

# GC4330 and GC4340

## New steel milling grades

### Secure steel milling

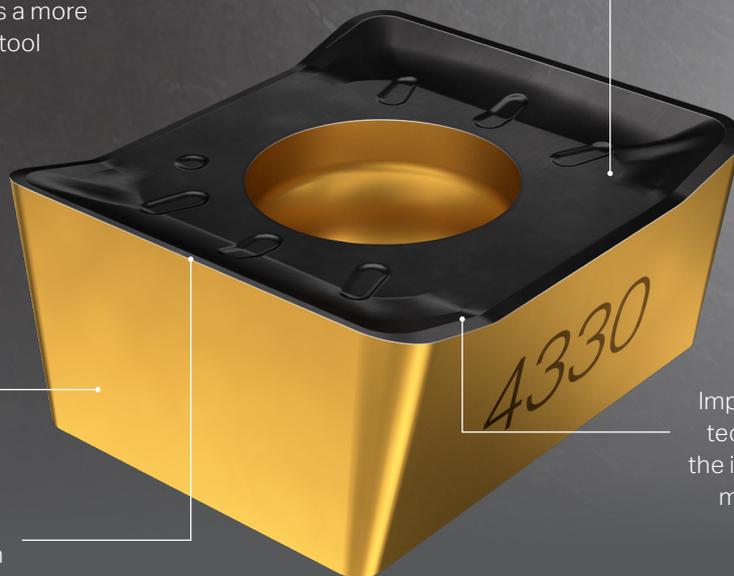
In-depth research and a focus on applying new production technologies have brought further advances in steel milling insert development.

The new CVD grades GC4330 and GC4340 offer substantially increased tool life and improved process security.

### Technical features

New substrate in grade GC4330 with well-controlled grain size distribution, which offers a more reliable and predictable tool behaviour.

Inveio® coating for high wear resistance and long tool life.

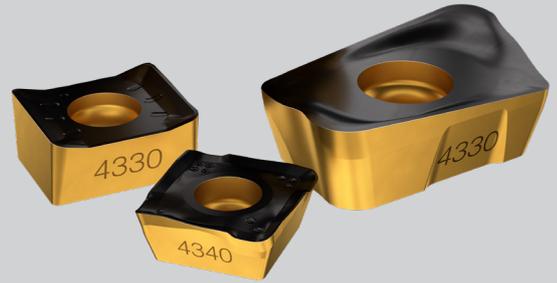


Improved post treatment technology strengthens the insert by modifying its mechanical properties.

More consistent tool life with more narrow edge rounding (ER) tolerance.

## Benefits

- Increased tool life provides a reduced cost per component
- Improved process security ensures a predictable performance and less downtime
- High component quality



## Application

- Optimized for steel milling
- GC4330: First choice for roughing to semi-finish face milling
- GC4340: First choice for rough shoulder milling and groove milling
- Wet and dry machining (dry is recommended)

## Customer case CoroMill® 490 with size 14 inserts

**Component:** Fixture

**Operation:** Face milling

**Machine:** Mori Seiki NH4000DCG

**Material:** Unalloyed steel P1.2.Z.AN (CMC 01.2)



	GC4230	GC4330
Tool	490-080Q27-14M	490-080Q27-14M
Insert	490R-140408M-PM	490R-140408M-PM
$Z_n$	6	6
$n$ r/min	900	900
$v_c$ m/min (ft/min)	226 (741)	226 (741)
$v_f$ mm/min (inch/min)	1000 (39.3)	1000 (39.3)
$f_z$ mm/z (in/z)	0.19 (0.007)	0.19 (0.007)
$a_p$ mm (inch)	2 (0.079)	2 (0.079)
$a_e$ mm (inch)	70 (2.75)	70 (2.75)
<b>Tool life (components)</b>	<b>32</b>	<b>45</b>
Surface roughness criteria reached		

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