SPK by CeramTec

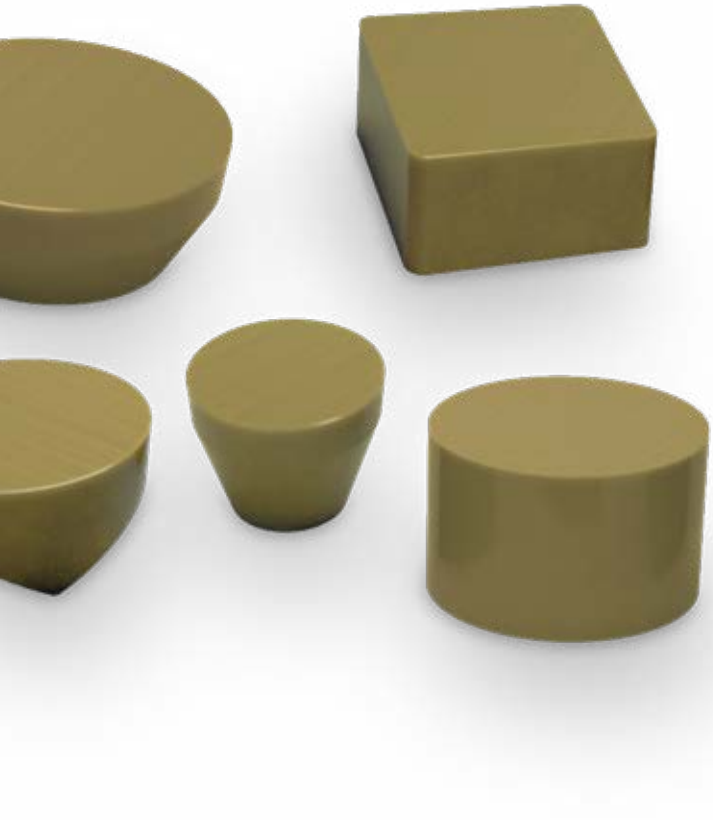
CUTTING TOOLS

Heat-resistant superalloys

LST 350 – for high productive HRSA machining

MACHINING MATTERS

LST 350 – for high productive HRSA machining



The SiAlON cutting material has been developed for turning at high cutting speeds and for achieving high material removal rates in demanding HRSA applications.

Where productivity, process reliability, and cutting material performance matter, LST 350 shows its strength: high hot hardness and reliable performance even under high thermal and mechanical loads.

LST 350 enables high cutting speeds and short machining times – with good wear control. This makes the cutting material suitable for machining tasks aimed at making HRSA machining more productive, safer, and more cost-efficient.

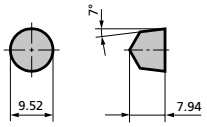
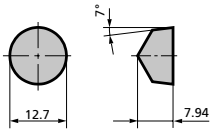
Recommended starting values	
SPK Grade	**LST 350**
Cutting material	SiAlON Keramik
Cutting speed v_c (m/min.)	approx. 150 – 250 m/min
Feed f (mm)	approx. 0.15 – 0.30 mm
Depth of cut a_p (mm)	approx. 1.0 – 3.0 mm
Cooling	yes

LST 350 for turning:

- Nickel-based alloys, e.g. Inconel materials
- Roughing, also through scale, as well as semi-finishing
- Applications with increased demands on process reliability and high material removal rates.

LST 350 is the right choice when the process requires greater stability:
Where HRSA machining generates high temperatures, changing engagement conditions, or increased mechanical load, LST 350 provides a strong solution for productive and stable machining.

Ceramic cutting materials
– SiAlON

			S		K			H			P	
Insert	**Designation**	**Grade**	NICKEL BASED	COBALT BASED	GJL	GJS	ADDITIONAL	STEEL HARDENED	CHILLED CAST IRON	MOLDED CASTING	STEEL	**SPK-Ref. No.**
RCGX 09 07 00	**RCGX 09 07 00 TX00520**	LST 350	✦		✧	✧	✧					21.42.103.49.5
	**RCGX 09 07 00 T01020**	LST 350	✦		✧	✧	✧					21.42.103.15.5
RCGX 12 07 00	**RCGX 12 07 00 TX00520**	LST 350	✦		✧	✧	✧					21.42.104.49.5
	**RCGX 12 07 00 T01020**	LST 350	✦		✧	✧	✧					21.42.104.15.5
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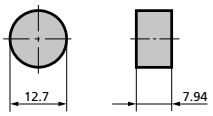	**RNGN 12 07 00 T01020**	LST 350	✦		✧	✧	✧					21.40.002.15.5
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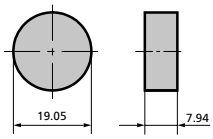												
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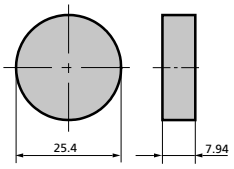												
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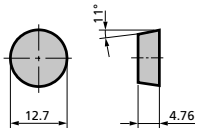												
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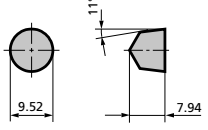												

ISO Application Group

K	Cast Iron	H	Hard Materials	S	HSRA	P	Steel	Main Application ✦	Additional Application ✧

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