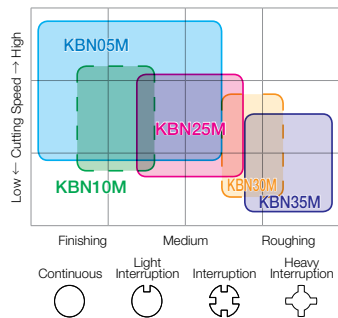


CBN TOOLS

Application Maps

Hardened Materials



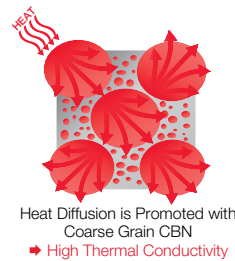
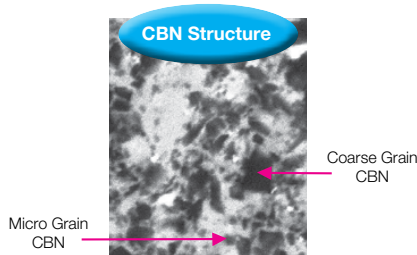
KBN05M

1st recommended grade for a wide range of applications from continuous (high speed finishing) to interrupted cutting.

Hybrid Grain Structure (KBN05M)

Mixed structure of micro grain CBN and coarse grain CBN

► CBN possesses high hardness, toughness, and thermal resistance characteristics.

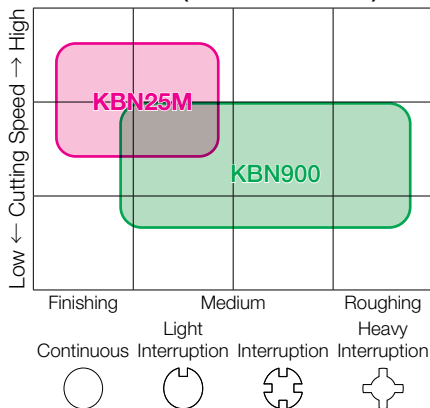


KBN25M: High Stability for General Cutting

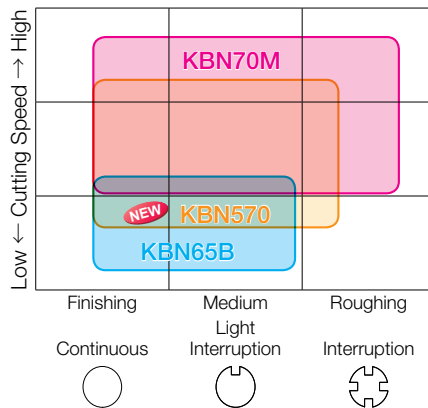
KBN30M: High Stability During Interrupted Cutting

KBN35M: Honeycomb Structure CBN with Superior Fracture Resistance in Heavy Interrupted Cutting

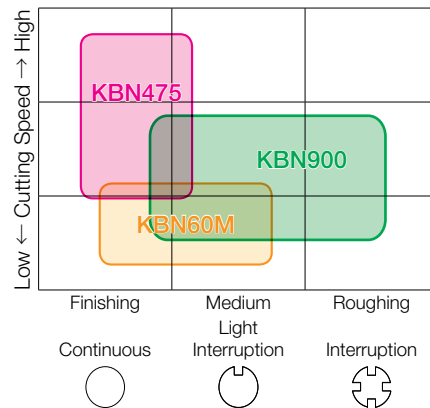
Roll Materials (Chilled Cast Iron)



Powdered Steel



Cast Iron



Recommended Cutting Conditions

Workpiece Material	Hardness	Applications		Recommended Insert Grade	Cutting Conditions		
					Vc (sfm)	D.O.C. (in)	f (ipr)
Heat Treated Steel	Over 55HRC	General Finishing	Continuous-Interruption	KBN05M	330 ~ 490 ~ 660	0.002 ~ 0.012 ~ 0.020	0.002 ~ 0.003 ~ 0.004
		High Efficiency Stable Machining	Light Interruption-Interruption	KBN25M	260 ~ 390 ~ 520	0.002 ~ 0.012 ~ 0.020	0.002 ~ 0.003 ~ 0.004
		Interruption (Small D.O.C.)	Interruption-Heavy interruption	KBN35M	200 ~ 330 ~ 490	0.002 ~ 0.008 ~ 1/64	0.002 ~ 0.003 ~ 0.004
	Under 55HRC	Heavy Machining	Continuous-Interruption	KBN900	230 ~ 300 ~ 360	0.020 ~ 0.039 ~ 0.079	0.002 ~ 0.004 ~ 0.008
Gray Cast Iron	Under 250HB	Finishing	Continuous	*PT600M	200 ~ 260 ~ 390	0.008 ~ 0.020 ~ 0.028	0.002 ~ 0.004 ~ 0.006
		Finishing	Continuous-Light interruption	KBN475	1310 ~ 2620 ~ 3940	0.002 ~ 0.008 ~ 0.020	0.004 ~ 0.008 ~ 0.012
		Finishing	Continuous-Light interruption	KBN60M	980 ~ 1640 ~ 2300	0.002 ~ 0.008 ~ 0.020	0.004 ~ 0.008 ~ 0.012
		High Efficiency Finishing	Continuous-Light interruption	KBN900	1640 ~ 2950 ~ 3940	0.004 ~ 0.020 ~ 0.039	0.002 ~ 0.004 ~ 0.008
Roll Materials (Chilled Cast Iron)	Over 55HRC	Finishing	Continuous-Interruption	KBN25M	260 ~ 390 ~ 520	0.002 ~ 0.012 ~ 0.020	0.002 ~ 0.003 ~ 0.004
		Heavy Machining	Continuous-Interruption	KBN900	230 ~ 300 ~ 360	0.012 ~ 0.028 ~ 0.039	0.002 ~ 0.004 ~ 0.006
Sintered Steel	-	Finishing	Continuous-Light interruption	KBN570	160 ~ 490 ~ 820	0.002 ~ 0.006 ~ 0.010	0.001 ~ 0.004 ~ 0.008
	-	Finishing	Continuous-Interruption	KBN70M	330 ~ 660 ~ 820	0.002 ~ 0.008 ~ 0.012	0.002 ~ 0.006 ~ 0.010

*PT600M : MEGACOAT on Al₂O₃+TiC Ceramic