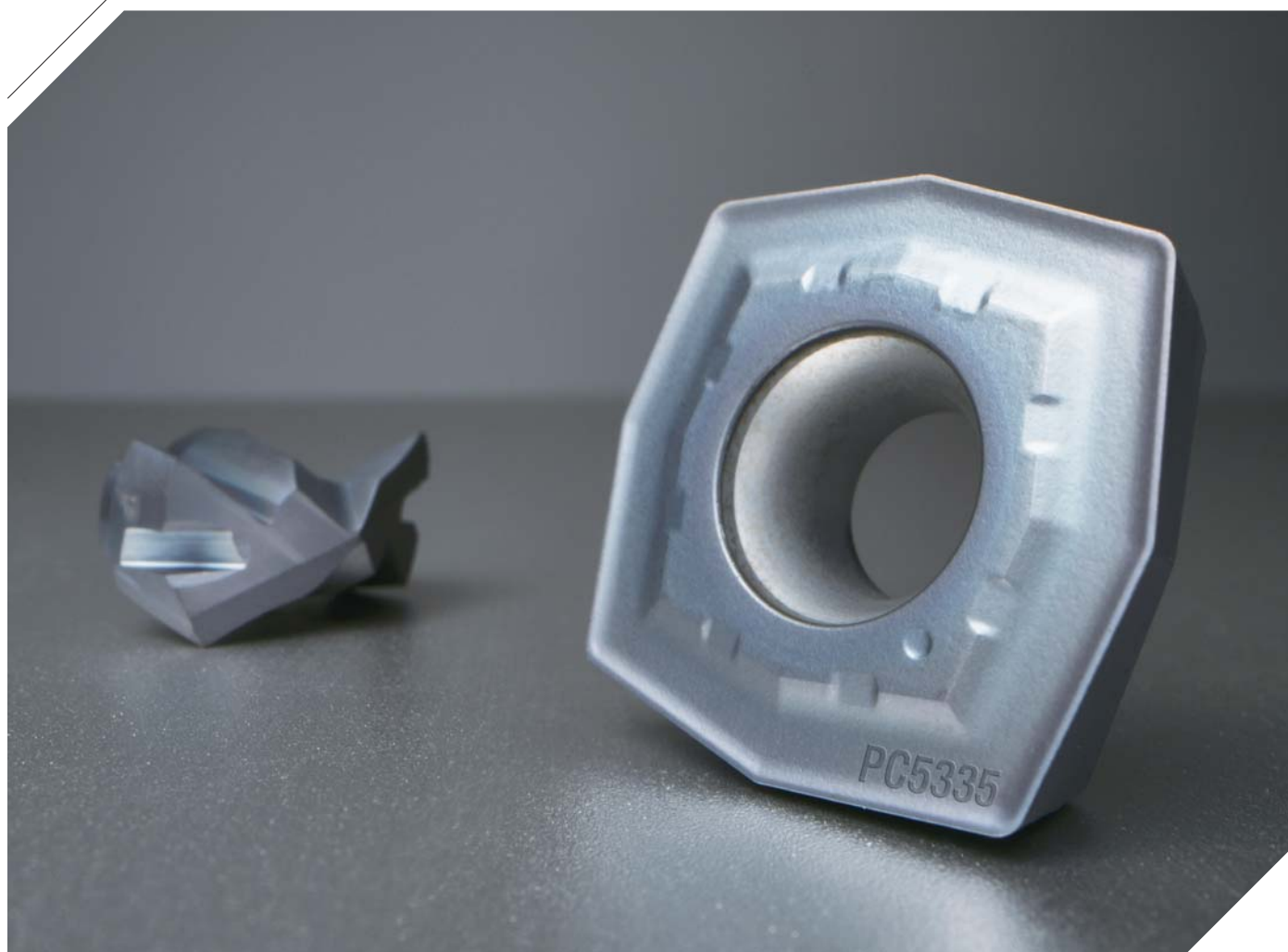


PC5335

Exclusive universal grade for indexable drill insert

- High efficient drill grade with enhanced chipping resistance and fracture resistance
- Universal grade optimized for various types of holes



Exclusive universal grade for indexable drill insert

PC5335

Holemaking is applied for various workpieces with various ways in overall industrial sectors and it requires high performance and stability for the better efficiency.

Holemaking is a difficult level machining due to frequent fracture and welding by low effective cutting speed. Therefore, a stable grade for effective drilling is necessary.

KORLOY introduces PC5335 which is an exclusive grade for indexable drill for high productivity in holemaking.

The **PC5335** is an exclusive grade for indexable drill applying for various workpieces in various cutting conditions. Especially, it shows excellent machinability in carbon steel and alloy steel drilling. The exclusive PVD coating technology, KROEX tech and cutting edge treatment technology, Point polishing tech reduce reaction between tools and chips and high toughness substrate controls chipping and fracture in tool's approaching in and out.

The PC5335, a leading grade in holemaking, provides high productivity and stable cutting quality.

» Excellent machining stability

- Applying high toughness cemented carbide substrate
- Exclusive PVD coating technology, KROEX tech

» Various workpieces

- Available for general workpieces, P, M, K, and S
- Applying special cutting edge treatment, Point polishing tech

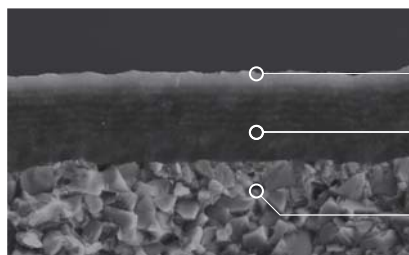


Features

PC5335

- Excellent machining stability due to high toughness ultra-fine substrate
- Enhanced cutting due to high lubricated coating layer with welding resistance
- Optimal and general grade in various drilling

Applying exclusive PVD coating KROEX tech and optimal substrate in drilling



- Good welding resistance due to applying lubricated coating layer
- Balance of wear resistance and chipping resistance from high hardness layer and high toughness layer
- Good fracture resistance and cutting stability due to optimal high toughness substrate in drilling

Point polishing tech

- Cutting stability by point polishing tech, special cutting edge treatment technology



[PC5335]

» Stable shape of cutting edge

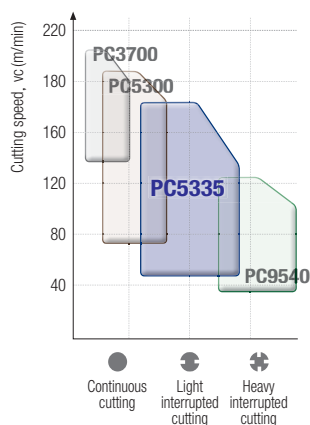


[Competitor]

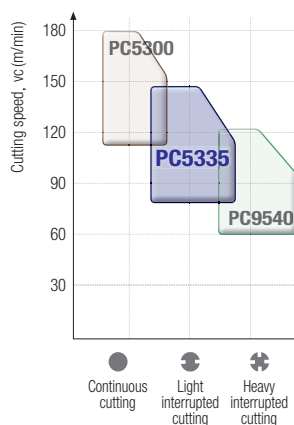
» Fracture of cutting edge due to brittleness wear

Application range_King Drill

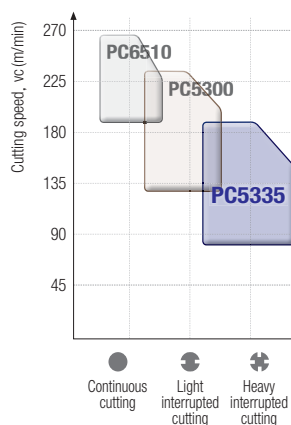
P Steel



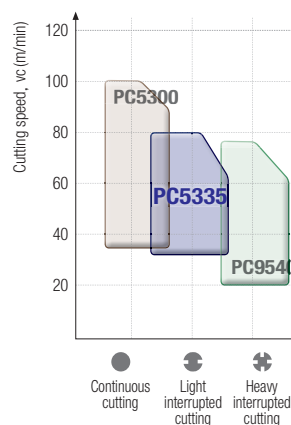
M Stainless steel



K Cast iron



S HRSA



Recommended cutting conditions _ King Drill

* quenching + tempering heat treatment

Workpiece				Specific cutting force (N/mm²)	Brinell hardness (HB)	Grade	Chip breaker			
ISO	Workpiece materials	ISO	AISI/SAE/ UNS/ASTM			PC5335	LD			
						vc (m/min)	fz (mm/t)			
							below Ø24	Ø24~29.9	over Ø30	
P	Low carbon steel	C15E4 C25 C35	1015 1025 1035	1500	120~210	60	0.30	0.35	0.40	
						120	0.15	0.25	0.30	
						170	0.10	0.20	0.25	
	Low alloy steel	20Cr4 42CrMo4 21NiCrMo2	5120 4140 8615	1700 2000*	170~270 220~360*	60	0.10	0.12	0.14	
						120	0.08	0.09	0.10	
						160	0.06	0.06	0.06	
M	Ferritic/ martensitic series	X6CrAl13 X6Cr17	405 430	1650	≤ 183	80	0.05	0.05	0.08	
						110	0.05	0.05	0.06	
						140	0.04	0.04	0.04	
		-	X12Cr13	403 410	1800	≤ 200	80	0.05	0.05	0.08
							110	0.05	0.05	0.06
							140	0.04	0.04	0.04
	Austenite series	X5CrNi18-9 X5CrNiMo17-12-2	304 316	2000	≤ 187	80	0.05	0.05	0.08	
						110	0.05	0.05	0.06	
						140	0.04	0.04	0.04	
K	Gray cast iron	150 250 350	No25B No35B No50B	900 1100 1300	≤ 212 ≤ 248 ≤ 277	130	0.15	0.20	0.28	
						170	0.10	0.14	0.20	
						230	0.05	0.08	0.12	
	Ductile cast iron	500 600 700	80-55-06 - 100-70-03	1200 1440 1650	170~241 192~269 229~302	80	0.09	0.12	0.14	
						110	0.07	0.09	0.11	
						140	0.05	0.06	0.07	
S	Ti alloy steel	TiAl5Sn2.5 TiAl6V4	R54520 R56401	1400	301~381	40	0.08	0.14	0.16	
						60	0.06	0.10	0.11	
						80	0.04	0.06	0.06	

Recommended cutting conditions _ TPDC, TPDB

* quenching + tempering heat treatment

Workpiece				Specific cutting force (N/mm²)	Brinell hardness (HB)	Grade	Chip breaker		
ISO	Workpiece materials	ISO	AISI/SAE/ UNS/ASTM			PC5335	TPDC-CP, TPDB Plus		
						vc (m/min)	fz (mm/t)		
						below Ø18	Ø18~25.9	over Ø26	
P	Low carbon steel	C15	1015	1500	120~210	60	0.30	0.35	0.40
		C25	1025			100	0.15	0.25	0.30
		C35	1035			140	0.10	0.20	0.25
	High carbon steel	C45	1045	1700 1820*	140~250 200~290*	50	0.30	0.35	0.40
		C53	1050			90	0.15	0.25	0.30
		C55	1055			130	0.10	0.20	0.25
	Low alloy steel	20Cr4	5120	1700 2000*	170~270 220~360*	60	0.40	0.43	0.48
		42CrMo4	4140			95	0.26	0.30	0.35
		21NiCrMo2	8615			130	0.13	0.18	0.23
	High alloy steel (alloy tool steel)	X100CrMoV5-1	D2	1950 3100*	200~320 480~650*	30	0.35	0.40	0.45
		X40CrMoV5-1	H13			60	0.25	0.26	0.31
		HS6-5-2	M2			90	0.13	0.15	0.20
K	Gray cast iron	150	No25B	900	≤ 212	60	0.45	0.50	0.55
		250	No35B	1100	≤ 248	100	0.32	0.37	0.42
		350	No50B	1300	≤ 277	140	0.20	0.25	0.30
	Ductile cast iron	500	80-55-06	1200	170~241	60	0.40	0.45	0.50
		600	-	1440	192~269	95	0.27	0.32	0.35
		700	100-70-03	1650	229~302	130	0.15	0.20	0.25

 Recommended cutting conditions _ WPDC

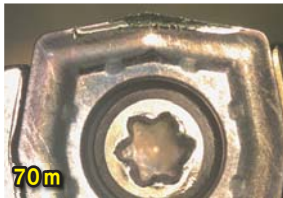
* quenching + tempering heat treatment

Workpiece				Specific cutting force (N/mm²)	Brinell hardness (HB)	Grade	Chip breaker				
ISO	Workpiece materials	ISO	AISI/SAE/ UNS/ASTM			PC5335	C20N, C21N				
						vc (m/min)	fz (mm/t)				
							below Ø30	Ø31~41	Ø41~50	Ø51~80	
P	Low carbon steel	C15	1015	1500	120~210	160	0.11	0.12	0.14	0.16	
		C25	1025			190	0.09	0.10	0.12	0.14	
		C35	1035			220	0.07	0.08	0.10	0.12	
	High carbon steel	C45	1045	1700 1820*	140~250 200~290*	110	0.11	0.12	0.14	0.16	
		C53	1050			140	0.09	0.10	0.12	0.14	
		C55	1055			170	0.07	0.08	0.10	0.12	
	Low alloy steel	20Cr4	5120	1700 2000*	170~270 220~360*	100	0.12	0.12	0.14	0.16	
		42CrMo4	4140			130	0.10	0.10	0.12	0.13	
		21NiCrMo2	8615			160	0.08	0.08	0.10	0.10	
	High alloy steel (alloy tool steel)	X100CrMoV5-1	D2	1950 3100*	200~320 480~650*	70	0.10	0.12	0.12	0.16	
		X40CrMoV5-1	H13			100	0.08	0.10	0.10	0.13	
		HS6-5-2	M2			130	0.06	0.08	0.08	0.10	
M	Ferritic/ martensitic series	X6CrAl13	405	1650	≤ 183	70	0.10	0.12	0.14	0.14	
		X6Cr17	430			100	0.08	0.10	0.12	0.13	
						130	0.06	0.08	0.10	0.12	
		-	403	1800	≤ 200	70	0.10	0.12	0.14	0.14	
			X12Cr13			410	100	0.08	0.10	0.12	0.13
							130	0.06	0.08	0.10	0.12
	Austenite series	X5CrNi18-9	304	2000	≤ 187	70	0.10	0.12	0.14	0.14	
		X5CrNiMo17-12-2	316			100	0.08	0.10	0.12	0.13	
						130	0.06	0.08	0.10	0.12	
K	Gray cast iron	150	No25B	900	≤ 212	130	0.15	0.16	0.20	0.22	
		250	No35B	1100	≤ 248	160	0.12	0.13	0.16	0.18	
		350	No50B	1300	≤ 277	190	0.09	0.10	0.12	0.14	
	Ductile cast iron	500	80-55-06	1200	170~241	110	0.15	0.16	0.20	0.22	
		600	-	1440	192~269	140	0.12	0.13	0.16	0.18	
		700	100-70-03	1650	229~302	170	0.09	0.10	0.12	0.14	
S	Ti alloy steel	TiAl5Sn2.5	R54520	1400	301~381	30	0.08	0.08	0.10	0.18	
		TiAl6V4	R56401			50	0.07	0.07	0.08	0.16	
						70	0.05	0.06	0.06	0.14	

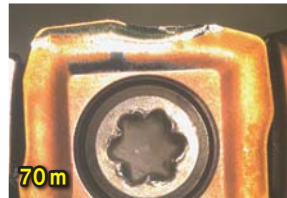
Performance evaluation

Wear resistance

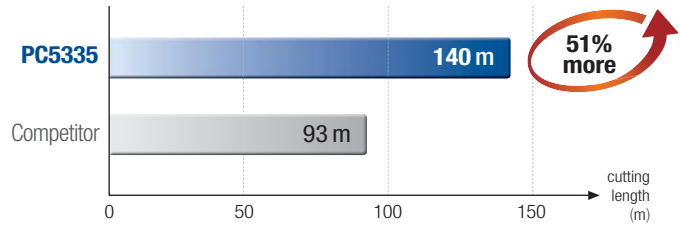
Workpiece	Carbon steel (C45)		
Cutting conditions	vc (m/min) = 150, fn (mm/rev) = 0.06, ap (mm) = 90, wet (30 bar)		
Tools	Insert XOMT07T205-LD (PC5335)	Holder	K4D21525-07



[PC5335]



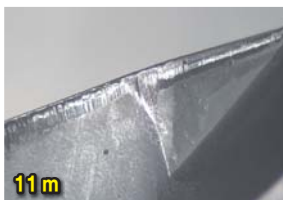
[Competitor]



>> 51% longer tool life than competitor

Flaking resistance

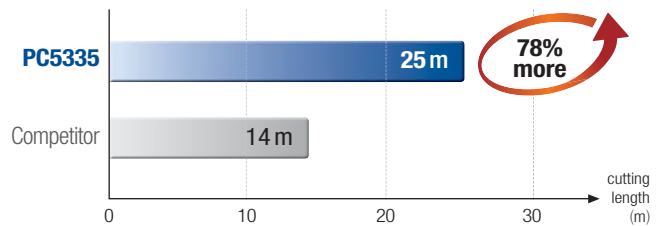
Workpiece	Carbon steel (C45)		
Cutting conditions	vc (m/min) = 80, fn (mm/rev) = 0.2, ap (mm) = 90, wet (30 bar)		
Tools	Insert TPD1500CP (PC5335)	Holder	TPDC3D-15020-45



[PC5335]



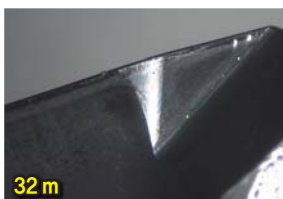
[Competitor]



>> 78% longer tool life than competitor

Wear resistance

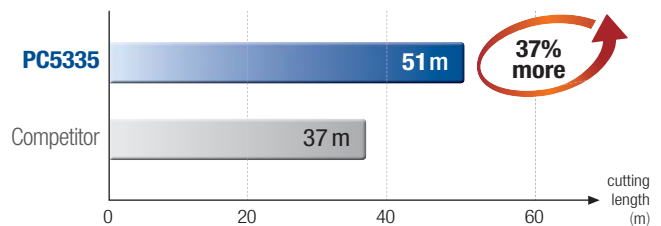
Workpiece	Alloy steel (42CrMo4)		
Cutting conditions	vc (m/min) = 80, fn (mm/rev) = 0.2, ap (mm) = 90, wet (30 bar)		
Tools	Insert TPD2000CP (PC5335)	Holder	TPDC3D-20025-60



[PC5335]



[Competitor]



>> 37% longer tool life than competitor

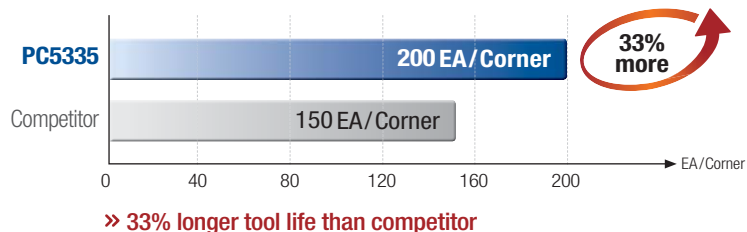
Application examples

Carbon steel (C35)

Workpiece use Automobile planet carrier FR

Cutting conditions $vc(m/min) = 152$, $fn(mm/rev) = 0.13$, $ap(mm) = 4.5$, wet

Tools **Insert** SPMT11T308-LD, XOMT11T306-LD (PC5335) **Holder** K2D20525-07

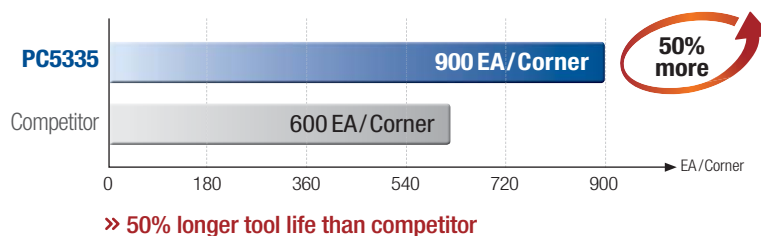


Carbon steel (C35)

Workpiece use Automobile yoke

Cutting conditions $vc(m/min) = 220$, $fn(mm/rev) = 0.05$, $ap(mm) = 10$, wet

Tools **Insert** TPD1500CP (PC5335) **Holder** TPDC3D-15020-45

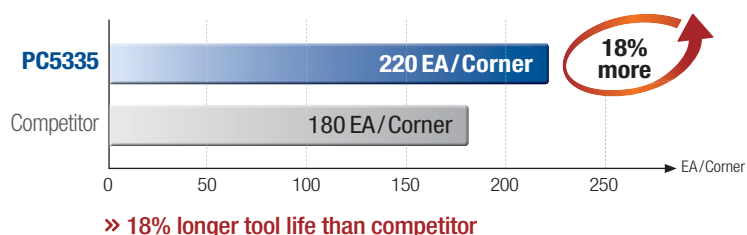


Alloy steel (20Cr4)

Workpiece use Machine tool turret flange

Cutting conditions $vc(m/min) = 256$, $fn(mm/rev) = 0.11$, $ap(mm) = 30$, wet

Tools **Insert** SPMT11T308-LD, XOMT11T306-LD (PC5335) **Holder** K3D35532-11

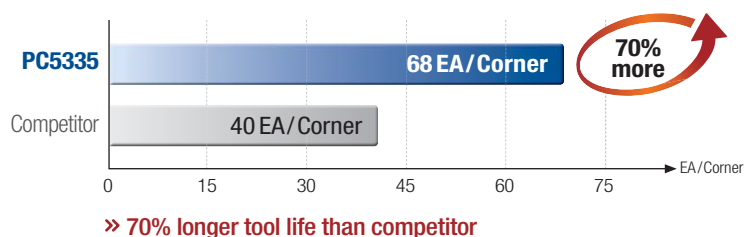


Stainless steel (X5CrNi18-9)

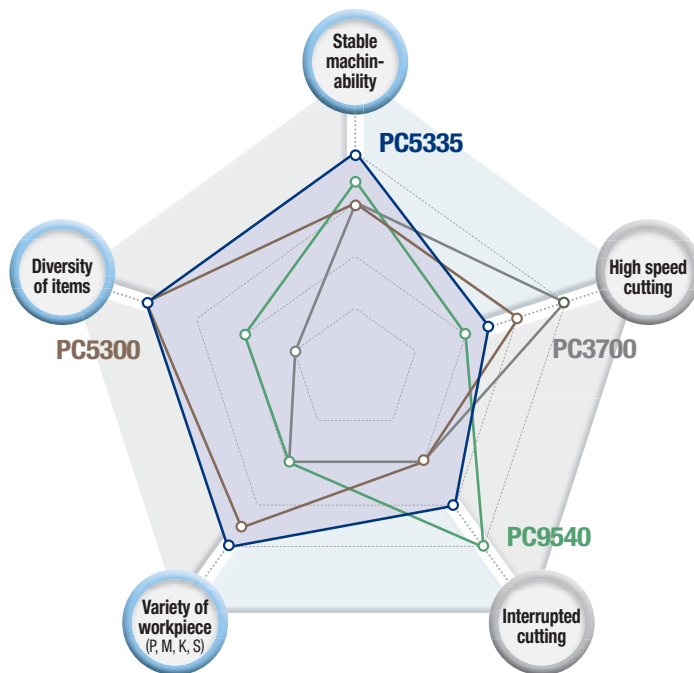
Workpiece use Flange for plumbing

Cutting conditions $vc(m/min) = 143$, $fn(mm/rev) = 0.15$, $ap(mm) = 70$, wet

Tools **Insert** SPMT15M510-LD, XOMT15M508-PD (PC5335) **Holder** K5D43540-15

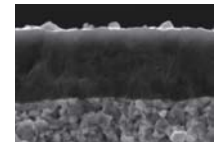


Indexable drill grade selection guide



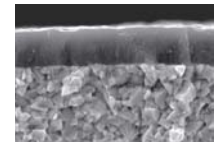
PC5335 New

- Stable machinability even in interrupted cutting
- Universal grade (P, M, K, S cutting)



PC5300

- Good wear resistance in high speed cutting
- Universal grade (P, M, K, S cutting)



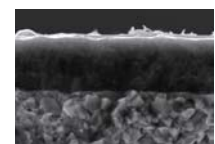
PC9540

- Applying high toughness substrate and coating layer
→ Suitable for hard-to-cut material
- Stainless steel machining grade



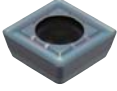
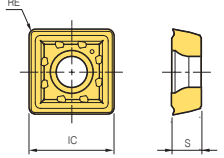
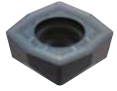
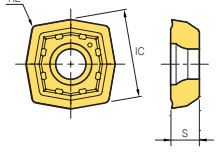
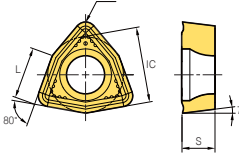
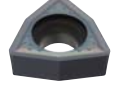
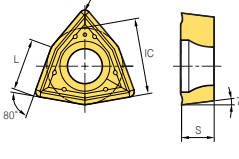
PC3700

- Stability in high speed cutting
- Steel machining grade

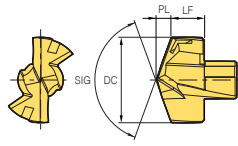


Grade	Stable machinability	High speed cutting	Interrupted cutting	Variety of workpiece (P, M, K, S)	Diversity of items
PC5335 New	★★★★★	★★★☆☆	★★★★	★★★★★	★★★★★
PC5300	★★★☆☆	★★★★	★★	★★★★★	★★★★★
PC9540	★★★★★	★★	★★★★★	★★	★★
PC3700	★★★☆☆	★★★★★	★★	★★	★

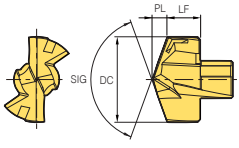
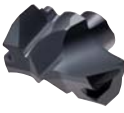
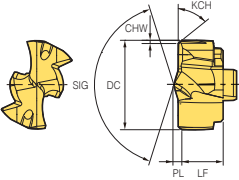
 Stock items

Items	Picture	Designation	Coated	Dimensions (mm)				Geometries
			PC5335	L	IC	S	RE	
King Drill		SPMT 060205-LD	●	-	6.2	2.5	0.5	
		07T208-LD	●	-	7.5	2.8	0.8	
		090308-LD	●	-	9.2	3.3	0.8	
		11T308-LD	●	-	11.0	4.0	0.8	
		130410-LD	●	-	13.0	4.5	1.0	
		15M510-LD	●	-	15.2	5.0	1.0	
		180510-LD	●	-	18.2	5.5	1.0	
		XOMT 060204-LD	●	-	6.6	2.5	0.4	
		07T205-LD	●	-	7.8	2.8	0.8	
		090305-LD	●	-	9.6	3.3	0.5	
		11T306-LD	●	-	11.4	4.0	0.6	
		130406-LD	●	-	13.6	4.5	0.6	
		15M508-LD	●	-	15.9	5.0	0.8	
		180508-LD	●	-	18.9	5.5	0.8	
WPDC		WCMT 030208-C20N	●	3.8	5.56	2.38	0.8	
		040208-C20N	●	4.3	6.35	2.38	0.8	
		050308-C20N	●	5.4	7.94	3.18	0.8	
		06T308-C20N	●	6.5	9.525	3.97	0.8	
		080408-C20N	●	8.7	12.7	4.76	0.8	
		080412-C20N	●	8.7	12.7	4.76	1.2	
		WCMT 030204-C21N	●	3.8	5.56	2.38	0.4	
		040204-C21N	●	4.3	6.35	2.38	0.4	
		040208-C21N	●	4.3	6.35	2.38	0.8	
		050308-C21N	●	5.4	7.94	3.18	0.8	
		06T308-C21N	●	6.5	9.525	3.97	0.8	
		080408-C21N	●	8.7	12.7	4.76	0.8	

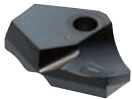
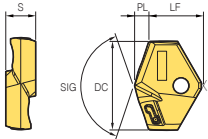
●: Stock item

Items	Picture	Designation	Coated	Dimensions (mm)						Geometries
			PC5335	DC	LF	PL	SIG	KCH	CHW	
TPDC Plus Drill		TPD 1200CP	●	12.0	6.2	1.89	140°	-	-	
		1220CP	●	12.2	6.2	1.92	140°	-	-	
		1250CP	●	12.5	6.1	1.97	140°	-	-	
		1260CP	●	12.6	6.1	1.99	140°	-	-	
		1300CP	●	13.0	6.8	2.05	140°	-	-	
		1350CP	●	13.5	6.7	2.13	140°	-	-	
		1400CP	●	14.0	7.3	2.21	140°	-	-	
		1410CP	●	14.1	7.3	2.22	140°	-	-	
		1420CP	●	14.2	7.3	2.24	140°	-	-	
		1430CP	●	14.3	7.3	2.25	140°	-	-	
		1450CP	●	14.5	7.2	2.29	140°	-	-	
		1500CP	●	15.0	7.7	2.36	140°	-	-	
		1550CP	●	15.5	7.7	2.44	140°	-	-	
		1600CP	●	16.0	8.3	2.52	140°	-	-	
		1630CP	●	16.3	8.2	2.57	140°	-	-	
		1650CP	●	16.5	8.2	2.60	140°	-	-	
		1670CP	●	16.7	8.2	2.63	140°	-	-	
		1700CP	●	17.0	8.8	2.68	140°	-	-	
		1750CP	●	17.5	8.7	2.76	140°	-	-	
		1770CP	●	17.7	8.7	2.79	140°	-	-	
		1800CP	●	18.0	9.4	2.84	140°	-	-	
		1810CP	●	18.1	9.4	2.85	140°	-	-	
		1850CP	●	18.5	9.3	2.92	140°	-	-	
		1860CP	●	18.6	9.3	2.93	140°	-	-	
		1870CP	●	18.7	9.3	2.95	140°	-	-	
		1900CP	●	19.0	9.8	3.00	140°	-	-	
		1920CP	●	19.2	9.8	3.03	140°	-	-	
		1950CP	●	19.5	9.7	3.07	140°	-	-	
		1970CP	●	19.7	9.7	3.11	140°	-	-	
		2000CP	●	20.0	10.4	3.15	140°	-	-	
		2050CP	●	20.5	10.3	3.23	140°	-	-	
		2100CP	●	21.0	10.9	3.31	140°	-	-	
		2150CP	●	21.5	10.8	3.39	140°	-	-	
		2200CP	●	22.0	11.4	3.52	140°	-	-	
		2250CP	●	22.5	11.3	3.60	140°	-	-	
		2260CP	●	22.6	11.3	3.62	140°	-	-	
		2270CP	●	22.7	11.3	3.63	140°	-	-	

●: Stock item

Items	Picture	Designation	Coated	Dimensions (mm)						Geometries
			PC5335	DC	LF	PL	SIG	KCH	CHW	
TPDC Plus Drill		TPD 2300CP	●	23.0	11.8	3.68	140°	-	-	
		2350CP	●	23.5	11.7	3.76	140°	-	-	
		2400CP	●	24.0	12.4	3.84	140°	-	-	
		2450CP	●	24.5	12.3	3.92	140°	-	-	
		2500CP	●	25.0	12.9	4.00	140°	-	-	
		2530CP	●	25.3	12.9	4.05	140°	-	-	
		2550CP	●	25.5	12.8	4.08	140°	-	-	
		2580CP	●	25.8	12.8	4.13	140°	-	-	
		2590CP	●	25.9	12.8	4.15	140°	-	-	
		2600CP	●	26.0	13.4	4.16	140°	-	-	
		2650CP	●	26.5	13.4	4.24	140°	-	-	
		2700CP	●	27.0	13.9	4.32	140°	-	-	
		2800CP	●	28.0	14.4	4.48	140°	-	-	
		2850CP	●	28.5	14.3	4.56	140°	-	-	
		2900CP	●	29.0	15.0	4.64	140°	-	-	
		2950CP	●	29.5	14.9	4.72	140°	-	-	
		3000CP	●	30.0	15.5	4.80	140°	-	-	
		3050CP	●	30.5	15.4	4.88	140°	-	-	
		TPD 1200CP-FC	●	12.0	5.7	1.05	145°	50°	0.38	
		1300CP-FC	●	13.0	6.4	1.05	145°	50°	0.38	
		1400CP-FC	●	14.0	6.9	1.15	145°	50°	0.38	
		1500CP-FC	●	15.0	7.3	1.15	145°	50°	0.38	
		1600CP-FC	●	16.0	8.0	1.25	145°	50°	0.38	
		1700CP-FC	●	17.0	8.2	1.35	145°	50°	0.46	
		1800CP-FC	●	18.0	8.8	1.45	145°	50°	0.46	
		1900CP-FC	●	19.0	9.2	1.45	145°	50°	0.46	
		2000CP-FC	●	20.0	9.8	1.45	145°	50°	0.46	
		2100CP-FC	●	21.0	10.0	1.55	145°	50°	0.46	
		2200CP-FC	●	22.0	11.0	1.55	145°	50°	0.46	
		2300CP-FC	●	23.0	11.4	1.65	145°	50°	0.46	
		2400CP-FC	●	24.0	12.2	1.65	145°	50°	0.46	
		2500CP-FC	●	25.0	12.5	1.75	145°	50°	0.46	
		2600CP-FC	●	26.0	13.1	1.85	145°	50°	0.55	
		2700CP-FC	●	27.0	13.4	1.95	145°	50°	0.55	
		2800CP-FC	●	28.0	13.8	1.95	145°	50°	0.55	
		2900CP-FC	●	29.0	14.4	2.05	145°	50°	0.55	
		3000CP-FC	●	30.0	15.1	2.05	145°	50°	0.55	

●: Stock item

Items	Picture	Designation	Coated	Dimensions (mm)					Geometries
			PC5335	S	DC	LF	PL	SIG	
TPDB Plus Drill		TPD 110B	●	3.5	11.0	6.9	1.73	140°	
		120B	●	3.5	12.0	7.0	2.07	140°	
		125B	●	3.5	12.5	7.0	2.15	140°	
		140B	●	4.0	14.0	8.2	2.41	140°	
		145B	●	4.0	14.5	8.1	2.50	140°	
		150B	●	4.0	15.0	8.5	2.58	140°	
		155B	●	4.0	15.5	8.4	2.67	140°	
		160B	●	5.5	16.0	9.4	2.75	140°	
		170B	●	5.5	17.0	9.7	2.93	140°	
		175B	●	5.5	17.5	9.6	3.01	140°	
		180B	●	6.0	18.0	10.5	3.10	140°	
		181B	●	6.0	18.1	10.5	3.12	140°	
		185B	●	6.0	18.5	10.4	3.19	140°	
		190B	●	6.0	19.0	10.8	3.27	140°	
		200B	●	6.5	20.0	11.7	3.44	140°	
		210B	●	6.5	21.0	12.0	3.62	140°	
		220B	●	7.0	22.0	12.3	3.79	140°	
		230B	●	7.0	23.0	12.6	3.96	140°	
		240B	●	7.5	24.0	13.0	4.13	140°	
		250B	●	7.5	25.0	13.2	4.43	140°	
		251B	●	7.5	25.1	13.2	4.44	140°	
		253B	●	7.5	25.3	13.1	4.48	140°	
		260B	●	8.5	26.0	13.5	4.60	140°	

● : Stock item

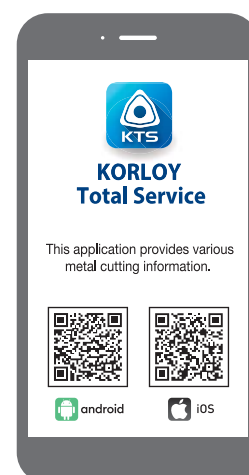
For the safe metalcutting

- Use safety supplies such as protective gloves to prevent possible injury while touching the edge of tools.
- Use safety glasses or safety cover to hedge possible dangers. Inappropriate usage or excessive cutting condition may lead tool's breakage or even the fragment's scattering.
- Clamp the workpiece tightly enough to prevent its movement while its machining.
- Properly manage the tool change phase because the inordinately used tool can be easily broken under the excessive cutting load or severe wear, and it may threat the operator's safety.
- Use safety cover because chips evacuated during cutting are hot and sharp and may cause burns and cuts. To remove chips safely, stop machining, put on protective gloves, and use a hook or other tools.
- Prepare for fire prevention measures as the use of the non-water soluble cutting oil may cause fire.
- Use safety cover and other safety supplies because the spare parts or the inserts can be pulled out due to centrifugal force while high speed machining.



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