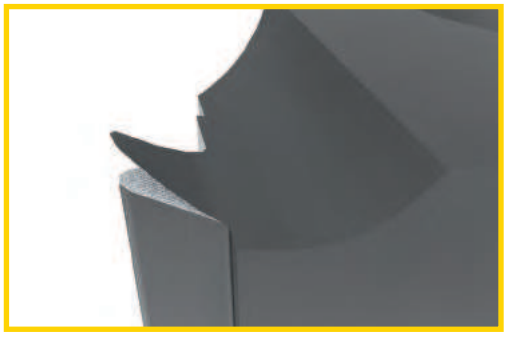
Threading Grade Descriptions

SP4066 has the perfect balance between wear resistance and toughness enabling multiple applications to be covered by one insert. This new grade also allows for longer tool life and is ideal for machining a variety of materials at elevated cutting speeds.



Cutting Speed v_c

ISO	Materials	Rm and Hardness	PVD SP4066 m/min min. - max.
P	Unalloyed Steel	<600 N/mm² <180 HBN	230 - 485
		<950 N/mm² <280 HBN	150 - 315
	Alloyed Steel	700-950 N/mm² 200-280 HBN	135 - 290
		950-1200 N/mm² 280-355 HBN	115 -240
		1200-1400 N/mm² 355-415 HBN	75 - 165
M	Stainless Steel	Austenitic + Ferritic 300 series	155 - 330
		Martensitic 400 series	160 - 340
	PH Stainless	Refractory P.H.	80 - 175
K	Cast Iron	Grey GG-Ft	225 - 480
		Spheroidal-Ductile GGG-FGS	195 - 415
		Malleable GTS - MN/MP	130 - 280
S	High Temperature Alloys	Iron Based	35 - 70
		Cobalt Based	30 - 60
		Nickel Based	30 - 60
		Titanium Based	45 - 95

Optimum Grade Performance

