




High Performance Wood Cutting Carbide Grade Chart

Grade	Binder %	Density	Hardness	T.R.S.	Grain	Main Advantages	Recommended Cutting Applications
STFM03H C-4	2.8	15.25	94.0	2300	Submicron	Excellent Anticorrosion, antioxidation, wear resistance and toughness	Particle board, melamine, faced board, MDF, HDF & Composite
					Submicron		
STFM05H C-4	3.5	15.15	93.6	2300	Submicron		
Hi-Performance Metal Cutting							
STFM10H C-5	10.0	12.4	91.0	2400	Medium	Excellent red hardness & strength to reduce impact cracking and edge abrasion.	For hand held saws, saws with coolant for rough & finish cutting of stainless steel, refractory steel, low carbon steel etc. Also suitable for slitting saws, planer knives, milling and turning cutters.
					Fine		
STFM12H C-6	10.0	12.5	91.5	2300	Fine		



Grade Chart for Cutting Applications

 Grade	Density g/Cm ³	Binder %	T.R.S N/mm ²	Hardness HRA	Recommended Cutting Materials
Micron and sub-micron grain grade					
C-4	15	4	1900	93.5	Hardwood, MDF, HDF, Aluminum & Plastic composites and thin non-ferrous metals.
C-4	14.8	5	2000	92.5	
C-6	12.5	10	2100	91.5	Excellent red hardness, specially for cutting of stainless steel, refractory steel & etc.
C-5 C-6	14.2	10	2000	91.5	
C-5	12.2	11	1800	91.5	Cast irons, High manganese steel, die steel and composites.
Medium & Fine Grain Grade					
C-1	14.5	10	2200	91.0	Hard wood, veneer board, PCB, PVC & Metals
C-3	15.1	5	2100	91.5	Solid wood, multiple-wood, aluminum and plastic-steel.
C-3	15	6	1900	90.5	Hard wood, original wood, aluminum section bar, brass rod and cast iron.
C-2	14.8	8	2000	89.5	Dry wood, soft wood, aluminum and brass, graphite and grass.
C-2	14.8	8	2050	90.0	General and hardwood.
C-2	14.8	8	2150	88.0	Soft and Dry Wood, general wood with loose knot, man-made, marble, ceramics and grass.
C-1 C-2	14.1	9	2200	90.5	Hard wood, non-ferrous metal, granite and marble.
C-1	14.3	11	2300	86.5	For debarking and cutting of frozen wood, soft wood and original wood.
C-6	13	8	1900	90.5	Carbon steel, refractory steel, manganese steel, stainless steel & Iron



Grade Comparison Chart

	Chip removal, woodworking Cast Iron, non-ferrous Plastic; wood				Chip removal Ferrous metal and steel alloy				Wear Applications Wear Resistance			Impact Applications			
	C-1	C-2	C-3	C-4	C-5	C-6	C-7	C-8	C-9	C-10	C-11	C-12	C-13	C-14	C-15
Ceratizit	HC 30	HC 20 HC 25	HC 10	HC 03	S6X7	SMX	S3X7	S1X7	GC 10	GC 15	GC 20 BC 20	GC 20 BC 20	GC 30 BC 40	GC 40	GC 50
Tigra	T10MF	T08MG T08SMF	T06M T06MG T06MF T05UMG	T02UMG T02SMG T03SMG T04F T08CR											
Eagle	RK 30 RK 40 RM 40	RK 15 RK 15S RK 20 RM 20	RK 10	RK 01 RGH 00 RK 01S	RP 30 RP 40	RP 20 RP 30 RM 20	RP 10 RP 25	RP 01 RP10	RG 05 RG 10	RG 10 RG 15	RG 20	RG 20 RG 25	RG 30	RG 40	RG 55
Camco / Kennametal	K 1	K 6	K 8	K 11	K 810 K 21 K 2S	K 29 K 21 KC 810 K 4 H	K 5 H KC 810 K 4 H	K 165 K 5 H	K 96 K 8 K 68	K 6 K 95 K 1	K 92 K 95 K 1	K 96 K 94 K 1	K 92 K 94 K 91	K 91 K 90	K 90
Multi-Metals	OM 1	OM 2	OM 3						OM 2	OM 1	1M 12	1M 12	2M 13	1M 20	
Carboloy	44 A 55 A	523 570 883	570 883 895	895 999	370 570 516 518	570 516 883 375	350 515 883 570	514 545	44 A 883 895	44 A 883 779	55 B 55 A 44 A	55 A 44 A 779	55 A 55 B 190	190	
ISO Grade	K 30 K 40 M 40	K 20 M 20	K 10	K 01	P 30 P 40	P 20 P 30 M 20	P 10 P 25	P 01 P 10							
Metal Carbide	C 89	C 91 C 91A	C 93 C 99	C 95	S 88	S 90	S 92	S 94	C 99	C 88	C 80	C 85	C 80	C 75	