

CBN & PCD TURNING INSERTS

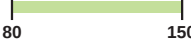
SINTERED ALLOY MACHINING

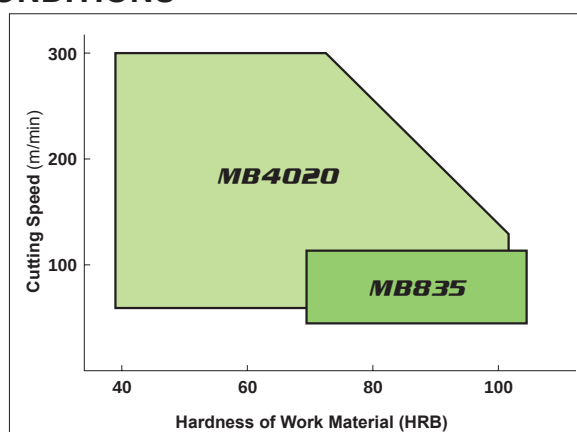
MB4020

FEATURES AND RECOMMENDED CUTTING CONDITIONS

For General Cutting

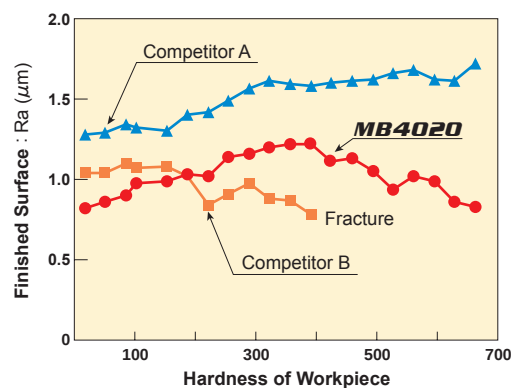
High CBN content and a special binder that bonds the CBN particles allows MB4020 to deliver long tool life during the machining of sintered alloys. A general-purpose grade suitable for the machining of various sintered alloys with different hardness and structures and varied workpiece geometries.

Work Material	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
General sintered alloy	80  300	—0.2	—0.3
High strength sintered alloy	80  250	—0.2	—0.3
Sintered alloy	80  150	—0.2	—0.3



CUTTING PERFORMANCE

Continuous cutting of high strength sintered alloy



<Cutting Conditions>

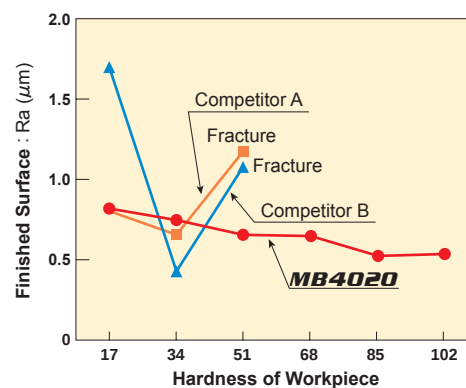
Workpiece : High strength sintered alloy Insert : NP-CNGA120408

Cutting Speed : 190m/min Feed : 0.15mm/rev

Depth of Cut : 0.1mm

Wet Cutting

Continuous cutting of sintered alloy



<Cutting Conditions>

Workpiece : Sintered alloy Insert : NP-CNGA120408

Cutting Speed : 100m/min Feed : 0.15mm/rev

Depth of Cut : 0.1mm

Wet Cutting