



CBN MILLING

- CBN milling is used in the automotive, aerospace, and general machining industries.
- It's ideal for high-speed cutting and long tool life.
- It's ideally used for cast iron machining

FEATURES

- High Machining Productivity
- Excellent Surface Finish
- Improvement In CPC

GRADE OVERVIEW

GRADE	TYPE OF MACHINING	SUITABLE WORKPIECE	FEATURES	STOCKABLE
XBN3000	Roughing, Semi Finishing And Finishing	Grey Cast Iron	High Con Content Grade With Perfect Balance Of Hardness And Toughness; Suitable For High Vc Milling Of Continuous And Light Interrupted Applications	●
XBN3600			Excellent Combination Of Toughness And Wear Resistance, Excellent Edge Stability, Suitable For High Speed Roughing And Finishing On Continuous And Interrupted Applications	○

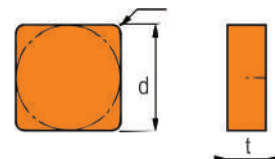
- STOCKABLE ○ NON STOCKABLE

INDUSTRY APPLICATIONS

- Cylinder Block
- Housing Components
- Cylinder Head
- Automotive Components
- General Engineering

RECOMMENDED CUTTING CONDITIONS

GRADE	TYPE OF MACHINING	CUTTING SPEED(M/MIN)
XBN3000	K	250-800
XBN3600		250-800



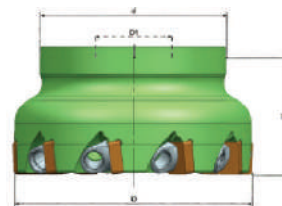
INSERT DESCRIPTION

DESCRIPTION	EDGE PREPARATION	DIMENSIONS			GRADE	
		d	l	r	XBN3000	XIN3600
SNGN 120408	T02020	12.7	4.70	0.8	●	○
SNGN120412	T02020	12.7	4.70	12	●	○
SNEX120412	W	12.7	4.70	12	●	○

- STOCKABLE ○ NON STOCKABLE

CUTTERS WITHOUT ADJUSTABLE WIPER

Not adjustable. It is suitable for rough milling, installing rough milling inserts, fast installation, no adjustment required. High processing efficiency can be obtained.



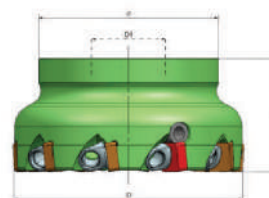
DESCRIPTION	NO OF TEETH		DIMENSIONS				INSERT	SPARES		AVAILABILITY
	MI*	WI*	D	D1	H	d		CLAMP	CLAMP SCREW	
XTSM-D50-A22-24- SN12-WG88-FP	4	0	50	22	50	45	SNGN 1204...	Clamping Wedge M6-D50-SN12	Wedge screw M6-D50-SN12	○
XTSM-D63-A22-26- SN12-WG88-FP	6	0	63	22	50	50		Clamping wedge-CBN Cutters	Wedge screw M8 X 21L- CBN Cutters	●
XTSM-D80-A27-28- SN12-WG88-FP	8	0	80	27	50	70				●
XTSM-D100-A32-210- SN12-WG88-FP	10	0	100	32	50	78				●
XTSM-D125-A40-Z12- SN12-WG88-FP	12	0	125	40	63	80				●
XTSM-D160-A40-216- SN12-WG88-FP	16	0	125	40	63	80		○		

*MI is Milling Insert, WI is Wiper Insert

● STOCKABLE ○ NON STOCKABLE

CUTTERS WITH ADJUSTABLE WIPER

Wiper is adjustable. It is suitable for fine milling. It can be used in combination with cutting inserts + wiper inserts. Only the wiper inserts can be adjusted to obtain high surface processing quality.



DESCRIPTION	NO OF TEETH		DIMENSIONS				INSERT	SPARES				AVAILABILITY
	MI*	WI*	D	D1	H	d		CLAMP	CLAMP SCREW	CLAMP	CLAMP SCREW	
XTSM-D50-A22- Z4-SN12-WG88	3	1	50	22	50	45	SNGN 1204...	Clamping Wedge M6-D50-SN12	Wedge screw M6-D50-SN12	Clamping Wedge M6-D50-SN12	Wedge screw M6-D50-SN12	○
XTSM-D63-A22- Z6-SN12-WG88	5	1	63	22	50	50		Clamping wedge- CBN Cutters	Wedge screw M8 X 21L- CBN Cutters	ADJ Wedge for Wiper- CBN Cutters	Wiper Wedge Screw M6-SN12	○
XTSM-D80-A27- Z8-SN12-WG88	7	1	80	27	50	70						○
XTSM-D100-A32- Z10-SN12-WG88	9	1	100	32	50	78						○
XTSM-D125-A40- Z12-SN12-WG88	11	1	125	40	63	80						○
XTSM-D160-A40- Z16-SN12-WG88	14	2	125	40	63	120	SNEX 120412...				○	

*MI is Milling Insert, WI is Wiper Insert

● STOCKABLE ○ NON STOCKABLE

TRIAL REPORT

CBN MILLING

PRODUCT DESCRIPTION	SNGN120412-T02020-XBN3000	
Material Hardness	Rear Axle -G Cast Iron (32-35HRC)	
PARAMETERS	COMPETITOR (h)	XCUT
Depth of Cut	3.0mm	3.0mm
Vc: m/min	800	750
Fz: mm/tooth	0.15/tooth (4750)	0.20/tooth (6000)

