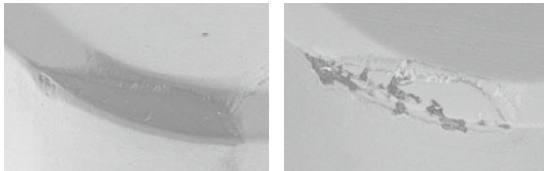


CUTTING PERFORMANCE

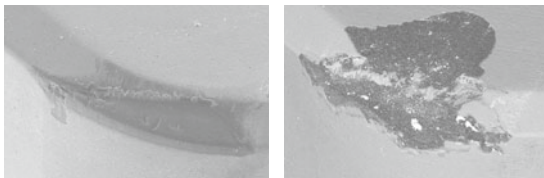
Machining length 0.7 km



BXA20

Conventional grade

Machining length 1.4 km

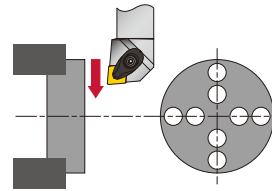


BXA20

Conventional grade

H Insert : 2QP-CNGA120408
 Workpiece material : SCM420 (60HRC)
 Cutting speed : $V_c = 100$ m/min
 Feed : $f = 0.1$ mm/rev
 Depth of cut : $a_p = 0.2$ mm
 Machining : Face turning
 (interrupted cutting)

Without peeling-off, tool life is extended even in heavy interrupted machining.



STANDARD CUTTING CONDITIONS

ISO	Grade	Insert feature	Workpiece condition	Cutting speed V_c (m/min)	Depth of cut a_p (mm)	Feed f (mm/rev)
H	BXA20	Standard (*QP-****)	Continuous	60 - 180	0.05 - 0.5	0.05 - 0.3
			Interrupted	60 - 180	0.05 - 0.3	0.05 - 0.2
		WavyJoint (*QS-****)	Continuous	60 - 180	0.05 - 0.8	0.05 - 0.3
			Interrupted	60 - 180	0.05 - 0.8	0.05 - 0.2
		HP chipbreaker (*QP-****-HP)	Light interrupted	60 - 180	0.05 - 0.2	0.05 - 0.2
			Interrupted	60 - 180	0.05 - 0.2	0.05 - 0.2

GRADE

Application	Grade Application code	Microstructure	Hardness (Hv)	T.R.S (Gpa)
H	BXA20 (H20)		3500 - 3700	1.35 - 1.50