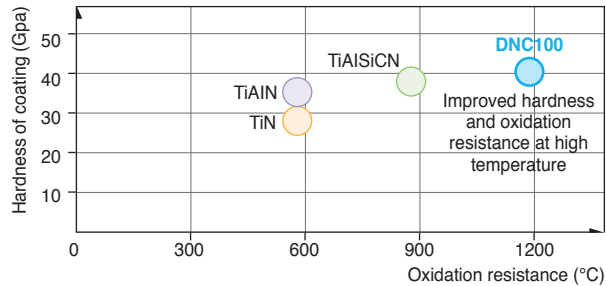


A Others

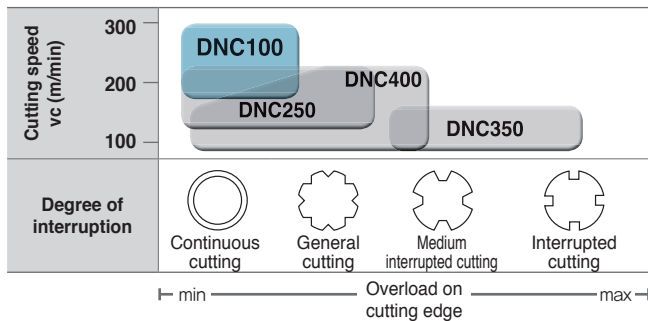
Coated cBN

DNC100 new

- Features**
- Excellent thermal resistance
 - Coating layer with high hardness, oxidation resistance and chipping resistance



Application range



Recommended cutting condition

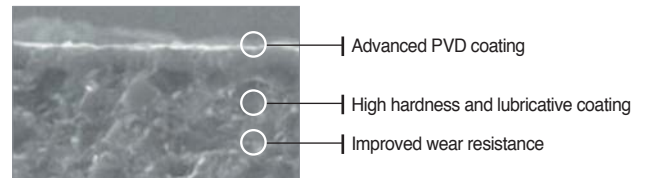
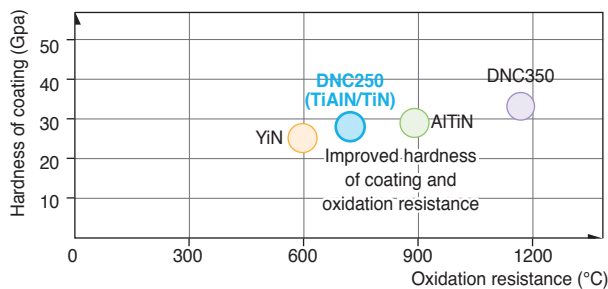
Cutting speed v_c (m/min)	180 ————— 300
Feed f_n (mm/rev)	0.03 ————— 0.3
Depth of cut per time a_p (mm)	0.03 ————— 0.3

- Increased oxidation resistance and wear resistance due to high hardness coating layer
- Dramatically improved fracture resistance and chipping resistance

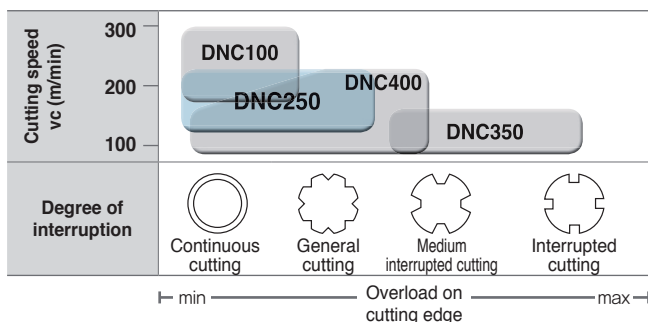
Multi-corner coated cBN for high efficient cutting of heat-treated alloy

DNC250

- Features**
- Stable and long tool life
 - Cost effective by multi-cornered one-use insert



Application range



Recommended cutting condition

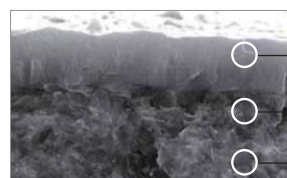
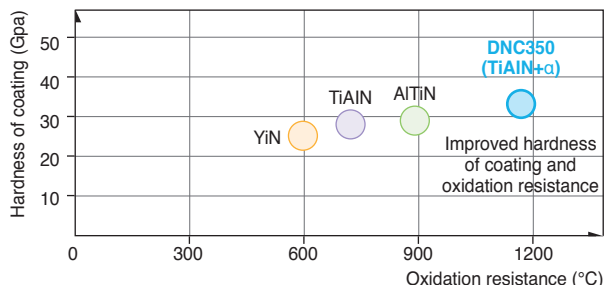
Cutting speed v_c (m/min)	120 ————— 220
Feed f_n (mm/rev)	0.05 ————— 0.3
Depth of cut per time a_p (mm)	0.05 ————— 0.3



Coated cBN for high interrupted cutting

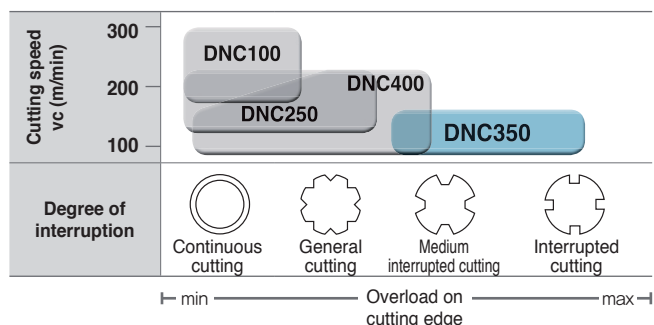
DNC350

- Features**
- Excellent tool life and productivity in interrupted cutting
 - New PVD coating applied with high hardness and oxidation resistance



- High hardness and oxidation-resistant coating
- High tough coating
- Fine cBN + High tough substrate

Application range



Recommended cutting condition

Cutting speed v_c (m/min)	90 — 150
Feed f_n (mm/rev)	0.05 — 0.3
Depth of cut per time a_p (mm)	0.05 — 0.3

Solid type coated cBN

DNC400 **new**

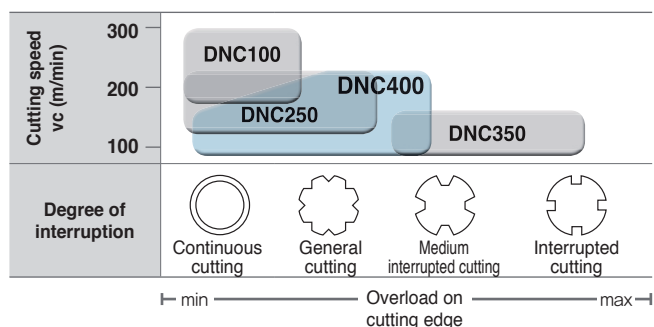
- Features**
- For machining heat-treated steel in continuous and medium interrupted cutting
 - Longer tool life due to coating layer
 - Solid type for universal purpose

Features of solid type cBN

- Increased productivity at high speed and high depth of cut
- Ideal for removing cemented layer and the welds
- Better welding stability due to 3-face blazing
- Excellent cutting performance at varying depth of cuts



Application range



Recommended cutting condition

Feed f_n (mm/rev)	DNC400	0.05 — 0.3
	DNC250	0.05 — 0.3
	DNC350	0.05 — 0.3
Depth of cut per time a_p (mm)	DNC400	0.05 — 0.5
	DNC250	0.05 — 0.3
	DNC350	0.05 — 0.3

