





PCBN/PCD TURNING TOOLS



PCBN/PCD

PCBN/PCD Turning Insert Grades

PCBN Grades for **K** Applications

Grade	Cutting Range	Advantages	Applications
B9121 (YP)	Finishing	<ul style="list-style-type: none"> Fine grain size, high CBN content and cermet binder system of PCBN inserts, which can realize continuous to heavy interrupted cutting. Superior impact resistance and chemical stability. 	<ul style="list-style-type: none"> Suitable for finish cutting of Cast iron and Sintered Powder Metal. Suitable for milling of tool steels and hardened steels.
 B9123 (YP)	Semi-finishing	<ul style="list-style-type: none"> Fine grain size, high CBN content and metal binder system. High abrasion resistance, Outstanding impact strength, excellent edge quality and fine surface finishes. 	<ul style="list-style-type: none"> Suitable for light interrupted or Rough cutting of pearlitic cast iron. Suitable for milling of tool steels or die steels. Suitable for finish cutting of Ni and Co-based super alloys.
 B9131 (YS/YZ)	Finishing and Semi-finishing	<ul style="list-style-type: none"> Solid CBN with mixed grain size distribution and high CBN content. High impact resistance and chemical wear resistance which has universal use. 	<ul style="list-style-type: none"> Suitable for semi-finishing and finishing of high hard alloy cast iron and gray cast iron. Suitable for semi-finishing and finishing of hardened steels.
 B9132 (YS/YZ)	Finishing	<ul style="list-style-type: none"> Solid CBN with fine grain size and high CBN content. Excellent abrasion resistance and chip resistance. 	<ul style="list-style-type: none"> Suitable for roughing and finishing of gray cast iron. Suitable for roughing and finishing of high hard alloy cast iron.
 B9141 (YS)	Heavy Roughing	<ul style="list-style-type: none"> Irregularly CBN grain appearance. Excellent impact and chip resistance. 	<ul style="list-style-type: none"> Suitable for heavy roughing or finishing of high hard alloy cast iron, gray cast iron. Suitable for roughing and finishing of high manganese steels.

PCBN Grades for H Applications

Grade	Cutting Range	Advantages	Applications
B9420 (YP)	Finishing	<ul style="list-style-type: none"> • Fine grain size, lower CBN content, ceramic binder system. • Excellent abrasion resistance and chemical stability, high fracture toughness. 	<ul style="list-style-type: none"> • It was designed for continuous and light interrupted finish machining of hardened steels (>50 HRC), and can successfully replace conventional Aluminum oxide grinding in hard turning operations.
B9523 (YP)	Finishing	<ul style="list-style-type: none"> • Fine grain size, lower CBN content, ceramic binder system. • Excellent abrasion resistance and chip resistance. 	<ul style="list-style-type: none"> • Suitable for finish cutting of automotive steels in high speed, continuous conditions. • Suitable for cool-work steels and Valve seat alloy steels.
 B9241 (YS)	Semi-finishing and Roughing	<ul style="list-style-type: none"> • Solid CBN is sintered by high percentage coarse grains. • Excellent impact resistance. 	<ul style="list-style-type: none"> • Suitable for roughing of hardened steels under interrupted conditions. • Suitable for cutting of cast high speed steels.
 B9310 (YS/YZ)	Finishing	<ul style="list-style-type: none"> • Solid CBN is sintered by low content micro grains. • Excellent wear resistance, flank wear resistance and good surface quality. 	<ul style="list-style-type: none"> • Suitable for semi-finishing and finishing of quenched alloy steels.

PCD Grades for N Applications

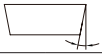
Grade	Cutting Range	Advantages	Applications
D9700 (YP)	Finishing and Roughing	<ul style="list-style-type: none"> High density sintered by super fine diamond grains, have highest wear resistance and fracture resistance, excellent shape edge also. 	<ul style="list-style-type: none"> Suitable for milling and rough cutting of aluminum alloy. Compare to other fine grain PCD material, it is suitable for machining medium and high silicon aluminum alloy, titanium and composites. It is also suitable for machining where mirror surface finishes are required.
D9852 (YP)	Finishing and Roughing	<ul style="list-style-type: none"> Medium grain PCD inserts, have good wear resistance and discharge ability, high fracture resistance, and good for general use. 	<ul style="list-style-type: none"> Mainly use for middle or low silicon aluminum alloy, copper or copper alloy, cemented carbide and ceramic presintered compact, etc.
D9900 (YP)	Finishing and Semi-finishing and Roughing	<ul style="list-style-type: none"> Mixed grain size distribution, combination of excellent wear resistance, high edge quality and high thermal stability. 	<ul style="list-style-type: none"> Application areas: Machining of high silicon aluminum, CFRP, GFRP, MMC and bi-metal alloy.
D9950 (YP)	Semi-finishing and Roughing	<ul style="list-style-type: none"> Coarse grain size, high wear resistance and excellent impact strength, have longer tool life but moderate surface quality. 	<ul style="list-style-type: none"> Suitable for interrupted cutting of high silicon Al alloy (Si > 14%) (ex. Milling), Tungsten carbide, sintered ceramic and other abrasive materials.

PCBN/PCD车削刀片型号表示规则

PCBN/PCD Turning Indexable Inserts Identification System

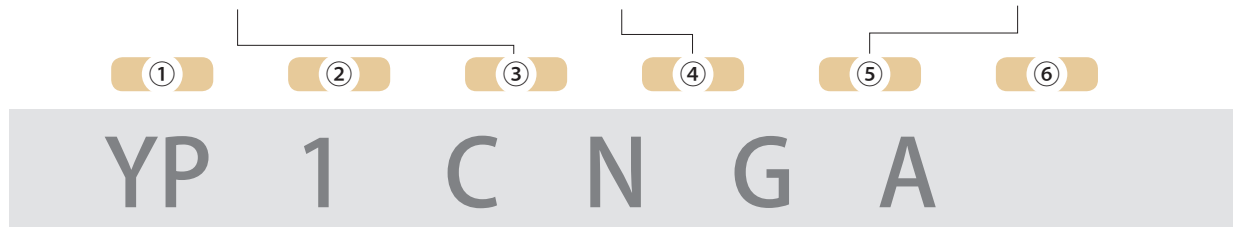
Symbol	Shape	Corner Angle	Figure
S	Square	90°	
T	Triangle	60°	
C	Rhombic	80°	
D		55°	
V		35°	
W	Trigon	80°	
L	Rectangle	90°	
A	Parallelogram	85°	
R	Round	--	
③ Shape Symbol			

Symbol	Clearance Angle
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Others



④ Clearance Angle Symbol

Symbol	Tolerance (mm)		
	Corner Height(m)	Thickness(s)	I.C.Size(Ød)
A	±0.005 ±0.005	±0.025 ±0.025	±0.025 ±0.013
C	±0.013	±0.025	±0.025
H	±0.013	±0.025	±0.013
E	±0.025	±0.025	±0.025
G	±0.025	±0.13	±0.025
K	±0.013	±0.025	±0.05~ ±0.13
L	±0.025	±0.025	±0.05~ ±0.13
M	±0.08~ ±0.18	±0.13	±0.05~ ±0.13
⑤ Tolerance Symbol			



① Insert Series









Symbol	Sample
YP	
YZ	
YS	

② Cutting Edge

Symbol	Edge
1	1
2	2
3	3
4	4
0	Other

⑥ Hole/Chipbreaker Symbol

Symbol	hole	Hole Shape	Chipbreaker	Shape
N	Without	—	Without	
A (G)	With	With Hole	Without	
W (T)	With	40° ~60°	Without	
X	—	—	—	

								IC Size(mm)
Symbol	Symbol	Symbol	Symbol	Symbol	Symbol	Symbol	Symbol	
	03	03		06	04			3.97
	04	04		08	05			4.76
05								5
	05	05	03	09	06			5.56
06								6
	06	06	04	11	07	11		6.35
	07	08	05	13	09			7.94
08								8
09	09	09	06	16	11	16	16	9.525
10								10
12								12
12	12	12	08	22	15	22		12.7
15	15	16	10	27	19			15.875
16								16
19	19	19	13	33	23			19.05
20								20
	22	22		38	27			22.225
25								25
25	25	25		44	31			25.4
31	31	32		55	38			31.75
31							—	32

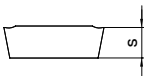
⑦ Inscribed Circle Size Symbol (mm)



09 T3 04 Q3

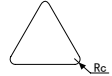


⑧ Thickness Symbol



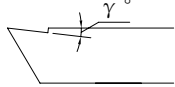
Symbol	Thickness(mm)
01	1.59
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76
05	5.56
06	6.35
07	7.94
09	9.52

⑨ Corner Symbol



Symbol	Corner-Rc(mm)
00	0.03
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
28	2.8
32	3.2

⑩ Rake Angle Symbol



Symbol	Rake Angle Symbol
Q5	5°
Q7	7°
Without	0°

Commonly used cutting Edge Conditions of PCBN Tools



The Negative Land and Honing Cutting Edge Condition

Both the strength and the comprehensive performance of this cutting edge are the best, and this edge is most widely used for CBN cutting tools. The cutting edge S10020 is used to turn hard alloy cast iron, and turning gray cast iron is S02020, turning hardened steel is S01020.



The Negative Land Cutting Edge Condition

The negative land helps to improve the impact resistance of the cutting edges. Compared with S type cutting edge, the quality of the machined surface could be improved and the dimensional stability could be ensured.



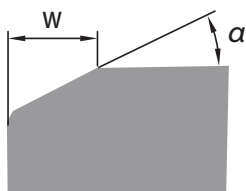
Honing by Er Cutting Edge Condition

Honing can help to reduce micro-chipping and to protect the cutting edges. Both the heavier honing and the more perfect cutting edges, the better strength will be improved. However, the cutting force and the cutting temperature will be also improved. Finally, the heavy honing would be selected under the condition that both the system rigidity and the machine power are enough, even if interrupted cutting.

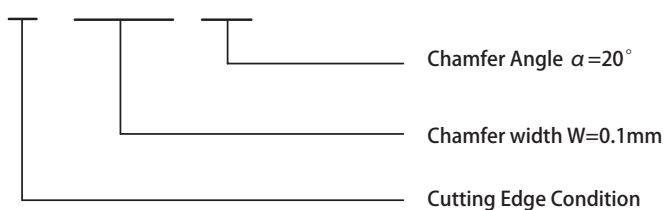


Sharp Cutting Edge Condition

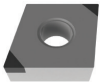
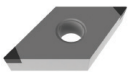


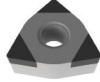
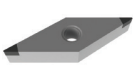







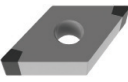


It is difficult to generate the chatter marks and easy to reduce the roughness of the machined surface if the sharp cutting edge would be used. But on the other hand the tool life would be reduced if the edges are over-sharpened. Consequently, this kind of edge is only adopted under the condition of cutting common cast iron and high precision surface requirement, such as finish turning gray cast iron brake discs.


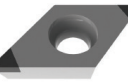

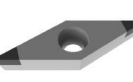




S 0 1 0 2 0

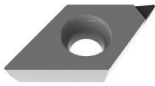

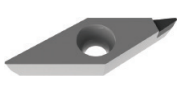


PCBN features of PCBN Turning Inserts

Insert Series	Rhombic 80°	Rhombic 55°	Square 90°	Triangle 60°	Trigon 80°	Rhombic 35°	Round360°
YP							
	CNGA	DNGA	SNGA	TNGA	WNGA	VNGA	
	Page63	Page64	Page65	Page66	Page67	Page68	
YS							
	CNGN	DNGN	SNGN	TNGN	WNGN		RNGN
	Page69	Page70	Page71	Page72	Page73		Page74
YZ							
	CNGA	DNGA		TNGA	WNGA		
	Page75	Page76		Page77	Page78		

Insert Series	Rhombic 80°	Rhombic 55°	Square 90°	Triangle 60°	Trigon 80°	Rhombic 35°	Round360°
YP							
	CCGW	DCGW		TCGW		VBGW	
	Page79	Page81		Page82		Page84	
	CPGW			TPGW		VCGW	
	Page80		Page83		Page85		
YS							
			SCGN				RCGN
			Page86				Page41

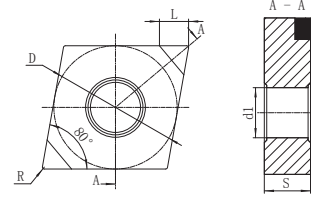
Features of PCD Turning Inserts

Insert Series	Rhombic 80°	Rhombic 55°	Triangle 60°	Rhombic 35°
YP				
	CCGW	DCGW	TCGW	VCGW
	Page88	Page90	Page91	Page93
	CPGW		TPGW	
	Page89		Page92	

PCBN Turning Inserts (Negative)

CNGA

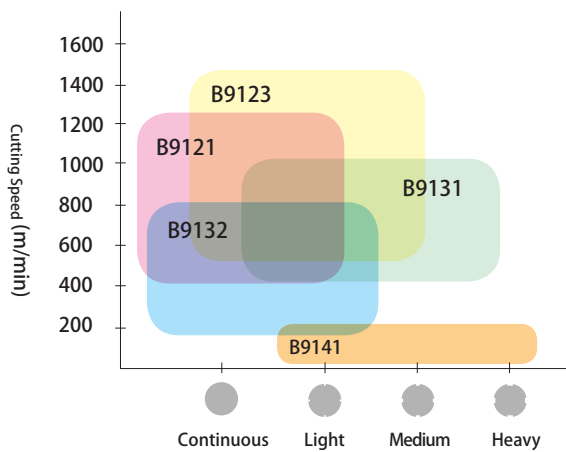
Rhombic 80° , with Hole



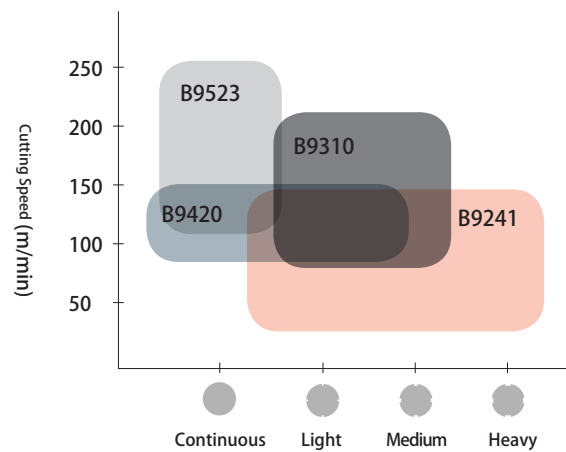
Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN				
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523	
	YP2CNGA120402	2	3.0	12.7	4.76	5.16	0.2	○	○	○	○
	YP2CNGA120404	2	3.0	12.7	4.76	5.16	0.4	●	○	●	○
	YP2CNGA120408	2	3.0	12.7	4.76	5.16	0.8	●	○	●	○
	YP2CNGA120412	2	3.0	12.7	4.76	5.16	1.2	●	○	●	○
	YP2CNGA120416	2	3.0	12.7	4.76	5.16	1.6	○	○	○	○

● Stock ○ Available upon Order

Grades for K Applications



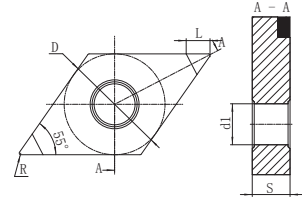
Grades for H Applications



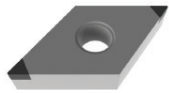
PCBN Turning Inserts (Negative)

DNGA

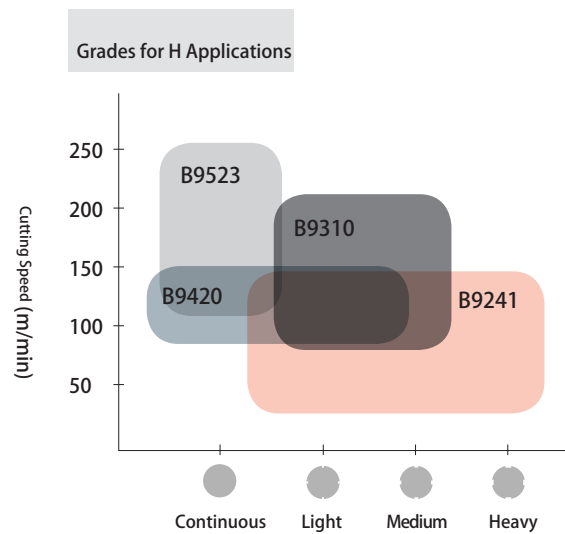
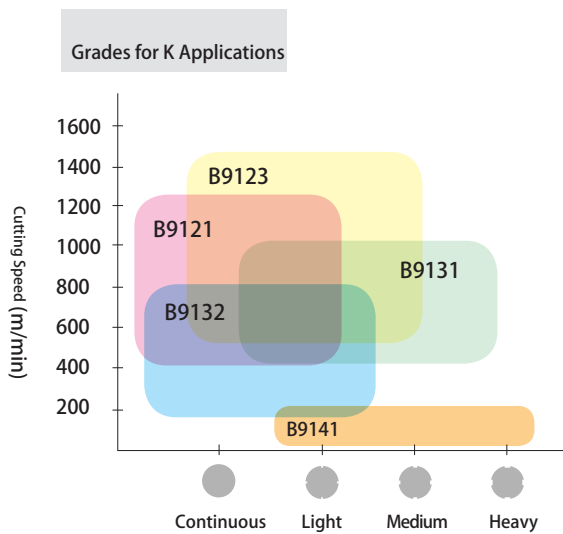
Rhombic 55° , with Hole



Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN			
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523
YP2DNGA150402	2	3.0	12.7	4.76	5.16	0.2	○	○	○	○
YP2DNGA150404	2	3.0	12.7	4.76	5.16	0.4	●	○	●	○
YP2DNGA150408	2	3.0	12.7	4.76	5.16	0.8	●	○	●	○
YP2DNGA150412	2	3.0	12.7	4.76	5.16	1.2	●	○	●	○
YP2DNGA150416	2	3.0	12.7	4.76	5.16	1.6	○	○	●	○
YP2DNGA150604	2	3.0	12.7	6.35	5.16	0.4	○	○	○	○
YP2DNGA150608	2	3.0	12.7	6.35	5.16	0.8	○	●	○	●
YP2DNGA150612	2	3.0	12.7	6.35	5.16	1.2	○	●	○	●
YP2DNGA150616	2	3.0	12.7	6.35	5.16	1.6	○	○	○	○



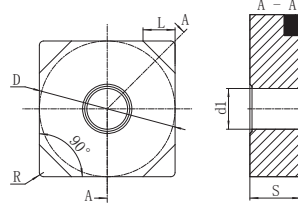
● Stock ○ Available upon Order




PCBN Turning Inserts (Negative)

SNGA

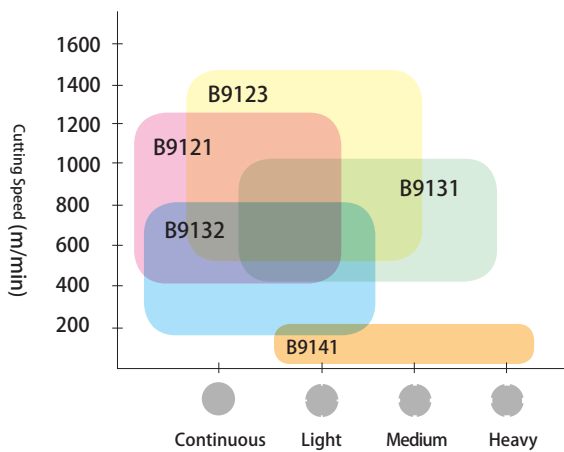
V Square 90° , with Hole



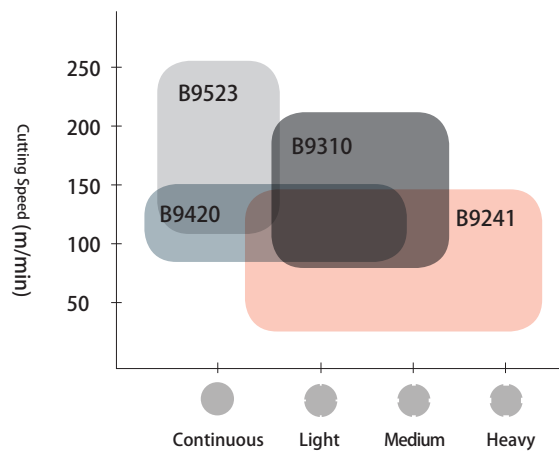
Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN				
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523	
	YP4SNGA120404	4	3.0	12.7	4.76	5.16	0.4	○	●	○	●
	YP4SNGA120408	4	3.0	12.7	4.76	5.16	0.8	○	●	○	●
	YP4SNGA120412	4	3.0	12.7	4.76	5.16	1.2	○	○	○	○
	YP4SNGA120416	4	3.0	12.7	4.76	5.16	1.6	○	○	○	○

● Stock ○ Available upon Order

Grades for K Applications



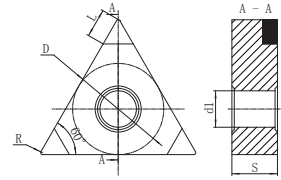
Grades for H Applications



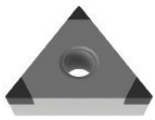
PCBN Turning Inserts (Negative)

TNGA

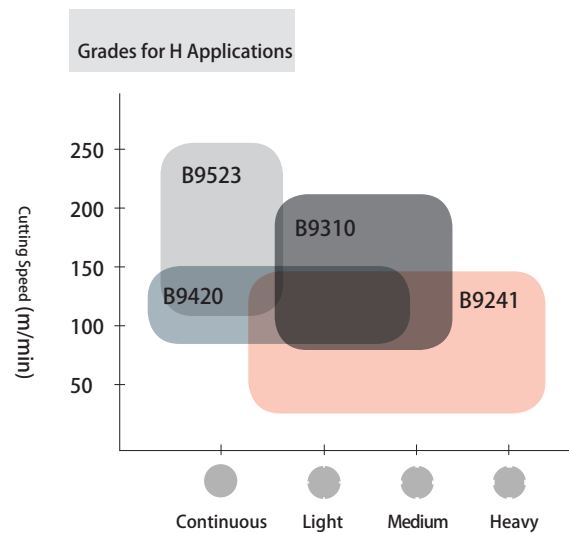
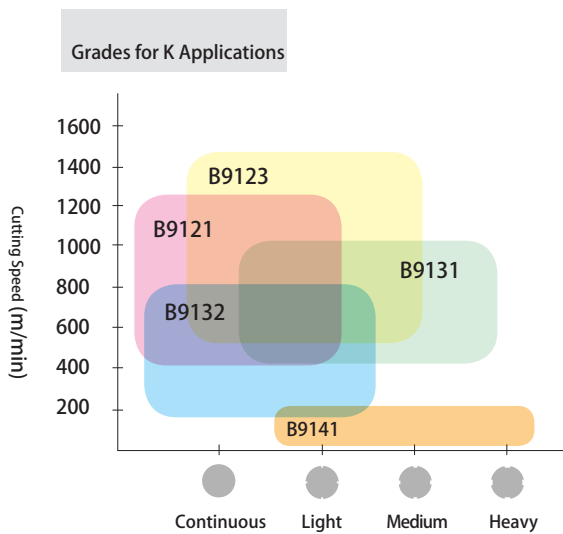
Triangle 60° , with Hole



Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN			
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523
YP3TNGA160402	3	3.0	9.525	4.76	3.81	0.2	○	●	○	●
YP3TNGA160404	3	3.0	9.525	4.76	3.81	0.4	○	●	○	●
YP3TNGA160408	3	3.0	9.525	4.76	3.81	0.8	○	●	○	●
YP3TNGA160412	3	3.0	9.525	4.76	3.81	1.2	○	●	○	●
YP3TNGA160416	3	3.0	9.525	4.76	3.81	1.6	○	○	○	●



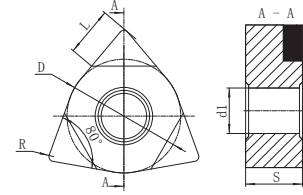
● Stock ○ Available upon Order



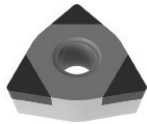
PCBN Turning Inserts (Negative)

WNGA

Trigon 80° , with Hole

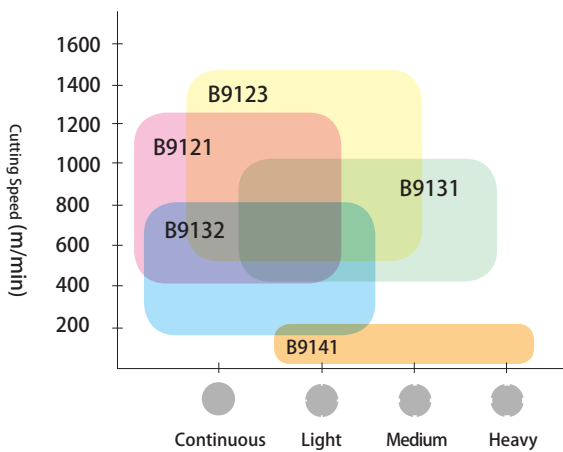


Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN			
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523
YP3WNGA060404	3	3.0	9.525	4.76	3.81	0.4	○	○	○	○
YP3WNGA060408	3	3.0	9.525	4.76	3.81	0.8	○	●	○	●
YP3WNGA060412	3	3.0	9.525	4.76	3.81	1.2	○	●	○	●
YP3WNGA060416	3	3.0	9.525	4.76	3.81	1.6	○	○	○	○
YP3WNGA080404	3	3.0	12.7	4.76	5.16	0.4	○	○	○	○
YP3WNGA080408	3	3.0	12.7	4.76	5.16	0.8	●	○	●	○
YP3WNGA080412	3	3.0	12.7	4.76	5.16	1.2	●	○	●	○
YP3WNGA080416	3	3.0	12.7	4.76	5.16	1.6	○	○	●	○

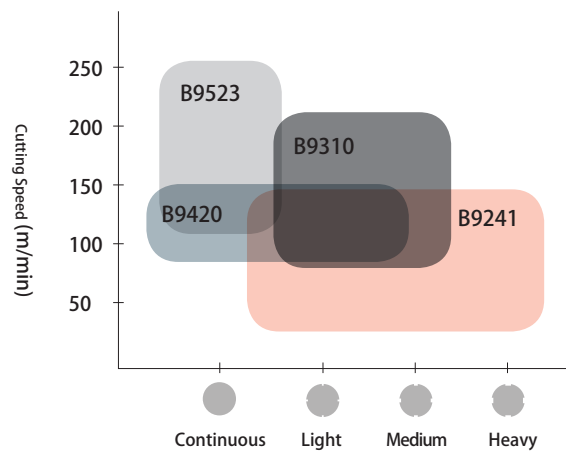


● Stock ○ Available upon Order

Grades for K Applications



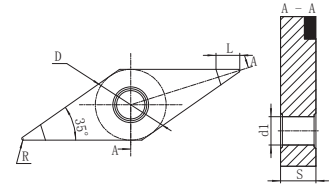
Grades for H Applications



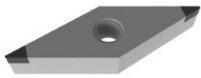
PCBN Turning Inserts (Negative)

VNGA

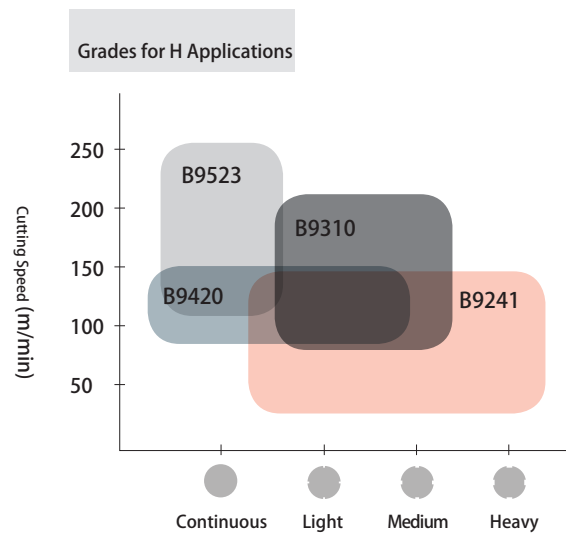
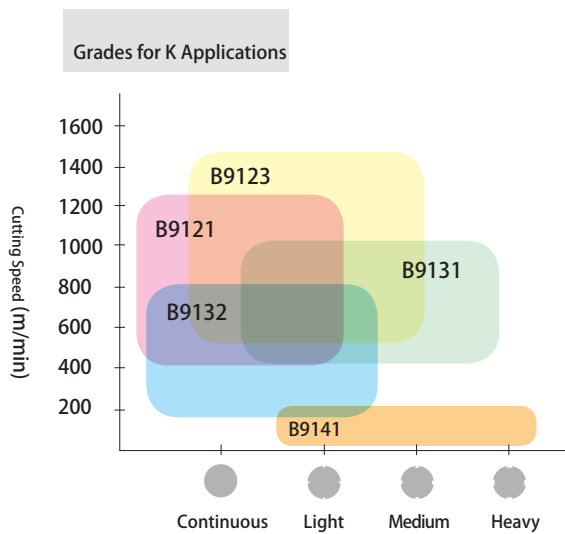
Rhombic 35°, with Hole



Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN			
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523
YP2VNGA160402	2	3.0	9.525	4.76	3.81	0.2	●	○	●	○
YP2VNGA160404	2	3.0	9.525	4.76	3.81	0.4	●	○	●	○
YP2VNGA160408	2	3.0	9.525	4.76	3.81	0.8	●	○	●	○
YP2VNGA160412	2	3.0	9.525	4.76	3.81	1.2	○	○	○	○
YP2VNGA160416	2	3.0	9.525	4.76	3.81	1.6	○	○	○	○
YP2VNGA220402	2	3.0	12.7	4.76	5.16	0.2	○	○	○	○
YP2VNGA220404	2	3.0	12.7	4.76	5.16	0.4	○	●	○	●
YP2VNGA220408	2	3.0	12.7	4.76	5.16	0.8	○	●	○	●
YP2VNGA220412	2	3.0	12.7	4.76	5.16	1.2	○	●	○	●
YP2VNGA220416	2	3.0	12.7	4.76	5.16	1.6	○	○	○	○



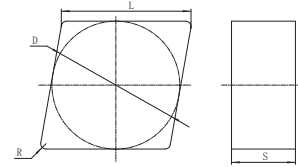
● Stock ○ Available upon Order



PCBN Turning Inserts (Negative)

CNGN **NEW**

Rhombic 80°, without Hole

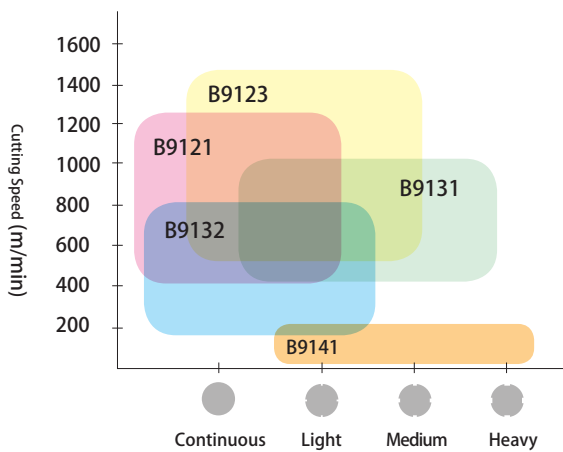


Ordering Code	Edge	Dimensions(mm)				PCBN Grades of PCBN				
		L	D	S	R	B9131	B9132	B9141	B9241	B9310
YS4CNGN090404	4	9.525	9.525	4.76	0.4	○	○			
YS4CNGN090408	4	9.525	9.525	4.76	0.8	○	○			
YS4CNGN090412	4	9.525	9.525	4.76	1.2	○	○			
YS4CNGN120404	4	12.7	12.7	4.76	0.4	●	●		●	○
YS4CNGN120408	4	12.7	12.7	4.76	0.8	●	●		●	○
YS4CNGN120412	4	12.7	12.7	4.76	1.2	●	●		●	○
YS4CNGN120704	4	12.7	12.7	7.94	0.4	●	●		○	○
YS4CNGN120708	4	12.7	12.7	7.94	0.8	●	●		○	○
YS4CNGN120712	4	12.7	12.7	7.94	1.2	●	●		○	○

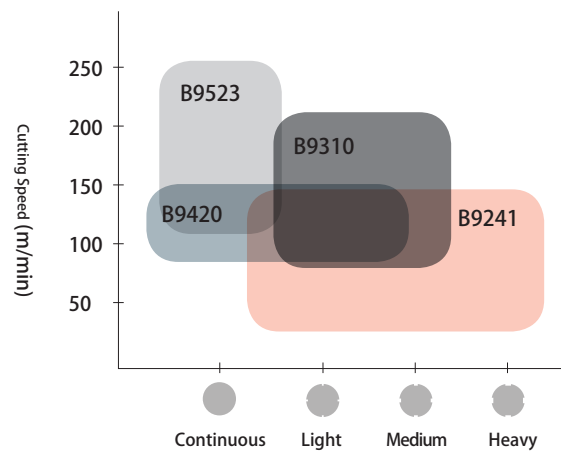


● Stock ○ Available upon Order

Grades for K Applications



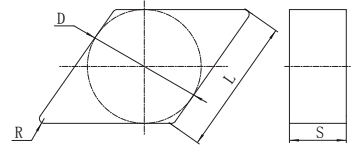
Grades for H Applications




PCBN Turning Inserts (Negative)

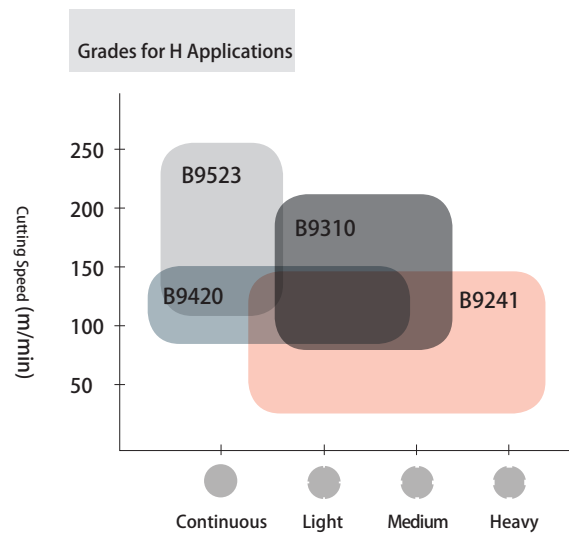
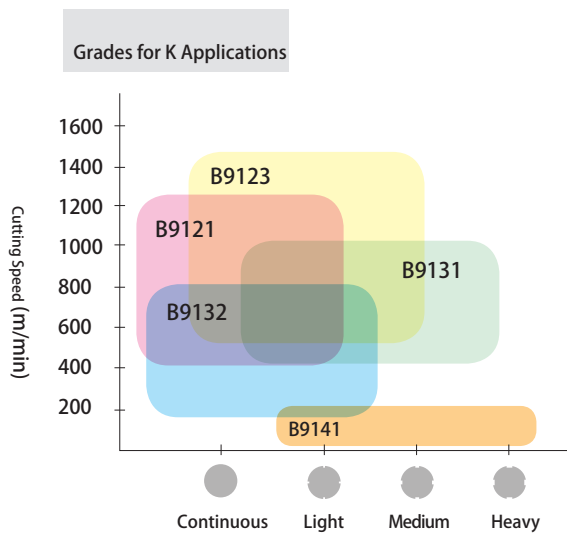
DNGN **NEW**

Rhombic 55° , without Hole



Ordering Code	Edge	Dimensions(mm)				PCBN Grades of PCBN					
		L	D	S	R	B9131	B9132	B9141	B9241	B9310	
	YS4DNGN150604	4	15.5	12.7	6.35	0.4	○	○			
	YS4DNGN150608	4	15.5	12.7	6.35	0.8	○	○			
	YS4DNGN150612	4	15.5	12.7	6.35	1.2	○	○			

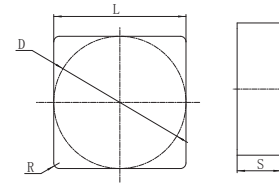
● Stock ○ Available upon Order



PCBN Turning Inserts (Negative)

SNGN **NEW**

Square 90° , without Hole

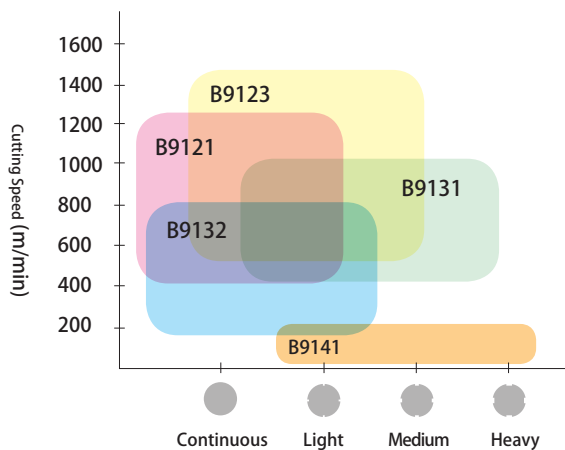


Ordering Code	Edge	Dimensions(mm)				PCBN Grades of PCBN				
		L	D	S	R	B9131	B9132	B9141	B9241	B9310
YS0SNGN090304	8	9.525	9.525	3.18	0.4	○	○			
YS0SNGN090308	8	9.525	9.525	3.18	0.8	○	○			
YS0SNGN090312	8	9.525	9.525	3.18	1.2	○	○			
YS0SNGN090404	8	9.525	9.525	4.76	0.4	○	○			
YS0SNGN090408	8	9.525	9.525	4.76	0.8	○	○			
YS0SNGN090412	8	9.525	9.525	4.76	1.2	○	○			
YS0SNGN120404	8	12.7	12.7	4.76	0.4	●	●	○	○	○
YS0SNGN120408	8	12.7	12.7	4.76	0.8	●	●	○	○	○
YS0SNGN120412	8	12.7	12.7	4.76	1.2	●	●	○	○	○
YS0SNGN120708	8	12.7	12.7	7.94	0.8	●	●	○	○	○
YS0SNGN120712	8	12.7	12.7	7.94	1.2	●	●	○	○	○
YS0SNGN150708	8	15.875	15.875	7.94	0.8	○	○	●	●	
YS0SNGN150712	8	15.875	15.875	7.94	1.2	○	○	●	●	
YS0SNGN201008	8	20	20	10	0.8			●	●	
YS0SNGN201012	8	20	20	10	1.2			●	●	

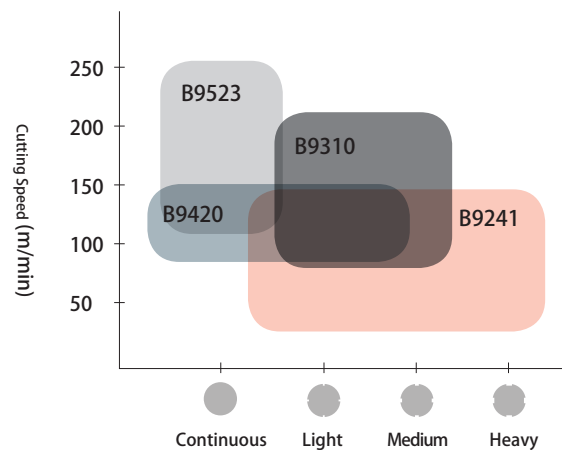


● Stock ○ Available upon Order

Grades for K Applications



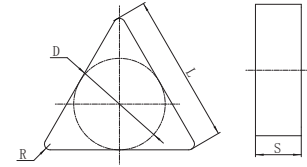
Grades for H Applications



PCBN Turning Inserts (Negative)

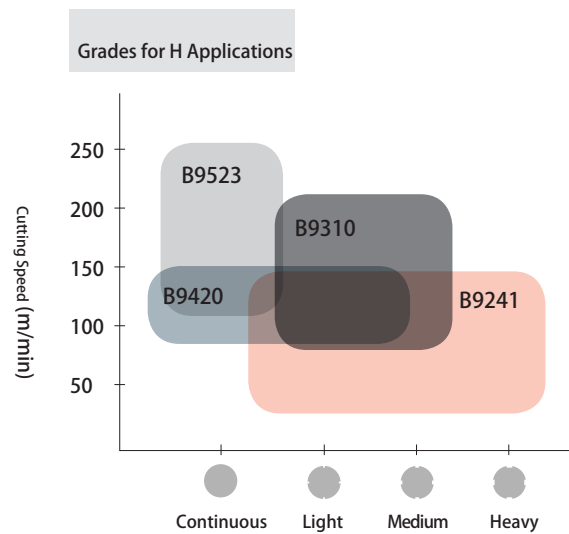
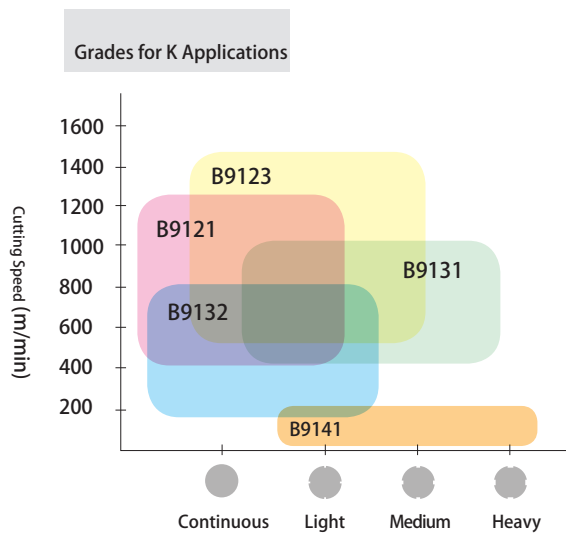
TNGN **NEW**

Triangle 60°, without Hole



Ordering Code	Edge	Dimensions(mm)				PCBN Grades of PCBN					
		L	D	S	R	B9131	B9132	B9141	B9241	B9310	
	YS0TNGN110304	6	11.0	6.35	3.18	0.4	○	○			
	YS0TNGN110308	6	11.0	6.35	3.18	0.8	○	○			
	YS0TNGN110312	6	11.0	6.35	3.18	1.2	○	○			
	YS0TNGN160404	6	16.5	9.25	4.76	0.4	○	○		○	○
	YS0TNGN160408	6	16.5	9.25	4.76	0.8	○	○		○	○
	YS0TNGN160412	6	16.5	9.25	4.76	1.2	○	○		○	○

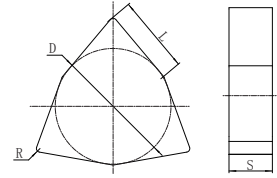
● Stock ○ Available upon Order




PCBN Turning Inserts (Negative)

WNGN **NEW**

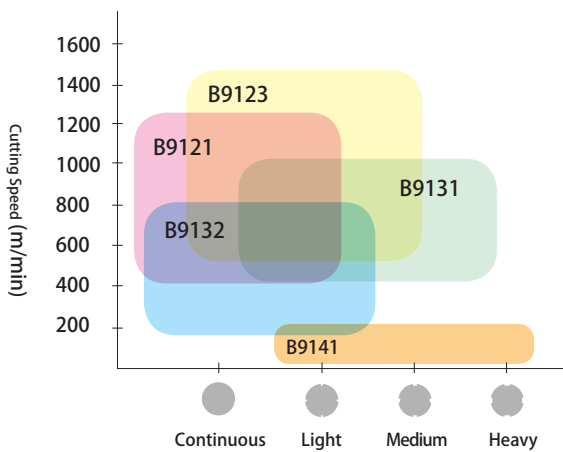
Trigon 80° , without Hole



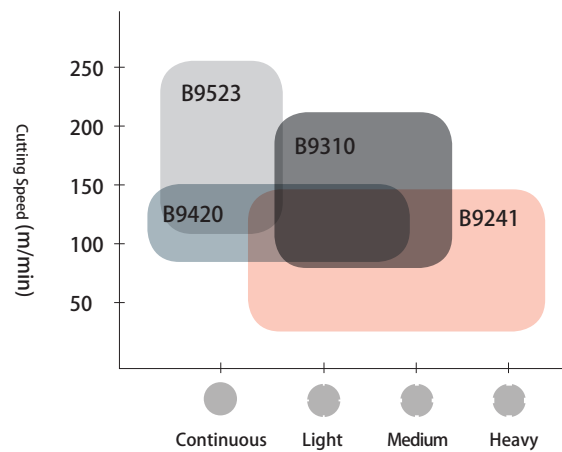
Ordering Code	Edge	Dimensions(mm)				PCBN Grades of PCBN					
		L	D	S	R	B9131	B9132	B9141	B9241	B9310	
	YS0WNGN080404	6	8.72	12.7	4.76	0.4	●	●		○	○
	YS0WNGN080408	6	8.72	12.7	4.76	0.8	●	●		○	○
	YS0WNGN080412	6	8.72	12.7	4.76	1.2	●	●		○	○
	YS0WNGN080416	6	8.72	12.7	4.76	1.6	●	●		○	○

● Stock ○ Available upon Order

Grades for K Applications



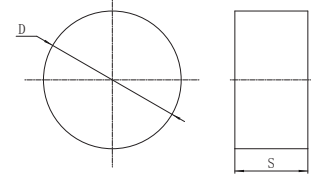
Grades for H Applications



PCBN Turning Inserts (Negative)

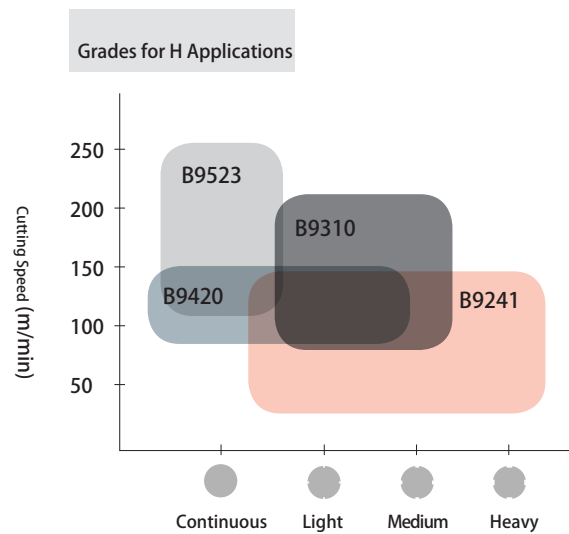
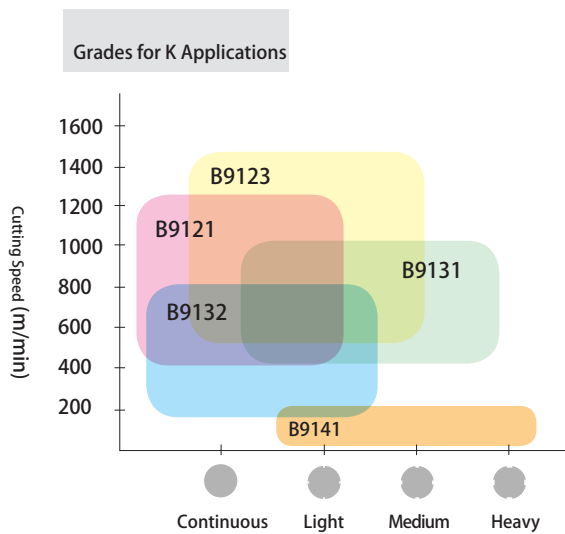
RNGN **NEW**

Round 360° , without Hole



Ordering Code	Edge	Dimensions(mm)		PCBN Grades of PCBN					
		D	S	B9131	B9132	B9141	B9241	B9310	
	YSORNGN090300	Round	9.525	3.18	○	○		○	○
	YSORNGN090400	Round	9.525	4.76	○	○		○	○
	YSORNGN120400	Round	12.7	4.76	○	○		○	○
	YSORNGN120600	Round	12.7	6.35	○	○		○	○
	YSORNGN120700	Round	12.7	7.94	○	○		●	○
	YSORNGN150700	Round	15.875	7.94	○	○	○	●	○
	YSORNGN201000	Round	20	10	○	○	●	○	○

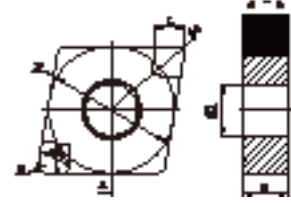
● Stock ○ Available upon Order

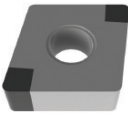


PCBN Turning Inserts (Negative)

CNGA **NEW**

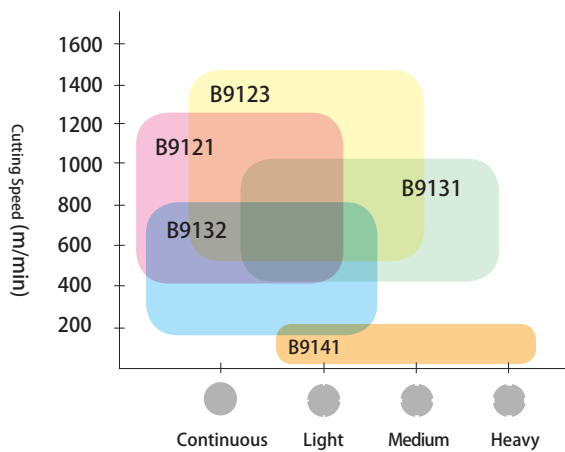
Rhombic 80° , with Hole



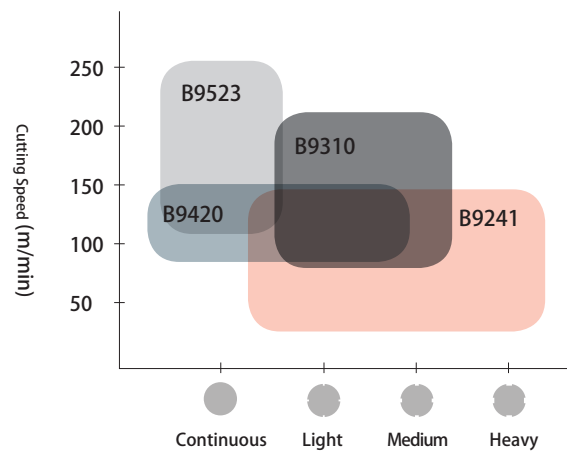
Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN					
		L	D	S	d1	R	B9131	B9132	B9141	B9241	B9310	
	YZ4CNGA120404	4	3.0	12.7	4.76	5.16	0.4	●	●			●
	YZ4CNGA120408	4	3.0	12.7	4.76	5.16	0.8	●	●			●
	YZ4CNGA120412	4	3.0	12.7	4.76	5.16	1.2	●	●			●
	YZ4CNGA120416	4	3.0	12.7	4.76	5.16	1.6	●	●			●

● Stock ○ Available upon Order

Grades for K Applications



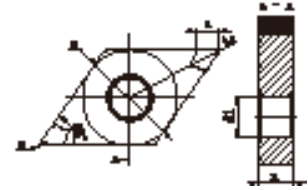
Grades for H Applications



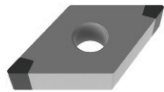
PCBN Turning Inserts (Negative)

DNGA **NEW**

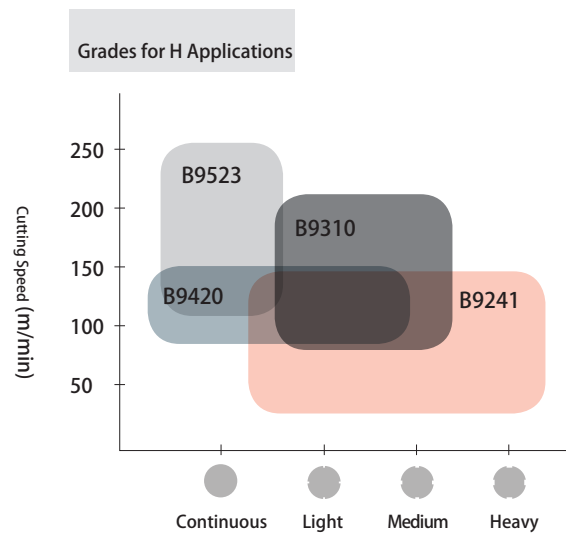
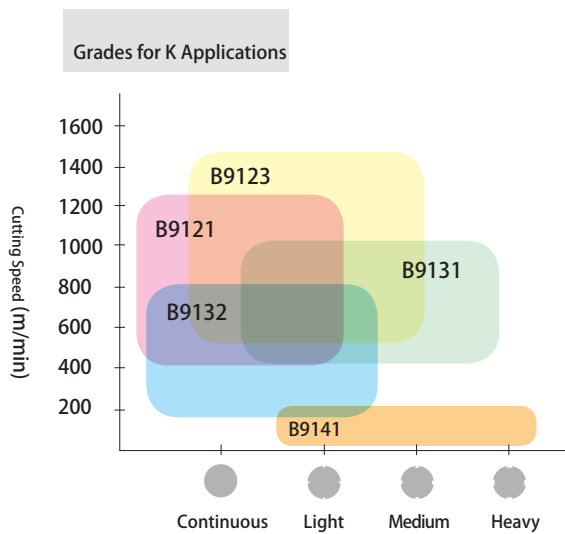
Rhombic 55° , with Hole



Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN				
		L	D	S	d1	R	B9131	B9132	B9141	B9241	B9310
YZ4DNGA150404	4	3.0	12.7	4.76	5.16	0.4	○	○			○
YZ4DNGA150408	4	3.0	12.7	4.76	5.16	0.8	○	○			○
YZ4DNGA150412	4	3.0	12.7	4.76	5.16	1.2	○	○			○
YZ4DNGA150604	4	3.0	12.7	6.35	5.16	0.4	○	○			○
YZ4DNGA150608	4	3.0	12.7	6.35	5.16	0.8	○	○			○
YZ4DNGA150612	4	3.0	12.7	6.35	5.16	1.2	○	○			○



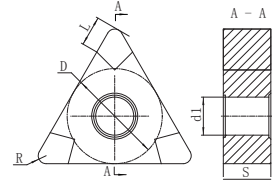
● Stock ○ Available upon Order




PCBN Turning Inserts (Negative)

TNGA **NEW**

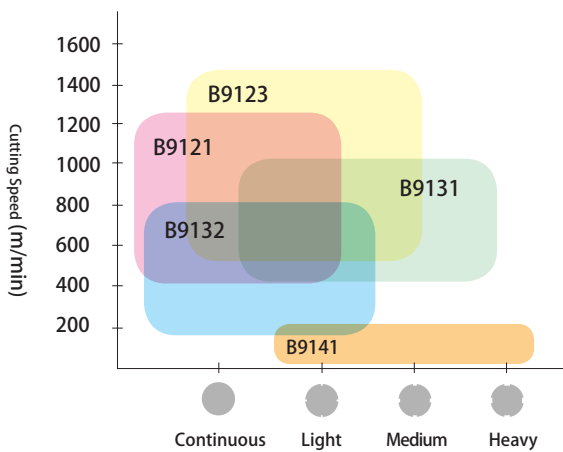
Triangle 60° , with Hole



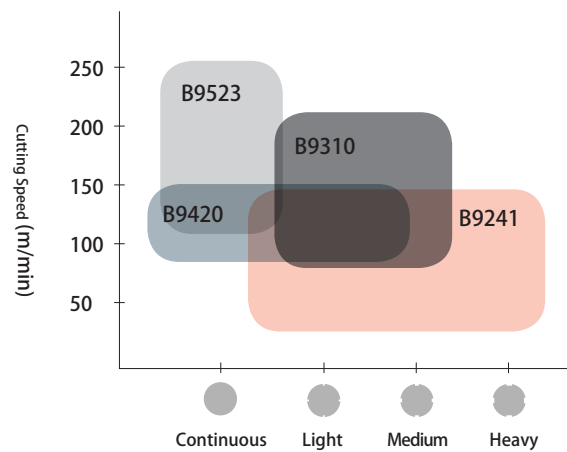
Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN					
		L	D	S	d1	R	B9131	B9132	B9141	B9241	B9310	
	YZ0TNGA160404	6	3.0	9.525	4.76	3.81	0.4	○	○			○
	YZ0TNGA160408	6	3.0	9.525	4.76	3.81	0.8	○	○			○
	YZ0TNGA160412	6	3.0	9.525	4.76	3.81	1.2	○	○			○
	YZ0TNGA160416	6	3.0	9.525	4.76	3.81	1.6	○	○			○

● Stock ○ Available upon Order

Grades for K Applications



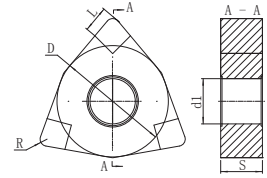
Grades for H Applications

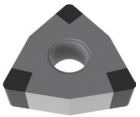


PCBN Turning Inserts (Negative)

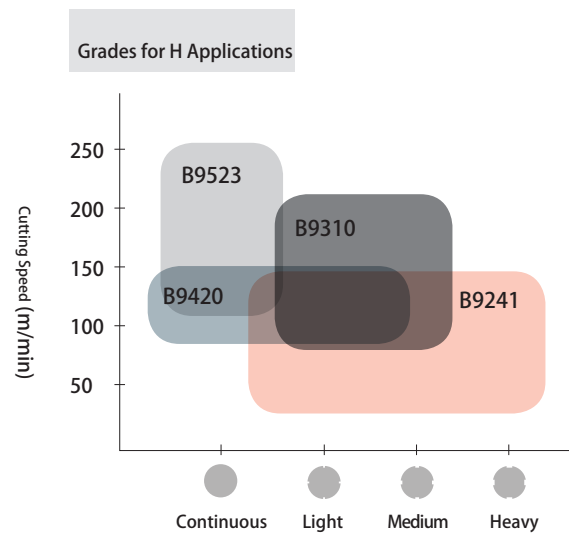
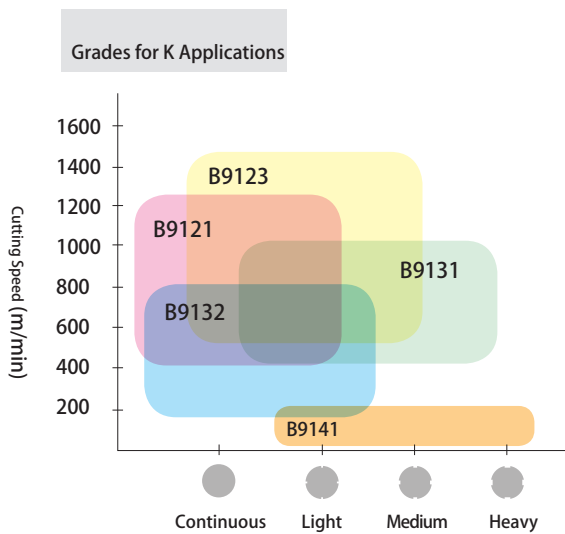
WNGA **NEW**

Trigon 80° , with Hole



Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN					
		L	D	S	d1	R	B9131	B9132	B9141	B9241	B9310	
	YZ0WNGA080404	6	3.0	12.7	4.76	5.16	0.4	●	●			●
	YZ0WNGA080408	6	3.0	12.7	4.76	5.16	0.8	●	●			●
	YZ0WNGA080412	6	3.0	12.7	4.76	5.16	1.2	●	●			●
	YZ0WNGA080416	6	3.0	12.7	4.76	5.16	1.6	●	●			●

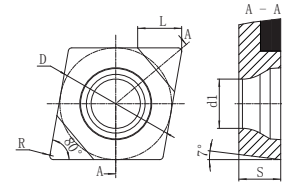
● Stock ○ Available upon Order



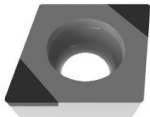
PCBN Turning Inserts (Positive)

CCGW

Rhombic 80°, with Hole

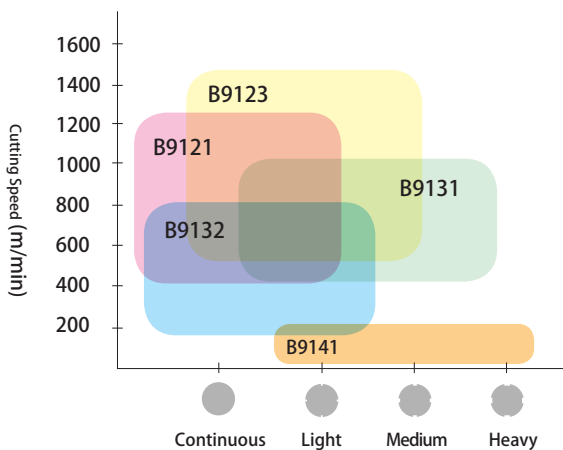


Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN			
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523
YP2CCGW060202	2	2.5	6.35	2.38	2.8	0.2	●	○	●	○
YP2CCGW060204	2	2.5	6.35	2.38	2.8	0.4	●	○	●	○
YP2CCGW060208	2	2.5	6.35	2.38	2.8	0.8	●	○	●	○
YP2CCGW09T302	2	3.0	9.525	3.97	4.4	0.2	●	○	●	○
YP2CCGW09T304	2	3.0	9.525	3.97	4.4	0.4	○	●	○	●
YP2CCGW09T308	2	3.0	9.525	3.97	4.4	0.8	○	●	○	●
YP2CCGW120402	2	3.0	12.7	4.76	5.5	0.2	○	○	○	○
YP2CCGW120404	2	3.0	12.7	4.76	5.5	0.4	○	●	○	●
YP2CCGW120408	2	3.0	12.7	4.76	5.5	0.8	○	●	○	●

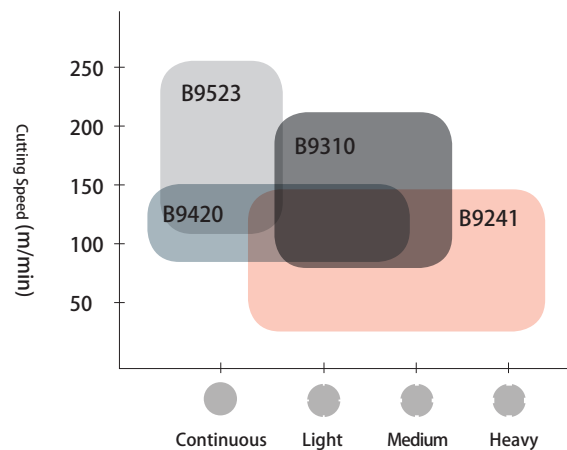


● Stock ○ Available upon Order

Grades for K Applications



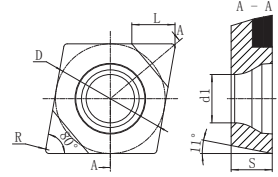
Grades for H Applications




PCBN Turning Inserts (Positive)

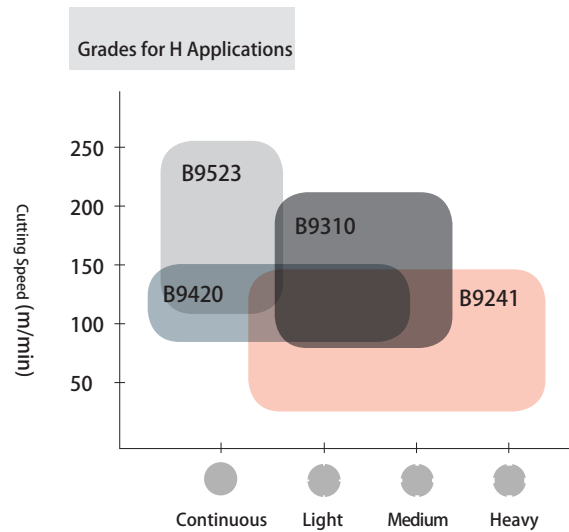
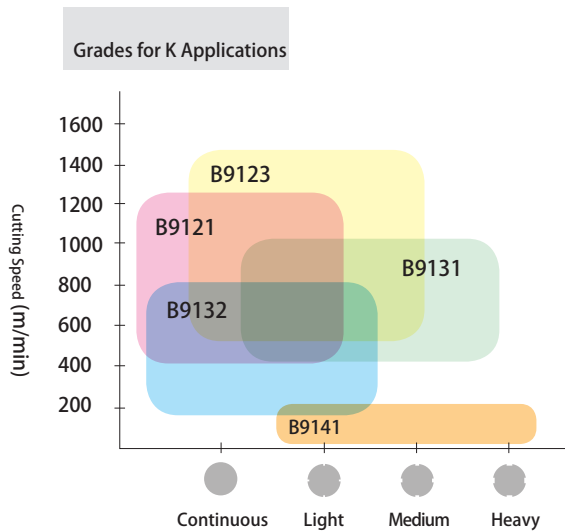
CPGW

Rhombic 80°, with Hole



Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN				
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523	
	YP2CPGW090302	2	3.0	9.525	3.18	4.4	0.2	○	○	○	○
	YP2CPGW090304	2	3.0	9.525	3.18	4.4	0.4	○	○	○	○
	YP2CPGW090308	2	3.0	9.525	3.18	4.4	0.8	○	○	○	○

● Stock ○ Available upon Order

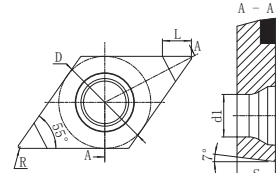


PCBN Turning Inserts (Positive)

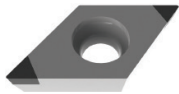
DCGW

有孔

Rhombic 55° , with Hole

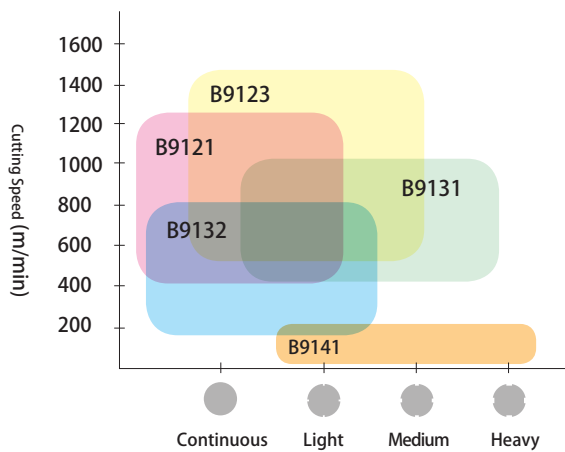


Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN			
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523
YP2DCGW070202	2	2.5	6.35	2.38	2.8	0.2	○	●	○	●
YP2DCGW070204	2	2.5	6.35	2.38	2.8	0.4	○	●	○	●
YP2DCGW070208	2	2.5	6.35	2.38	2.8	0.8	○	●	○	●
YP2DCGW11T302	2	3.0	9.525	3.97	4.4	0.2	●	○	●	○
YP2DCGW11T304	2	3.0	9.525	3.97	4.4	0.4	●	○	●	○
YP2DCGW11T308	2	3.0	9.525	3.97	4.4	0.8	●	○	●	○

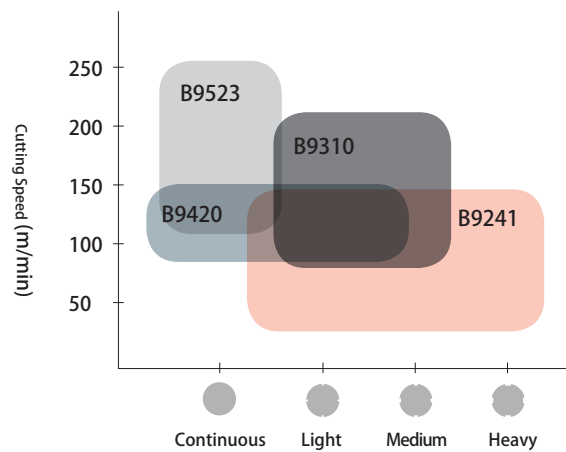


● Stock ○ Available upon Order

Grades for K Applications



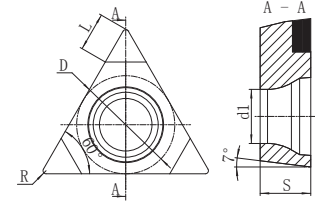
Grades for H Applications



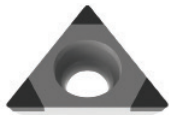
PCBN Turning Inserts (Positive)

TCGW

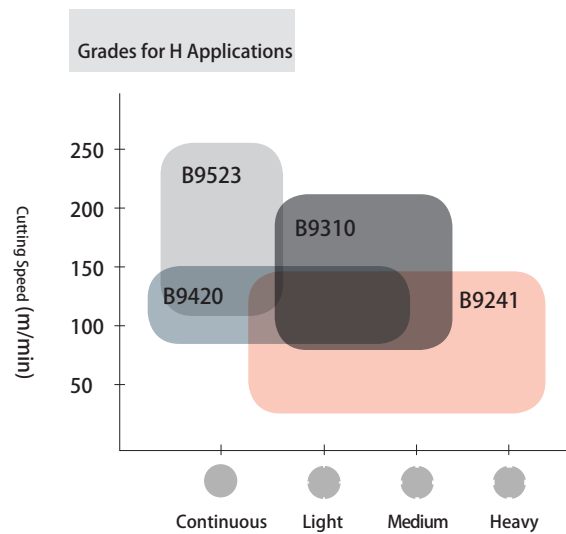
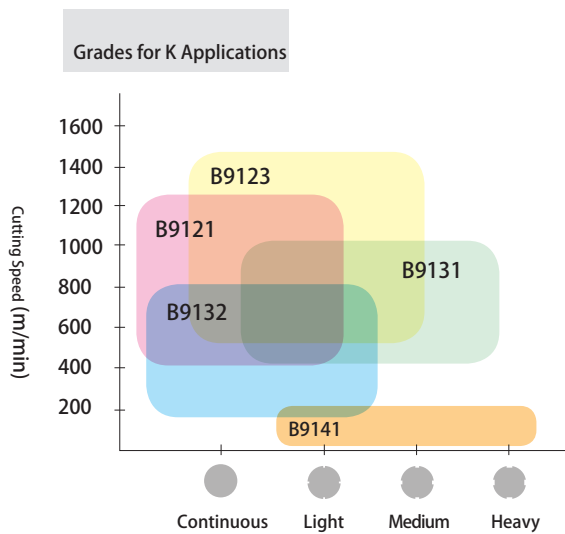
Triangle 60° , with Hole



Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN			
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523
YP3TCGW110302	3	2.5	6.35	3.18	2.8	0.2	○	●	○	●
YP3TCGW110304	3	2.5	6.35	3.18	2.8	0.4	○	●	○	●
YP3TCGW110308	3	2.5	6.35	3.18	2.8	0.8	○	●	○	●
YP3TCGW160404	3	3.0	9.525	4.76	4.4	0.4	●	○	●	○
YP3TCGW160408	3	3.0	9.525	4.76	4.4	0.8	●	○	●	○
YP3TCGW160412	3	3.0	9.525	4.76	4.4	1.2	●	○	●	○



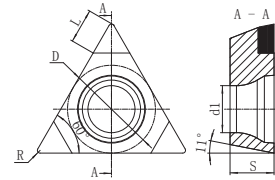
● Stock ○ Available upon Order



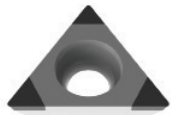
PCBN Turning Inserts (Positive)

TPGW

Triangle 60° , with Hole

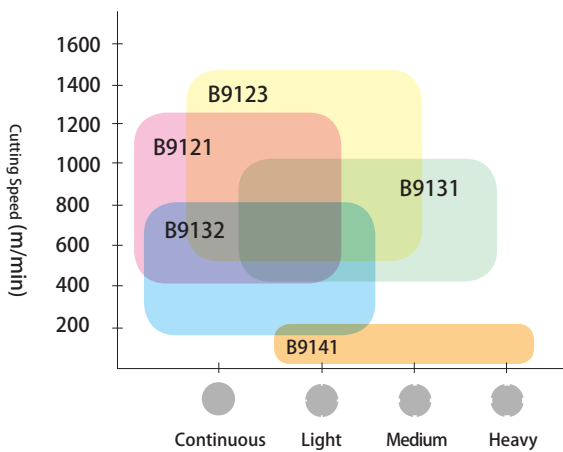


Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN			
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523
YP3TPGW110202	3	2.5	6.35	2.38	2.8	0.2	○	○	○	○
YP3TPGW110204	3	2.5	6.35	2.38	2.8	0.4	○	○	○	○
YP3TPGW110208	3	2.5	6.35	2.38	2.8	0.8	○	○	○	○
YP3TPGW110302	3	2.5	6.35	3.18	2.8	0.2	○	○	○	○
YP3TPGW110304	3	2.5	6.35	3.18	2.8	0.4	○	○	○	○
YP3TPGW110308	3	2.5	6.35	3.18	2.8	0.8	○	○	○	○
YP3TPGW160402	3	3.0	9.525	4.76	4.4	0.2	○	○	○	○
YP3TPGW160404	3	3.0	9.525	4.76	4.4	0.4	○	○	○	○
YP3TPGW160408	3	3.0	9.525	4.76	4.4	0.8	○	○	○	○

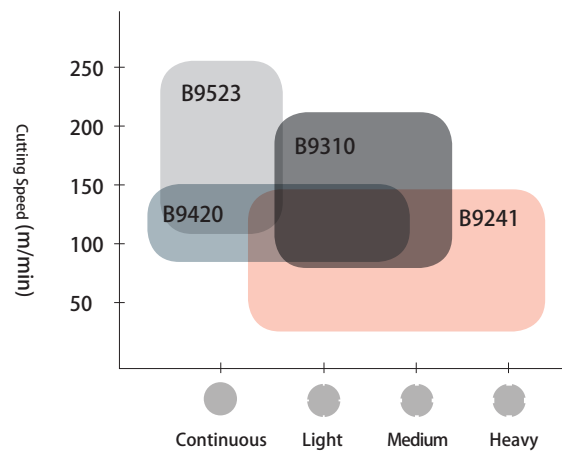


● Stock ○ Available upon Order

Grades for K Applications



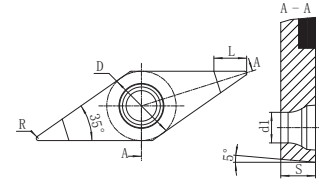
Grades for H Applications



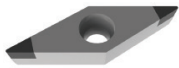
PCBN Turning Inserts (Positive)

VBGW

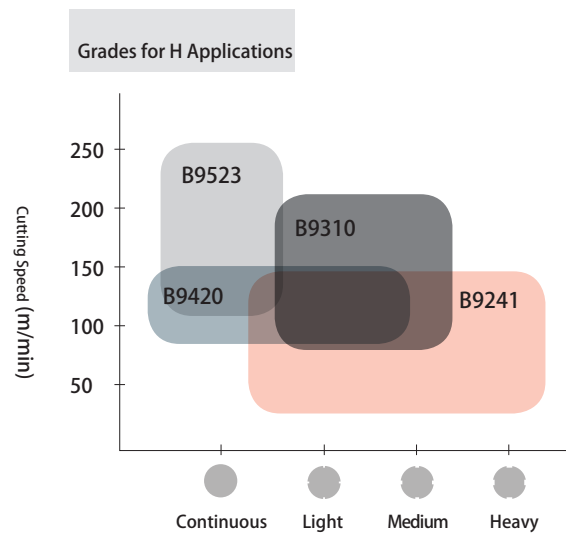
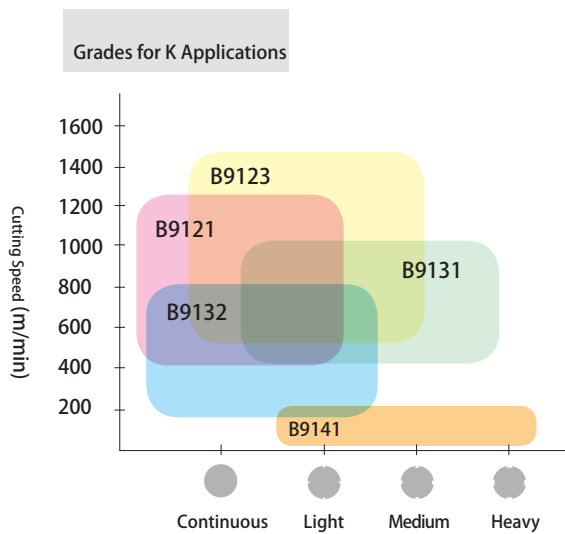
Rhombic 35° , with Hole



Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN			
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523
YP2VBGW110302	2	3.0	6.35	3.18	2.8	0.2	○	○	○	○
YP2VBGW110304	2	3.0	6.35	3.18	2.8	0.4	○	○	○	○
YP2VBGW110308	2	3.0	6.35	3.18	2.8	0.8	○	○	○	○
YP2VBGW160402	2	3.0	9.525	4.76	4.4	0.2	○	○	○	○
YP2VBGW160404	2	3.0	9.525	4.76	4.4	0.4	○	○	○	○
YP2VBGW160408	2	3.0	9.525	4.76	4.4	0.8	○	○	○	○



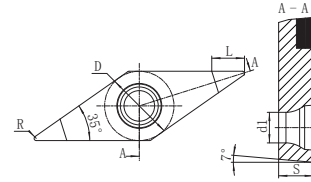
● Stock ○ Available upon Order



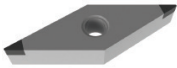
PCBN Turning Inserts (Positive)

VCGW

Rhombic35° , with Hole

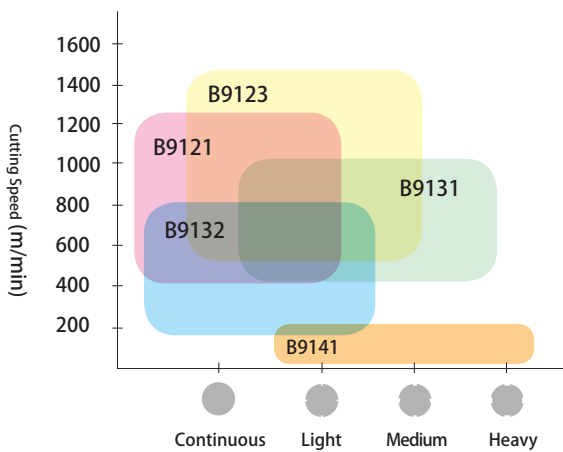


Ordering Code	Edge	Dimensions(mm)					PCBN Grades of PCBN			
		L	D	S	d1	R	B9121	NEW B9123	B9420	B9523
YP2VCGW110302	2	3.0	6.35	3.18	2.8	0.2	○	●	○	●
YP2VCGW110304	2	3.0	6.35	3.18	2.8	0.4	○	●	○	●
YP2VCGW110308	2	3.0	6.35	3.18	2.8	0.8	○	●	○	●
YP2VCGW160402	2	3.0	9.525	4.76	4.4	0.2	○	●	○	●
YP2VCGW160404	2	3.0	9.525	4.76	4.4	0.4	●	○	●	○
YP2VCGW160408	2	3.0	9.525	4.76	4.4	0.8	●	○	●	○

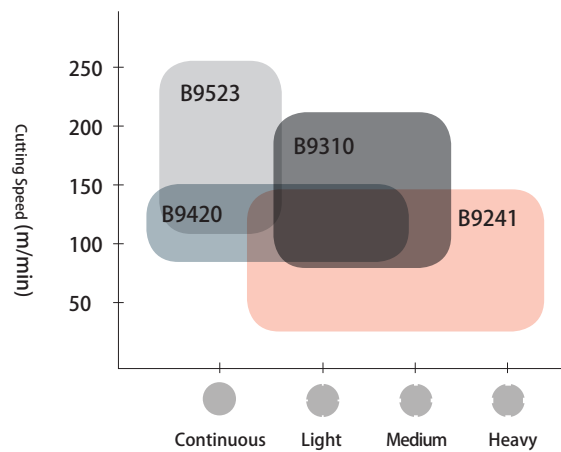


● Stock ○ Available upon Order

Grades for K Applications



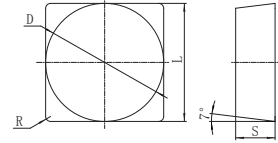
Grades for H Applications



PCBN Turning Inserts (Positive)

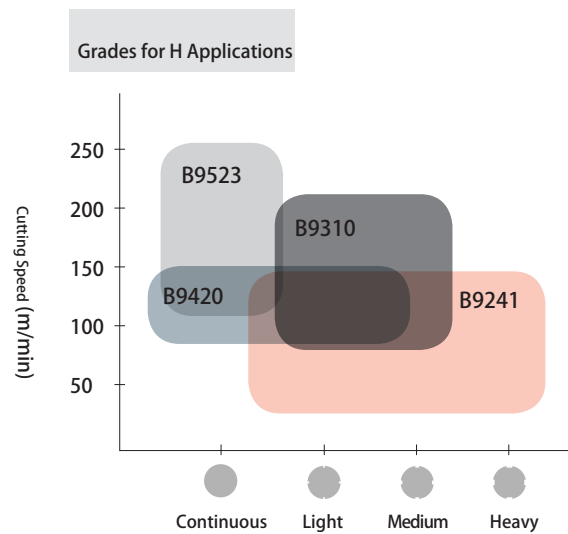
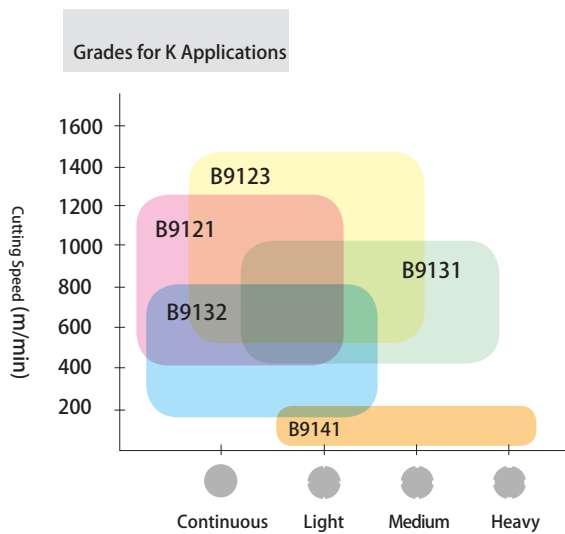
SCGN **NEW**

Square 90°, without Hole



Ordering Code	Edge	Dimensions(mm)				PCBN Grades of PCBN					
		L	D	S	R	B9131	B9132	B9141	B9241	B9310	
	YS4SCGN090304	4	9.525	9.525	3.18	0.4		○			
	YS4SCGN090308	4	9.525	9.525	3.18	0.8		○			
	YS4SCGN090312	4	9.525	9.525	3.18	1.2		○			
	YS4SCGN090404	4	9.525	9.525	4.76	0.4		●			
	YS4SCGN090408	4	9.525	9.525	4.76	0.8		●			
	YS4SCGN090412	4	9.525	9.525	4.76	1.2		●			

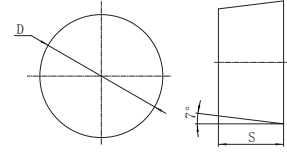
● Stock ○ Available upon Order



PCBN Turning Inserts (Positive)

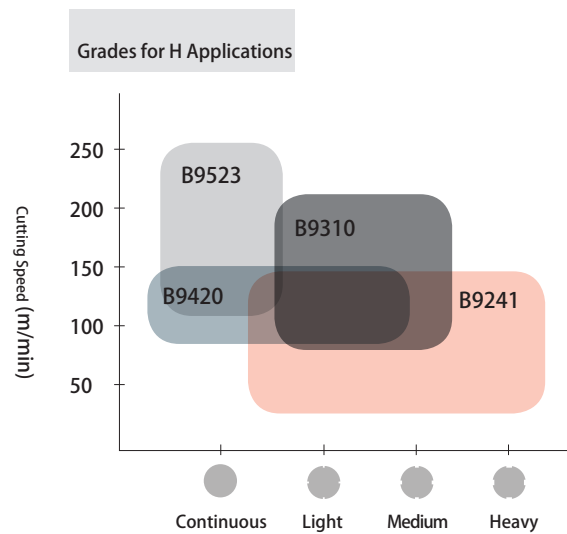
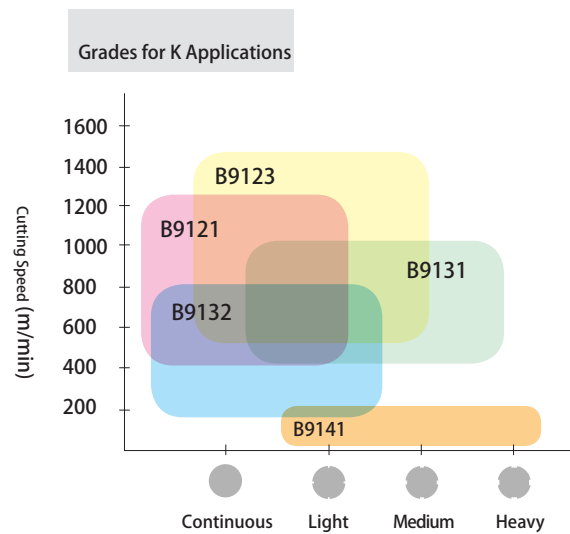
RCGN **NEW**

Round 360° , without Hole



Ordering Code	Edge	Dimensions(mm)		PCBN Grades of PCBN					
		D	S	B9131	B9132	B9141	B9241	B9310	
	YSORCGN090400	Round	9.525	4.76		○			○
	YSORCGN090600	Round	9.525	6.35		○			○
	YSORCGN120600	Round	12.7	6.35		○			○
	YSORCGN120700	Round	12.7	7.94		○			○

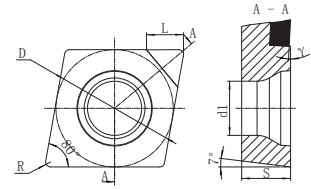
● Stock ○ Available upon Order



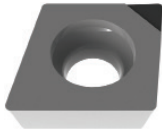
PCD Turning Inserts (Positive)

CCGW

Rhombic 80° , with Hole



Ordering Code	Edge	Dimensions(mm)						PCD Grades of PCD			
		L	D	S	d1	R	(°)	D9950	D9852	D9900	D9700
YP1CCGW09T304	1	3.0	9.525	3.97	4.4	0.4	0	●	●	○	○
YP1CCGW09T308	1	3.0	9.525	3.97	4.4	0.8	0	●	●	○	○
YP1CCGW09T304Q5	1	3.0	9.525	3.97	4.4	0.4	5	●	●	○	○
YP1CCGW09T308Q5	1	3.0	9.525	3.97	4.4	0.8	5	●	●	○	○
YP1CCGW09T304Q7	1	3.0	9.525	3.97	4.4	0.4	7	●	●	○	○
YP1CCGW09T308Q7	1	3.0	9.525	3.97	4.4	0.8	7	●	●	○	○
YP1CCGW120404	1	3.0	12.7	4.76	5.5	0.4	0	○	●	○	●
YP1CCGW120408	1	3.0	12.7	4.76	5.5	0.8	0	○	●	○	●
YP1CCGW120404Q5	1	3.0	12.7	4.76	5.5	0.4	5	○	●	○	●
YP1CCGW120408Q5	1	3.0	12.7	4.76	5.5	0.8	5	○	●	○	●
YP1CCGW120404Q7	1	3.0	12.7	4.76	5.5	0.4	7	○	●	○	●
YP1CCGW120408Q7	1	3.0	12.7	4.76	5.5	0.8	7	○	●	○	●

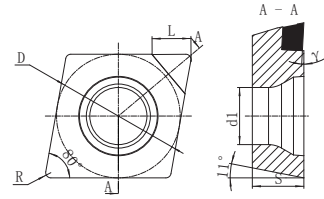


● Stock ○ Available upon Order

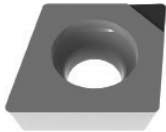
PCD Turning Inserts (Positive)

CPGW

Rhombic 80° , with Hole



Ordering Code	Edge	Dimensions(mm)						PCD Grades of PCD			
		L	D	S	d1	R	γ (°)	D9950	D9852	D9900	D9700
YP1CPGW09T304	1	3.0	9.525	3.97	4.4	0.4	0	○	●	○	●
YP1CPGW09T308	1	3.0	9.525	3.97	4.4	0.8	0	○	●	○	●
YP1CPGW09T304Q5	1	3.0	9.525	3.97	4.4	0.4	5	○	●	○	●
YP1CPGW09T308Q5	1	3.0	9.525	3.97	4.4	0.8	5	○	●	○	●
YP1CPGW09T304Q7	1	3.0	9.525	3.97	4.4	0.4	7	○	●	○	●
YP1CPGW09T308Q7	1	3.0	9.525	3.97	4.4	0.8	7	○	●	○	●
YP1CPGW120404	1	3.0	12.7	4.76	5.5	0.4	0	○	●	○	●
YP1CPGW120408	1	3.0	12.7	4.76	5.5	0.8	0	○	●	○	●
YP1CPGW120404Q5	1	3.0	12.7	4.76	5.5	0.4	5	●	●	○	○
YP1CPGW120408Q5	1	3.0	12.7	4.76	5.5	0.8	5	●	●	○	○
YP1CPGW120404Q7	1	3.0	12.7	4.76	5.5	0.4	7	●	●	○	○
YP1CPGW120408Q7	1	3.0	12.7	4.76	5.5	0.8	7	●	●	○	○

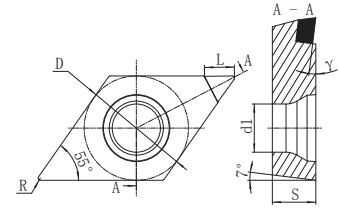


● Stock ○ Available upon Order

PCD Turning Inserts (Positive)

DCGW

Rhombic 55° , with Hole



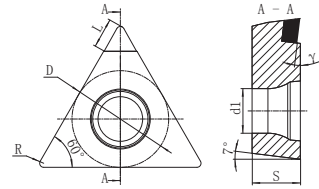
Ordering Code	Edge	Dimensions(mm)						PCD Grades of PCD			
		L	D	S	d1	R	γ (°)	D9950	D9852	D9900	D9700
YP1DCGW110302	1	3.0	9.525	3.97	4.4	0.2	0	○	●	○	●
YP1DCGW110304	1	3.0	9.525	3.97	4.4	0.4	0	○	●	○	●
YP1DCGW110308	1	3.0	9.525	3.97	4.4	0.8	0	○	●	○	●
YP1DCGW110302Q5	1	3.0	9.525	3.97	4.4	0.2	5	○	●	○	●
YP1DCGW110304Q5	1	3.0	9.525	3.97	4.4	0.4	5	○	●	○	●
YP1DCGW110308Q5	1	3.0	9.525	3.97	4.4	0.8	5	○	●	○	●
YP1DCGW110302Q7	1	3.0	9.525	3.97	4.4	0.2	7	●	●	○	○
YP1DCGW110304Q7	1	3.0	9.525	3.97	4.4	0.4	7	●	●	○	○
YP1DCGW110308Q7	1	3.0	9.525	3.97	4.4	0.8	7	●	●	○	○
YP1DCGW11T302	1	3.0	9.525	3.97	4.4	0.2	0	●	●	○	○
YP1DCGW11T304	1	3.0	9.525	3.97	4.4	0.4	0	●	●	○	○
YP1DCGW11T308	1	3.0	9.525	3.97	4.4	0.8	0	●	●	○	○
YP1DCGW11T302Q5	1	3.0	9.525	3.97	4.4	0.2	5	●	●	○	○
YP1DCGW11T304Q5	1	3.0	9.525	3.97	4.4	0.4	5	●	●	○	○
YP1DCGW11T308Q5	1	3.0	9.525	3.97	4.4	0.8	5	●	●	○	○
YP1DCGW11T302Q7	1	3.0	9.525	3.97	4.4	0.2	7	○	●	○	●
YP1DCGW11T304Q7	1	3.0	9.525	3.97	4.4	0.4	7	○	●	○	●
YP1DCGW11T308Q7	1	3.0	9.525	3.97	4.4	0.8	7	○	●	○	●


● Stock ○ Available upon Order

PCD Turning Inserts (Positive)

TCGW

Triangle 60° , with Hole



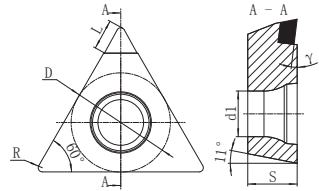
Ordering Code	Edge	Dimensions(mm)							PCD Grades of PCD			
		L	D	S	d1	R	γ (°)	D9950	D9852	D9900	D9700	
	YP1TCGW110302	1	3.0	6.35	3.18	2.8	0.2	0	○	●	○	●
	YP1TCGW110304	1	3.0	6.35	3.18	2.8	0.4	0	○	●	○	●
	YP1TCGW110302Q5	1	3.0	6.35	3.18	2.8	0.2	5	○	●	○	●
	YP1TCGW110304Q5	1	3.0	6.35	3.18	2.8	0.4	5	○	●	○	●

● Stock ○ Available upon Order

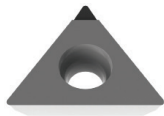
PCD Turning Inserts (Positive)

TPGW

Triangle 60° , with Hole



Ordering Code	Edge	Dimensions(mm)						PCD Grades of PCD			
		L	D	S	d1	R	Y (°)	D9950	D9852	D9900	D9700
YP1TPGW110302	1	3.0	6.35	3.18	2.8	0.2	0	○	●	○	●
YP1TPGW110304	1	3.0	6.35	3.18	2.8	0.4	0	○	●	○	●
YP1TPGW110302Q5	1	3.0	6.35	3.18	2.8	0.2	5	○	●	○	●
YP1TPGW110304Q5	1	3.0	6.35	3.18	2.8	0.4	5	○	●	○	●
YP1TPGW160404	1	3.0	9.525	4.76	4.4	0.4	0	●	●	○	○
YP1TPGW160408	1	3.0	9.525	4.76	4.4	0.8	0	●	●	○	○
YP1TPGW160404Q5	1	3.0	9.525	4.76	4.4	0.4	5	●	●	○	○
YP1TPGW160408Q5	1	3.0	9.525	4.76	4.4	0.8	5	●	●	○	○
YP1TPGW160404Q7	1	3.0	9.525	4.76	4.4	0.4	7	●	●	○	○
YP1TPGW160408Q7	1	3.0	9.525	4.76	4.4	0.8	7	●	●	○	○

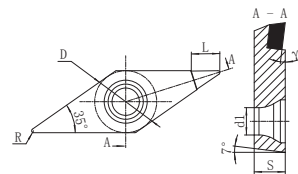


● Stock ○ Available upon Order

PCD Turning Inserts (Positive)

VCGW

Rhombic 35° , with Hole



Ordering Code	Edge	Dimensions(mm)						PCD Grades of PCD			
		L	D	S	d1	R	γ (°)	D9950	D9852	D9900	D9700
YP1VCGW110302	1	3.0	6.35	3.18	2.8	0.2	0	○	●	○	●
YP1VCGW110304	1	3.0	6.35	3.18	2.8	0.4	0	○	●	○	●
YP1VCGW110302Q5	1	3.0	6.35	3.18	2.8	0.2	5	○	●	○	●
YP1VCGW110304Q5	1	3.0	6.35	3.18	2.8	0.4	5	○	●	○	●
YP1VCGW110302Q7	1	3.0	6.35	3.18	2.8	0.2	7	○	●	○	●
YP1VCGW110304Q7	1	3.0	6.35	3.18	2.8	0.4	7	○	●	○	●
YP1VCGW160404	1	3.0	9.525	4.76	4.4	0.4	0	●	●	○	○
YP1VCGW160408	1	3.0	9.525	4.76	4.4	0.8	0	●	●	○	○
YP1VCGW160404Q5	1	3.0	9.525	4.76	4.4	0.4	5	●	●	○	○
YP1VCGW160408Q5	1	3.0	9.525	4.76	4.4	0.8	5	●	●	○	○
YP1VCGW160404Q7	1	3.0	9.525	4.76	4.4	0.4	7	●	●	○	○
YP1VCGW160408Q7	1	3.0	9.525	4.76	4.4	0.8	7	●	●	○	○



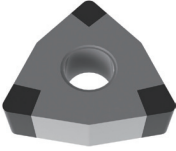

● Stock ○ Available upon Order

PCBN Turning Insert



PCBN Inserts for Cutting of Cast Iron

Case Studies

Case 1 **NEW**

B9132 for Cutting of Cast Iron		Workpiece			
Workpiece	Air Conditioning Compressor Bearing Cover				
Type	WNGA080408				
Workpiece Materials	HT250 (190-220HB)	Comparison	Vc Cutting Speed	Efficiency	Life
Cutting Parameters	Vc=600m/min ap=1.5mm f=0.25mm/r	Coated Alloy	300m/min	30Sec/pcs	120pcs/edge
Cutting Method	Dry Interrupted Cutting	WINTECH B9132	600m/min	15Sec/pcs	500pcs/edge



Case 2 **NEW**

B9132 for Cutting of Cast Iron		Workpiece			
Workpiece	Pulley				
Type	CNMN120412				
Workpiece Materials	HT200 (190-220HB)	Comparison	Vc Cutting Speed	Efficiency	Life
Cutting Parameters	Vc=520m/min ap=0.5mm f=0.35mm/r	Japanese Series Coated Alloy	280m/min	19Sec/pcs	30pcs/edge
Cutting Method	High Speed Turning	WINTECH B9132	520m/min	10Sec/pcs	125pcs/edge

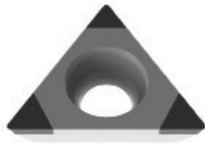
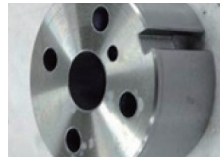
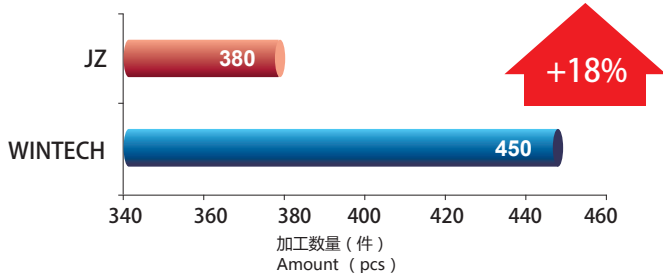
PCBN Turning Insert PCBN Inserts for Cutting of Cast Iron

Case Studies

Case 3 **NEW**

B9132 for Cutting of Cast Iron		Workpiece			
Workpiece	Brake Disc				
Type	CNGN120720				
Workpiece Materials	HT200 (170-210HB)	Comparison	Vc Cutting Speed	Efficiency	Life
Cutting Parameters	Vc=320m/min ap=3mm f=0.5mm/r	Japanese Series Coated Alloy	150m/min	90Sec/pcs	45pcs/edge
Cutting Method	Turning Wet,Ra3.2	WINTECH B9132	320m/min	40Sec/pcs	120pcs/edge

Case 4 **NEW**



B9123 for Cutting of Cast Iron		Workpiece	
Workpiece	Auto Sleeve		
Type	TPGW110304		
Workpiece Materials	Powder Metallurgy FNF4Q	 <p>加工数量 (件) Amount (pcs)</p>	
Cutting Parameters	Vc=290m/min ap=0.01mm f=0.05mm/r		
Cutting Method	Light Interrupted Finishing		

PCBN Turning Insert



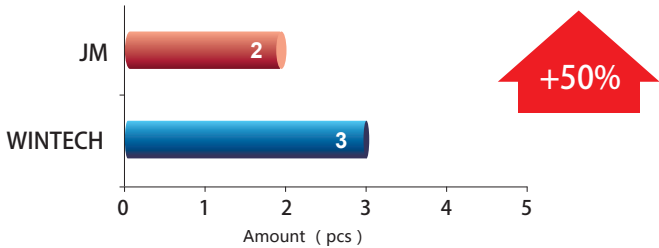
PCBN Inserts for Cutting of Steel

Case Studies

Case 1 **NEW**

B9241 for Cutting of Steel		Workpiece			
Workpiece	Gear				
Type	SNGN201020				
Workpiece Materials	40CrMo (45~55HRC)	Comparison	Vc Cutting Speed	Efficiency	Life
Cutting Parameters	Rough: ap=4mm, f=0.7mm/r Finishing: ap=0.5mm, f=0.6mm/r	European Series Alloy	20m/min	20h/pcs	0.25pcs/edge
Cutting Method	Gear Top Excircle Turning	WINTech B9241	50m/min	2h/pcs	2pcs/edge



Case 2 **NEW**

B9241 for Cutting of Steel		Workpiece	
Workpiece	Bearing		
Type	SNGN150720		
Workpiece Materials	Gr15 (55-62HRC)	 <p>JM: 2 pcs</p> <p>WINTech: 3 pcs</p> <p>Amount (pcs)</p> <p>+50%</p>	
Cutting Parameters	Vc=120m/min ap=4mm f=0.1mm/r		
Cutting Method	Excircle, face turning		

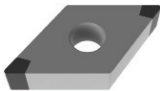

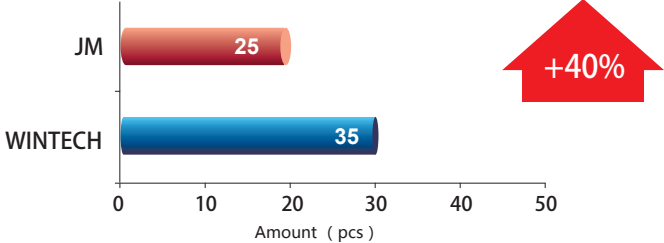
PCBN Turning Insert PCBN Inserts for Cutting of Steel

Case Studies

Case 3 **NEW**

B9310 for Cutting of Steel		Workpiece			
Workpiece	Rotary Support				
Type	RCGN090700				
Workpiece Materials	42CrMo (47-55HRC)	Comparison	Vc Cutting Speed	Efficiency	Life
Cutting Parameters	Vc=90m/min ap=0.2mm f=0.3mm/r	Coated Alloy	50m/min	2h/pcs	1pcs/edge
Cutting Method	Inner Circle Turning	WINTECHB9310	90m/min	30min/pcs	4pcs/edge

Case 4 **NEW**

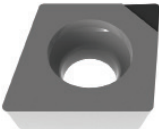

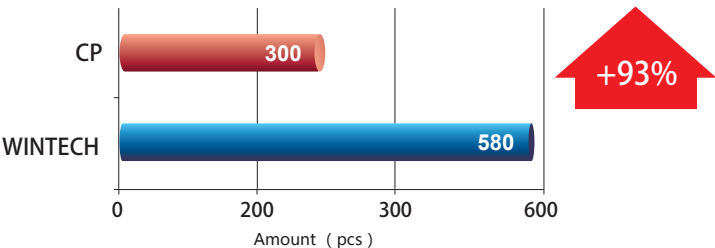
B9310 for Cutting of Steel		Workpiece	
Workpiece	Crankshaft		
Type	DNGA110408		
Workpiece Materials	42CrMo (42-47HRC)	 <p>JM: 25 WINTECH: 35 Amount (pcs)</p> <p>+40%</p>	
Cutting Parameters	Vc=170m/min ap=0.3mm f=0.1mm/r		
Cutting Method	Excircle Interrupted Turing, Wet		

PCD Turning Insert

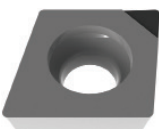
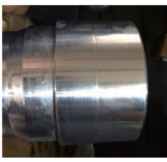
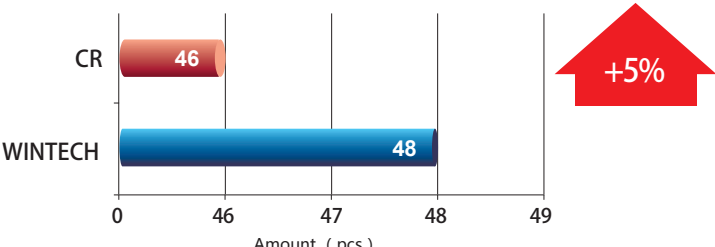
PCD Inserts for Cutting of Cast Aluminum Alloy

Case Studies

Case 1 **NEW**

D9700 for Cutting of Cast Aluminum Alloy		Workpiece	
Workpiece	Auto Valve Seat		
Type	CCGW09T304Q5		
Workpiece Materials	Cast Aluminum Alloy	 <p>CP: 300 WINTECH: 580 Amount (pcs) +93%</p>	
Cutting Parameters	Vc=500m/min ap=1.2mm f=0.2mm/r		
Cutting Method	Light Interrupted Semi-finishing		

Case 2 **NEW**

D9700 for Cutting of Cast Aluminum Alloy		Workpiece	
Workpiece	Auto Mould		
Type	CCGW09T304Q5		
Workpiece Materials	20HRC Cast Aluminum Alloy	 <p>CR: 46 WINTECH: 48 Amount (pcs) +5%</p>	
Cutting Parameters	Vc=480m/min ap=0.15mm f=0.02mm/r		
Cutting Method	Continuous Finishing		