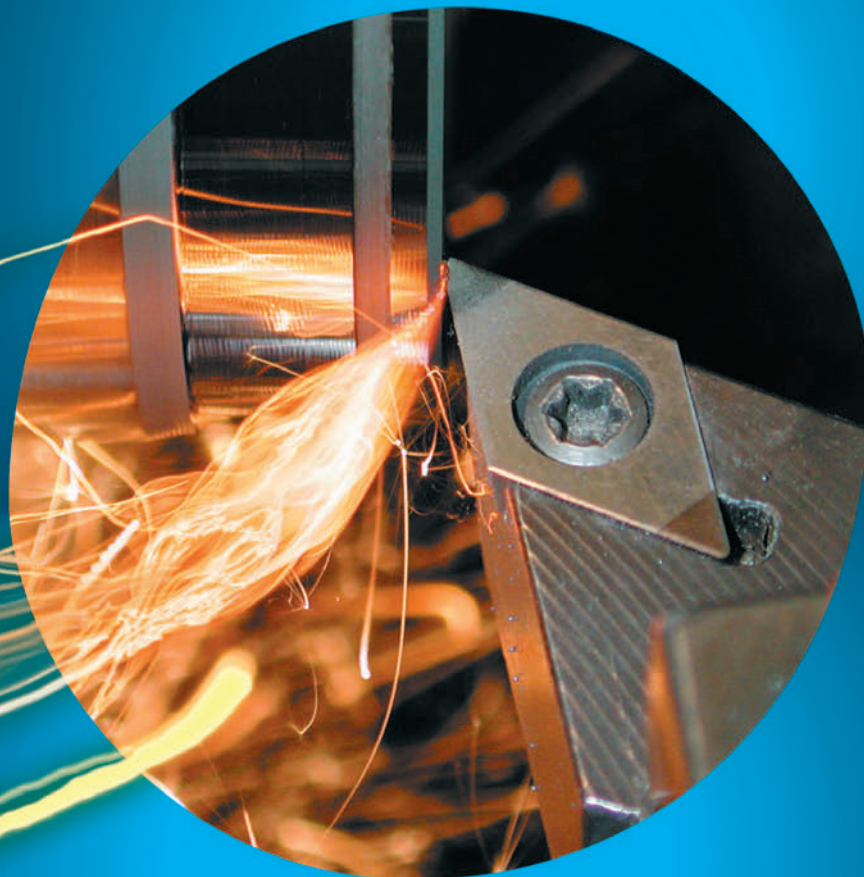


# **LACH DIAMANT<sup>®</sup>**

## **»CBN-DUO-power«**

***for the finishing of hardened steels  
and cast iron***



**Power-CBN for maximum efficiency  
...now also with »chipbreaker« !**

# » CBN-DU



## CBN insert

### » CBN-power« grade B610

for tool and case-hardened steels, components such as universal joint-shafts, valves and similar

#### Recommended cutting values:

interrupted cut  $v_c =$  up to 230 m/min  
 continuous cut  $v_c =$  up to 300 m/min  
 $f_n =$  up to 0,4 mm/R  
 $a_p =$  up to 0,8 mm

### » CBN-power« grade B600

for high alloy, quenched and tempered and hardened steels

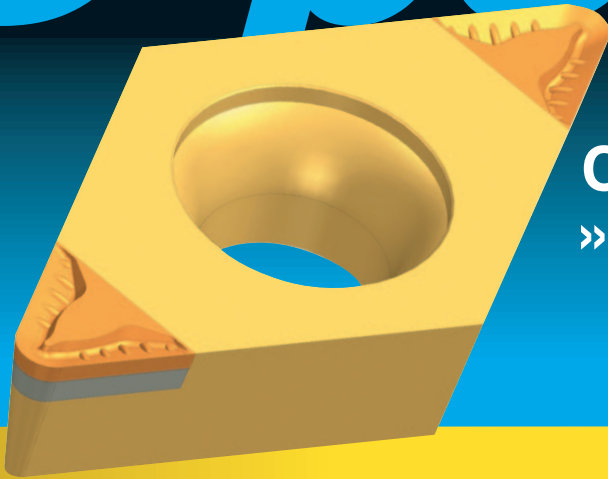
#### Recommended cutting values:

interrupted cut  $v_c =$  up to 140 m/min  
 continuous cut  $v_c =$  up to 220 m/min  
 $f_n =$  up to 0,4 mm/R  
 $a_p =$  up to 0,8 mm

**With cast iron:** components such as gear boxes, rollings and similar  $v_c =$  up to 900 m/min

Type	Ordering description	CBN grade	Art No.
negative CBN-DUO inserts			
CNMA 	CNMA 120404S-DUO	B610	43220050
		B600	43211008
	CNMA 120408S-DUO	B610	43220051
		B600	43210969
DNMA 	DNMA 150604S-DUO	B610	43220061
		B600	43220130
	DNMA 150608S-DUO	B610	43220062
		B600	43220131
positive CBN-DUO inserts			
CCMW 	CCMW 09T304S-DUO	B610	43220083
		B600	43220132
	CCMW 09T308S-DUO	B610	43220085
		B600	43220133
DCMW 	DCMW 11T304S-DUO	B610	43220059
		B600	43220134
	DCMW 11T308S-DUO	B610	43220060
		B600	43220135
VBMW 	VBMW 160404S-DUO	B610	43220057
		B600	43220136
	VBMW 160408S-DUO	B610	43220058
		B600	43220137

# O-power



## CBN insert with » chipbreaker« type CO\*

\*European Patent EP1 023 961

### » CBN-power« grade B610

for tool and case-hardened steels for cuts free of burrs of thin and especially unstable elements – also with different hardness

#### Recommended cutting values:

interrupted cut  $v_c =$  up to 180 m/min  
 continuous cut  $v_c =$  up to 240 m/min  
 $f_n =$  up to 0,2 mm/R  
 $a_p =$  up to 0,5 mm

### » CBN-power« grade B600

for high alloy, quenched and tempered and hardened steels – especially medium hardness – for cuts free of burrs

#### Recommended cutting values:

interrupted cut  $v_c =$  up to 80 m/min  
 continuous cut  $v_c =$  up to 140 m/min  
 $f_n =$  up to 0,2 mm/R  
 $a_p =$  up to 0,5 mm

**With cast iron:** components such as gear boxes, rollings and similar

$v_c =$  up to 900 m/min  
 $f_n =$  up to 0,5 mm/R  
 $a_p =$  up to 1,0 mm

Type	Ordering description	CBN grade	Art No.
<b>negative CBN-DUO inserts</b>			
CNMM 	CNMM 120404S-DUO-CO	B610	43220300
		B600	43220310
	CNMM 120408S-DUO-CO	B610	43220320
		B600	43220330
DNMM 	DNMM 150604S-DUO-CO	B610	43220340
		B600	43220350
	DNMM 150608S-DUO-CO	B610	43220360
		B600	43220370
<b>positive CBN-DUO inserts</b>			
CCMT 	CCMT 09T304S-DUO-CO	B610	43220380
		B600	43220390
	CCMT 09T308S-DUO-CO	B610	43220400
		B600	43220410
DCMT 	DCMT 11T304S-DUO-CO	B610	43220420
		B600	43220430
	DCMT 11T308S-DUO-CO	B610	43220440
		B600	43220450
VBMT 	VBMT 160404S-DUO-CO	B610	43220460
		B600	43220470
	VBMT 160408S-DUO-CO	B610	43220480
		B600	43220490

# »CBN-DUO-power«

## CBN inserts with »chipbreaker«\* – another innovation by LACH DIAMANT

\*European Patent EP1 023 961

With the development of the »chipbreaker« for the turning of hardened steels and cast iron, entirely new possibilities were opened up. This began at LACH DIAMANT already more than 25 years ago and led to several patents.

The question „turning or grinding?“ has now another option which goes in favour of CBN turning.

With this development LACH DIAMANT draws from 50 years of experience in the manufacturing and application of polycrystalline synthetic cutting materials diamond (PCD) and CBN (PCBN). This started with their availability of PCD in 1973 respectively 1974 for CBN.

LACH DIAMANT employs 200 people with plants in Hanau and Lichtenau near Chemnitz in Germany as well as in Grand Rapids, Michigan, USA and is considered a pioneer in this type of industry.

Even the grinding and spark erosion processing of polycrystalline materials had its origin in the „think tank“ of LACH DIAMANT, as proven by the universal grinding machines according to the original spark erosion process by LACH DIAMANT.

LACH DIAMANT – has its rightful place in the group of innovative system providers for turning, milling and drilling.

**Challenge us! We would like to be of service and advise you!**



Headquarter Hanau/Frankfurt/M.



Plant Lichtenau/Chemnitz/Sachsen



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