

Recommended Cutting Datas

CBN Insert

ISO	Workpiece Material	Hardness	Cutting Range	Appli- cation	Grade	Min-Optimum-Max		
						Vc(m/min)	ap(mm)	f(mm/rev)
K	Gray cast iron	HB200~230	Finishing	General	BKN115P	400-600-1500	0.05-0.20-0.50	0.05-0.20-0.40
	Alloy cast iron	≥HB200	Finishing	General	BKN115P	200-400-800	0.05-0.20-0.50	0.05-0.20-0.40
	Nodular cast iron	QT450~QT700	Finishing	General	BKC120P	150-300-500	0.10-0.20-0.50	0.05-0.12-0.30
H	Hardened Material	≥HRC50	Finishing	Continous	BHC115P	120-150-220	0.05-0.10-0.20	0.05-0.10-0.20
	Hardened Material	≥HRC50	Finishing-Rounging	General	BHC125P	100-130-180	0.05-0.10-0.50	0.05-0.10-0.20
	Hardened Material	≥HRC50	Finishing-Semi-finishing	interrupt	BHC135P	80-100-150	0.05-0.10-0.40	0.05-0.10-0.20
S	Powder Metallurgy	HRB50~90	Finishing	Continous	BSN115P	50-150-300	0.05-0.20-0.50	0.05-0.12-0.30