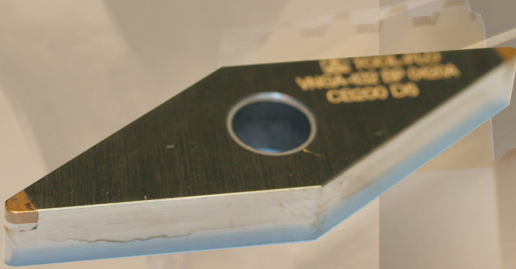
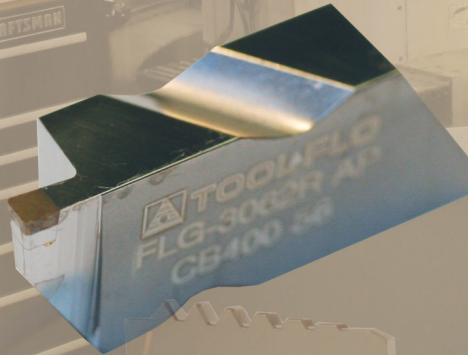
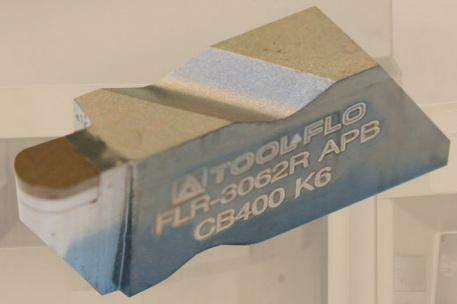




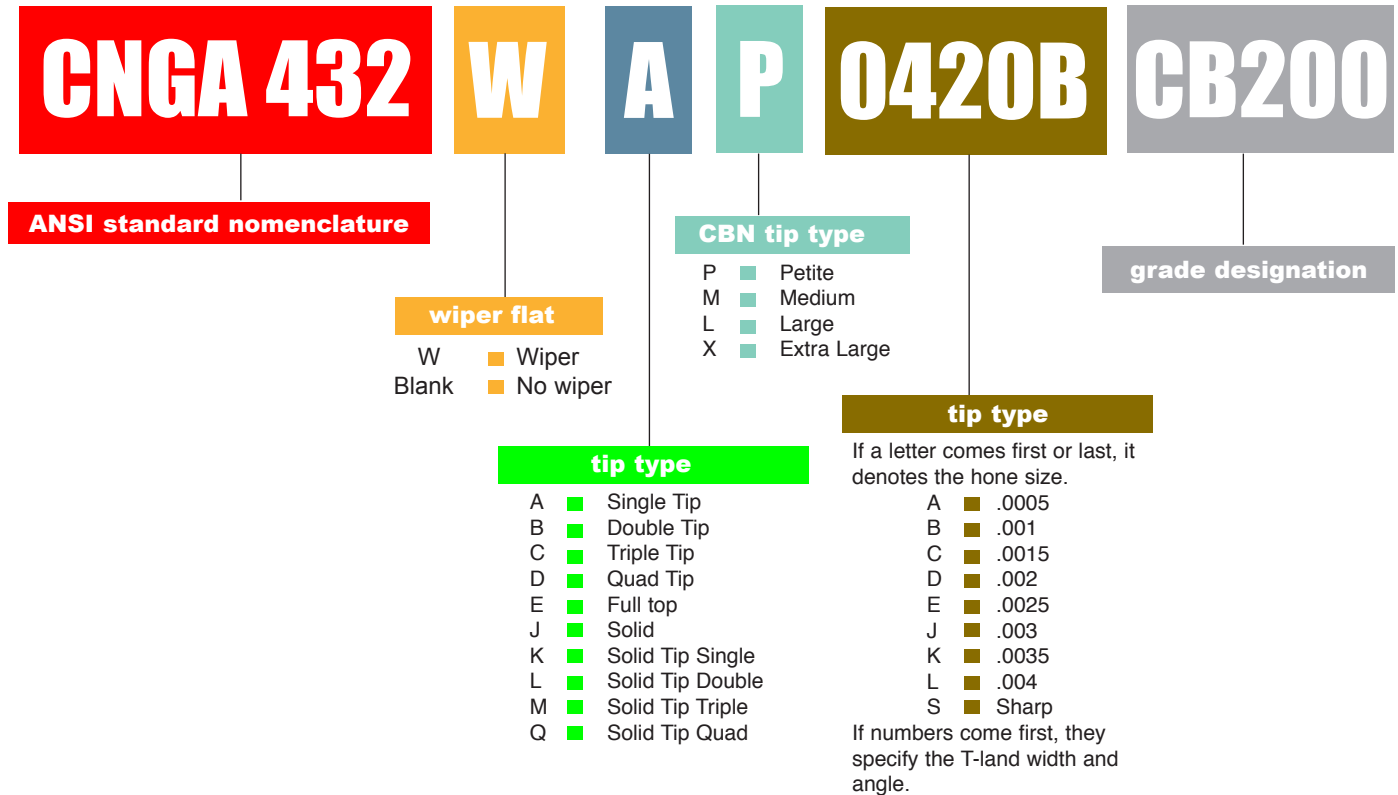
TOOL-FLO



PCBN



PCBN - Polycrystalline Cubic Boron Nitride Insert Nomenclature Chart

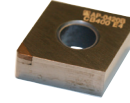
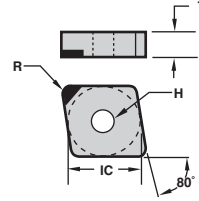


PCBN Grade Descriptions

Grades	Descriptions
CB200	A high CBN content, PCBN tip brazed onto a carbide insert. Superior impact resistance. Ideally suited for machining cast iron and powder metal alloys, fully pearlitic gray cast iron, chilled irons; excellent results in high temperature alloys such as Inconel with an up sharp edge. Apply to tool steels and hard steels 45 HRC and higher; high chrome alloy steels. Application ranges from continuous to highly interrupted cuts.
CB400	A low CBN content, PCBN tip brazed onto a carbide insert. Ideally suited for roughing to finishing of hardened steels 45 HRC and higher. Use on bearing steel, hot and cold work steels, die steels, case hardened steels, carburized and nitrided irons.
CB410	PCBN tip brazed onto a carbide insert. Ideally suited for roughing to finishing of hardened steels 45 HRC and higher. Use on bearing steel, hot and cold work steels, die steels, case hardened steels, carburized and nitrided irons.

**PCBN**

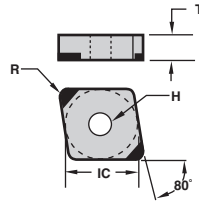
SINGLE TIP PCBN

CNGA

For Holders see pg. 187-206.

Description	EDP Code	IC	R	T	H	Edge Prep	CB200	CB400
CNGA-431 APS	CBGAM1APS	.500	.015	.187	.203	Sharp	●	●
CNGA-432 APS	CBGAM2APS	.500	.031	.187	.203	Sharp	●	●
CNGA-433 APS	CBGAM3APS	.500	.047	.187	.203	Sharp	●	●
CNGA-431 AP 0420A	CBGAM1AP0420A	.500	.015	.187	.203	T-Land W=.004, Angle 20°	●	●
CNGA-432 AP 0420A	CBGAM2AP0420A	.500	.031	.187	.203	T-Land W=.004, Angle 20°	●	●
CNGA-433 AP 0420A	CBGAM3AP0420A	.500	.047	.187	.203	T-Land W=.004, Angle 20°	●	●
CNGA-431 AL 0420A	CBGAM1AL0420A	.500	.015	.187	.203	T-Land W=.004, Angle 20°	●	●
CNGA-432 AL 0420A	CBGAM2AL0420A	.500	.031	.187	.203	T-Land W=.004, Angle 20°	●	●
CNGA-433 AL 0420A	CBGAM3AL0420A	.500	.047	.187	.203	T-Land W=.004, Angle 20°	●	●

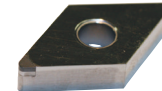
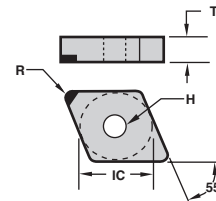
DOUBLE TIP PCBN

CNGA

For Holders see pg. 187-206.

Description	EDP Code	IC	R	T	H	Wiper	Edge Prep	CB200	CB400
CNGA-431 BPS	CBGAM1BPS	.500	.015	.187	.203		Sharp	●	●
CNGA-432 BPS	CBGAM2BPS	.500	.031	.187	.203		Sharp	●	●
CNGA-433 BPS	CBGAM3BPS	.500	.047	.187	.203		Sharp	●	●
CNGA-431 BP 0420A	CBGAM1BP0420A	.500	.015	.187	.203		T-Land W=.004, Angle 20°	●	●
CNGA-432 BP 0420A	CBGAM2BP0420A	.500	.031	.187	.203		T-Land W=.004, Angle 20°	●	●
CNGA-433 BP 0420A	CBGAM3BP0420A	.500	.047	.187	.203		T-Land W=.004, Angle 20°	●	●
CNGA-431 WBP 0420A	CBGAM1WBP0420A	.500	.015	.187	.203	✓	T-Land W=.004, Angle 20°	●	●
CNGA-432 WBP 0420A	CBGAM2WBP0420A	.500	.031	.187	.203	✓	T-Land W=.004, Angle 20°	●	●
CNGA-433 WBP 0420A	GBGAM2WBP0420A	.500	.047	.187	.203	✓	T-Land W=.004, Angle 20°	●	●

SINGLE TIP PCBN

DNGA

For Holders see pg. 187-206.

Description	EDP Code	IC	R	T	H	Edge Prep	CB200	CB400
DNGA-431 APS	CEGAM1APS	.500	.015	.187	.203	Sharp	●	●
DNGA-432 APS	CEGAM2APS	.500	.031	.187	.203	Sharp	●	●
DNGA-433 APS	CEGAM3APS	.500	.047	.187	.203	Sharp	●	●
DNGA-431 AP 0420A	CEGAM1AP0420A	.500	.015	.187	.203	T-Land W=.004, Angle 20°	●	●
DNGA-432 AP 0420A	CEGAM2AP0420A	.500	.031	.187	.203	T-Land W=.004, Angle 20°	●	●
DNGA-433 AP 0420A	CEGAM3AP0420A	.500	.047	.187	.203	T-Land W=.004, Angle 20°	●	●
DNGA-431 AL 0420A	CEGAM1AL0420A	.500	.015	.187	.203	T-Land W=.004, Angle 20°	●	●
DNGA-432 AL 0420A	CEGAM2AL0420A	.500	.031	.187	.203	T-Land W=.004, Angle 20°	●	●
DNGA-433 AL 0420A	CEGAM3AL0420A	.500	.047	.187	.203	T-Land W=.004, Angle 20°	●	●

In an effort to improve our stock standard grade offering, there are periodic changes. Please see current price list for up to date grade offering.

● High performance choice in optimal conditions.
 ▲ Recommended grade under general conditions.

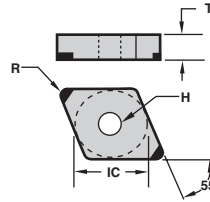
Cast Irons	●
Hardened & Bearing Steel	●
Powdered Metals	●
Super Alloys	●

PCBN

DOUBLE TIP PCBN

DNGA

For Holders see pg. 187-206.

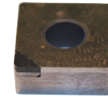
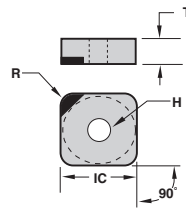


Description	EDP Code	IC	R	T	H	Wiper	Edge Prep	CB200	CB400
DNGA-431 BPS	CEGAM1BPS	.500	.015	.187	.203		Sharp	●	●
DNGA-432 BPS	CEGAM2BPS	.500	.031	.187	.203		Sharp	●	●
DNGA-433 BPS	CEGAM3BPS	.500	.047	.187	.203		Sharp	●	●
DNGA-431 BP 0420A	CEGAM1BP0420A	.500	.015	.187	.203		T-Land W=.004, Angle 20°	●	●
DNGA-432 BP 0420A	CEGAM2BP0420A	.500	.031	.187	.203		T-Land W=.004, Angle 20°	●	●
DNGA-433 BP 0420A	CEGAM3BP0420A	.500	.047	.187	.203		T-Land W=.004, Angle 20°	●	●
DNGA-431 WBP 0420A	CEGAM1WBP0420A	.500	.015	.187	.203	✓	T-Land W=.004, Angle 20°	●	●
DNGA-432 WBP 0420A	CEGAM2WBP0420A	.500	.031	.187	.203	✓	T-Land W=.004, Angle 20°	●	●
DNGA-433 WBP 0420A	CEGAM3WBP0420A	.500	.047	.187	.203	✓	T-Land W=.004, Angle 20°	●	●

SINGLE TIP PCBN

SNGA

For Holders see pg. 187-206.

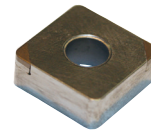
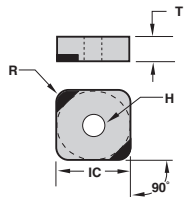


Description	EDP Code	IC	R	T	H	Edge Prep	CB200	CB400
SNGA-431 APS	CNGAM1APS	.500	.015	.187	.203	Sharp	●	●
SNGA-432 APS	CNGAM2APS	.500	.031	.187	.203	Sharp	●	●
SNGA-433 APS	CNGAM3APS	.500	.047	.187	.203	Sharp	●	●
SNGA-431 AP 0420A	CNGAM1AP0420A	.500	.015	.187	.203	T-Land W=.004, Angle 20°	●	●
SNGA-432 AP 0420A	CNGAM2AP0420A	.500	.031	.187	.203	T-Land W=.004, Angle 20°	●	●
SNGA-433 AP 0420A	CNGAM3AP0420A	.500	.047	.187	.203	T-Land W=.004, Angle 20°	●	●
SNGA-431 AL 0420A	CNGAM1AL0420A	.500	.015	.187	.203	T-Land W=.004, Angle 20°	●	●
SNGA-432 AL 0420A	CNGAM2AL0420A	.500	.031	.187	.203	T-Land W=.004, Angle 20°	●	●
SNGA-433 AL 0420A	CNGAM3AL0420A	.500	.047	.187	.203	T-Land W=.004, Angle 20°	●	●

DOUBLE TIP PCBN

SNGA

For Holders see pg. 187-206.



Description	EDP Code	IC	R	T	H	Wiper	Edge Prep	CB200	CB400
SNGA-431 BPS	CNGAM1BPS	.500	.015	.187	.203		Sharp	●	●
SNGA-432 BPS	CNGAM2BPS	.500	.031	.187	.203		Sharp	●	●
SNGA-433 BPS	CNGAM3BPS	.500	.047	.187	.203		Sharp	●	●
SNGA-431 BP 0420A	CNGAM1BP0420A	.500	.015	.187	.203		T-Land W=.004, Angle 20°	●	●
SNGA-432 BP 0420A	CNGAM2BP0420A	.500	.031	.187	.203		T-Land W=.004, Angle 20°	●	●
SNGA-433 BP 0420A	CNGAM3BP0420A	.500	.047	.187	.203		T-Land W=.004, Angle 20°	●	●
SNGA-431 WBP 0420A	CNGAM1WBP0420A	.500	.015	.187	.203	✓	T-Land W=.004, Angle 20°	●	●
SNGA-432 WBP 0420A	CNGAM2WBP0420A	.500	.031	.187	.203	✓	T-Land W=.004, Angle 20°	●	●
SNGA-433 WBP 0420A	CNGAM3WBP0420A	.500	.047	.187	.203	✓	T-Land W=.004, Angle 20°	●	●

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- High performance choice in optimal conditions.
- ▲ Recommended grade under general conditions.

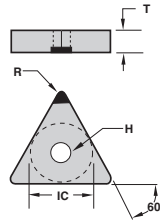
Cast Irons	●
Hardened & Bearing Steel	●
Powdered Metals	●
Super Alloys	●

**PCBN**

SINGLE TIP PCBN

TNGA

For Holders see pg. 187-206.

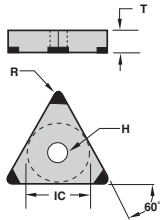


Description	EDP Code	IC	R	T	H	Edge Prep	CB200	CB400
TNGA-331 APS	CTGAH1APS	.375	.015	.187	.150	Sharp	●	●
TNGA-332 APS	CTGAH2APS	.375	.031	.187	.150	Sharp	●	●
TNGA-333 APS	CTGAH3APS	.375	.047	.187	.150	Sharp	●	●
TNGA-331 AP 0420A	CTGAH1AP0420A	.375	.015	.187	.150	T-Land W=.004, Angle 20°	●	●
TNGA-332 AP 0420A	CTGAH2AP0420A	.375	.031	.187	.150	T-Land W=.004, Angle 20°	●	●
TNGA-333 AP 0420A	CTGAH3AP0420A	.375	.047	.187	.150	T-Land W=.004, Angle 20°	●	●
TNGA-331 AL 0420A	CTGAH1AL0420A	.375	.015	.187	.150	T-Land W=.004, Angle 20°	●	●
TNGA-332 AL 0420A	CTGAH2AL0420A	.375	.031	.187	.150	T-Land W=.004, Angle 20°	●	●
TNGA-333 AL 0420A	CTGAH3AL0420A	.375	.047	.187	.150	T-Land W=.004, Angle 20°	●	●
TNGA-431 APS	CTGAJ1APS	.500	.015	.187	.203	Sharp	●	●
TNGA-432 APS	CTGAJ2APS	.500	.031	.187	.203	Sharp	●	●
TNGA-433 APS	CTGAJ3APS	.500	.047	.187	.203	Sharp	●	●
TNGA-431 AP 0420A	CTGAJ1AP0420A	.500	.015	.187	.203	T-Land W=.004, Angle 20°	●	●
TNGA-432 AP 0420A	CTGAJ2AP0420A	.500	.031	.187	.203	T-Land W=.004, Angle 20°	●	●
TNGA-433 AP 0420A	CTGAJ3AP0420A	.500	.047	.187	.203	T-Land W=.004, Angle 20°	●	●
TNGA-431 AL 0420A	CTGAJ1AL0420A	.500	.015	.187	.203	T-Land W=.004, Angle 20°	●	●
TNGA-432 AL 0420A	CTGAJ2AL0420A	.500	.031	.187	.203	T-Land W=.004, Angle 20°	●	●
TNGA-433 AL 0420A	CTGAJ3AL0420A	.500	.047	.187	.203	T-Land W=.004, Angle 20°	●	●

TRIPLE TIP PCBN

TNGA

For Holders see pg. 187-206.



Description	EDP Code	IC	R	T	H	Wiper	Edge Prep	CB200	CB400
TNGA-331 CPS	CTGAH1CPS	.375	.015	.187	.150		Sharp	●	●
TNGA-332 CPS	CTGAH2CPS	.375	.031	.187	.150		Sharp	●	●
TNGA-333 CPS	CTGAH3CPS	.375	.047	.187	.150		Sharp	●	●
TNGA-331 CP 0420A	CTGAH1CP0420A	.375	.015	.187	.150		T-Land W=.004, Angle 20°	●	●
TNGA-332 CP 0420A	CTGAH2CP0420A	.375	.031	.187	.150		T-Land W=.004, Angle 20°	●	●
TNGA-333 CP 0420A	CTGAH3CP0420A	.375	.047	.187	.150		T-Land W=.004, Angle 20°	●	●
TNGA-331 WCP 0420A	CTGAH1WCP0420A	.375	.015	.187	.150	✓	T-Land W=.004, Angle 20°	●	●
TNGA-332 WCP 0420A	CTGAH2WCP0420A	.375	.031	.187	.150	✓	T-Land W=.004, Angle 20°	●	●
TNGA-333 WCP 0420A	CTGAH3WCP0420A	.375	.047	.187	.150	✓	T-Land W=.004, Angle 20°	●	●
TNGA-431 CPS	CTGAJ1CPS	.500	.015	.187	.203		Sharp	●	●
TNGA-432 CPS	CTGAJ2CPS	.500	.031	.187	.203		Sharp	●	●
TNGA-433 CPS	CTGAJ3CPS	.500	.047	.187	.203		Sharp	●	●
TNGA-431 CP 0420A	CTGAJ1CP0420A	.500	.015	.187	.203		T-Land W=.004, Angle 20°	●	●
TNGA-432 CP 0420A	CTGAJ2CP0420A	.500	.031	.187	.203		T-Land W=.004, Angle 20°	●	●
TNGA-433 CP 0420A	CTGAJ3CP0420A	.500	.047	.187	.203		T-Land W=.004, Angle 20°	●	●
TNGA-431 WCP 0420A	CTGAJ1WCP0420A	.500	.015	.187	.203	✓	T-Land W=.004, Angle 20°	●	●
TNGA-432 WCP 0420A	CTGAJ2WCP0420A	.500	.031	.187	.203	✓	T-Land W=.004, Angle 20°	●	●
TNGA-433 WCP 0420A	CTGAJ3WCP0420A	.500	.047	.187	.203	✓	T-Land W=.004, Angle 20°	●	●

In an effort to improve our stock standard grade offering, there are periodic changes. Please see current price list for up to date grade offering.

- High performance choice in optimal conditions.
- ▲ Recommended grade under general conditions.

Cast Irons	●
Hardened & Bearing Steel	●
Powdered Metals	●
Super Alloys	●

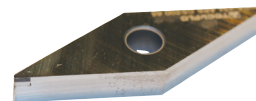
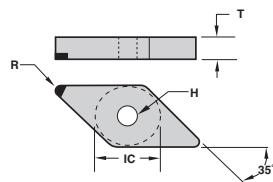
PCBN



SINGLE TIP PCBN

VNGA

For Holders see pg. 187-206.

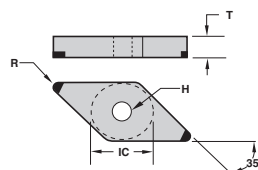


Description	EDP Code	IC	R	T	H	Edge Prep	CB200	CB400
VNGA-331 APS	CXGAH1APS	.375	.015	.187	.150	Sharp	●	●
VNGA-332 APS	CXGAH2APS	.375	.031	.187	.150	Sharp	●	●
VNGA-333 APS	CXGAH3APS	.375	.047	.187	.150	Sharp	●	●
VNGA-331 AP 0420A	CXGAH1AP0420A	.375	.015	.187	.150	T-Land W=.004, Angle 20°	●	●
VNGA-332 AP 0420A	CXGAH2AP0420A	.375	.031	.187	.150	T-Land W=.004, Angle 20°	●	●
VNGA-333 AP 0420A	CXGAH3AP0420A	.375	.047	.187	.150	T-Land W=.004, Angle 20°	●	●
VNGA-331 AL 0420A	CXGAH1AL0420A	.375	.015	.187	.150	T-Land W=.004, Angle 20°	●	●
VNGA-332 AL 0420A	CXGAH2AL0420A	.375	.031	.187	.150	T-Land W=.004, Angle 20°	●	●
VNGA-333 AL 0420A	CXGAH3AL0420A	.375	.047	.187	.150	T-Land W=.004, Angle 20°	●	●
VNGA-431 APS	CXGAJ1APS	.500	.015	.187	.203	Sharp	●	●
VNGA-432 APS	CXGAJ2APS	.500	.031	.187	.203	Sharp	●	●
VNGA-433 APS	CXGAJ3APS	.500	.047	.187	.203	Sharp	●	●
VNGA-431 AP 0420A	CXGAJ1AP0420A	.500	.015	.187	.203	T-Land W=.004, Angle 20°	●	●
VNGA-432 AP 0420A	CXGAJ2AP0420A	.500	.031	.187	.203	T-Land W=.004, Angle 20°	●	●
VNGA-433 AP 0420A	CXGAJ3AP0420A	.500	.047	.187	.203	T-Land W=.004, Angle 20°	●	●
VNGA-431 AL 0420A	CXGAJ1AL0420A	.500	.015	.187	.203	T-Land W=.004, Angle 20°	●	●
VNGA-432 AL 0420A	CXGAJ2AL0420A	.500	.031	.187	.203	T-Land W=.004, Angle 20°	●	●
VNGA-433 AL 0420A	CXGAJ3AL0420A	.500	.047	.187	.203	T-Land W=.004, Angle 20°	●	●

DOUBLE TIP PCBN

VNGA

For Holders see pg. 187-206.



Description	EDP Code	IC	R	T	H	Wiper	Edge Prep	CB200	CB400
VNGA-331 BPS	CXGAH1BPS	.375	.015	.187	.150		Sharp	●	●
VNGA-332 BPS	CXGAH2BPS	.375	.031	.187	.150		Sharp	●	●
VNGA-331 BP 0420A	CXGAH1BP0420A	.375	.015	.187	.150		T-Land W=.004, Angle 20°	●	●
VNGA-332 BP 0420A	CXGAH2BP0420A	.375	.031	.187	.150		T-Land W=.004, Angle 20°	●	●
VNGA-333 BP 0420A	CXGAH3BP0420A	.375	.047	.187	.150		T-Land W=.004, Angle 20°	●	●
VNGA-331 WBP 0420A	CXGAH1WBP0420A	.375	.015	.187	.150	✓	T-Land W=.004, Angle 20°	●	●
VNGA-332 WBP 0420A	CXGAH2WBP0420A	.375	.031	.187	.150	✓	T-Land W=.004, Angle 20°	●	●
VNGA-333 WBP 0420A	CXGAH3WBP0420A	.375	.047	.187	.150	✓	T-Land W=.004, Angle 20°	●	●
VNGA-431 BPS	CXGAJ1BPS	.500	.015	.187	.203		Sharp	●	●
VNGA-432 BPS	CXGAJ2BPS	.500	.031	.187	.203		Sharp	●	●
VNGA-433 BPS	CXGAJ3BPS	.500	.047	.187	.203		Sharp	●	●
VNGA-431 BP 0420A	CXGAJ1BP0420A	.500	.015	.187	.203		T-Land W=.004, Angle 20°	●	●
VNGA-432 BP 0420A	CXGAJ2BP0420A	.500	.031	.187	.203		T-Land W=.004, Angle 20°	●	●
VNGA-433 BP 0420A	CXGAJ3BP0420A	.500	.047	.187	.203		T-Land W=.004, Angle 20°	●	●
VNGA-431 WBP 0420A	CXGAJ1WBP0420A	.500	.015	.187	.203	✓	T-Land W=.004, Angle 20°	●	●
VNGA-432 WBP 0420A	CXGAJ2WBP0420A	.500	.031	.187	.203	✓	T-Land W=.004, Angle 20°	●	●
VNGA-433 WBP 0420A	CXGAJ3WBP0420A	.500	.047	.187	.203	✓	T-Land W=.004, Angle 20°	●	●

In an effort to improve our stock standard grade offering, there are periodic changes. Please see current price list for up to date grade offering.

- High performance choice in optimal conditions.
- ▲ Recommended grade under general conditions.

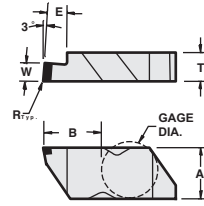
Cast Irons	●
Hardened & Bearing Steel	●
Powdered Metals	●
Super Alloys	●

**PCBN**

SINGLE TIP PCBN GROOVING

FLG

For Holders see pg. 107-109.



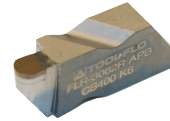
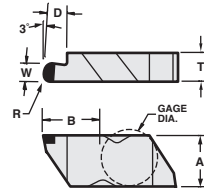
Description	EDP Code	W	R	T	H	E	Edge Prep	CB200	CB400
FLG-3047L APB	CB563647LAPB	.047	.005/.010	.195	.219	.075	.001 Hone	●	●
FLG-3047R APB	CB563647RAPB	.047	.005/.010	.195	.219	.075	.001 Hone	●	●
FLG-3062L APB	CB563662LAPB	.062	.005/.010	.195	.219	.120	.001 Hone	●	●
FLG-3062R APB	CB563662RAPB	.062	.005/.010	.195	.219	.120	.001 Hone	●	●
FLG-3094L AMB	CB563694LAMB	.094	.005/.010	.195	.219	.180	.001 Hone	●	●
FLG-3094R AMB	CB563694RAMB	.094	.005/.010	.195	.219	.180	.001 Hone	●	●
FLG-3125L AMB	CB563825LAMB	.125	.005/.010	.195	.219	.180	.001 Hone	●	●
FLG-3125R AMB	CB563825RAMB	.125	.005/.010	.195	.219	.180	.001 Hone	●	●
FLG-3189L ALB	CB563889LALB	.189	.020/.025	.195	.219	.180	.001 Hone	●	●
FLG-3189R ALB	CB563889RALB	.189	.020/.025	.195	.219	.180	.001 Hone	●	●
FLG-4250L ALB	CB574050LALB	.250	.020/.025	.255	.453	.250	.001 Hone	●	●
FLG-4250R ALB	CB574050RALB	.250	.020/.025	.255	.453	.250	.001 Hone	●	●

SINGLE TIP PCBN GROOVING

FLR

Full Nose Radius

For Holders see pg.107-109.

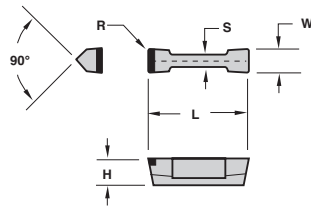


Description	EDP Code	W	R	T	H	E	Edge Prep	CB200	CB400
FLR-3031L APB	CB593031LAPB	.062	.031	.195	.219	.125	.001 Hone	●	●
FLR-3031R APB	CB593031RAPB	.062	.031	.195	.219	.125	.001 Hone	●	●
FLR-3062L APB	CB593062LAPB	.125	.062	.195	.219	.180	.001 Hone	●	●
FLR-3062R APB	CB593062RAPB	.125	.062	.195	.219	.180	.001 Hone	●	●

SINGLE TIP PCBN GROOVING

VDB

For Holders see pg. 215-218



Description	EDP Code	W	R	L	H	S	Edge Prep	CB200	CB400
VDB 125 A015 AMB	CB79125AMB	.125	.015	1.125	.250	.106	.001 Hone	●	●
VDB 188 A015 ALB	CB79188ALB	.188	.015	1.125	.250	.144	.001 Hone	●	●
VDB 250 A015 ALB	CB79250ALB	.250	.015	1.125	.250	.144	.001 Hone	●	●

In an effort to improve our stock standard grade offering, there are periodic changes. Please see current price list for up to date grade offering.

- High performance choice in optimal conditions.
- ▲ Recommended grade under general conditions.

Cast Irons
Hardened & Bearing Steel
Powdered Metals
Super Alloys

PCBN



Recommended Feed rate - inch/rev (mm/rev)

workpiece material	hardened steels	grey cast irons	white alloy cast iron	super alloys	powder metal	bearing steels
CB200 high content CBN for finishing		.010 - .020 (0,25 - 0,51)	.010 - .030 (0,25 - 0,76)	.003 - .008 (0,08 - 0,20)	.003 - .008 (0,08 - 0,20)	
CB400 low content CBN for roughing	.004 - .008 (0,10 - 0,20)					.002 - .008 (0,05 - 0,20)

Recommended Grade and Speed - sfpm (mm/min)

workpiece material	hardened steels	grey cast irons	white alloy cast iron	super alloys		bearing steels
CB200 high content CBN for finishing		< 240 HBN 1500 - 3500(457 - 1067) > 240 HBN 1000 - 2000(305 - 610)	300 - 600 (91 - 200)	500 - 1000 (152 - 305)	300 - 1000 (91 - 305)	
CB400 low content CBN for roughing	400 - 500 (122 - 152)					375 - 500 (114 - 152)

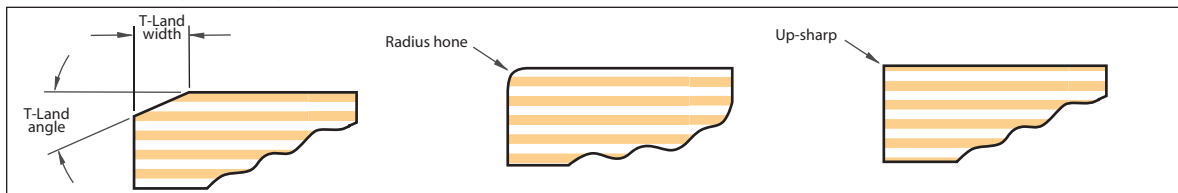
Recommended Edge Preparation

The following are suggestions for standard edge preparations.

Turning	CB200	.008 x 20° and/or .001 hone
Grooving (Flo-Lock and Vee-Bottom)	CB400	.004 x 20° and/or .001 hone

Due to unique applications, special edge preparations may be required.

T-Land and hones protect the cutting edge by eliminating a sharp cutting edge which reduces edge chipping and breakage. Up-sharp edges are prone to chipping or breakage.



T-Land and hones strengthen the cutting edges by redirecting the cutting forces back into the insert.

