



CBN Insert

SBN30

Tungaloy Report No. 568-G

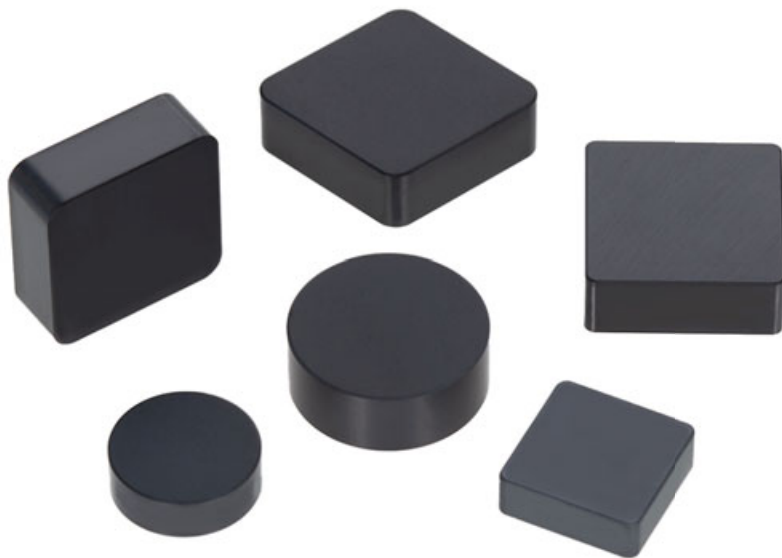
New solid CBN grade for high speed machining of cast iron







SBN30



New economical solid CBN insert

Solid CBN grade for cast iron machining

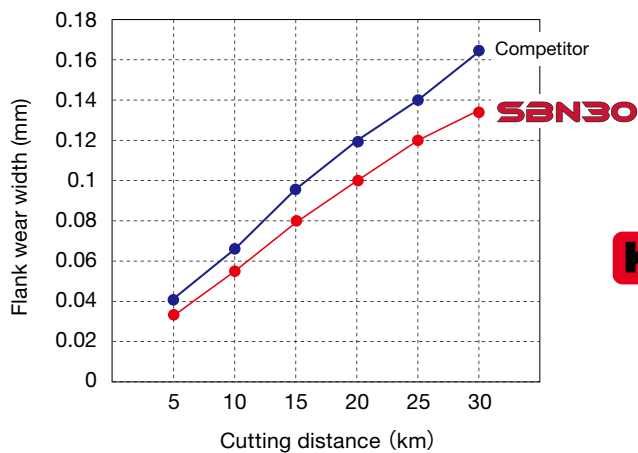


SBN30

- A solid CBN grade, SBN30 is made primarily of polycrystalline cubic boron nitride (PcBN) material with no carbide backing. This allows for a greater cutting depth at increased feeds and speeds.
- Featuring the CBN grain size optimized for cast iron applications, combined with a dedicated binder, the grade provides the insert with unparalleled wear and fracture resistance.

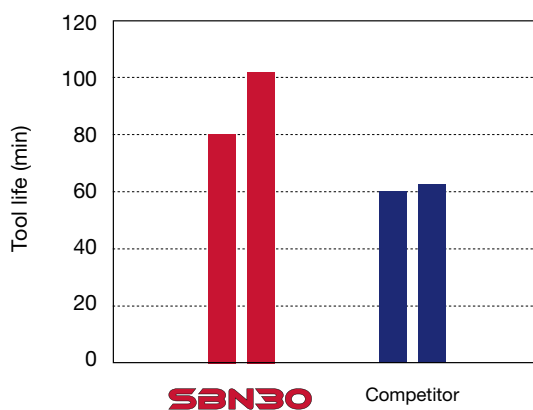
CUTTING PERFORMANCE

■ Turning



K	Toolholder	: TSKNL2525M1204-F
	Insert	: S-SNUN12041HU6
	Workpiece material:	FC200 / 200
	Cutting speed	: $V_c = 900$ m/min
	Feed	: $f = 0.4$ mm/rev
	Depth of cut	: $a_p = 0.5$ mm
	Machining	: Continuous cutting on face surface
	Coolant	: Wet

■ Milling



K	Cutter	: TGN4205R-A (ø125 mm, z = 8)
	Insert	: S-SNUN12041HU6
	Workpiece material:	FC300 / 300
	Cutting speed	: $V_c = 1,500$ m/min
	Feed per tooth	: $f_z = 0.1$ mm/t
	Depth of cut	: $a_p = 1$ mm
	Width of cut	: $a_e = 80$ mm
	Machining	: Face milling
	Coolant	: Dry



● : New product

IC : 9.525 mm
S : 3.18 mm



● : New product

IC : 12.7 mm
S : 4.76 mm



● : New product

IC : 9.525 mm
S : 3.18 mm



Square without hole

[illegible]

● : New product

Diagram illustrating the dimensions of the component:

- IC : 12.7 mm
- S : 4.76 mm

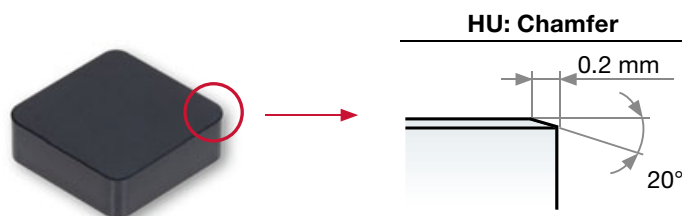


Square without hole

[illegible]

● : New product

Available for high speed cutting of cast irons



S

ISO	Workpiece material	Operation	Grade	Cutting speed V _c (m/min)	Depth of cut a _p (mm)	Feed f (mm/rev)
	Grey cast iron FC250, etc. 250, etc.	Turning	SBN30	300 - 2000	0.08 - 4	0.05 - 0.5
		Milling	SBN30	300 - 2000	0.08 - 3	0.05 - 0.5

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