

ToolingBox PCBN composite sheet Materials Introduction for Multi-tipped insert

Material Group (ISO513 Standard)

- P** P: Steel
- M** M: Stainless Steel
- K** K: Cast Iron
- N** N: Non-Ferrous Materials
- S** S: High-Temp Alloys
- H** H: Hardend Materials

Materials grade		
Grades	Multi-tipped	
TBN10	●	
TBN20	●	
TBN30	●	

Hard Steel Machining - Special PCBN Introduction.

Workpiece Material	PCBN Grades	Content %	CBN Grade μm	Bond	Hardness	Characteristics	Applications
H	TBN10	45~50	1	TiC	2600~2800	Good thermal stability and crater wear resistance	● Used for high-speed continuous turning of hardened steel
	TBN20	60~65	1~2	TiCN	2600~2800	Combination of wear resistance and thermal stability	● Used for moderately interrupted and continuous turning of hardened steel
	TBN30	65~70	1<	TiN	2700~2900	High degree of toughness due to fine CBN and ceramic binder matrix	● Used for heavy interrupted turning of hardened steel

ToolingBox Brazed CBN Insert: scope of application

