

NON-COATED CBN SERIES

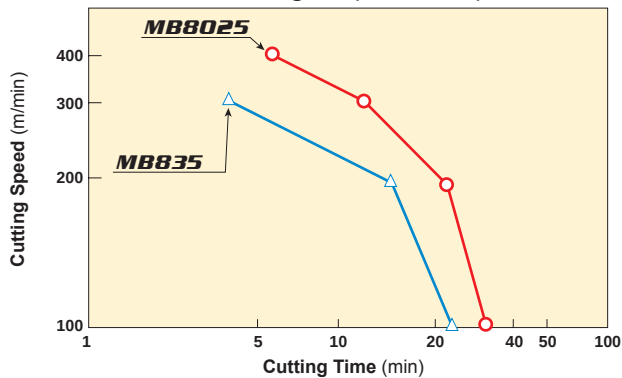
HARDENED STEEL MACHINING

Grade	Grade Features and Application	Main Component
MB8025	For General Purpose Turning, For Continuous to Light Interrupted Cutting By employing a "Particle-activated Sintering Method", the new sintered CBN technology is recommended for continuous cutting at medium to high speeds.	CBN (Micro Grain) TiN Al ₂ O ₃
MB835	For Heavy Interrupted Cutting Improved grade employing micro-grain CBN particles. Excellent fracture resistance for use in heavy interrupted cutting.	CBN (Micro Grain) TiN Al ₂ O ₃

CUTTING PERFORMANCE

Continuous Cutting

V-T Diagram (VB=0.1mm)



<Cutting Conditions>

Workpiece : Alloy steel (60HRC)

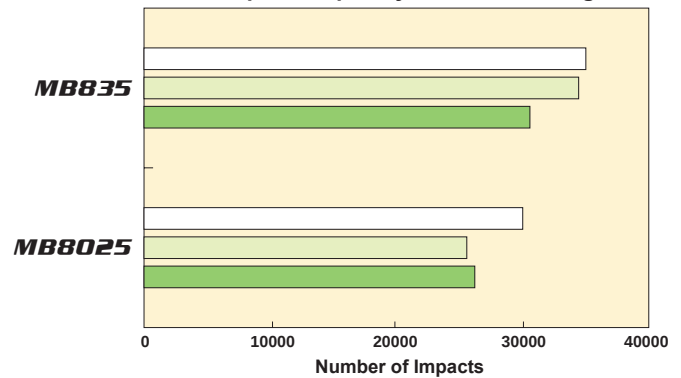
Feed : 0.1mm/rev

Depth of Cut : 0.1mm

Wet Cutting

Interrupted Cutting

Impact frequency before fracturing



<Cutting Conditions>

Workpiece : Alloy steel (60HRC)

External Interrupted

Cutting 8 Groove

Cutting Speed : 150m/min

Feed : 0.15mm/rev

Depth of Cut : 0.2mm

Dry Cutting

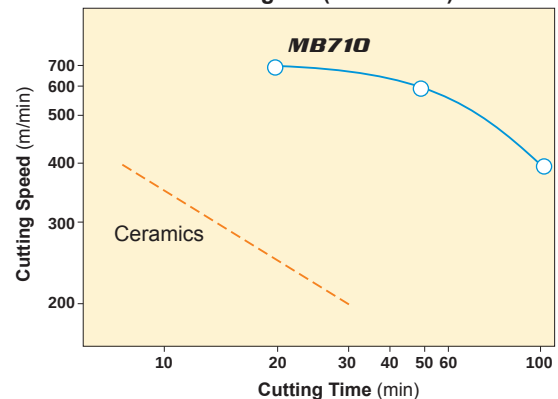
CAST IRON MACHINING

Grade	Grade Features and Application	Main Component
MB710	For General Cutting General purpose grade with well balanced wear and fracture resistance.	CBN TiC Al ₂ O ₃
MB730	For High Speed Cutting Has the larger CBN content and therefore displays good thermal conductivity. It is suitable for the high temperatures that are generated in high speed cutting.	CBN (High Content) Co Base Alloy
MB5140	For High Speed Cutting and Roughing of Cast Iron Highest CBN content, high thermal conductivity. Enables deep depth of cut.	CBN AlN (Solid)

CUTTING PERFORMANCE

Continuous Cutting

V-T Diagram (VB=0.1mm)



<Cutting Condition of **MB710**>

Workpiece : DIN GG25

Insert : TNGA160408

Feed : 0.1mm/rev

Depth of Cut : 0.15mm

Wet Cutting

<Cutting Condition of Ceramics>

Workpiece : DIN GG25

Insert : TNGA160408

Feed : 0.1mm/rev

Depth of Cut : 0.1mm

Dry Cutting