New coated CBN grades

BXM series

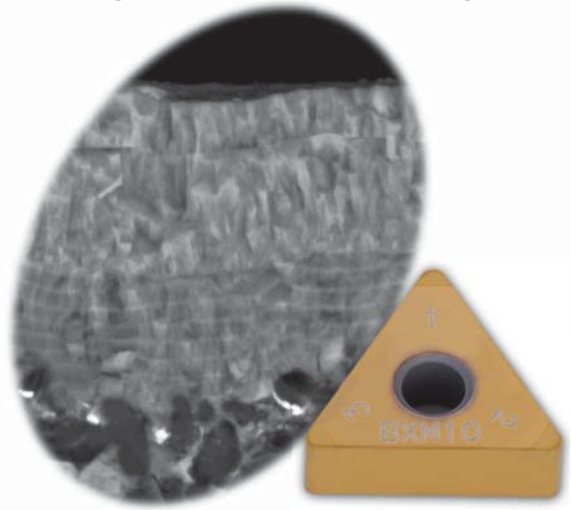
Applicable for all types of hard

NEW For high speed machining

BXM10

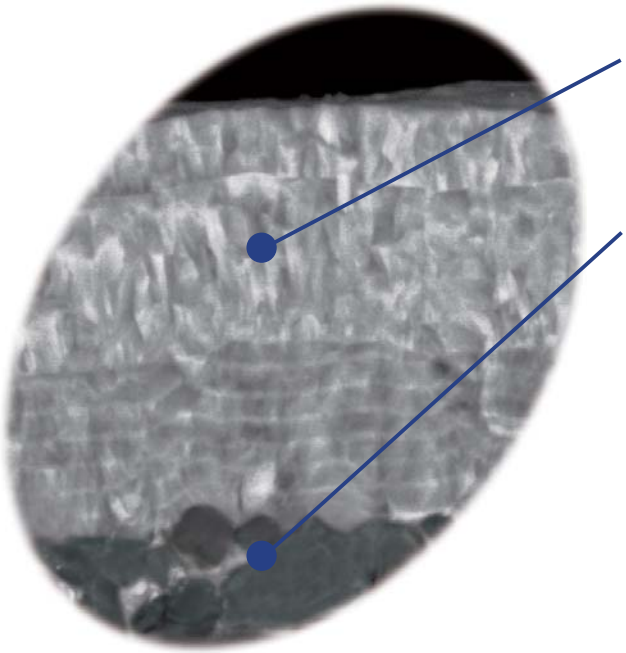
Continuous cutting

Excellent crater wear resistance !
Newly developed CBN substrate for high speed cutting !



NEW All-round

BXM20



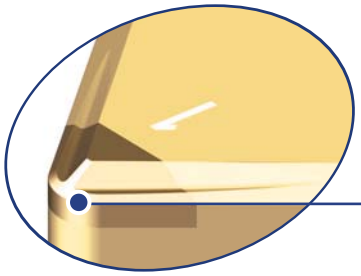
● Standard cutting condition

Application	Grades	Machining Mode	Cutting speed *Vc* (m/min)	Depth of cut *ap* (mm)	Feed *f* (mm/rev)
H Hard Materials	BXM10	Continuous	**200** (150 - 350)	**0.1** (0.05 - 0.30)	**0.1** (0.03 - 0.18)
		Light interrupted	**170** (150 - 250)	**0.1** (0.05 - 0.30)	**0.1** (0.03 - 0.15)
	BXM20	Continuous	**150** (70 - 220)	**0.2** (0.05 - 0.30)	**0.1** (0.05 - 0.25)
		Interrupted	**150** (70 - 220)	**0.1** (0.05 - 0.30)	**0.1** (0.05 - 0.15)

“Hard Breakers” for removing the carburized layer

Two types of chipbreaker provide excellent chip control in a wide application range !

HF type For finishing

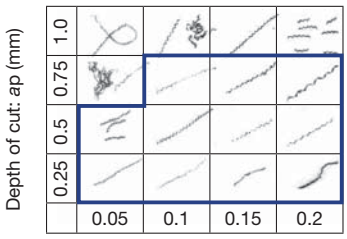


Single sided CBN insert provides higher stability in heavy machining.

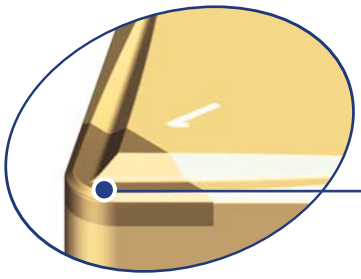
Excellent chip control in small DoC due to the high functional nose. Delivers exceptional surface finishes.

■ Example of chips

● HF Chipbreaker



HM type For medium cutting

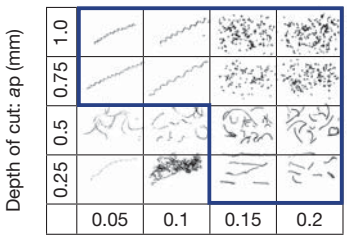


Single sided CBN insert provides higher stability in heavy machining.

Providing ideal chip control in large DoC by the well designed chipbreaker. Suitable for medium cutting or roughing.

■ Example of chips

● HF Chipbreaker



● Standard cutting condition (for removing the carburized layer)

Application	Grades	Chipbreaker	Cutting speed *Vc* (m/min)	Depth of cut *ap* (mm)	Feed *f* (mm/rev)
H Hard Materials	BXM20	HF	**150** (70 - 220)	**0.4** (0.2 - 0.75)	**0.1** (0.05 - 0.20)
		HM	**150** (70 - 200)	**0.7** (0.5 - 1.0)	**0.1** (0.05 - 0.20)