



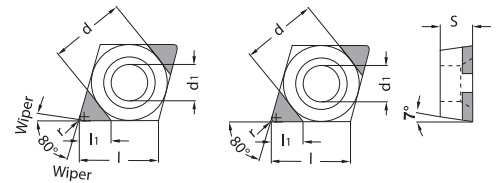
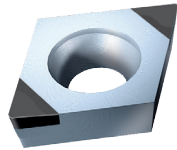
"SANDWICH" CBN Program

Advanced Cutting Materials
 Made in Germany

With technology advancing continuously in ultrahard cutting materials, the new "SANDWICH" CBN is now available. This new design allows multiple corners or double full face negative inserts with a very strong high temperature vacuum braze. With this advancement in technology, it provides higher insert integrity and lower cost per corner.

To go along with this new technology, the "SANDWICH" inserts are being introduced in 4 grades with a specially designed coating that resists tribo-oxidation, adhesion, or diffusion. In turn the coating increases wear resistance and dissipates heat from the cutting edge more efficiently thus drastically improving tool life and surface finish.

The "SANDWICH" CBN inserts are offered in the largest selection of stocked edge preps on the market. This range of 8 different edge preps will allow complete optimization to fully suit your application needs.

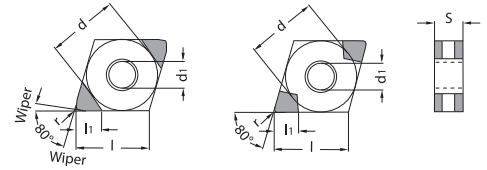
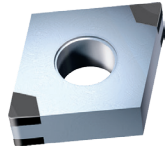


CCGW-2MC

Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S												
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H					
CCGW-21.50.5-?-2MC					.126	.008	•		•	•					•			•	•									•		•	•	•	•			•		•	•	•	•		
CCGW-21.51-?-2MC	.250	.110	.094	.254	.110	.016	•	•	•	•	•	•	•	•		•	•	•	•	•	•	•						•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
CCGW-21.52-?-2MC					.094	.031		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
CCGW-32.50.5-?-2MC					.126	.008	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•						•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
CCGW-32.51-?-2MC	.375	.173	.156	.382	.110	.016		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
CCGW-32.52-?-2MC					.094	.031	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•						•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
CCGW-21.50.5W-?-2MC					.126	.008	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•						•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
CCGW-21.51W-?-2MC	.250	.110	.094	.254	.110	.016	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•						•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
CCGW-32.51W-?-2MC					.126	.016	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•						•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
CCGW-32.52W-?-2MC	.375	.173	.156	.382	.110	.031		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•						•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•

Ordering Example: CCGW-32.51W-D-2MC PBC-10S
W= Wiper Edge

Letters represent various edge preps available, please see designation chart for cutting parameters.

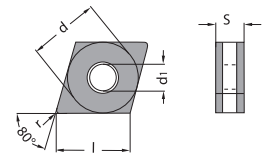
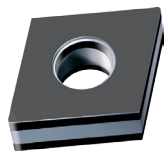


CNGA-4SC

Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S													
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H						
CNGA-431-?-4SC					.110	.016	●				●	●			●	●	●	●	●	●	●	●							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
CNGA-432-?-4SC	.500	.202	.187	.508	.098	.031	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
CNGA-433-?-4SC					.087	.047	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
CNGA-431W-?-4SC					.110	.016	●				●	●			●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
CNGA-432W-?-4SC	.500	.202	.187	.508	.098	.031	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Ordering Example: CNGA-432-F-4SC PBC-40S
W= Wiper Edge

Letters represent various edge preps available, please see designation chart for cutting parameters.

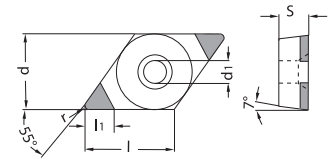
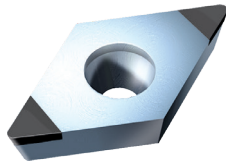


CNGA-SE

Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S												
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H					
CNGA-432-?-SE					--	.031	●	●							●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
CNGA-433-?-SE	.500	.202	.190	.510	--	.047	●	●							●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Ordering Example: CNGA-432-D-SE PBC-15S

Letters represent various edge preps available, please see designation chart for cutting parameters.

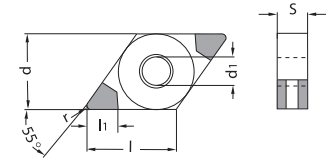
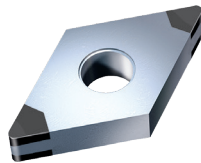


DCGW-2MC

Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S												
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H					
DCGW-21.50.5-?-2MC					.134	.008	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
DCGW-21.51-?-2MC	.250	.110	.094	.305	.118	.016	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
DCGW-21.52-?-2MC					.102	.031	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
DCGW-32.50.5-?-2MC					.134	.008	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
DCGW-32.51-?-2MC	.375	.173	.156	.457	.118	.016	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
DCGW-32.52-?-2MC					.102	.031	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Ordering Example: DCGW-21.51-F-2MC PBC-15S

Letters represent various edge preps available, please see designation chart for cutting parameters.

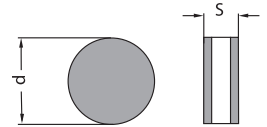


DNGA-4SC

Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S												
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H					
DNGA-431-?-4SC					.110	.016	●				●	●			●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
DNGA-432-?-4SC	.500	.202	.187	.610	.098	.031	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Ordering Example: DNGA-431-G-4SC PBC-10S

Letters represent various edge preps available, please see designation chart for cutting parameters.

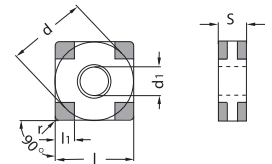
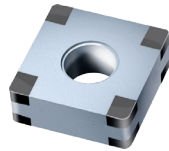


RNGN-SE

Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S													
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H						
RNGN-090300-?-SE	.375		.125		--	--	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
RNGN-120300-?-SE	.500	--	.125	--	--	--	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
RNGN-120400-?-SE	.500		.187		--	--	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Ordering Example: RNGN-120300-F-SE PBC-15S

Letters represent various edge preps available, please see designation chart for cutting parameters.

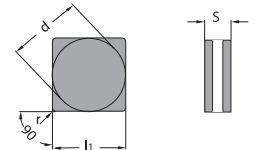
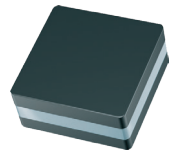


SNGA-8SC

Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S													
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H						
SNGA-432-?-8SC	.500	.202	.187	.500	.110	.031	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
SNGA-433-?-8SC					.102	.047	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Ordering Example: SNGA-432-C-8SC PBC-10S

Letters represent various edge preps available, please see designation chart for cutting parameters.

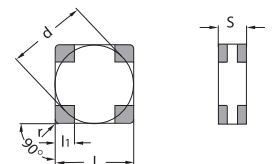
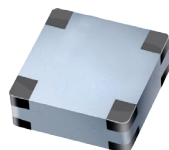


SNGN-SE

Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S													
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H						
SNGN-322-?-SE	.370	--	.125	.375	--	.031	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
SNGN-422-?-SE	.500	--	.125	.500	--	.031	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
SNGN-432-?-SE						.031	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
SNGN-433-?-SE	.500	--	.187	.500	--	.047	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Ordering Example: SNGN-432-F-SE PBC-25S

Letters represent various edge preps available, please see designation chart for cutting parameters.



SNGN-8SC

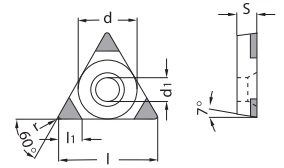
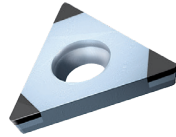
Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S													
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H						
SNGN-432-?-8SC	.500	--	.187	.500	.110	.031	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
SNGN-433-?-8SC					.102	.047	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Ordering Example: SNGN-433-D-8SC PBC-40S

Letters represent various edge preps available, please see designation chart for cutting parameters.



Sandwich CBN Inserts

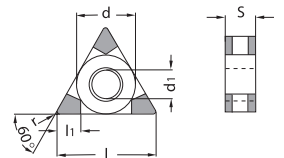
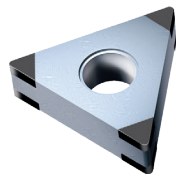


TCGW-3MC

Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S							
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H
TCGW-1.81.50.5-?-3MC						.102	.008	•	•	•					•	•	•	•					•	•		•					•	•	•					
TCGW-1.81.51-?-3MC	.219	.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	.433	.098	.016			•	•	•		•	•	•	•		•	•	•	•	•	•	•	•	•	•			•	•	•	•	•	•			
TCGW-21.52-?-3MC					.083	.031	•		•	•	•			•	•	•		•				•		•	•	•	•			•	•		•	•	•			
TCGW-32.51-?-3MC					.126	.016	•		•	•				•	•							•	•		•		•			•	•	•	•	•	•		•	
TCGW-32.52-?-3MC	.375	.173	.156	.650	.106	.031			•	•	•			•	•	•		•	•	•	•	•	•	•	•	•	•			•	•	•	•	•	•			

Ordering Example: TCGW-1.81.51-C-3MC PBC-15S

Letters represent various edge preps available, please see designation chart for cutting parameters.

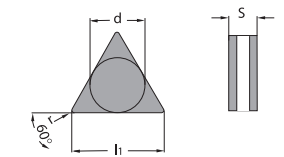
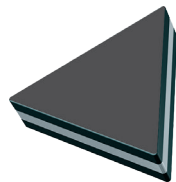


TNGA-6SC

Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S							
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H
TNGA-331-?-6SC					.110	.016	•				•	•	•		•	•	•	•	•		•		•	•		•	•	•			•		•	•	•	•		
TNGA-332-?-6SC	.375	.150	.187	.650	.098	.031	•	•	•	•	•	•			•	•	•	•	•	•	•	•	•	•	•	•	•	•	•		•	•	•	•	•	•	•	
TNGA-333-?-6SC					.087	.047	•				•	•	•		•	•	•	•	•	•	•	•	•	•		•	•	•			•		•	•	•	•		

Ordering Example: TNGA-333-C-6SC PBC-15S

Letters represent various edge preps available, please see designation chart for cutting parameters.



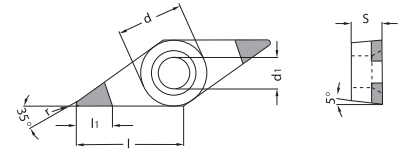
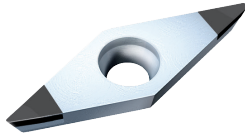
TNGN-SE

Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S							
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H
TNGN-221-?-SE						.016	•	•	•					•	•	•	•					•	•	•	•					•		•	•	•	•			
TNGN-222-?-SE	.250	--	.125	.433		.031	•	•	•					•	•	•	•					•	•	•	•					•		•	•	•	•			
TNGN-331-?-SE						.016	•	•	•					•	•	•	•					•	•	•	•					•		•	•	•	•			
TNGN-331-?-SE	.375	--	.187	.650		.031	•	•	•					•	•	•	•					•	•	•	•					•		•	•	•	•			
TNGN-333-?-SE						.047	•	•	•					•	•	•	•					•	•	•	•					•		•	•	•	•			

Ordering Example: TNGN-221-B-SE PBC-15S

Letters represent various edge preps available, please see designation chart for cutting parameters.

VBGW-2MC

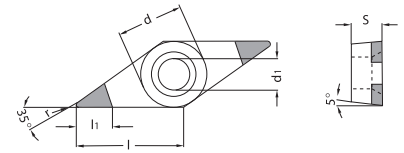
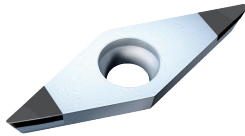


Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S																																
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H																									
VBGW-331-?-2MC	.375	.173	.187	.654	.122	.016	●		●	●	●	●			●	●	●	●	●	●	●	●							●	●	●	●	●	●	●	●										●	●	●	●	●	●	●	●										
VBGW-332-?-2MC					.098	.031			●	●	●	●					●	●	●	●	●	●									●	●	●	●	●	●												●	●	●	●	●	●										

Ordering Example: VBGW-331-E-2MC PBC-10S

Letters represent various edge preps available, please see designation chart for cutting parameters.

VCGW-2MC

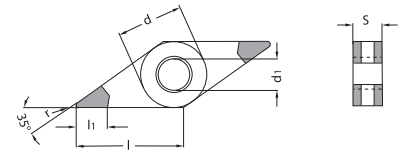
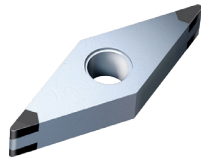


Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S																																
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H																									
VCGW-221-?-2MC	.250	.114	.125	.437	.122	.016	●		●	●	●	●			●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●										●	●	●	●	●	●	●	●											
VCGW-222-?-2MC					.098	.031			●	●	●	●					●	●	●	●	●	●								●	●	●	●	●	●												●	●	●	●	●	●											
VCGW-331-?-2MC	.375	.173	.187	.654	.122	.016	●		●	●	●	●			●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●										●	●	●	●	●	●	●	●											
VCGW-332-?-2MC					.098	.031			●	●	●	●					●	●	●	●	●	●								●	●	●	●	●	●													●	●	●	●	●	●										

Ordering Example: VCGW-331-E-2MC PBC-10S

Letters represent various edge preps available, please see designation chart for cutting parameters.

VNGA-4SC

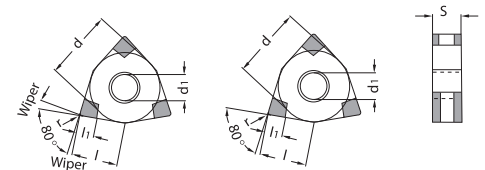
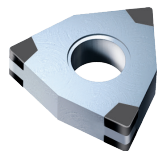


Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S																															
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H																								
VNGA-331-?-4SC	.375	.150	.187	.654	.110	.016	●			●	●	●	●		●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●										●	●	●	●	●	●	●	●										
VNGA-332-?-4SC					.087	.031			●	●	●	●					●	●	●	●	●	●								●	●	●	●	●	●												●	●	●	●	●	●										

Ordering Example: VNGA-331-C-4SC PBC-15S

Letters represent various edge preps available, please see designation chart for cutting parameters.

WNGA-6SC



Designation	Dimensions						PBC-10S								PBC-15S								PBC-25S								PBC-40S																															
	d	d ¹	s	l	l ¹	r	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H	A	B	C	D	E	F	G	H																								
WNGA-431-?-6SC					.110	.016	●				●	●	●		●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●										●	●	●	●	●	●	●	●										
WNGA-432-?-6SC	.500	.202	.187	.335	.098	.031	●	●	●	●	●	●	●		●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●										●	●	●	●	●	●	●	●										
WNGA-433-?-6SC					.087	.047	●			●	●	●	●		●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●										●	●	●	●	●	●	●	●										
WNGA-431W-?-6SC	.500	.202	.187	.335	.110	.016	●			●	●	●	●		●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●										●	●	●	●	●	●	●	●										
WNGA-432W-?-6SC					.098	.031	●	●	●	●	●	●	●		●	●	●	●	●	●	●	●						●	●	●	●	●	●	●	●										●	●	●	●	●	●	●	●										

Ordering Example: WNGA-432W-C-6SC PBC-10S

W= Wiper Edge

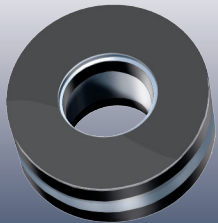
Letters represent various edge preps available, please see designation chart for cutting parameters.



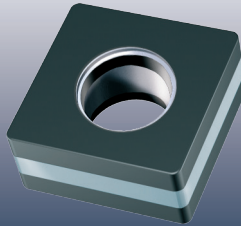
Sandwich CBN Grades & Cutting Parameters

TyCarb	ISO	Composition - Performance	Application
PBC-10S	BH-C	Coated PcBN grade with a very high content of CBN (95%) in sandwich performance. Fine grain, higher wear resistance and toughness than PBC-10 in the HSC-range.	Grey cast iron (GG25) Sintered powdered alloys Super alloys
PBC-15S	BH-C	Coated PcBN grade with high content of CBN (90%) in sandwich performance. Fine grain, high wear resistance and toughness at lower cutting speed than with PBC-10S.	Nodular cast iron Grey cast iron Sintered powdered alloys Super alloys
PBC-25S	BL-C	Coated PcBN grade with low content of CBN (65%) in sandwich performance. Super fine grain, very high wear resistance, compressive strength and toughness for hard turning with continuous cut.	Hard turning, dry + wet HRc = 48 - 62 ap = 0.001" - 0.016" Ra = 8 - 125 RMS
PBC-40S	BL-C	Coated PcBN grade with low content of CBN (55%) in sandwich performance. Super fine grain, very high wear resistance, compressive strength and toughness for hard turning with continuous to extremely interrupted cut.	Hard turning, dry + wet HRc = 48 - 65 ap = 0.002" - 0.020" Ra = 4 - 125 RMS

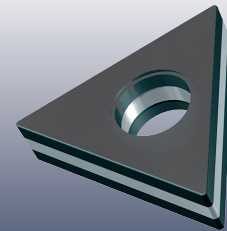
Other Insert Styles Also Available:



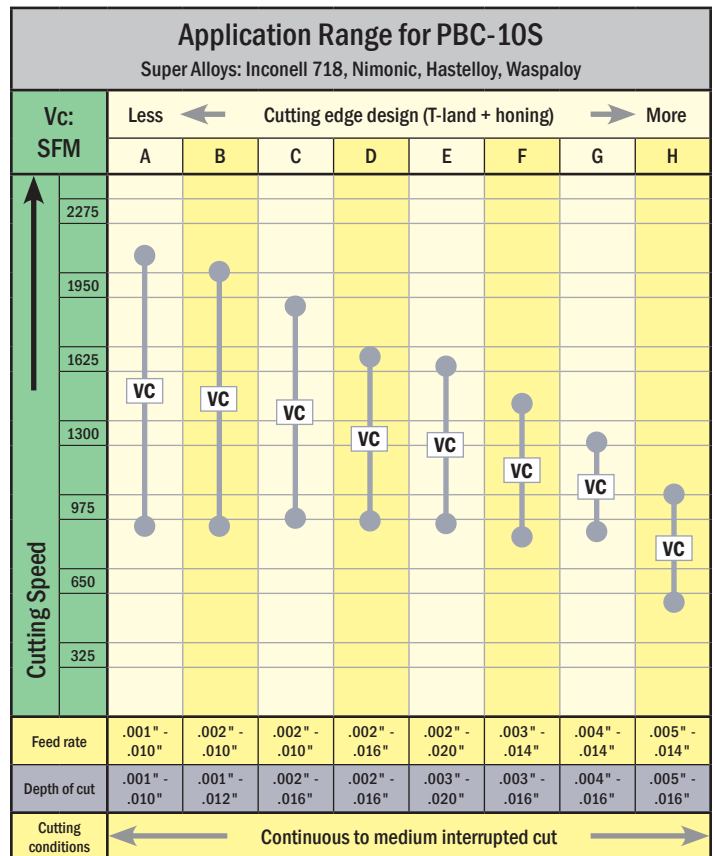
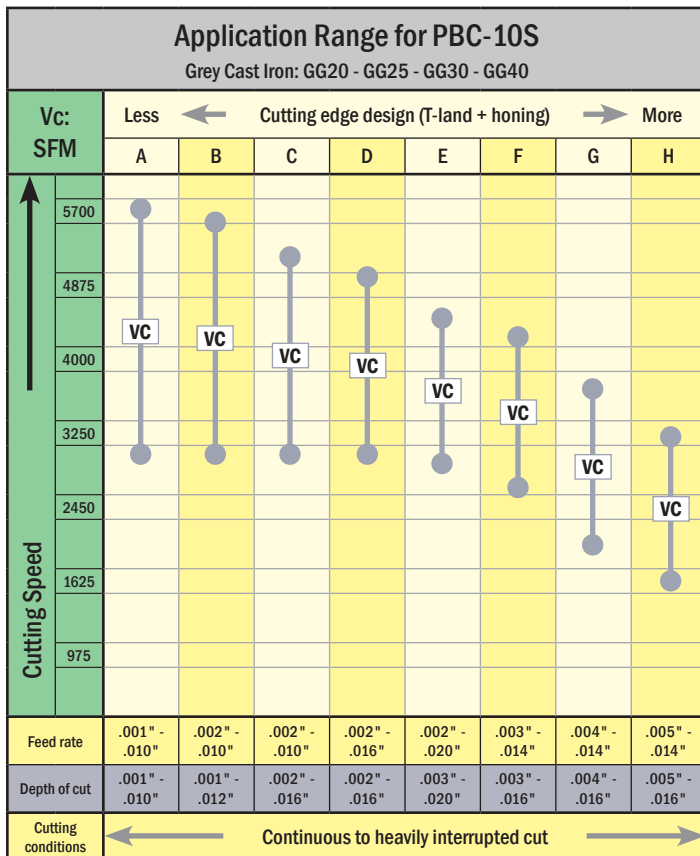
RNGA



SNGA

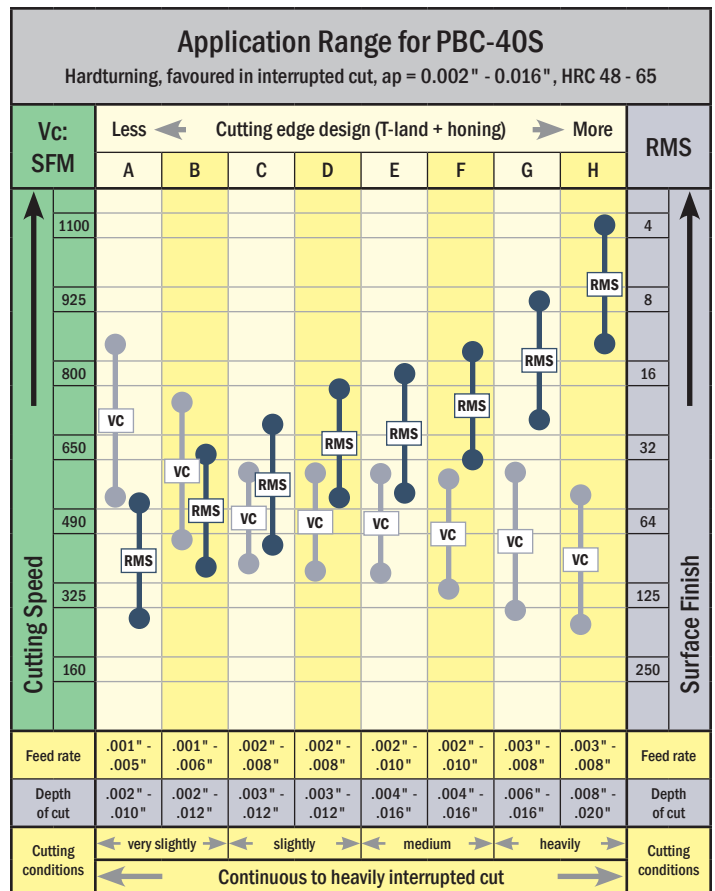
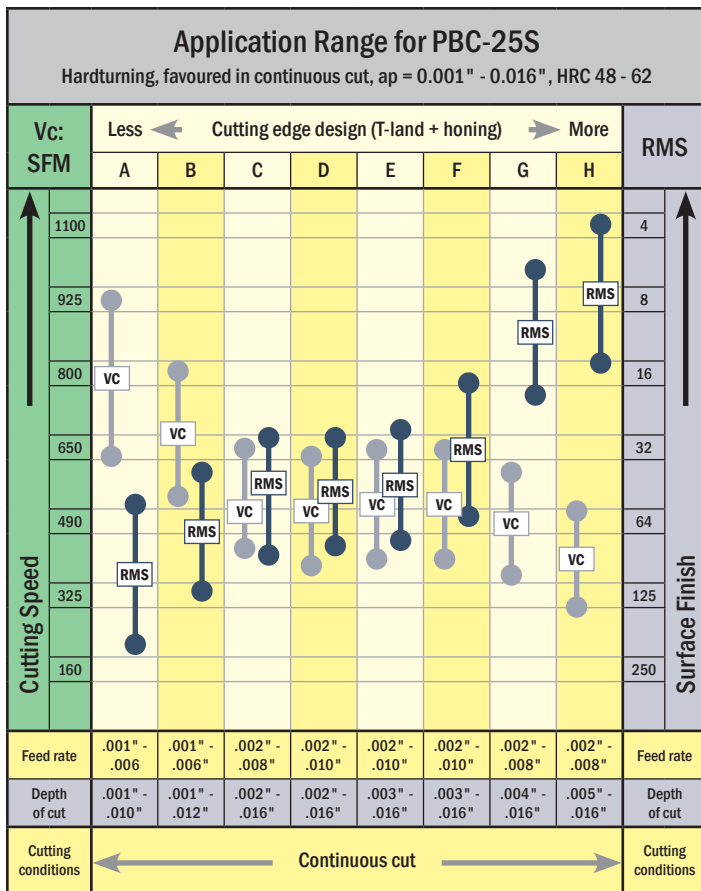
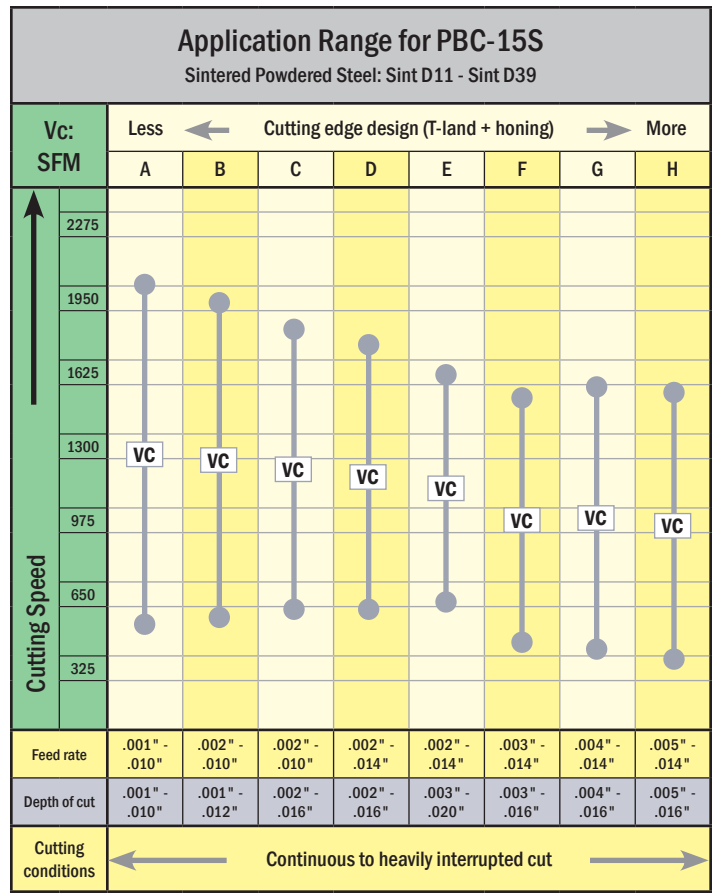
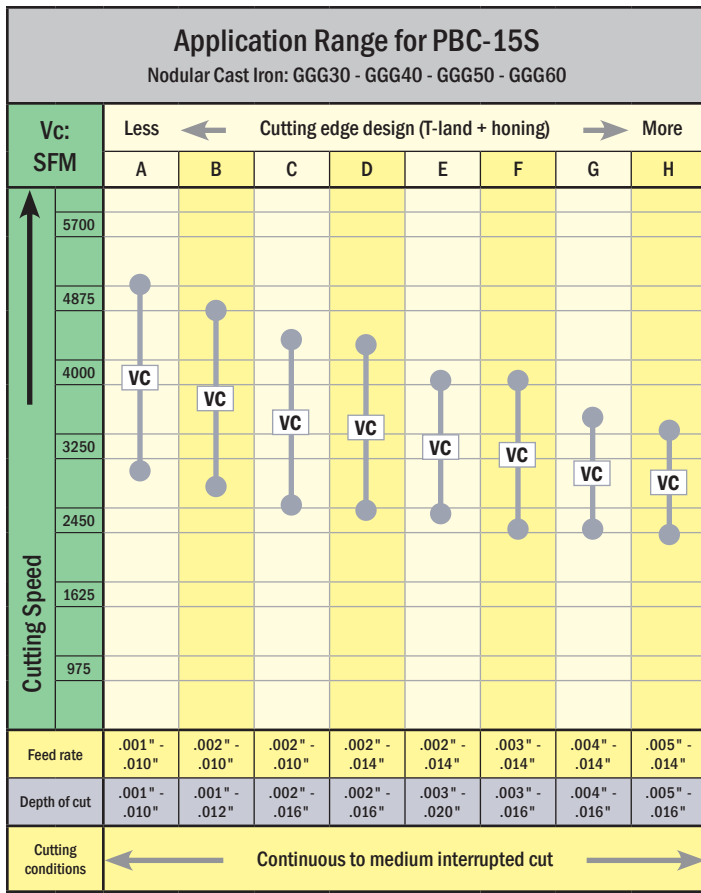


TNGA





Sandwich CBN Cutting Parameters

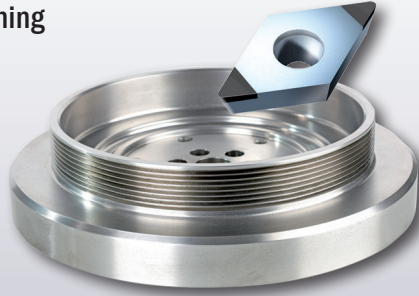




Sandwich CBN Inserts

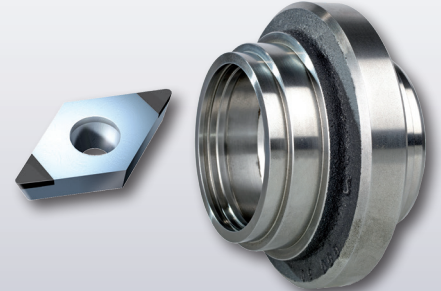
CBN Inserts For Cast Iron, Powdered Sintered Metals & Finishing of Super-Alloys

PBC-10S - for high cutting speed and long tool life in machining of all cast irons, powdered / sintered metals, and finishing of super-alloys



For example: Bearing, GGG 60, diameter 200 mm
Insert Used: DCGW-21.52-D-2MC PBC-10S
Super finishing: $V_c = 2952$ SFM, $a_p = 0.012"$, $f = 0.011$ IPR
Tool life: 120 parts
For comparison only: coated carbide insert: 15 parts, 720 SFM

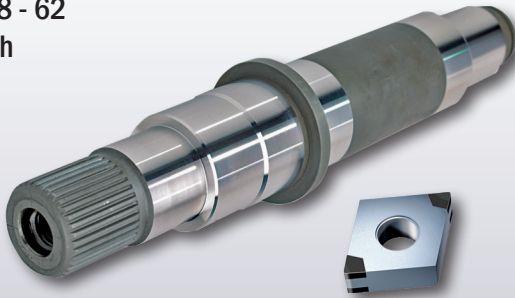
PBC-15S - for extremely high tool life in machining of nodular cast irons and powdered / sintered metals



For example: FLC-4608 Powdered Metal
Insert Used: DCGW-32.52-E-2MC PBC-15S
Super finishing: $V_c = 475$ SFM, $a_p = .012"$, $f = .010$ IPR
Tool life: 350 parts
Competitor's Insert: 250 parts

TyCarb CBN Inserts For Hard Turning Applications

PBC-25S - favoured in continuous cut
Hardness: HRc 48 - 62
Best surface finish



For example: drive shaft HRc 60,
Mat: 4145 Steel
Insert Used: CNGA-432-E-4SC PBC-25S
Super-finishing: $V_c = 585$ SFM, $a_p = 0.010"$, $f = 0.004$ ipr
Surface finish: RMS = 7.2

PBC-40S - favoured in interrupted cut
Hardness: HRc 48 - 65
Highest tool life



For example: Gear HRc 58,
Mat: 4130 Steel
Insert Used: CNGA-432-G-4SC PBC-40S
Super-finishing: $V_c = 750$ SFM, $a_p = 0.0087"$, $f = 0.007$ ipr
Surface finish: RMS = 16



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