PCBN

Polycrystalline Cubic Boron Nitride

HIGH QUALITY

For Hardened Steel (HRC45~65) Machining !

Features :

◎ For hardened steel (HRC45~65) machining.

◎ We used high quality PCBN material for wear resistance and heat resistance.

◎ Special design makes stable and high efficiency.

◎ 100% made in Taiwan with full size and stable quality.



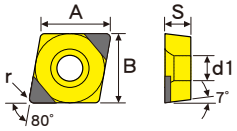
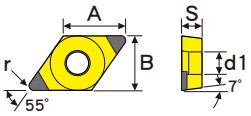
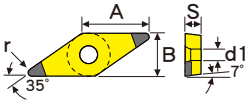
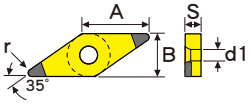
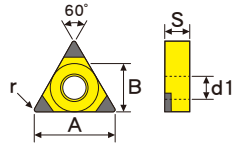
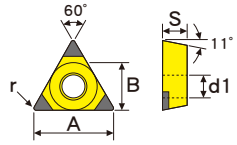
High Hardness, Wear Resistance, Heat Resistance

PCBN TURNING INSERTS

Polycrystalline Cubic Boron Nitride

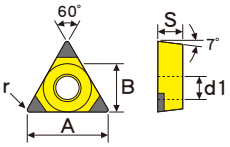
PCBN Turning Insert Size

加工材質								
	P	Alloy Steels	—	—				● First / ○ Second : Continuous Cutting ◐ First / ◔ Second : General Cutting ✱ First / ❁ Second : Interrupted Cutting — NO Recommend
	M	Stainless Steels	—	—				
	K	Cast Iron	—	—				
	N	Aluminum Alloys	—	—				F : Finishing S : Semi Finishing M : Medium R : Roughing
	S	High Temp Alloys	—	—				
	H	Hardened Steels	◐	◐				

Insert	Order No.	Grade					Dimension (mm)					Drawing
		BC9020	BC9030				A	B	S	r	d1	
	CCGW060202	●					6.35	6.35	2.38	0.2	2.8	
	CCGW060204	●					6.35	6.35	2.38	0.4	2.8	
	CCGW09T302	●					9.52	9.52	3.97	0.2	4.4	
	CCGW09T304	●					9.52	9.52	3.97	0.4	4.4	
	CCGW09T308	●					9.52	9.52	3.97	0.8	4.4	
	CCGW120402	●					12.7	12.7	4.76	0.2	5.5	
	CCGW120404	●					12.7	12.7	4.76	0.4	5.5	
F S M R	CCGW120408	●					12.7	12.7	4.76	0.8	5.5	
	DCGW070202	●					7.94	6.35	2.38	0.2	2.8	
	DCGW070204	●					7.94	6.35	2.38	0.4	2.8	
	DCGW11T302	●					11.6	9.52	3.97	0.2	4.4	
F S M R	DCGW11T304	●					11.6	9.52	3.97	0.4	4.4	
	VCGW110302	●					11.1	6.35	3.18	0.2	2.8	
	VCGW110304	●					11.1	6.35	3.18	0.4	2.8	
	VCGW160402	●					16.5	9.52	4.76	0.2	4.4	
F S M R	VCGW160404	●					16.5	9.52	4.76	0.4	4.4	
	VNGA160402	●					16.5	9.52	4.76	0.2	3.81	
	VNGA160404	●					16.5	9.52	4.76	0.4	3.81	
	VNGA160408	●					16.5	9.52	4.76	0.8	3.81	
F S M R												
	TNGA160402		●				16.5	9.52	4.76	0.2	3.81	
	TNGA160404		●				16.5	9.52	4.76	0.4	3.81	
	TNGA160408		●				16.5	9.52	4.76	0.8	3.81	
F S M R												
	TPGW080202		●				8.2	4.76	2.38	0.2	2.4	
	TPGW080204		●				8.2	4.76	2.38	0.4	2.4	
	TPGW080208		●				8.2	4.76	2.38	0.8	2.4	
F S M R												
	TPGW110302		●				11.0	6.35	3.18	0.2	3.4	
	TPGW110304		●				11.0	6.35	3.18	0.4	3.4	
	TPGW110308		●				11.0	6.35	3.18	0.8	3.4	
F S M R												

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加工材質								
	P	Alloy Steels		–				● First / ○ Second : Continuous Cutting ◐ First / ◔ Second : General Cutting ✱ First / ❁ Second : Interrupted Cutting – NO Recommend
	M	Stainless Steels		–				
	K	Cast Iron		–				
	N	Aluminum Alloys		–				F : Finishing S : Semi Finishing M : Medium R : Roughing
	S	High Temp Alloys		–				
	H	Hardened Steels		◐				

Insert	Order No.	Grade					Dimension (mm)					Drawing
		BC9020	BC9030				A	B	S	r	d1	
	TCGW110204		●				11.0	6.35	2.38	0.4	2.8	
F S M R												

PCBN Turning Insert Grades

Grade Type	Cutting Edges	CBN %	Coolant	Type of Operation
BC9020	2	90%	Dry Wet	← Continuous — General — Interrupted →
BC9030	3			

PCBN Turning Condition Table

Material	Powder Metallurgy	Hardened Steels
Material Code	—	SKT,SKD
Hardness	HB≧200	HRC45 ~ 65
Vc	80 ~ 120m/min	100 ~ 150m/min
f (mm/rev)	0.05 ~ 0.30	0.05 ~ 0.30
Ap (mm) Roughing	0.25 ~ 0.30	0.25 ~ 0.30
Ap (mm) Finishing	0.05 ~ 0.20	0.05 ~ 0.20

※ Cutting formula : S = Vc × 1000 / D/ π (3.14) F = f × S
※ For powder metallurgy, we recommend choosing the CPBN which contains CBN more than 50%.

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MADE IN TAIWAN

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PCBN TURNING INSERTS