204PDSR-RH			●	22.0	12.7	4.76	0.8	-	1.8	-			
Alpha Mill		APKT	1604PDSR	●	16.4	9.525	4.76	0.8	4.4	-	-		
		APKT	1604PDSR-MM	●	16.4	9.525	5.2	0.8	4.4	-	-		
		APMT	11T3PDSR-MF	●	11.2	6.467	3.6	0.5	2.9	-	-		
			1604PDSR-MF	●	16.4	9.41	5.76	0.8	4.5	-	-		
			1806PDSR-MF	●	17.4	10.98	6.35	0.8	4.5	-	-		
		APMT	0602PDSR-MM	●	6	4.24	2.6	0.4	2.0	-	-		
			0903PDSR-MM	●	9.4	6.21	3.6	0.4	2.8	-	-		
			11T3PDSR-MM	●	11.2	6.467	3.6	0.5	2.85	-	-		
1604PDSR-MM			●	16.4	9.41	5.76	0.8	4.5	-	-			
1806PDSR-MM			●	17.4	10.98	6.35	0.8	4.5	-	-			
Future Mill		RDKT	10T3M0-MM	●	-	10	3.97	-	3.85	-	-		
			1204M0-MM	●	-	12	4.76	-	4.5	-	-		
		SDXT	09M405R-MF	●	-	9.525	4.0	0.5	4.0	1.2	-		
			130508R-MF	●	-	13.5	5.56	0.8	5.56	2.2	-		

: Stock item

➔ Available Stock

Type	Shape	Designation		Grade	Dimensions (mm)							Figure	
				PC6510 <small>New</small>	l	d	t	r	d ₁	a	f		
Future Mill		SDXT	09M405R-MM	●	-	9.525	4.0	0.5	4.0	1.2	-		
			09M405L-MM	●	-	9.525	4.0	0.5	4.0	1.2	-		
			130508R-MM	●	-	13.5	5.56	0.8	5.56	2.2	-		
		SEET	0903AGSN-MF	●	-	9.525	3.18	-	3.4	2.11	-		
			14M4AGSN-MF	●	-	14.0	4.0	-	4.4	2.64	-		
		SEET	0903AGSN-MM	●	-	9.525	3.18	-	3.4	2.11	-		
			14M4AGSN-MM	●	-	14.0	4.0	-	4.4	2.64	-		
		SEEW	14M4AGTN-W	●	-	14.0	4.0	-	4.4	8.5	-		
		SEXT	0903AGSN-MF	●	-	9.525	3.18	-	3.4	2.11	-		
			14M4AGSN-MF	●	-	14.0	4.0	-	4.4	2.64	-		
		SEXT	0903AGSN-MM	●	-	9.525	3.18	-	3.4	2.11	-		
			14M4AGSN-MM	●	-	14.0	4.0	-	4.4	2.64	-		
	HRMD		WDKT	080316ZDSR-MH	●	-	8.0	3.18	1.6	3.3	-	1.8	
				10T320ZDSR-MH	●	-	10.0	3.97	2.0	4.3	-	2.3	
				130520ZDSR-MH	●	-	13.5	5.56	2.0	5.56	-	3.1	
				150625ZDSR-MH	●	-	15.0	6.35	2.5	5.56	-	3.4	
	TP2P		LNKT	170708PNR-ML	●	16.5	7.0	11.0	0.8	4.5	-	-	

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