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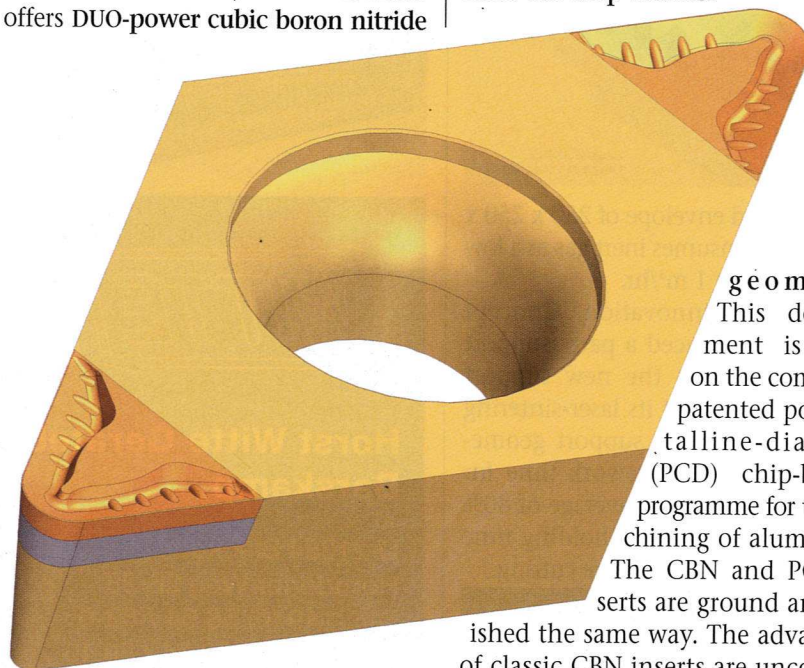
TOOL & MOULD MAKING

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CBN Cutting Inserts Developed for Hardened Steels, Cast Iron

For the finish turning of hardened steels and cast iron, Lach Diamant offers DUO-power cubic boron nitride

(CBN) cutting inserts with type-CO laser-cut chip-breaker



geometry. This development is based on the company's patented polycrystalline-diamond (PCD) chip-breaker programme for the machining of aluminium. The CBN and PCD inserts are ground and polished the same way. The advantages of classic CBN inserts are uncompro-

mised despite the laser processing.

Lach Diamant recommends the proven CBN-power grade B600 with CO chip breaker for the cutting of high-alloy quenched and tempered and hardened steels, especially those of medium hardness. Both interrupted and continuous cuts should be free of burrs. Another area of application for the B600 grade is the processing of components such as gearboxes and of rolled cast iron.

The supplier suggests using CBN-power grade B610 for tool and case-hardened steels in order to obtain cuts free of burrs when processing workpieces featuring thin or, especially, unstable elements. Success can be achieved even with material of variable hardness.

Lach Diamant (Jakob Lach GmbH & Co. KG)



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