

MEGACOAT CBN



Extended Tool Life

Improved Stability

High Speed Cutting

Kyocera's new innovative CBN tools.
CBN Variation and Features Ref. Page **A16**

Various Edge Preparations Added to the High Performance MEGACOAT CBN Inserts

Turning Insert Identification System

C N G A 12 04 04 S01225 ME

Refer to **B2** for "Turning Indexable Inserts Identification System"

Insert Type	Part Number	Edge Prep.	Manufacturer's Option	Cutting Edge Length	No. of Edges	Re-Grinding
Negative	CNGA431MEF	F	MEF	Short (Small Edge)	2	Not Recommended
	CNGA431S00525ME	S00525	ME		2	
	CNGA431S00245MEP	S00245	MEP		2	
	CNGA431S00525SE	S00525	SE	1	Possible	
	CNMN431S00820	S00820	No Indication (Only KBN900)	Multiple Edge		
Positive	CCMW3251MEF	F	MEF	Short (Small Edge)	2	Not Recommended
	CCMW3251T00315ME	T00315	ME		2	
	CCMW3251S00525MES	S00525	MES	2	Possible	
	CCMW3251T00315SE	T00315	SE	1		

Re-Grinding

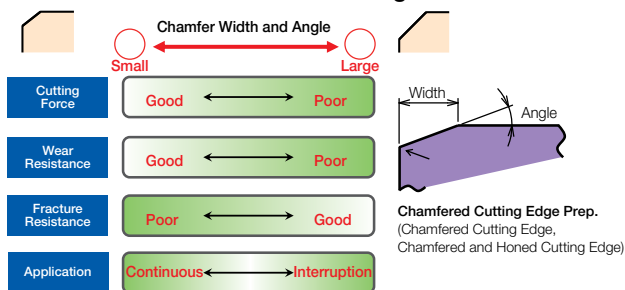
- 1) Regrinding is possible for inserts without any indication in manufacturer's option. Regrinding may not be available depending on the edge condition.
- 2) Regrinding is not recommended for inserts with manufacturer's symbol like "ME" or "SE".

Refer to **Page B6** for insert color.

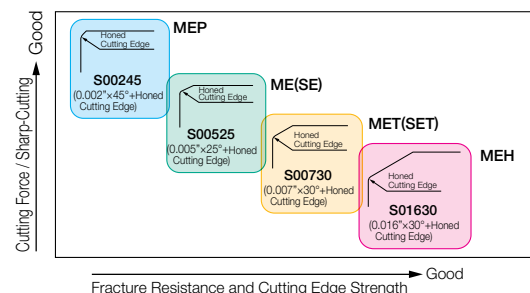
How To Identify Edge Preparation

Symbol	Cutting Edge Spec.	Example	Shape
F	Sharp Edge	F Sharp Edge	
E	Honed Cutting Edge	E003 R0.003" Honed Cutting Edge	
T	Chamfered Cutting Edge	T00515 0.005" X 15° Chamfered Cutting Edge	
S	Chamfered and Honed Cutting Edge	S00525 0.005" X 25° Chamfered + Honed Cutting Edge	

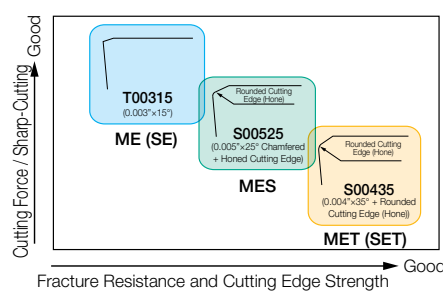
Features of Chamfer Width % Angle



Standard Cutting Edge Prep. of Negative inserts



Standard Cutting Edge Prep. of Positive Inserts



Manufacturer's Option	Cutting Edge Prep.	Application & Features
MEP	S00245 0.002" X 45° + Honed Cutting Edge	High speed, continuous machining Excellent crater wear resistance
ME	S00525 0.005" X 25° + Honed Cutting Edge	General Purpose
MET	S00730 0.007" X 30° + Honed Cutting Edge	Superior fracture resistance
MEH	S01630 0.016" X 30° + Honed Cutting Edge	Interrupted high feed machining Prevention of flaking

Manufacturer's Option	Cutting Edge Prep.	Application & Features
ME	T00315 0.003" X 15°	Chamfered Sharp cutting oriented, less burring
MES	S00525 0.005" X 25° + Rounded Cutting Edge (Hone)	General Purpose
MET	S00435 0.004" X 35° + Rounded Cutting Edge (Hone)	Interrupted Cutting Stable cutting oriented