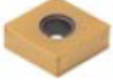



Speeds and Feeds



Cutting condition of cBN grades

Workpiece	Grades	Insert color	Application	Cutting speed, vc (sfm)	Feed, fn (ipr)	Depth of cut, ap (inch)
H HARD STEEL	CBNH10C		Continuous and low interrupted cutting at high speed	394  722	0.002 ~ 0.012	0.002 ~ 0.012

Coated cBN application range

