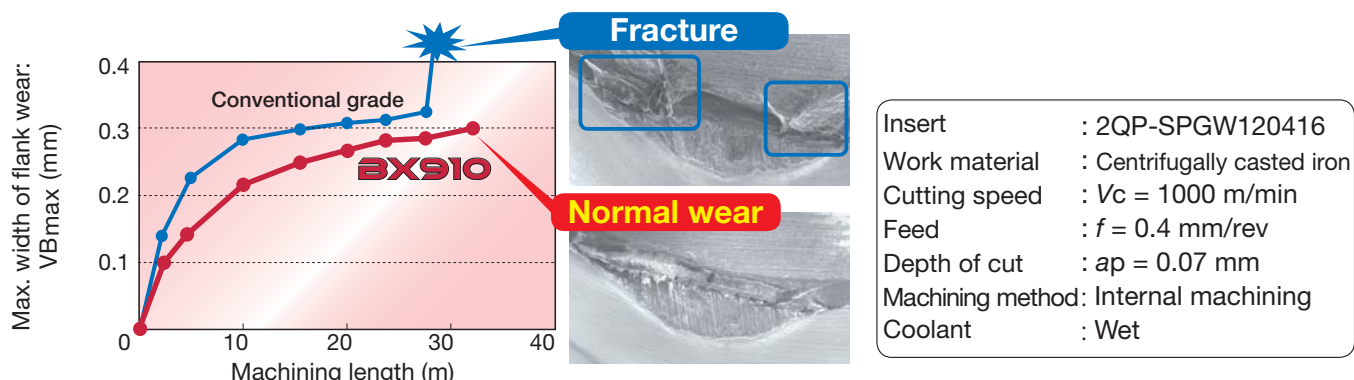


Cutting performance

BX910 remains stable without sudden fracture.



Grade properties

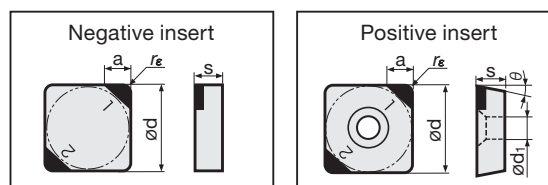
Application	Grade	Hardness (HV)	T. R. S. (GPa)	Features
Cast iron	BX910	2600 ~ 2800	0.8 ~ 0.9	CBN grade for centrifugally casted iron machining CBN grade with high wear resistance in high cutting speed, provides long and stable tool life in the machining of centrifugally casted iron, such as cylinder liners.

Standard cutting conditions

Application	Grade	Cutting speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)
Cast iron	BX910	1000 (500 - 1200)	0.1 (0.03 - 0.5)	0.3 (0.2 - 0.5)

Inserts

Negative type



Features	Cat. No.	Grade	No. of corners	Dimensions (mm)				
				I.C.dia ϕd	Thickness s	Hole dia ϕd_1	Corner R r_E	CBN length a
Standard	2QP-SNGN090308	●	2	9.525	3.18	-	0.8	2.4
	2QP-SNGN090312	●	2	9.525	3.18	-	1.2	2.4

Positive type

Features	Cat. No.	Grade	No. of corners	Dimensions (mm)					
				Relief angle θ	I.C.dia ϕd	Thickness s	Hole dia ϕd_1	Corner R r_E	CBN length a
Standard	2QP-SPGW09T308	●	2	11°	9.525	3.97	4.4	0.8	2.4
	2QP-SPGW09T312	●	2	11°	9.525	3.97	4.4	1.2	2.4
	2QP-SPGW120408	●	2	11°	12.7	4.76	5.5	0.8	2.4
	2QP-SPGW120412	●	2	11°	12.7	4.76	5.5	1.2	2.4
	2QP-SPGW120416	●	2	11°	12.7	4.76	5.5	1.6	2.4
	2QP-SPGN090308	●	2	11°	9.525	3.18	-	0.8	2.4
	2QP-SPGN090312	●	2	11°	9.525	3.18	-	1.2	2.4
	3QP-TPGW110308	●	3	11°	6.35	3.18	3.4	0.8	1.9
	3QP-TPGN110308	●	3	11°	6.35	3.18	-	0.8	1.9
	3QP-TPGN110312	●	3	11°	6.35	3.18	-	1.2	2.4

● : Stocked items