

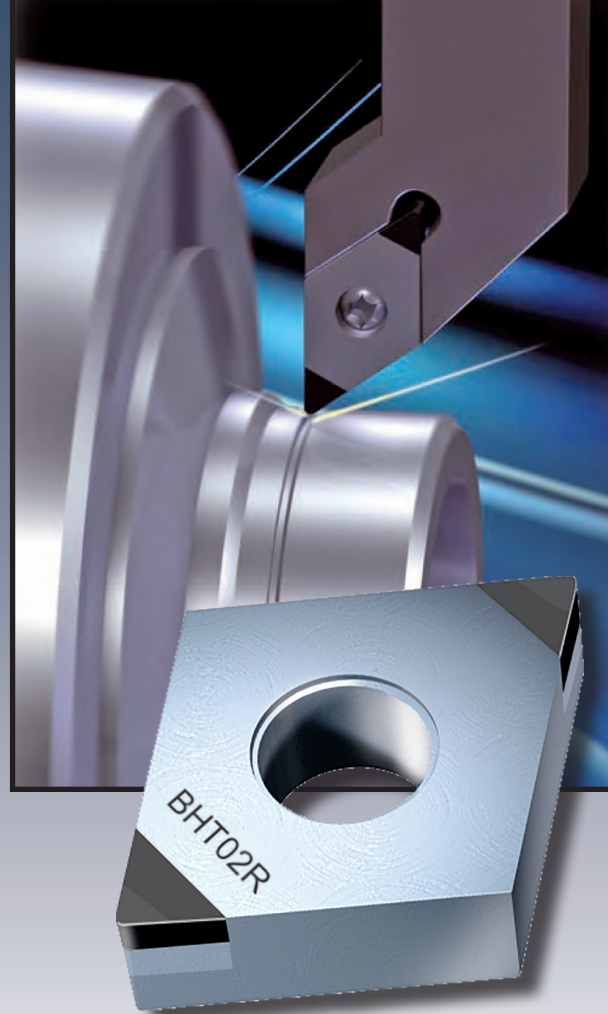
TV Carb

Advanced Cutting Materials
🇩🇪 **Made in Germany**

BHT02R

New PcBN Grade for Hard Turning

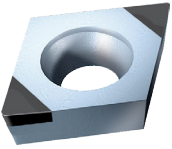
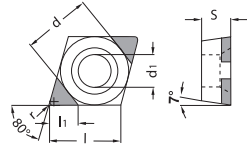
- Large range of applications for continuous and interrupted cuts
- Small grain size produces excellent surface finishes
- First choice for case hardened work pieces and hard/soft machining
- Expanded hardness range. Suitable from 32Rc and up
- Coated PcBN tips for longer tool life
- Made in Germany



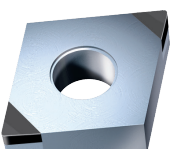
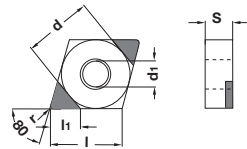


BHT02R Grade for Hard Turning

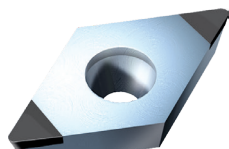
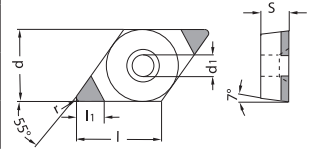
CCGW-2MC

									BHT02R				
		Designation	d	d ¹	s	l	l ¹	r	B	D	F	R	
		CCGW-21.50.5-2MC						.126	.008	●	●		
		CCGW-21.51-2MC	.250	.110	.094	.250	.110	.016		●	●	●	
		CCGW-21.52-2MC					.094	.031		●	●	●	
		CCGW-32.50.5-2MC					.126	.008			●	●	
		CCGW-32.51-2MC					.110	.016			●	●	
		CCGW-32.51W-2MC	.375	.173	.156	.375	.126	.016			●	●	
		CCGW-32.52-2MC					.094	.031			●	●	
		CCGW-32.52W-2MC					.110	.031			●	●	

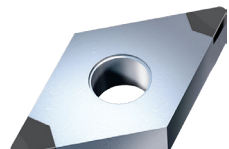
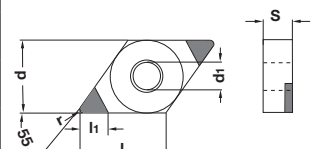
CNGA-2MC

									BHT02R				
		Designation	d	d ¹	s	l	l ¹	r	B	D	F	R	
		CNGA-431-2MC						.118	.016	●	●	●	
		CNGA-431W-2MC					.118	.016		●	●	●	
		CNGA-432-2MC	.500	.202	.187	.500	.106	.031		●	●	●	
		CNGA-432W-2MC					.106	.031		●	●	●	
		CNGA-433-2MC					.078	.047		●	●	●	
		CNGA-433W-2MC					.078	.047		●	●	●	

DCGW-2MC

									BHT02R				
		Designation	d	d ¹	s	l	l ¹	r	B	D	F	R	
		DCGW-21.50.5-2MC						.153	.008	●	●		
		DCGW-21.51-2MC	.250	.110	.094	.305	.138	.016		●	●	●	
		DCGW-21.52-2MC					.118	.031		●	●	●	
		DCGW-32.50.5-2MC					.153	.008			●	●	●
		DCGW-32.51-2MC	.375	.173	.156	.456	1.38	.016			●	●	●
		DCGW-32.52-2MC					.118	.031			●	●	●

DNGA-2MC*

									BHT02R				
		Designation	d	d ¹	s	l	l ¹	r	B	D	F	R	
		DNGA-441-2MC	.500	.201	.250	.610	.228	.016			●	●	
		DNGA-441L/RW-2MC**					.216	.016			●	●	
		DNGA-442-2MC	.500	.201	.250	.610	.216	.031			●	●	
		DNGA-442L/RW-2MC**					.200	.031			●	●	
		DNGA-443-2MC	.500	.201	.250	.610	.200	.047			●	●	
		DNGA-443L/RW-2MC**					.188	.047			●	●	

* May require thinner shim in toolholder. ** L used for Internal, R used for External

Ordering Example: CCGW-32.51-D-2MC BHT02R



BHT02R Grade for Hard Turning

SCGW-4MC

		BHT02R											
		Designation	d	d ¹	s	l	l ¹	r	B	D	F	R	
		SCGW-32.50.5-4MC						.110	.008	●	●		
		SCGW-32.51-4MC	.375	.173	.156	.375		.110	.016	●	●		
		SCGW-32.52-4MC						.102	.031	●	●		

TCGW-3MC

		BHT02R											
		Designation	d	d ¹	s	l	l ¹	r	B	D	F	R	
		TCGW-1.81.50.5-3MC						.102	.008	●	●		
		TCGW-1.81.51-3MC	.218	.098	.094	.378		.087	.016	●	●		
		TCGW-1.81.52-3MC						.071	.031	●	●		
		TCGW-21.50.5-3MC						.114	.008		●	●	
		TCGW-21.51-3MC	.250	.110	.094	.378		.098	.016		●	●	
		TCGW-21.52-3MC						.083	.031		●	●	

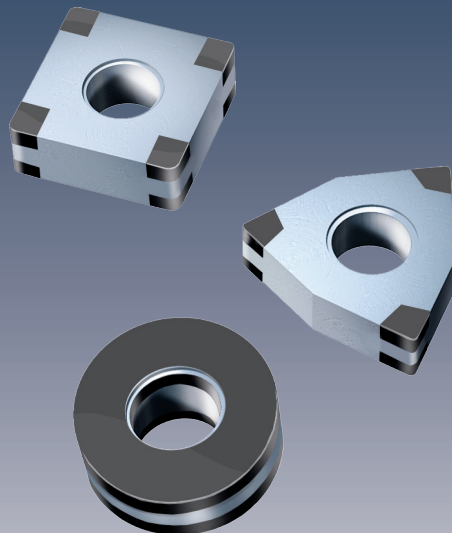
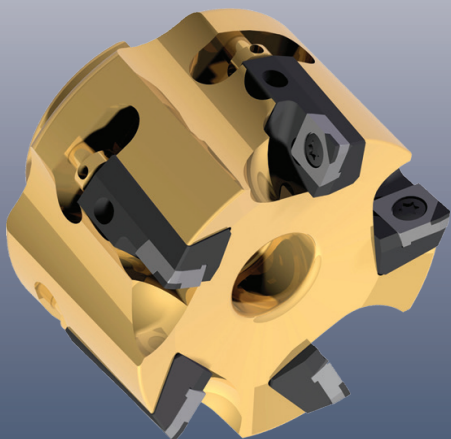
VCGW-2MC

		BHT02R											
		Designation	d	d ¹	s	l	l ¹	r	B	D	F	R	
		VCGW-220.5-2MC						.200	.008	●	●	●	
		VCGW-221-2MC	.250	.114	.125	.433		.185	.016	●	●	●	
		VCGW-222-2MC						.149	.031	●	●	●	
		VCGW-330.5-2MC						.212	.008		●	●	●
		VCGW-331-2MC	.375	.173	.187	.649		.197	.016		●	●	●
		VCGW-332-2MC						.161	.031		●	●	●

Ordering Example: VCGW-221-D-2MC BHT02R

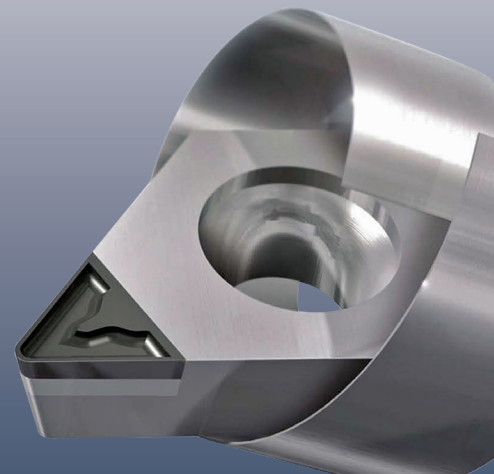
Other Superabrasive Tooling Offered

TCP90 Milling Cutters



"Sandwich" CBN

Laser ChipBreaker Program





BHT02R Technical Information

BHT02R – New low content coated PcBN grade for machining hardened steel. The BHT02R grade is a micro-grain PcBN which produces excellent surface finishes and operates in a wider range of hardnesses over conventional PcBN grades. BHT02R is an excellent choice for machining case hardened materials where there is a possibility of cutting into soft materials. This new PcBN grade can handle hardness 32Rc and up in continuous and slightly interrupted cuts.

Cutting Edge Preparation for BHT Series		
cutting edge prep	chamfer design	
	width	angle
B	-	-
D	.0004"	15
F	.0006"	25
R	trumpet profile	

Application Recommendation	
cutting edge prep	Application
B	Internal machining and external machining of unstable workpieces. Suitable for hard/soft machining.
D	Internal and external machining with excellent surface finish. Suitable for hard/soft machining.
F	External machining of stable workpieces, excellent surface finish. Can be used in interrupted cut.
R	External machining, very good surface finish, medium cutting pressure, hard/soft machining. Can be used in interrupted cut.

Recommended Cutting Data						
cutting edge prep	cutting speed		feed rate f (in/rev)		depth of cut ap (in)	
	min	max	min	max	min	max
B	525	790	0.001	0.006	0.002	0.012
D	460	656	0.002	0.008	0.003	0.012
F	395	590	0.002	0.010	0.004	0.016
R	425	690	0.002	0.008	0.003	0.012



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