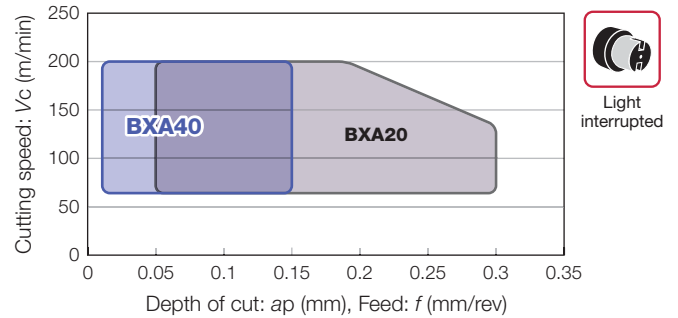


## BXA40

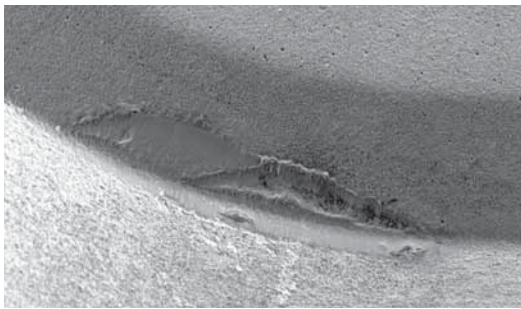
### Coated CBN grade ideal of extremely light D.O.C.

Thanks to the cBN substrate being formulated for superior adhesion with the coating, edge chipping is significantly reduced for extended tool life during interrupted cuts using extremely light depths-of-cut and low feed rates.

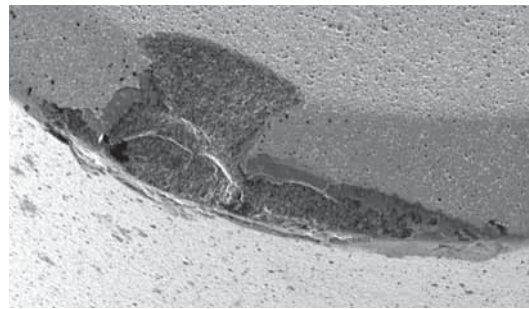


### Small depth of cutting

Depth of cut  $a_p = 0.03$  mm, Machining time 20 min



**BXA40**



Coated CBN (BXA20)

<b>H</b>	Insert	: 2QP-CNGA120408
	Workpiece material	: SCM415 (58HRC)
	Cutting speed	: $V_c = 200$ m/min
	Feed	: $f = 0.08$ mm/rev
	Depth of cut	: $a_p = 0.03$ mm
	Coolant	: Wet

## STANDARD CUTTING CONDITIONS

ISO	Grade	Workpiece condition	Cutting speed $V_c$ (m/min)	Depth of cut $a_p$ (mm)	Feed $f$ (mm/rev)
<b>H</b>	BXA30	Continuous	160 (50 - 230)	0.1 (0.02 - 0.15)	0.1 (0.02 - 0.15)
	BXA40	Light interrupted	140 (50 - 200)	0.1 (0.02 - 0.4)	0.15 (0.02 - 0.25)