




## GRADES

Application	Grade	Microstructure	Hardness (Hv)	T.R.S. (GPa)	Grade property
	<b>BX470</b>		4100 - 4300	1.90 - 2.10	Fine grained PcBN grade most suited for ferrous powder metal. Excellent edge quality reduces burr formation
	<b>BX480</b>		4100 - 4300	1.90 - 2.10	High cBN content PcBN grade with well-sintered medium-sized cBN grains. Suited for interrupted cuts of ferrous powder metal and high speed turning of gray cast iron

## STANDARD CUTTING CONDITIONS

Application	Grade	Cutting speed $V_c$ (m/min)	Depth of cut $a_p$ (mm)	Feed $f$ (mm/rev)
	BX470	100 - 300	0.05 - 0.50	0.05 - 0.30
	BX480	100 - 350	0.05 - 0.50	0.05 - 0.30
	BX480	300 - 1,200	0.05 - 0.50	0.05 - 0.30

## Designation system for honing

Example:

Honing width: 0.13 mm

Honing angle:  $-25^\circ$

Tough honing



Shape

Honing width (W)

Honing angle ( $\alpha$ )

T ... Chamfered honing

S ... Tough honing

F ... Sharp edge

