

SumiBoron PCBN Grades

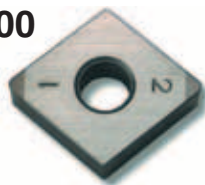
GRADE DESCRIPTION

General Info	Grades	Hardness (Hv)	T.R.S. (kg/mm ²)	Features	Applications
	BN100	4000 4500	80	<ul style="list-style-type: none"> • High CBN content • Good heat and adhesion resistance 	Turning of gray cast iron and exotic materials
Negative Inserts	BNX10	2800 3200	80 90	<ul style="list-style-type: none"> • High speed wet or dry applications • Better wear and thermal shock resistance than ceramics • Improved surface finish 	High speed continuous cutting of hardened steels
	BN250	3200 3500	100 110	<ul style="list-style-type: none"> • Fine grain CBN with ceramic binder material • Very strong cutting edge • Tough and wear resistant 	Continuous to moderately interrupted cutting of hardened steels and cast irons
Positive Inserts	BNX20	3200 3400	95 110	<ul style="list-style-type: none"> • Extremely high thermal resistant binder material • Excellent wear resistance and toughness at high cutting speeds 	High speed continuous cutting of hardened steels (HrC 45-68)
	BNX25	3000 3200	100 110	<ul style="list-style-type: none"> • Tougher CBN material • New secure brazing alloy • High reliability performance against tool breakage 	High speed interrupted cutting of hardened steel (HrC 45-68)
Ace-Fix Inserts	BN300	3300 3500	110 120	<ul style="list-style-type: none"> • Ultra-fine grain CBN and high strength ceramic binder material • Extremely strong and sharp cutting edge 	Heavy interrupted cutting of hardened steels
Threading, Grooving, & Cut-Off Inserts	BN500	3300 3500	100 110	<ul style="list-style-type: none"> • CBN sintered with ceramic binder material • Good thermal and wear resistance 	Continuous and interrupted turning of nodular and gray cast iron
	BN600	3900 4200	95 110	<ul style="list-style-type: none"> • High CBN content • Superior thermal conductivity and adhesion resistance • Milling geometries available 	Turning of cast iron, powdered metals, exotic materials and heat resistant alloys High speed milling of gray cast iron
Ceramic Inserts	BN700	4100 4400	120 130	<ul style="list-style-type: none"> • High CBN content • Excellent wear resistance and toughness at high cutting speeds • Milling geometries available 	High speed machining of cast irons and powdered metals
	BNC80	3200 3400	100 110	<ul style="list-style-type: none"> • TiN based coating • Increased notch wear resistance • Excellent surface roughness capability • Multi-corner inserts • Numbered corners 	High speed continuous cutting with the ability to achieve superior surface finishes
PCBN & PCD Inserts	BNC150	3000 3300	100 110	<ul style="list-style-type: none"> • TiCN based coating • Heat resistant substrate • High wear resistant coating 	TiCN base coated for high speed machining of hardened steels
	BNC200	3400 3600	110 120	<ul style="list-style-type: none"> • TiAlN based coating • Excellent wear resistance and toughness at high cutting speeds • Increased flank wear resistance • Multi-cornered inserts • Numbered corners 	High speed turning of continuous and mild interrupted hardened steels (HrC 45-68)
Toolholders	BNC300	3300 3500	120 130	<ul style="list-style-type: none"> • TiAlN based coating • Micro-grain CBN • High fracture toughness 	Excellent performance in a wide range of interrupted hard turning
Swiss Toolholders	BNS800	4000 4300	100 120	<ul style="list-style-type: none"> • Solid CBN • High thermal resistance • Excellent fracture resistance 	High speed turning and milling of gray cast iron Turning of chilled iron, nickel-based iron, and ductile iron

Multi-Corner PCBN Grade

NEW

BN700



NEW

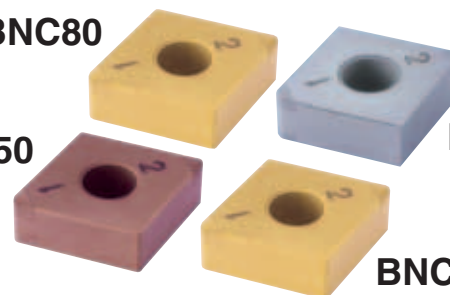
Coated PCBN Grades

BNC80

BNC150

BNC200

BNC300



General Info

Negative Inserts

Positive Inserts

Ace-Fix Inserts

Threading, Grooving, & Cut-Off Inserts

Ceramic Inserts

PCBN & PCD Inserts

Toolholders

Swiss Toolholders

Boring Bars

Technical Info

ALMT