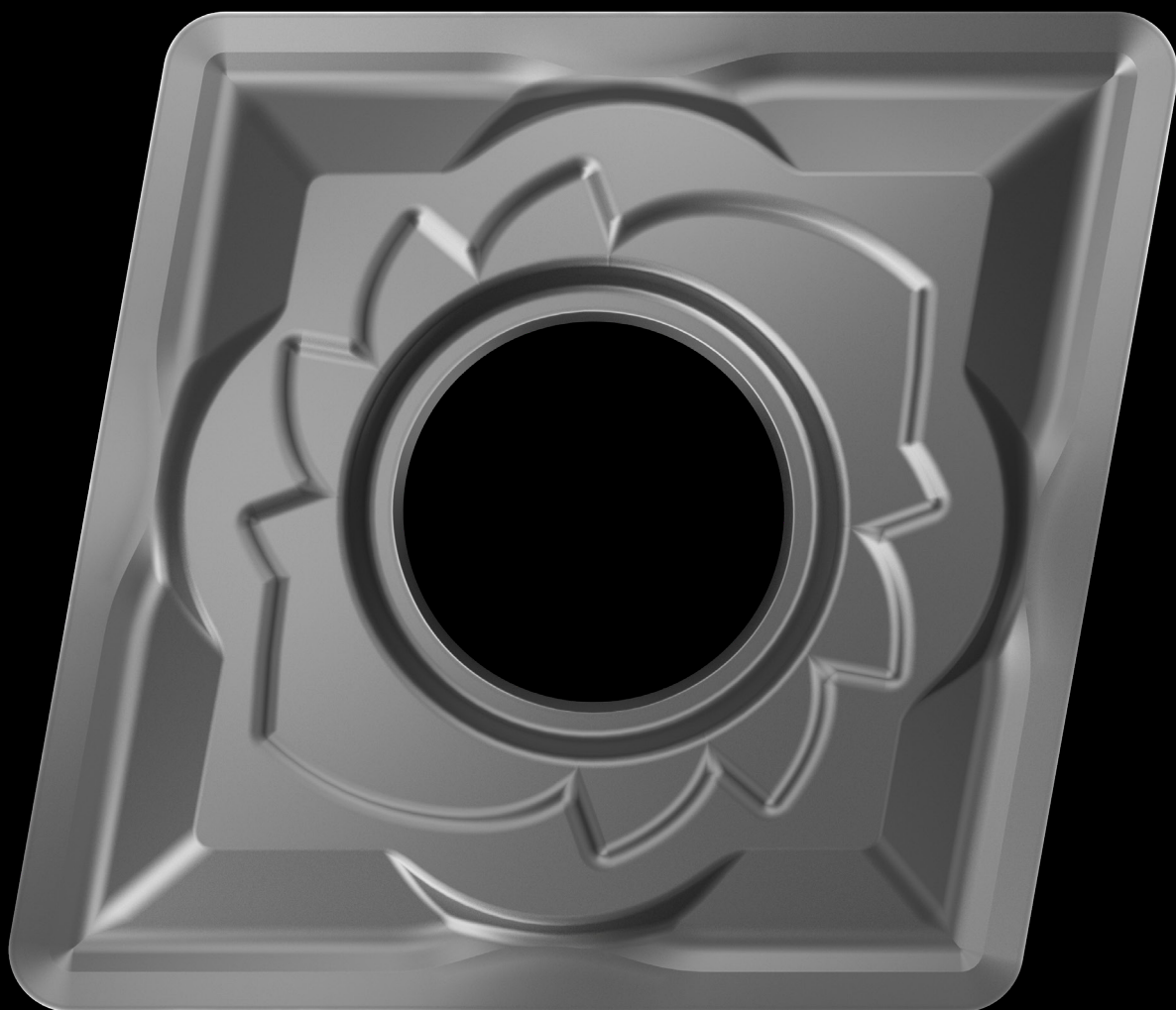


# Grades GC1205 and GC1210

## Secure turning in HRSA materials



When turning aero-engine components, the surface requirements are high but no longer difficult to reach thanks to the new grades GC1205 and GC1210.

These grades are developed for machining aged nickel-based HRSA materials and cover a large application area within last stage machining (LSM) and intermediate stage machining (ISM).

# Gain more tool life and remarkable output

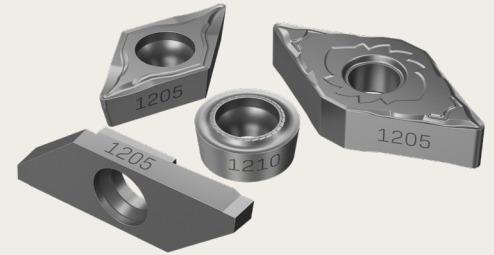
Featuring the latest substrate and coating technologies, these grades offer excellent flank and adhesive wear resistance, increasing tool life and productivity gains.

Adding on the ability to use higher cutting speeds, without compromising quality, will further lower your manufacturing costs and increase your output.



## Features and benefits

- A hard, very fine-grained substrate offers excellent flank and notch wear resistance
- Superior edge-line security contributes to a more consistent tool life
- Optimized cutting-edge integrity reduces flaking
- The combination of the hard substrate and PVD coatings allows for a significant increase in cutting speed (GC1205) and tool life (GC1210)

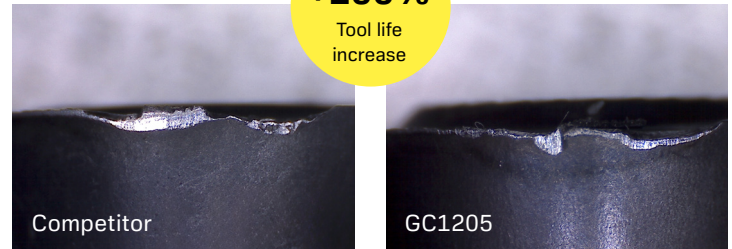


## Customer case

**Component:** Shaft  
**Material:** S2.0.Z.AG (Inconel 718)  
**Operation:** Roughing external axial  
**Machine:** Mori-Seiki NL2500

	Competitor	Sandvik Coromant
Tool	-	C5-SRSCL-35060-12HP
Insert	-	RCMT 1204M0-SM 1205
$z_n$	1	1
$n$ , rpm	204	204
$v_c$ , m/min (ft/min)	50 (164)	50 (164)
$f_n$ , mm/rev (in/rev)	0.35 (0.014)	0.35 (0.014)
$a_p$ , mm (inch)	2.5 (0.098)	2.5 (0.098)
<b>MRR, cm<sup>3</sup>/min (in<sup>3</sup>/min)</b>	<b>43.75 (2.67)</b>	<b>43.75 (2.67)</b>
<b>Tool life, pcs</b>	<b>6</b>	<b>12</b>

**+100%**  
Tool life increase



**Result:** Grade GC1205 provided a 100% increase in tool life compared to the competitor thanks to increased flank and crater wear resistance.

Read more about GC1205 and GC1210:  
[sandvik.coromant.com/hrsaturning](https://sandvik.coromant.com/hrsaturning)



Authorized distributor

