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BCK10T and BCK20T – the revolution in cast iron turning

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Austrian carbide and tool specialist Boehlerit has optimised the successful TERAspeed 2.0 coating for use in cast iron milling and now cast iron turning applications are also set to benefit. In cast iron turning, oxide coatings are used, as opposed to the TERAspeed 2.0 nitride coating for milling, due to the increased temperature load, which is reflected in the development of the new casting grade. A thorough analysis of the market situation and coating tests that were completed internally paved the way for a new generation of coatings. The new cast CVD coating makes the most of the advantages of its individual components.

Alpha-aluminium oxide is separated by means of targeted process management. It works as a heat shield and protects the indexable insert from high temperatures. Underneath, a medium-temperature titanium-carbon nitride layer provides the required wear resistance. A thickness of 20µm and the optimised roundings of the edges ensure a high level of edge stability and ideal cutting conditions.

The current geometries of the casting programme are made with the latest generation of reference clamping systems. Compared to older systems, the increased rigidity and repetition accuracy makes for a reduction of the pressing gap, which in turn increases press quality (burr-free pressing). This has a positive influence on work flows further down the line and significantly improves productivity. BCK10T is designed primarily for use in finishing operations on any kind of cast materials as well as in grey cast iron roughing operations. The focus of the somewhat tougher variant BCK20T is on roughing operations in all cast materials and finishing castings with nodular graphite.

The new Boehlerit casting grades BCK10T and BCK20T offer top quality, excellent machining properties and optimal distribution of cutting forces.

Press release

The company

Boehlerit, a family business that is part of the Brucklacher group (Leitz, Bilz and Boehlerit) and headquartered in the Austrian town of Kapfenberg, sets global standards with carbides and tools for the processing of metal, wood, plastics and composites. With cutting materials, semi-finished products, precision tools and tool systems for milling, turning, drilling and forming, Boehlerit ensures process safety and efficiency on a global scale. The company's extensive product portfolio includes highly specialised tools for the machining of crankshafts as well as for the mining industry, for bar peeling, tube and sheet metal processing and heavy-duty machining. The Boehlerit product range also features carbides for construction components and wear protection. When it comes to coating technology, Boehlerit occupies a unique position worldwide, ranging from the first-ever nano-CVD bonding layer to the hardest diamond layer worldwide. With its many years' experience in metallurgy, coating technology and state-of-the-art press technology, Boehlerit is a highly competent development partner for toolmakers.

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Abb. 1: BCK10T and BCK20T Image

