

Supratools

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CARBIDE FOR BRAZED TOOLS






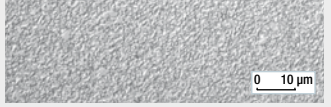
04

SUPRATOOLS grade	Binder	Hardness		Bending strength		Toughness
	%	HV 10	HRA ± 0.2	N/mm ²	psi	K _{1C} / MPa.m ^{-1/2}
T04F ISO: K05 USA: C4	4.0	1750	92.8	2350	341.000	8.6
T06M ISO: K20 USA: C3 -	6.5	1400	90.3	2400	348.000	10.4
T06MF ISO: K20 USA: C3	6.5	1600	92.0	2500	363.000	9.9
T08MF ISO: K30 USA: C2	8.5	1470	90.9	2700	392.000	10.3
T10MG ISO: K10-k40 USA: C3+	10.0	1650	92.3	3600	522.000	9.4
TL15*	13.5	1450	90.7	3800	551.000	10.5
TL20*	20.0	1400	90.3	3800	551.000	12.0

* Special binder

SUPRATOOLS grade	HDF	MDF	Chipboard	Hardwood	Softwood
T04F	0	+	++	++	+
T06M	--	-	-	+	+
T06MF	-	0	+	++	++
T08MF	--	-	0	+	++
T10MG	-	0	+	++	++
TL15	-	-	0	++	+++
TL20	--	-	-	++	+++

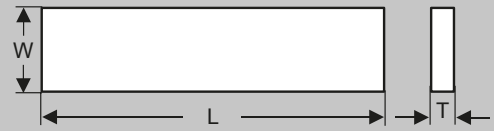
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Excellent Very Good Good Acceptable Not Poor Not suitable

SUPRATOOLS grade	Main usage	
T04F	Hardwood, board	
T06M	Dry tool grinding	
T06MF	Universal grade	
T08MF	Softwood with knotholes	
T10MG	Wood, large angles	
TL15 /TL 20	Micrograin - Softwood with knots	



T=2-4mm

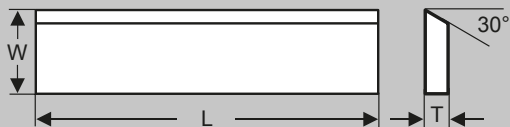
L mm	W mm	T mm	T04F	T06MF	T08MF	T10MG
310	2	2				110300
310	4	2	100307	121839	054306	054405
310	5	2	100308	112933	105994	100549
310	6	2	100309	039888	031189	029130
310	8	2	101107	039889	031190	029131
310	10	2	100710	100785	031191	029132
310	12	2	100709	039891	031192	029133
310	14	2	101637	039892	031193	029136
310	15	2	108730	112935	114830	054311
310	16	2	108731	039893	031194	029138
310	18	2	108732	039894	031195	029139
310	20	2	055678	039895	031196	029140
310	22	2	108737	100792	050324	038192
310	25	2	055679	039896	031197	029141
310	30	2	055680	039897	031198	031186
310	3	3				110301
310	5	3	121840	112934	035891	054598
310	6	3	100310	039898	024509	024511
310	8	3	100311	039899	024513	024515
310	10	3	101638	039900	024517	024519
310	12	3	100619	039901	024521	024523
310	13	3	121841	121842	121843	041839
310	14	3	108738	039902	024525	024527
310	15	3	100312	100798	035892	041072
310	16	3	105249	039903	024529	024531
310	18	3	108739	039904	024533	024535
310	20	3	100313	039905	024537	024539
310	25	3	108740	039906	024541	024543
310	30	3	108741	039907	024545	024547
310	4	4				110302
310	8	4	100626	039909	024564	024566
310	10	4	101106	039910	024568	024570
310	12	4	100625	039911	024572	024574
310	14	4	102820	039912	024576	024578
310	15	4	100315	102784	040305	103213
310	16	4	100621	037636	024580	024582
310	18	4	100316	037637	024584	024586
310	20	4	101729	039913	024588	024590
310	22	4	100317	102883	103194	047082
310	25	4	100318	039914	024592	024594
310	28	4	106131	103181	103196	103214
310	30	4	105525	039915	024596	024598
310	35	4	108742	004348	051785	051786



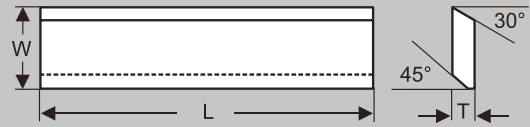
T=5-6mm

04

L mm	W mm	T mm	T04F	T06MF	T08MF	T10MG
310	5	5				110303
310	8	5	108743	039917	024625	024627
310	10	5	108768	039918	024629	024631
310	12	5	100319	039919	024633	024635
310	14	5	102229	039920	024637	024639
310	15	5	100627	103185	103205	039582
310	16	5	108744	039921	024641	024643
310	18	5	100321	039922	024645	024647
310	20	5	100322	039923	024649	024651
310	25	5	100323	039924	024653	024655
310	30	5	108745	039925	024657	024659
310	35	5	108746	103187	051787	051788
170	40	5	108747	024715	113381	050106
310	10	6		024677		024680
310	16	6		112936		024692
310	20	6		024694		024700
310	25	6		024701		024704
310	30	6		024705		024708



L mm	W mm	T mm	T04F	T06MF	T08MF	T10MG
310	8	3	108748	039927	024723	024725
310	10	3	108749	039928	024727	024729
310	12	3	108750	039929	024731	024733
310	14	3	108752	039930	024735	024737
310	15	3	108753	115073	038985	041080
310	16	3	108754	039931	024739	024741
310	18	3	108755	039932	024743	024745
310	20	3	108756	039933	024747	024749
310	25	3	108757	039934	024751	024753
310	30	3	108758	039935	024755	024757
310	8	4	108759	039937	024763	024765
310	10	4	108760	039938	024767	024769
310	12	4	108761	039939	024771	024773
310	14	4	108762	039940	024775	024777
310	15	4	108763	039459	049252	041081
310	16	4	108703	039941	024779	024781
310	18	4	108764	039942	024783	024785
310	20	4	102884	039943	024787	024789
310	22	4	102885	035925	049253	041082
310	25	4	102886	039944	024791	024793
310	28	4	102887	035926	049254	041083
310	30	4	108765	039945	024795	024797
310	35	4	108766	100275	051791	041084
310	8	5	108767	039947	024803	024805
310	10	5	108769	039948	024807	024809
310	12	5	108771	039949	024811	024813
310	14	5	108772	039950	024815	024817
310	15	5	108773	103186	103206	103218
310	16	5	108704	039951	024819	024821
310	18	5	108774	039952	024823	024825
310	20	5	108705	039953	024827	024829
310	25	5	108706	039954	024831	024833
310	30	5	108707	039955	024835	024837
310	35	5	108775	100843	051792	051793
170	40	5	115072	025208	029625	029264
310	10	6		024846	024847	024849
310	12	6		039959	024851	024853
310	16	6		039961	024859	024861
310	20	6		039963	024867	024869
310	25	6		039964	024871	024873
310	30	6		039965	024875	024877



04

L mm	W mm	T mm	T04F	T06MF	T08MF	T10MG
310	8	3	108777	039967	024883	024885
310	10	3	108778	100860	024887	024889
310	12	3	108779	039969	024891	024893
310	14	3	108780	039970	024895	024897
310	15	3	108781	103178		103222
310	16	3	108782	039971	024899	024901
310	18	3	108783	039972	024903	024905
310	20	3	108784	039973	024907	024909
310	25	3	108785	039974	024911	024913
310	30	3	108786	039975	024915	024917
310	8	4	100629	039977	024929	024931
310	10	4	108787	039978	024933	024935
310	12	4	103853	039979	024937	024939
310	14	4	102230	039980	024941	024943
310	15	4	108788	103175	035893	050690
310	16	4	103854	039981	024945	024947
310	18	4	108789	039982	024949	024951
310	20	4	108790	039983	024953	024955
310	22	4	108791	102675	103195	103223
310	25	4	108792	100875	024957	024959
310	28	4	108793	102677	103198	101527
310	30	4	108794	039985	024961	024963
310	35	4	108797	100877	050600	051797
310	8	5	108798	039987	024976	024978
310	10	5	054402	039988	024980	024982
310	12	5	055663	039990	024984	024986
310	14	5	102563	039991	024988	024990
310	15	5	100628	100882	035894	035897
310	16	5	106180	039992	024992	024994
310	18	5	004371	039993	024996	024998
310	20	5	054231	039994	025000	025002
310	25	5	054439	039995	025004	025006
310	30	5	054677	039996	025008	025010
310	35	5	056072	054692	051798	051799
170	40	5	053297	100889	114831	039094
310	10	6	054403	039999	025021	025023
310	12	6	004372	040000	025025	025027
310	16	6	108799	040002	025033	025035
310	20	6	054323	040004	025041	025043
310	25	6	108800	040005	025045	025047
310	30	6	004375	040006	025049	025051

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