

CBN & PCD TURNING INSERTS

● Roll

Work Material	Grade	Recommended Cutting Conditions		
		Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
Cast Steel Adamite Cast Steel	MB8025	80 (30—130)	0.3 (0.1—0.5)	0.2—3.0
Ductile Cast Iron Granular Cast Iron Chilled Cast Iron	MB710	80 (30—130)	0.3 (0.1—0.5)	0.2—3.0
High Chromium Steel High Alloy Steel	MB8025	80 (30—130)	0.3 (0.1—0.5)	0.2—3.0
High Speed Steel	MB730	50 (20—70)	0.25 (0.1—0.4)	0.1—3.0
Cemented Carbide	MB730, MBS140	20 (10—30)	—0.2	—0.2

● Heat Resistant Alloy

Work Material	Grade	Recommended Cutting Conditions		
		Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
Ni Base Heat Resistant Alloy (e.g. Inconel)	MB730	120 (100—150)	—0.2	—0.5
Co Base Heat Resistant Alloy (e.g. Stellite)	MB730	70 (50—100)	—0.2	—0.5