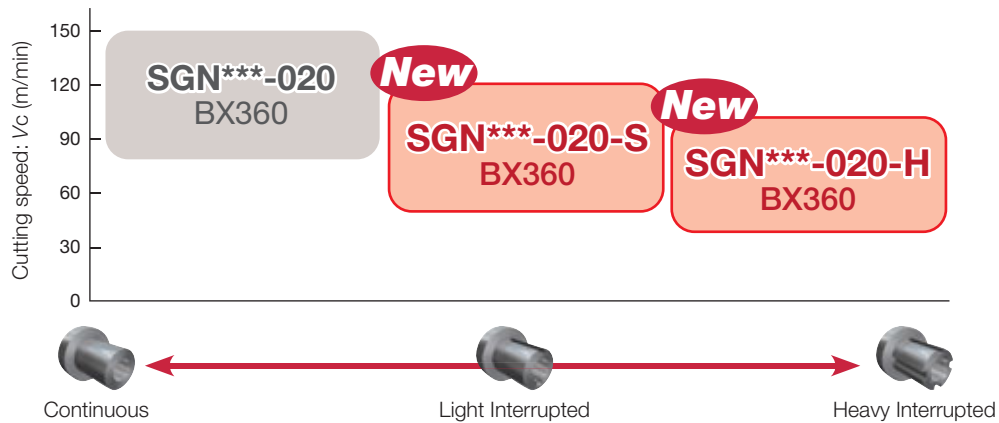


# Expansion of CBN inserts for interrupted grooving of hardened steel

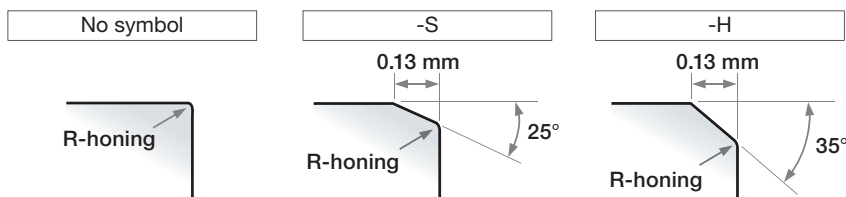




## Two new options of edge preparations are available for grooving hardened steel parts

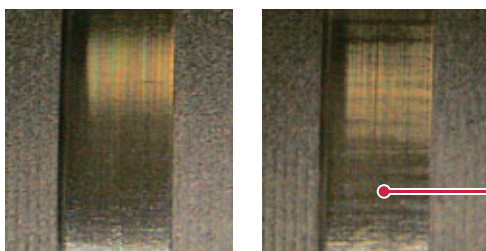


### Edge preparations



## CUTTING PERFORMANCE

### Continuous grooving



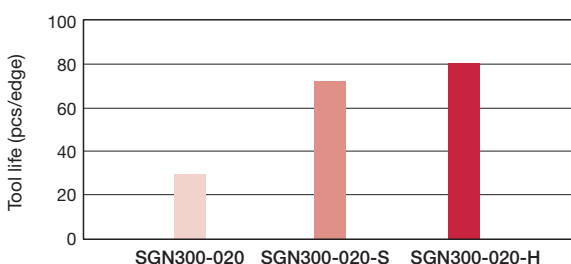
SGN300-020  
BX360

SGN300-020-S  
BX360

**H** Toolholder : CTEL2525-3T  
 Workpiece material : SCM420 (58HRC)  
 Cutting speed :  $V_c = 150$  m/min  
 Feed :  $f = 0.05$  mm/rev  
 Coolant : Wet

**Inserts without edge preparation symbol recommended for continuous grooving**

### Heavy interrupted grooving

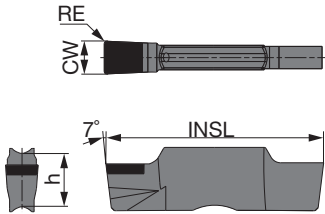


**H** Toolholder : CTEL2525-3T  
 Workpiece material : SCM435 (58HRC)  
 Cutting speed :  $V_c = 100$  m/min  
 Feed :  $f = 0.05$  mm/rev  
 Coolant : Dry

**-H type edge preparation recommended for heavy interrupted grooving**

## SGN

External grooving of hardened steel



<b>P</b>	Steel								
<b>M</b>	Stainless								
<b>K</b>	Cast iron								
<b>N</b>	Non-ferrous								
<b>S</b>	Superalloys								
<b>H</b>	Hard materials	★							

★ : First choice  
☆ : Second choice

Designation	Seat size	CW±0.025	RE	CBN						INSL	h	Edge prep.		
				BX360								No symbol	S	H
SGN200-020	2	2	0.2	●						20	5	○		
SGN200-020-S	2	2	0.2	●						20	5		○	
SGN200-020-H	2	2	0.2	●						20	5			○
SGN300-020	3	3	0.2	●						20	5	○		
SGN300-020-S	3	3	0.2	●						20	5		○	
SGN300-020-H	3	3	0.2	●						20	5			○
SGN400-020	4	4	0.2	●						20	5	○		
SGN400-020-S	4	4	0.2	●						20	5		○	
SGN400-020-H	4	4	0.2	●						20	5			○
SGN500-020-S	5	5	0.2	●						25	5.5		○	
SGN500-020-H	5	5	0.2	●						25	5.5			○

● : New

## STANDARD CUTTING CONDITIONS

ISO	Grade	Edge preparation	Workpiece condition	Cutting speed V <sub>c</sub> (m/min)	Feed f (mm/rev)
<b>H</b>	BX360	No symbol	Continuous	80 - 150	0.03 - 0.08
		-S	Light interrupted	50 - 120	0.03 - 0.08
		-H	Heavy interrupted	40 - 100	0.03 - 0.06

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