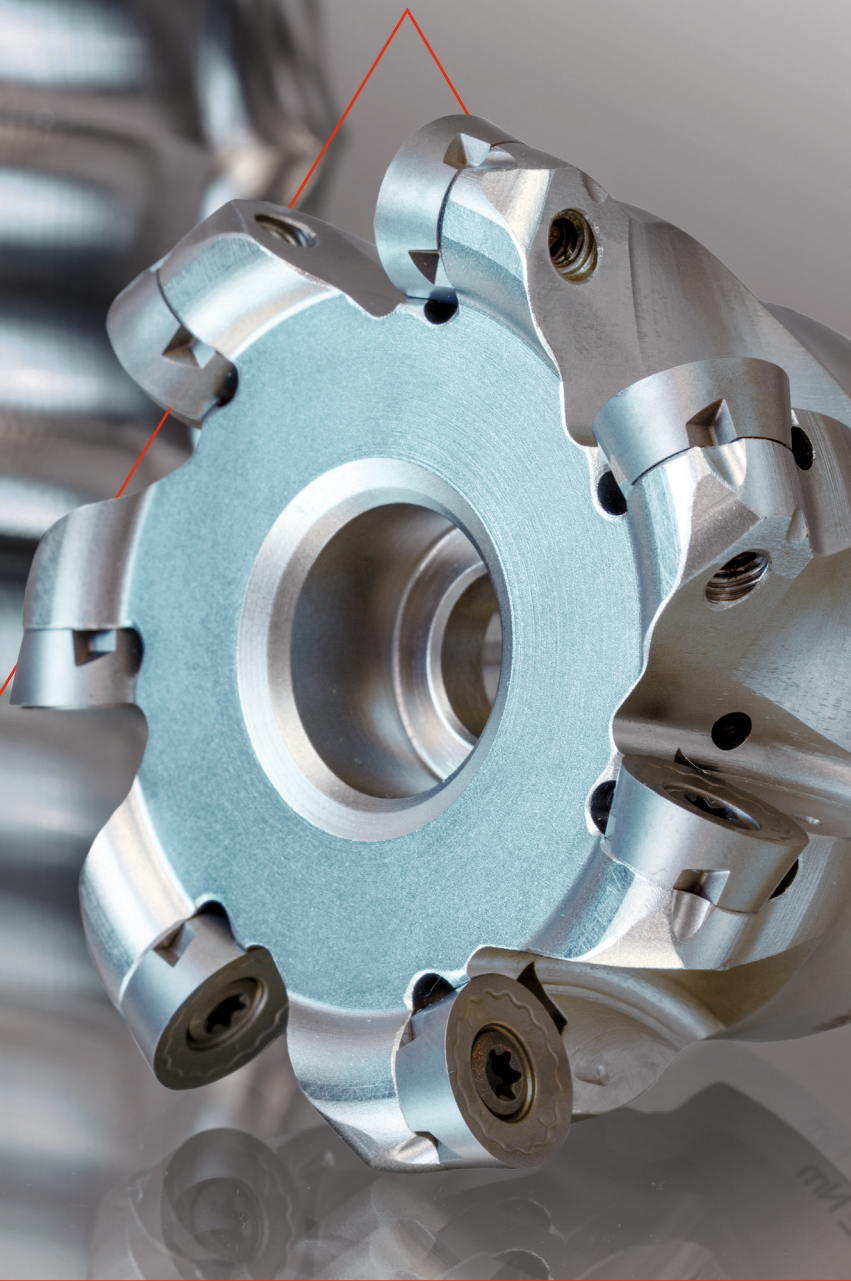


NEW GRADE **CTCS245**

FOR MILLING HEAT RESISTANT NICKEL-BASED ALLOYS



CERATIZIT is a high-tech engineering group
specialized in tooling and hard material technologies.

Tooling the Future

Cutting data

The following chart includes rough guidelines for milling nickel-based alloys.

Depending on the application, work piece, clamping, machine conditions and other factors the data can vary and should be adapted.

Material no.	Designation	V_c [sfm]	d.o.c. min [inch]	d.o.c. max [inch]	f min [ipt]	f max [ipt]
12273304	RDHX 0802MOEN-F50 CTCS245	100 - 165	.020	.051	.002	.006
12241481	RPHX 10T3M4SN-F50 CTCS245	100 - 165	.020	.098	.003	.010
12273305	RPHX 10T3M8SN-F50 CTCS245	100 - 165	.020	.098	.003	.010
12241461	RPHX 1204M4SN-F50 CTCS245	100 - 165	.020	.118	.004	.012
12270087	RPHX 1204M8SN-F50 CTCS245	100 - 165	.020	.118	.004	.012
12280702	XDKT 070308ER-F40 CTCS245	100 - 165	.031	.157	.001	.003
12241487	XDKT 11T308ER-F40 CTCS245	100 - 165	.031	.236	.003	.006
12280699	XDKT 11T312ER-F40 CTCS245	100 - 165	.047	.236	.003	.006
12241466	XDKT 11T316ER-F40 CTCS245	100 - 165	.063	.236	.003	.006
12280178	XDKT 11T320ER-F40 CTCS245	100 - 165	.079	.236	.003	.006
12247042	XDKT 11T332ER-F40 CTCS245	100 - 165	.126	.236	.003	.006
12241492	XDKT 150508ER-F40 CTCS245	100 - 165	.031	.394	.004	.010
12294550	XDLX 09T308ER-F40 CTCS245	100 - 165	.010	.039	.010	.045
12241500	XOLX 120410ER-F40 CTCS245	100 - 165	.010	.079	.010	.047
12280170	XDHT 150560ER-F40 CTCS245	100 - 165	.236	.394	.004	.010
12241497	OFHT 040305SN-F50 CTCS245	100 - 165	.010	.098	.004	.007
12241472	RPNX 2006M8SN-F50 CTCS245	100 - 165	.020	.197	.006	.020

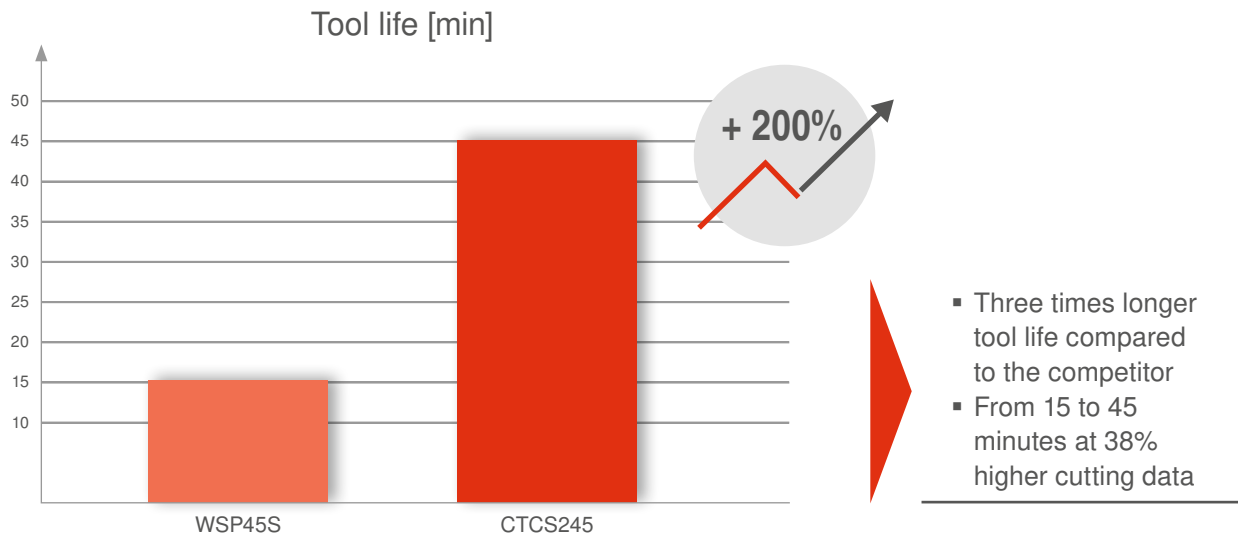
Success Story

Turbine blade machining

Customer: Blade manufacturer
Material: Inconel 625
Tool: A251.66.R.07-12-RS
Test 1: RPHX 1204M8SN-F50 CTCS245
Test 2: RPMX 1204MO-F67 WSP45S

Cutting data:

v_c = 141 [sfm]
 f = .011 [ipt]
d.o.c. = .079"
w.o.c. = < 1.575"



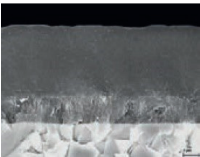
Application

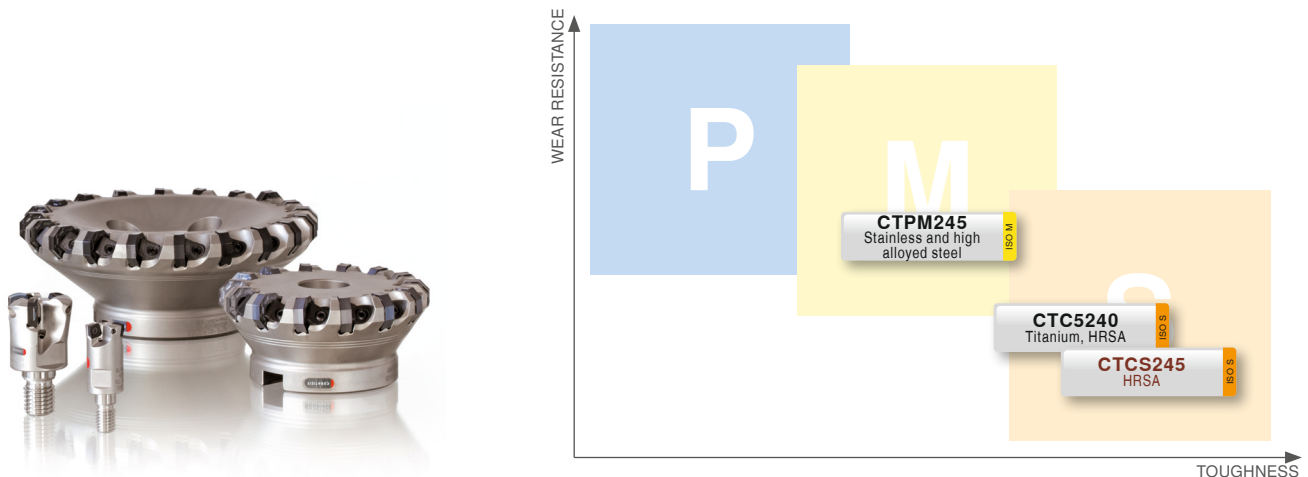
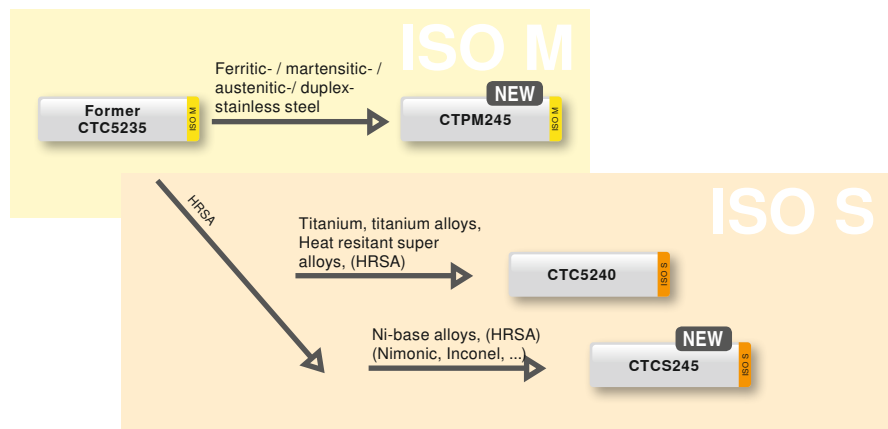
Superior performance in:

- ▲ HRSA
- ▲ Nickel based alloys
- ▲ Inconel
- ▲ Nimonic
- ▲ Rene

Grade designation	Standard designation:		Cutting material	Application:	P	M	K	N	S	H
					Steel	Stainless	Cast iron	Non-ferrous metals	Heat-resistant	Hardened materials
CTCS245	HC-S45	-	C	01 05 10 15 20 25 30 35 40 45 50					•	
				01 05 10 15 20 25 30 35 40 45 50	Main application Extended application					

Specs

CTCS245	HC-S40 / HC-S45	•
	Composition: 12,0 % binder; WC balance Grain size: 2 µm Hardness 1330 HV ₃₀ Coating specification: CVD TiN-TiB ₂	



Product range:

Please see the chart below for our current product offerings in CTCS245. The majority of our standard products are available from stock.

Material no.	Designation
12273304	RDHX 0802MOEN-F50 CTCS245
12241481	RPHX 10T3M4SN-F50 CTCS245
12273305	RPHX 10T3M8SN-F50 CTCS245
12241461	RPHX 1204M4SN-F50 CTCS245
12270087	RPHX 1204M8SN-F50 CTCS245
12280702	XDKT 070308ER-F40 CTCS245
12241487	XDKT 11T308ER-F40 CTCS245
12280699	XDKT 11T312ER-F40 CTCS245
12241466	XDKT 11T316ER-F40 CTCS245
12280178	XDKT 11T320ER-F40 CTCS245
12247042	XDKT 11T332ER-F40 CTCS245
12241492	XDKT 150508ER-F40 CTCS245
12294550	XDLX 09T308ER-F40 CTCS245
12241500	XOLX 120410ER-F40 CTCS245
12298734	SAKU 1706ABSR-F50 CTCS245
12241497	OFHT 040305SN-F50 CTCS245
12241472	RPNX 2006M8SN-F50 CTCS245



e-techstore.com
Available 24/7 for you

A well-organized warehouse means that we can respond quickly and reliably to your order, even for bulk quantities. Thanks to our advanced supply chain management, our production capacity is flexible and able to produce large quantities, even in a short time frame. You can order stock products online around the clock at our e-Techstore.

DEPEND ON INSERT GRADES FROM CERATIZIT

- ▲ Patented CVD coating
- ▲ Reliable performance
- ▲ Substantial increase in tool life over current grades



Headquarters:

CERATIZIT S.A.
LU-8232 Mamer
T. +352 31 20 85-1
E. info@ceratizit.com
www.ceratizit.com

Contact for further information:

USA / Canada
CERATIZIT USA, Inc.
US-Warren, MI 48089-1833
Toll free +1-800-783-2280
T. +1-586-759-2280
E. info.usa@ceratizit.com

Technical support:
+1-888-706-2664