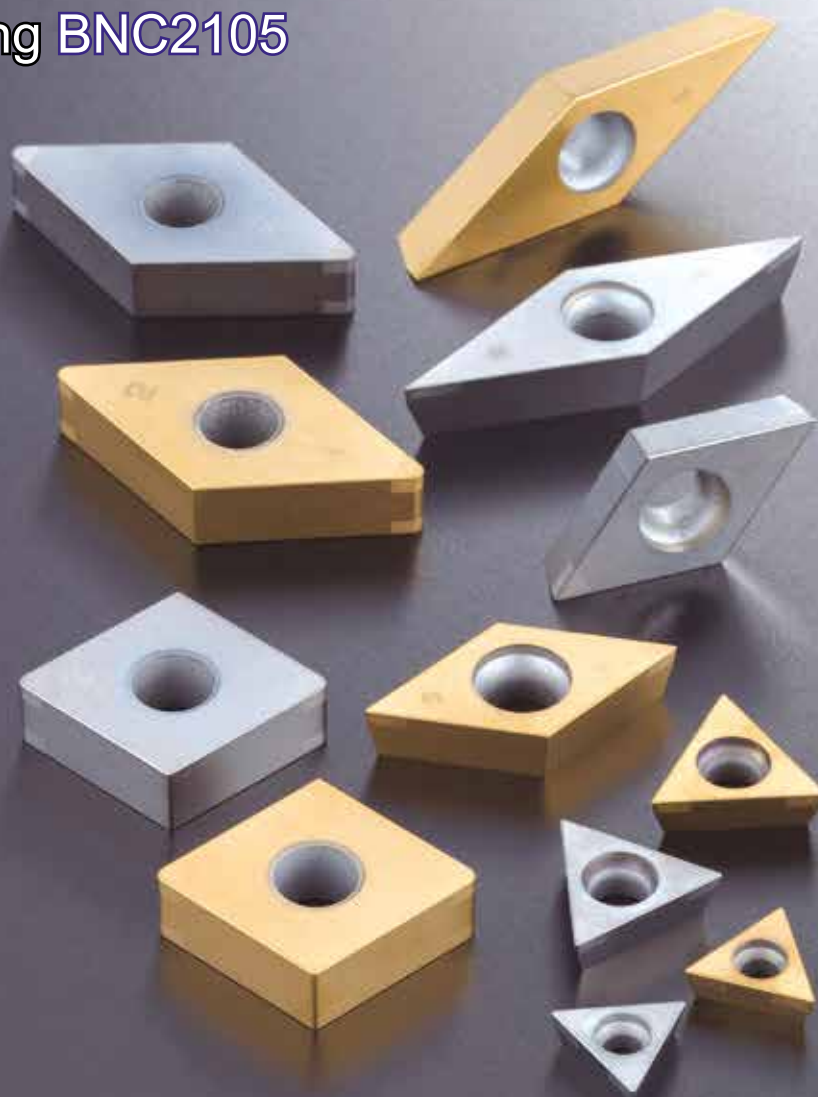


Coated SUMIBORON

Coated SUMIBORON Series for Hardened Steel

NEW

Grades for High-speed Machining
Introducing BNC2105



Lineup:

BNC2125 **BNC2020**
BNC2115 **BNC2010**
BNC2105 NEW
BNC300

General Machining
High-Precision Machining
High-speed Machining
Heavy Interrupted Machining

■ Features

BNC2105 **Highly wear-resistant grade for high-speed machining**
 for a stable and long tool life under highspeed machining conditions due to new coating technologies and modified CBN substrate.

BNC2115 **The definitive grade in high-accuracy machining**
 Realises long tool life with excellent surface roughness and stable machining.
Further maintains excellent surface roughness
 Maintains excellent surface roughness thanks to a coating with high notch wear resistance and tough CBN substrate.

BNC2125 **First recommendation for hardened steel machining**
 Superb wear and fracture resistance.
Achieves long, stable tool life even in high-efficiency and interrupted machining
 Along with a tough CBN substrate, the coating combines wear resistance and toughness to realise stable machining.

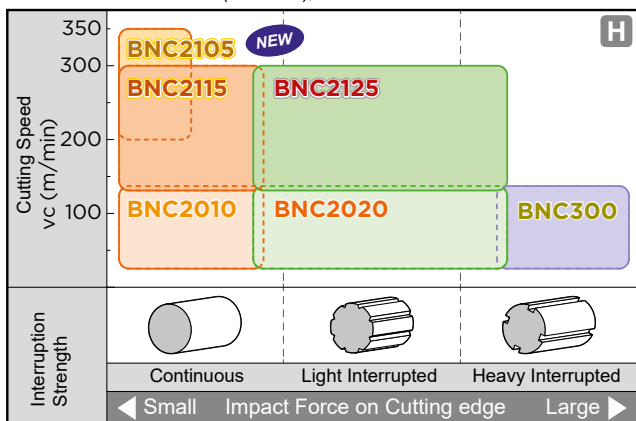
BNC2010 **Grade for high-precision machining with excellent surface roughness and finished surface accuracy**
 Grade ideal for high-precision machining, with highly wear-resistant CBN substrate and coating.

BNC2020 **General-purpose grade suitable for typical hardened steel machining applications**
 Achieves further stability in machining of a wide range of hardened steel components.

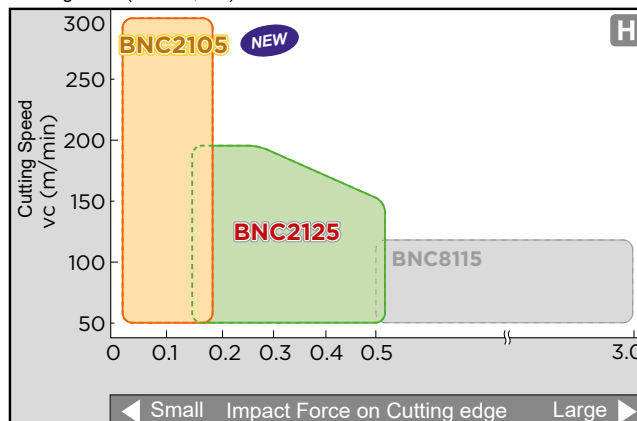
BNC300 **Achieves long, stable tool life even in machining including heavy interrupted cutting**
 Achieves long, stable tool life even on work material requiring both continuous and interrupted cutting.

■ Application Range

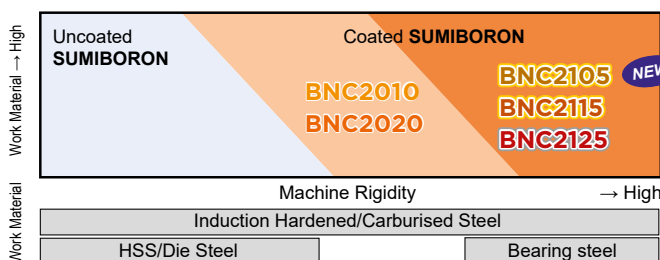
Induction Hardened Steel (C45/C55), Carburised Steel



Bearing Steel (100Cr6, etc)



■ Differentiation



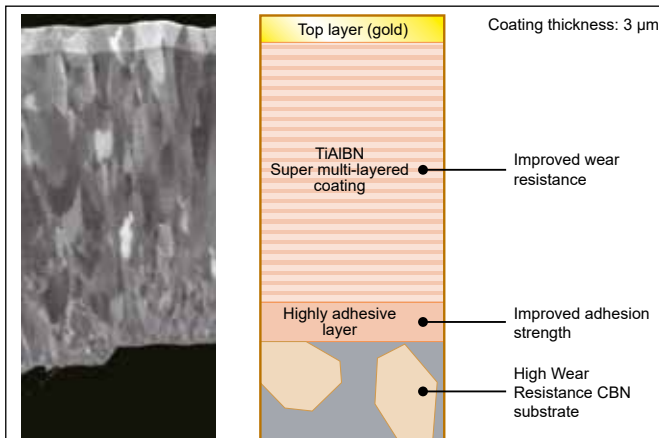
■ Recommended Cutting Conditions

Grade	Cutting Speed (vc) (m/min) Min. - Optimum -Max.	Feed Rate f (mm/rev) Min. - Optimum -Max.	Depth of Cut ap (mm) Min. - Optimum -Max.
BNC2105	150 - 200 - 350	0.03 - 0.10 - 0.15	0.03 - 0.15 - 0.20
BNC2115	110 - 180 - 300	0.03 - 0.10 - 0.20	0.03 - 0.20 - 0.35
BNC2125	110 - 160 - 300	0.05 - 0.20 - 0.40	0.05 - 0.30 - 0.50
BNC2010	50 - 140 - 180	0.03 - 0.10 - 0.20	0.03 - 0.20 - 0.35
BNC2020	50 - 120 - 180	0.03 - 0.20 - 0.40	0.05 - 0.30 - 0.50
BNC300	50 - 100 - 150	0.03 - 0.10 - 0.20	0.03 - 0.20 - 0.30

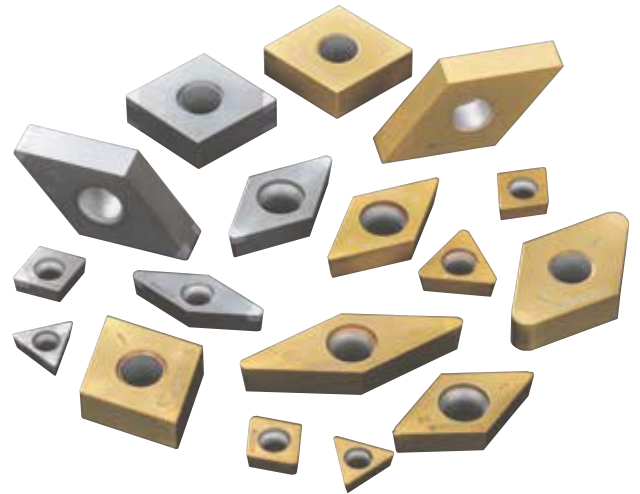
■ CBN Substrate und Coating Structure

BNC2105 **NEW**

High-precision Machining
(High-speed)

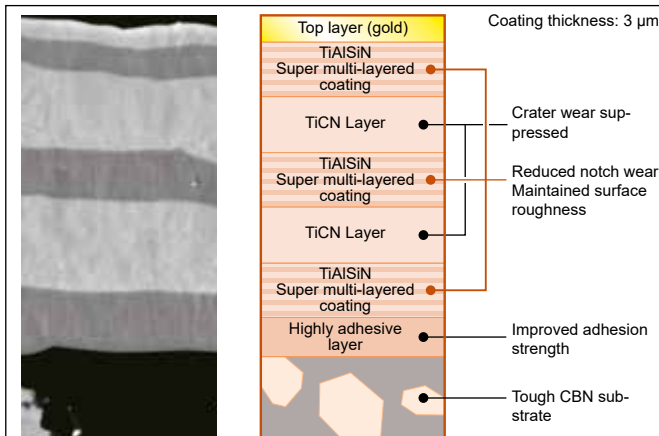


Highly wear-resistant TiAlN super multi-layered coating is made thicker. Realises long tool life in high-speed cutting in combination with a substrate using a newly developed TiCN binder with excellent thermal resistance



BNC2115

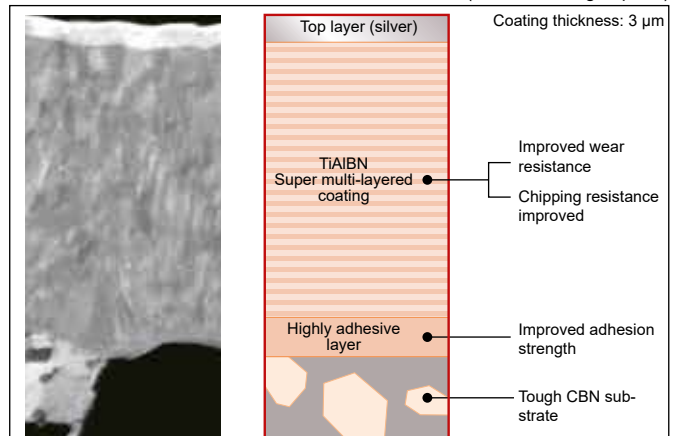
High-Precision Machining
(Medium- to high-speed)



Thick layer of laminated high-strength TiAlSiN super multi-layered coating and highly heat-resistant TiCN coating. Achieves excellent surface finish quality with application to a tough substrate.

BNC2125

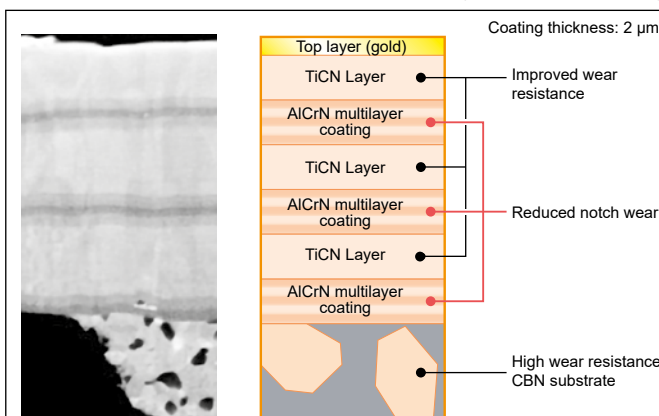
General Machining
(Medium- to high-speed)



Thick layer of super-multilayered ultra-fine TiAlBN coating with high strength and high hardness. High performance in a wide range of cutting through application to a tough substrate.

BNC2010

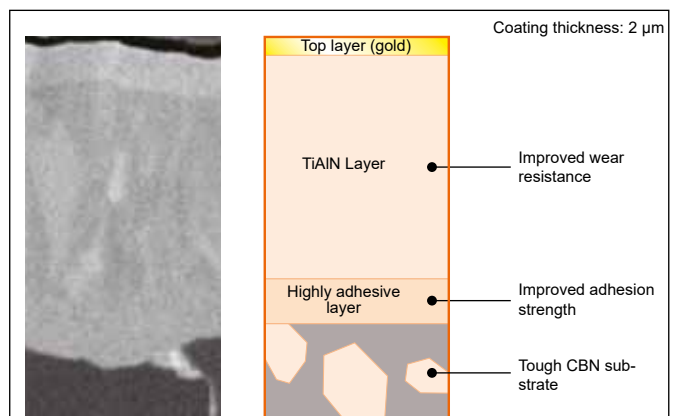
High-Precision Machining
(Low- to medium-speed)



Laminated high-strength AlCrN multi-layered coating and highly heat-resistant TiCN coating is applied to a highly wear-resistant substrate to maintain excellent surface finish quality.

BNC2020

General Purpose Machining
(Low to medium speed, unstable cutting)

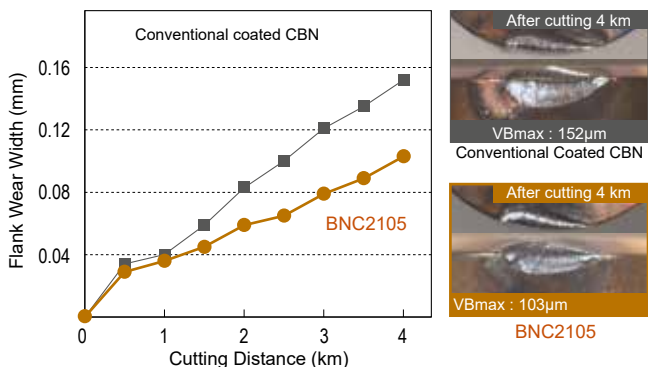


Application of highly wear-resistant TiAlN coating to a tough substrate. Machining stability in low-rigidity environments and high-load cutting is dramatically improved.

Cutting Performance

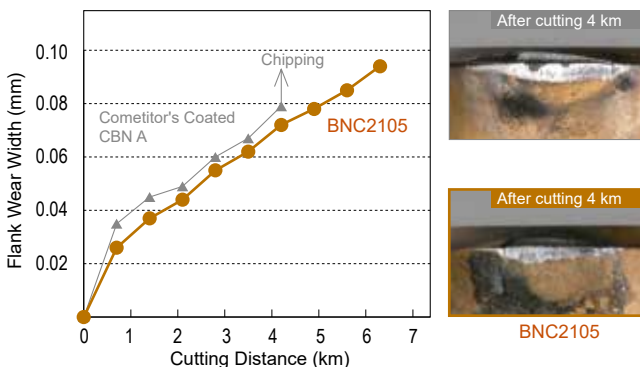
BNC2105 NEW

Continuous Cutting, Wear Resistance



Work Material: 100Cr6 (58-62HRC)
 Insert: DNGA1504084NC
 Cutting Data: $v_c = 200\text{m/min}$, $f = 0.1\text{mm/rev}$, $a_p = 0.1\text{mm}$ Wet

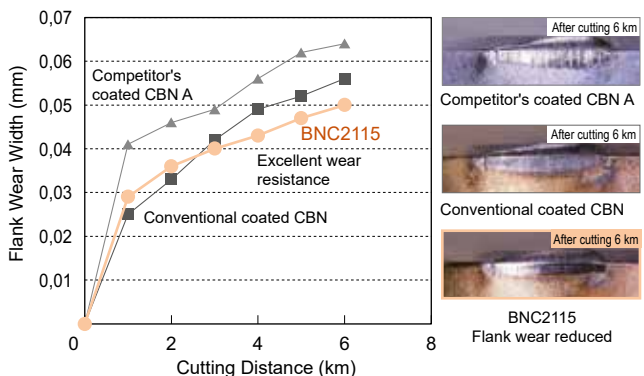
Continuous Cutting, Wear Resistance



Work Material: 15CrMo5 (58-62HRC)
 Insert: DNGA1504084NC-
 Cutting Data: $v_c = 250\text{m/min}$, $f = 0.06\text{mm/rev}$, $a_p = 0.1\text{mm}$ Wet

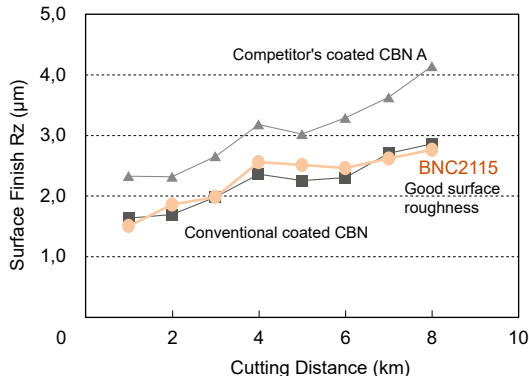
BNC2115

Continuous Cutting, Wear Resistance



Work Material: 16CrMo4 (58-62 HRC)
 Insert: DNGA150408NC4
 Cutting Data: $v_c = 200\text{ m/min}$, $f = 0,1\text{ mm/rev}$, $a_p = 0,15\text{ mm}$, wet

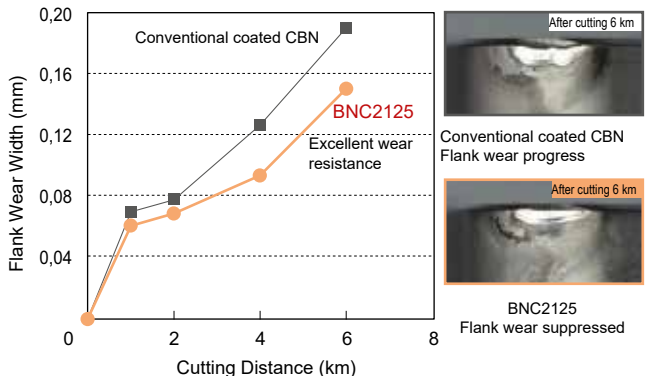
Continuous Cutting, Machined Surface Roughness



Work Material: 16CrMo4 (58-62 HRC)
 Insert: DNGA150408NC4
 Cutting Data: $v_c = 200\text{ m/min}$, $f = 0,1\text{ mm/rev}$, $a_p = 0,15\text{ mm}$, wet

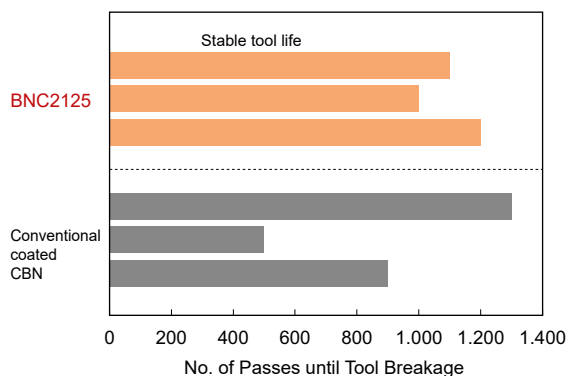
BNC2125

Continuous Cutting, Wear Resistance



Work Material: 100Cr6 (58-62 HRC)
 Insert: DNGA150408NC4
 Cutting Data: $v_c = 150\text{ m/min}$, $f = 0,1\text{ mm/rev}$, $a_p = 0,2\text{ mm}$, wet

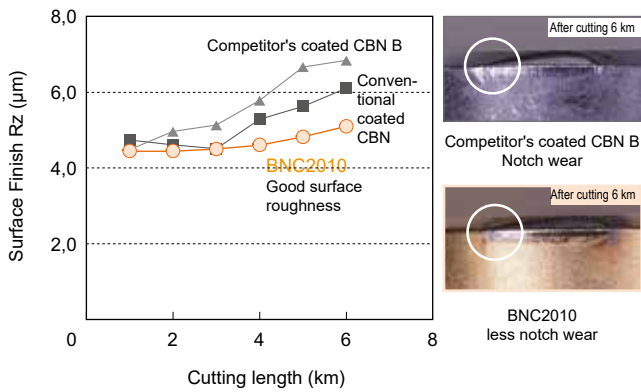
High-Load Cutting, Fracture Resistance



Work Material: 100Cr6 (58-62 HRC)
 Insert: DNGA150408NC4
 Cutting Data: $v_c = 150\text{ m/min}$, $f = 0,15\text{ mm/rev}$, $a_p = 0,5\text{ mm}$, 63 m/times, wet

BNC2010

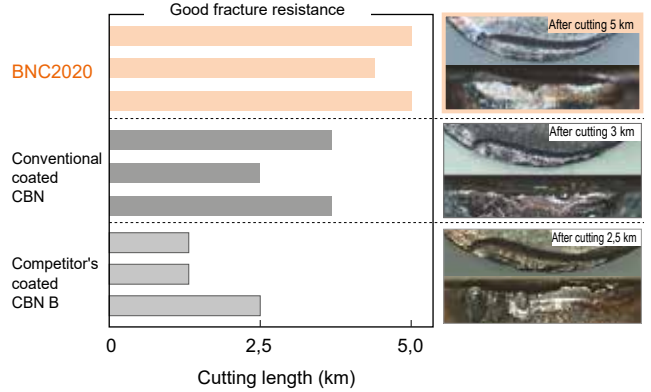
Continuous Cutting, Machined Surface Roughness



Work Material: 16CrMo4 (58–62 HRC)
 Insert: DNGA150408NC4
 Cutting Data: $v_c = 120$ m/min, $f = 0,14$ mm/rev, $a_p = 0,15$ mm, wet

BNC2020

Interrupted Cutting, Fracture Resistance

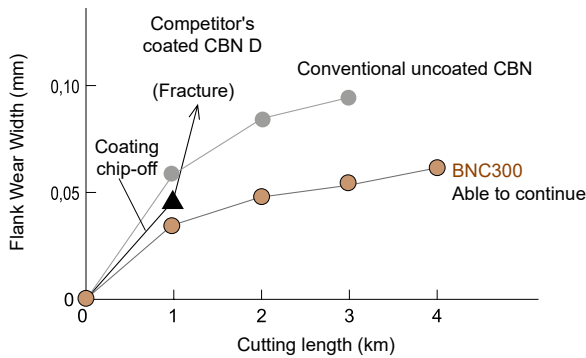


Work Material: 16CrMo4 with 5 grooves (58–62 HRC)
 Insert: DNGA1204012NC4
 Cutting Data: $v_c = 130$ m/min, $f = 0,1$ mm/rev, $a_p = 0,6$ mm, dry

Cutting Performance

BNC300

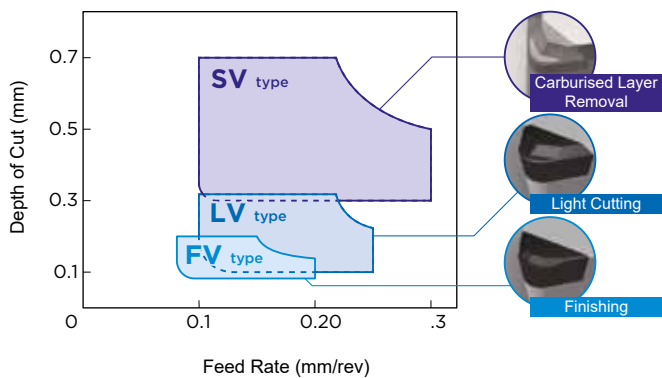
Interrupted Cutting, Fracture Resistance



Work Material: Grooved 15CrMo5 (58–62 HRC)
 Insert: CNGA120408NC4
 Cutting Data: $v_c = 120$ m/min, $f = 0,1$ mm/rev, $a_p = 0,2$ mm, dry

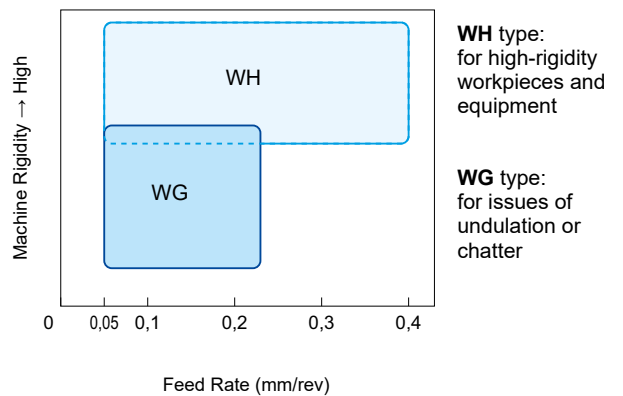
One-use Inserts with Chipbreaker Breakmaster

Application Range



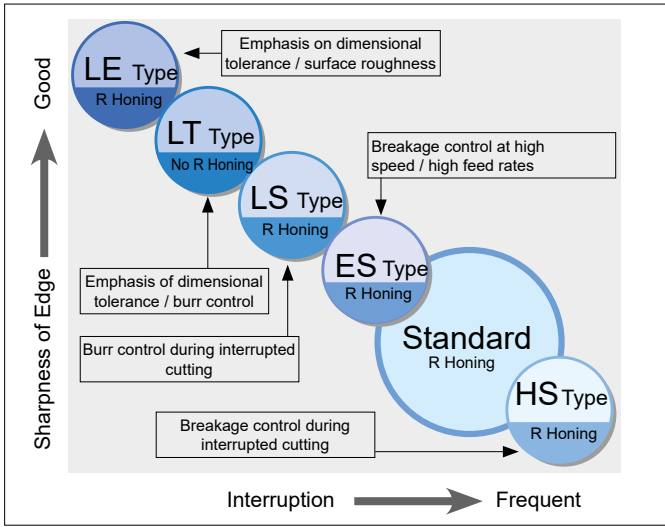
One-use Wiper Inserts

Application Range



Cutting Edge Specification

Treatment with the optimum cutting edge preparation for the various grades and geometries avoids cutting edge fracture caused by the heavy loads generated during the machining of high-hardness materials such as hardened steel.



High Precision Types LE, LT, LS

World's smallest class edge treatment with coated CBN for hardened steel machining. Minimises cutting force.

High Efficiency Type ES

Suppresses crater wear and resulting fractures. Stabilises tool life in high-speed, high-feed machining.

Strong Edge Type HS

Suppresses cutting edge chipping and fracture. Stabilises tool life in interrupted machining.

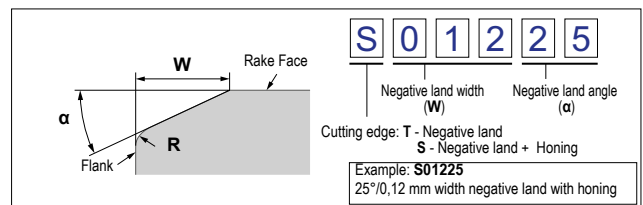
Insert Cutting Edge Specification

Work Material	Grade	Negative / Positive	Standard				Low Cutting Force Type L / High Efficiency Type E				Strong Edge Type H					
			Identification Code	α	W	Honing	Notation	Identification Code	α	W	Honing	Notation	Identification Code	α	W	Honing
Hardened Steel	BNC2105	Neg./Pos.	S01225	25°	0,12	Yes	LS	S00515	15°	0,05	Yes	-	-	-	-	-
	BNC2115	Neg./Pos.	S01225	25°	0,12	Yes	LS	S00515	15°	0,05	Yes	HS	S01730	30°	0,17	Yes
	BNC2125	Neg./Pos.	S01225	25°	0,12	Yes	LS	S00515	15°	0,05	Yes	HS	S02735	35°	0,27	Yes
	BNC2010	Neg./Pos.	S01225	25°	0,12	Yes	LE	(Sharp edge)	0°	0	Yes	HS	S01730	30°	0,17	Yes
	BNC2020	Neg./Pos.	S01225	25°	0,12	Yes	LT	T00515	15°	0,05	No	HS	S02735	35°	0,27	Yes
	BNC300	Neg./Pos.	S01225	25°	0,12	Yes	ES	S00535	35°	0,05	Yes	HS	S01735	35°	0,17	Yes

Cutting Edge Preparation with Wiper/Chipbreaker

Type	Notation	Negative / Positive	Identification Code	α	W	Honing
Wiper Insert	WG	Neg./Pos.	S01215	15°	0,12	Yes
	WH	Neg./Pos.	S01215	15°	0,12	Yes
Insert with chip breaker	N-FV	Neg./Pos.	-	0°	0	Yes
	N-LV	Neg./Pos.	S00535	35°	0,05	Yes
	N-SV	Neg.	S01235	35°	0,12	Yes

Edge Preparation Identification Code

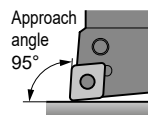


Tool-Setup WG / WH Wiper

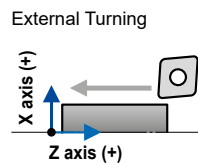
CNGA / CCGW / WNGA Type Wiper

1. Use a holder with a 95° approach angle.
2. Tool compensation required.

CNGA / CCGW / WNGA type wiper inserts do not follow the ISO standard. Correction of the tool offset of the cutting edge as explained on the right.



Cutting Edge Position Compensation, Outer Processing



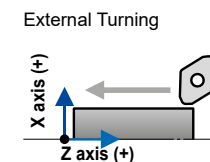
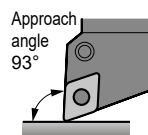
Nose Radius	Type	X-Direction	Z-Direction
RE 0,4	WG	-0,02	-0,02
	WH	-0,06	-0,06
RE 0,8/1,2	WG	-0,01	-0,01
	WH	-0,06	-0,06

DNGA / DCGW Type Wiper

1. Use a holder with a 93° approach angle.
2. Tool compensation required.

DNGA / DCGW type wiper inserts do not follow the ISO standard. Correction of the tool offset of the cutting edge as explained on the right.

Note: DNGA/DCGW type wiper inserts are only possible for external and internal turning, not for facing.



Nose Radius	Type	X-Direction	Z-Direction
RE 0,4	WG	-0,17	-0,01
	WH	-0,70	-0,06
RE 0,8	WG	-0,05	0
	WH	-0,58	-0,05

Multi-Cornered, One-Use Inserts, Negative

○ Square Type

◇ 35° Diamond Type

Shape	Cat. No.	Stock					Cutting Edge Length	Dimensions (mm)			
		BNC2105	BNC2115	BNC2125	BNC2010	BNC2020		BNC300	Inscribed Circle	Thickness	Hole diameter Ø
	SNGA 120404 NC4	○	○	○			2,5	12,7	4,76	5,16	0,4
	120408 NC4	●	●	●	●	●	2,3				
	120412 NC4	●	●	●	●	●	2,1				
	SNGA 120408 HS-NC2			●			2,3	12,7	4,76	5,16	0,8
	120412 HS-NC2			●			2,1				

△ Triangular Type

Shape	Cat. No.	Stock					Cutting Edge Length	Dimensions (mm)			
		BNC2105	BNC2115	BNC2125	BNC2010	BNC2020		BNC300	Inscribed Circle	Thickness	Hole diameter Ø
	TNGA 160404 NC3			○			2,3	9,525	4,76	3,81	0,4
	160408 NC3			○			2,0				
	160412 NC3			○			2,0				
	TNGA 160416 NC3*1			○			3,3	9,525	4,76	3,81	2,0
	160420 NC3*1			○			2,7				
	160424 NC3*1			○			2,4				
	TNGA 160402 NC6	○	○	○			2,4	9,525	4,76	3,81	0,2
	160404 NC6	○	○	○			2,3				
	160408 NC6	○	○	○			2,0				
	160412 NC6	○	○	○			2,0				
	160416 NC6*1	○	○	○			3,3				
	TNGA 160420 NC6*1			○			3,0	9,525	4,76	3,81	2,0
	160424 NC6*1			○			2,7				
	160412 NC6*1			○			2,4				
	TNGG 160404 N-FV NC6	○	○	○			2,3	9,525	4,76	3,81	0,8
	160408 N-FV NC6	○	○	○			2,0				
	160412 N-FV NC6	○	○	○			2,0				
	TNGG 160404 N-LV NC6	○	○	○			2,3	9,525	4,76	3,81	0,8
	160408 N-LV NC6	○	○	○			2,0				
	160412 N-LV NC6	○	○	○			2,0				
	TNGG 160404 N-SV NC6	○	○	○			2,3	9,525	4,76	3,81	0,8
	160408 N-SV NC6	○	○	○			2,0				
	160412 N-SV NC6	○	○	○			2,0				
	TNGA 160404 LE-NC3			○			2,3	9,525	4,76	3,81	0,8
	160408 LE-NC3			○			2,0				
	160412 LE-NC3			○			2,0				
	TNGA 160402 LT-NC3				○		2,4	9,525	4,76	3,81	0,2
	160404 LT-NC3				○		2,3				
	160408 LT-NC3				○		2,0				
	160412 LT-NC3				○		2,0				
	TNGA 160402 LS-NC3				○		2,4	9,525	4,76	3,81	0,2
	160404 LS-NC3				○		2,3				
	160408 LS-NC3				○		2,0				
	160412 LS-NC3				○		2,0				
	TNGA 160404 ES-NC6	□	○	○			2,3	9,525	4,76	3,81	0,4
	160408 ES-NC6	□	○	○			2,0				
	160412 ES-NC6	□	○	○			2,0				
	TNGA 160404 HS-NC3			○			2,3	9,525	4,76	3,81	0,8
	160408 HS-NC3			○			2,0				
	160412 HS-NC3			○			2,0				
	TNGA 160404 HS-NC6			○			2,3	9,525	4,76	3,81	0,4
	160408 HS-NC6			○			2,0				
	160412 HS-NC6			○			2,0				

Shape	Cat. No.	Stock					Cutting Edge Length	Dimensions (mm)			
		BNC2105	BNC2115	BNC2125	BNC2010	BNC2020		BNC300	Inscribed Circle	Thickness	Hole diameter Ø
	VNGA 160404 NC2			○	○	●	2,8	9,525	4,76	3,81	0,4
	160408 NC2			○	○	●	2,0				
	160412 NC2			○	○	●	1,7				
	VNGA 160402 NC4			○	○	○	3,3	9,525	4,76	3,81	0,2
	160404 NC4	○	○	○	○	○	2,8				
	160408 NC4	○	○	○	○	○	2,0				
	160412 NC4	○	○	○	○	○	1,7				
	VNGG 160404 N-FV NC4			○	○	○	2,8	9,525	4,76	3,81	0,4
	160408 N-FV NC4			○	○	○	2,0				
	VNGG 160404 N-LV NC4			○	○	○	2,8	9,525	4,76	3,81	0,4
	160408 N-LV NC4			○	○	○	2,0				
	VNGA 160402 LT-NC2				○		3,3	9,525	4,76	3,81	0,2
	160404 LT-NC2				○		2,8				
	160408 LT-NC2				○		2,0				
	160412 LT-NC2				○		1,7				
	VNGA 160402 LS-NC2			○	○		3,3	9,525	4,76	3,81	0,2
	160404 LS-NC2	○	○	○	○		2,8				
	160408 LS-NC2	○	○	○	○		2,0				
	160412 LS-NC2	○	○	○	○		1,7				
	VNGA 160404 ES-NC4			○	○	○	2,8	9,525	4,76	3,81	0,4
	160408 ES-NC4	□		○	○	○	2,0				
	160412 ES-NC4	□		○	○	○	1,7				
	VNGA 160404 HS-NC4			○	○	○	2,8	9,525	4,76	3,81	0,4
	160408 HS-NC4			○	○	○	2,0				
	160412 HS-NC4			○	○	○	1,7				

△ Trigon Type







Shape	Cat. No.	Stock					Cutting Edge Length	Dimensions (mm)			
		BNC2105	BNC2115	BNC2125	BNC2010	BNC2020		BNC300	Inscribed Circle	Thickness	Hole diameter Ø
	WNGA 080404 NC6	○	○	○	○	○	2,3	12,7	4,76	5,16	0,4
	080408 NC6	○	○	○	○	○	2,0				
	080412 NC6	○	○	○	○	○	2,0				
	WNGA 080408 NC-WG6			○	○	○	2,0	12,7	4,76	5,16	0,8
	WNGA 080408 NC-WH6			○	○	○	1,9				
	WNGA 080408 LT-NC3				○		3	12,7	4,76	5,16	0,8
	WNGA 080408 LS-NC3				○		3				
	WNGA 080408 HS-NC6				○		6	12,7	4,76	5,16	0,8
	WNGA 080408 HS-NC6				○		6				

*1 For use with SUMIBORON special holders for high-efficiency machining.


● Euro stock ○ Japan stock □ = Delivery on request

■ Single-Cornered, One-Use Inserts, Positive


Triangular Type

Shape	Relief Angle	Cat. No.	Stock					No. of Cutt. Edges	Dimensions (mm)				
			BNC2105	BNC2115	BNC2125	BNC2010	BNC2020		BNC300	Cutting Edge Length	Inscribed Circle	Thickness	Hole diameter Ø
	7°	TCGW 090204 NC	●	●	●	●	●	1	2,2	5,56	2,38	2,5	0,4
		090208 NC	●	●	●	●	●	●	1,9				0,8
	7°	TCGW 110202 NC	●	●	●	●	●	1	2,5	6,35	2,38	2,8	0,2
		110204 NC	●	●	●	●	●	○	1	2,4			0,4
	7°	TCGW 110208 NC	●	●	●	●	●	1	2,1				0,8
		110208 LS-NC	□						1	2,4	6,35	2,38	2,8
	7°	TCGW 110204 LS-NC	□					1	2,1				0,8
		110208 LS-NC	□						1	2,4	6,35	2,38	2,8
	7°	TPGW 080202 NC		●	●	●	●	1	2,6	4,76	2,39	2,3	0,2
		080204 NC		●	●	●	●	●	1	2,5			
	7°	TPGW 110304 NC		●	●	●	●	1	2,3	6,35	3,18	3,4	0,4
		110308 NC		●	●	●	●	●	1	2,0			

35° Diamond Type

Shape	Relief Angle	Cat. No.	Stock					No. of Cutt. Edges	Dimensions (mm)				
			BNC2105	BNC2115	BNC2125	BNC2010	BNC2020		BNC300	Cutting Edge Length	Inscribed Circle	Thickness	Hole diameter Ø
	5°	VBGW 110202 NC		●	●	●	●	1	3,2	6,35	2,38	2,8	0,2
		110204 NC		●	●	●	●	1	2,8				0,4
		110208 NC		●	●	●	●	○	1	2,0			

80° Special

Shape	Relief Angle	Cat. No.	Stock					No. of Cutt. Edges	Dimensions (mm)					
			BNC2105	BNC2115	BNC2125	BNC2010	BNC2020		BNC300	Cutting Edge Length	Inscribed Circle	Thickness	Hole diameter Ø	Nose Radius
	5°	ZNEX 040102 NC	●	●	●	●	●	1	2,3	4,76	1,59	2,3	0,2	
		040104 NC	●	●	●	●	●	●	1	2,3				0,4
		ZNEX 040102 LE-NC				○			1	2,3	4,76	1,59	2,3	0,2
		040104 LE-NC				○			1	2,3				0,4
		ZNEX 040102 LT-NC				○			1	2,3	4,76	1,59	2,3	0,2
		040104 LT-NC				○			1	2,3				0,4

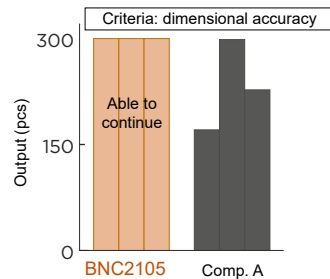
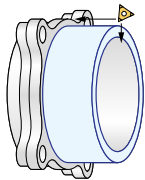
● Euro stock ○ Japan stock □ = Delivery on request

Application Examples

BNC2105 NEW

100Cr6 Bearing Steel Hub (60HRC)

BNC2105 suppresses fractures due to crater wear and realises stable machining

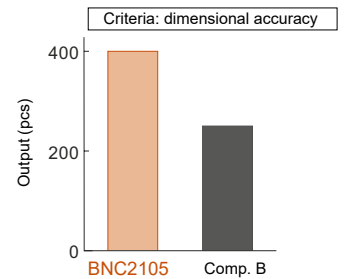
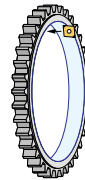


Insert: TNGA160408 NC6 (BNC2105)
Cutting Data: $v_c = 230\text{m/min}$, $f = 0.12\text{mm/rev}$,
 $a_p = 0.10\text{mm Wet}$

BNC2105 NEW

20Cr4 Hardened Steel Ring Gear (60HRC)

BNC2105 maintains excellent wear resistance for a long time compared to competitors' coated CBN

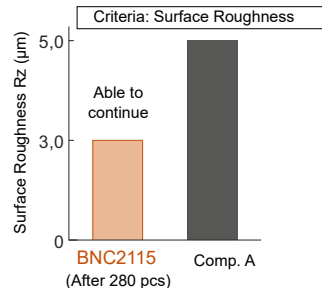
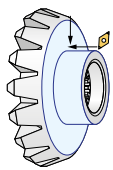


Insert: CNGA120412 NC4 (BNC2105)
Cutting Data: $v_c = 200\text{m/min}$, $f = 0.10\text{mm/rev}$,
 $a_p = 0.10\text{mm Wet}$

BNC2115

15CrMo5, Gear (60 HRC), Surface Roughness

Compared to competitors' coated CBN, BNC2115 reduces flank wear width by 30%, able to continue with good surface roughness.

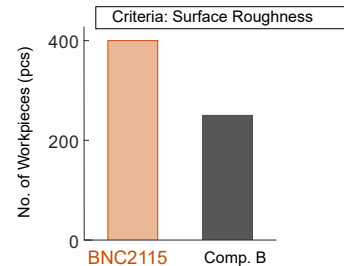
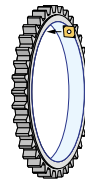


Insert: DNGA150404 NC4 (BNC2115)
Cutting Data: $v_c = 160\text{ m/min}$, $f = 0,10\text{ mm/rev}$,
 $a_p = 0,25\text{ mm Wet}$

BNC2115

41Cr4, Ring Gear (60 HRC), Surface Roughness

BNC2115 with a WH type wiper insert maintains excellent surface roughness for a long time compared to competitors' coated CBN (wiper insert).

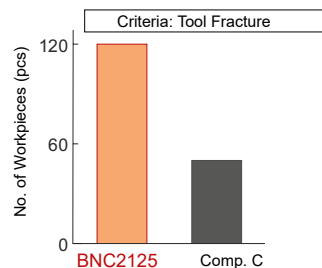
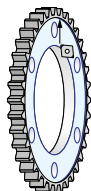


Insert: CCGW09T308 NC-WH2 (BNC2115)
Cutting Data: $v_c = 150\text{ m/min}$, $f = 0,12\text{ mm/rev}$,
 $a_p = 0,10\text{ mm Wet}$

BNC2125

20Cr4, Ring Gear (60 HRC), Tool Fracture

BNC2125 suppresses fractures due to crater wear and realises at least double the tool life.

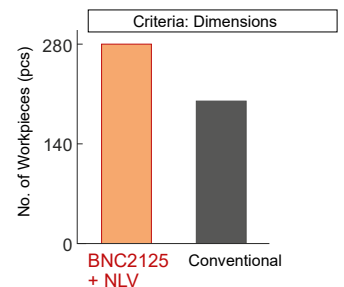
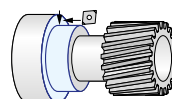


Insert: CNGA120412 NC4 (BNC2125)
Cutting Data: $v_c = 150\text{ m/min}$, $f = 0,20\text{ mm/rev}$,
 $a_p = 0,30\text{ mm Dry}$

BNC2125

C15, Sun Gear (60 HRC), Dimensions

BNC2125 Break Master N-LV Type offers long tool life and resolves chip control problems.



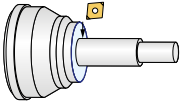
Insert: CNGG120408 NLV NC4 (BNC2125)
Cutting Data: $v_c = 190\text{ m/min}$, $f = 0,13\text{ mm/rev}$,
 $a_p = 0,30\text{ mm Wet}$

Application Examples

BNC2010

C45, CVJ Outer Race (60 HRC), Surface Roughness

BNC2010 with a WH type wiper insert maintains excellent surface roughness for a long time.



Criteria: Surface Roughness

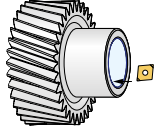
Criteria	BNC2010 +WH	Conventional
No. of Workpieces (pcs)	700	400
Surface Roughness (Rz)	1,6 µm	-

Insert: CNGA120412 NC-WH2 (BNC2010)
Cutting Data: $v_c = 150$ m/min, $f = 0,20$ mm/rev, $a_p = 0,20$ mm dry

BNC2020

20Cr4, Gear (60 HRC), Burrs

BNC2020 high-precision LT Type cutting edge treatment suppresses burrs and improves tool life.



Criteria: Burr

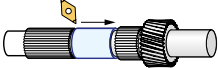
Criteria	BNC2020 +LT	Conventional
No. of Workpieces (pcs)	300	180

Insert: CNGA120408 LT-NC2 (BNC2020)
Cutting Data: $v_c = 100$ m/min, $f = 0,10$ mm/rev, $a_p = 0,15$ mm dry

BNC2020

20Cr4, Shaft (60 HRC), Tool Fracture

BNC2020 high-efficiency ES Type cutting edge treatment suppresses fractures due to crater wear and offers long tool life.



Criteria: Tool Fracture

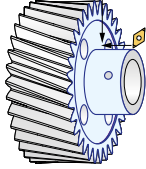
Criteria	BNC2020 +ES	Conventional
No. of Workpieces (pcs)	300	180

Insert: DNGA150408 ES-NC4 (BNC2020)
Cutting Data: $v_c = 150$ m/min, $f = 0,15$ mm/rev, $a_p = 0,10$ mm dry

BNC300

20CrM05, Gear (62 HRC), Dimensions

BNC300 strong edged HS Type cutting edge treatment enables stable machining without fractures in interrupted cutting.



Criteria: dimensional accuracy

Criteria	BNC300 +HS	Comp. D
No. of Workpieces (pcs)	100 (Stable cutting)	60 (Dimensional deviation)

Insert: DNGA150408 HS-NC4 (BNC300)
Cutting Data: $v_c = 100$ m/min, $f = 0,10$ mm/rev, $a_p = 0,30$ mm dry



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