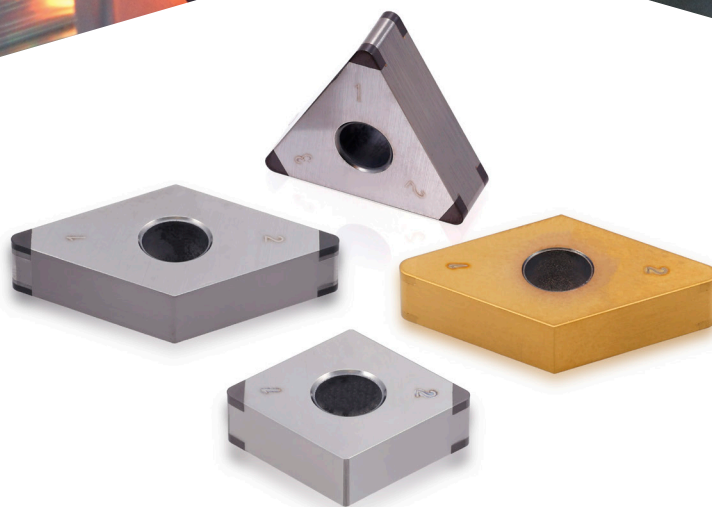


# CBN BHN/BH/BK シリーズ

高硬度材, 鋳鉄・焼結合金 加工用CBN



生まれ変わった NEW CBN

*CERTainly* | but not only | *CERamics*  
Outstanding solutions for demanding applications



**高硬度材**

For Hardened Material

H



クレーター摩耗からの欠損を防止 新コーティングが驚異の長寿命を実現！  
安定加工を重視したノンコートもレパートリー  
アプリケーションに応じ最適な刃先処理をラインナップ

H

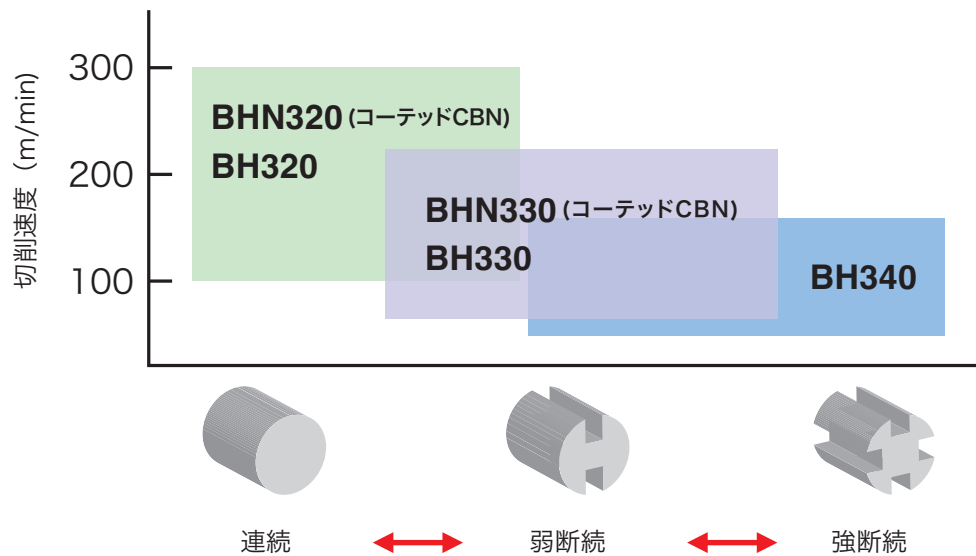
コーテッドCBN

**BHN320 / BHN330**

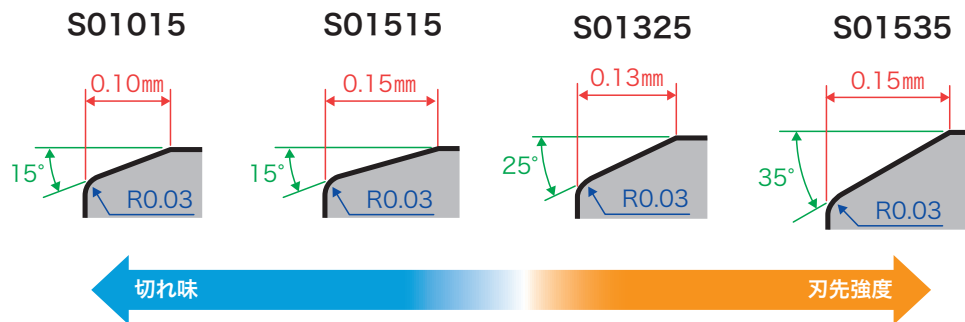
ノンコートCBN

**BH320 / BH330 / BH340**

## 高硬度材(仕上げ)



### 加工用途に応じた刃先処理



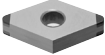
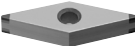
### 推奨加工条件

●:第一推奨

| 断続の長さ   | 推奨材質                         | 切削速度     | 送り       | 切込み   | 切削油 |     |
|---------|------------------------------|----------|----------|-------|-----|-----|
|         |                              | (m/min)  | (mm/rev) | (mm)  | DRY | WET |
| 連続加工    | BHN320 / BH320<br>(コーテッドCBN) | 100～ 300 | ～0.2     | ～ 0.5 | △   | ●   |
| 軽～中断続加工 | BHN330 / BH330<br>(コーテッドCBN) | 75～225   | ～0.15    |       | ●   | △   |
| 強断続加工   | BH340                        | 50 ～ 150 | ～ 0.1    |       | ●   | △   |

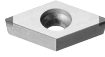
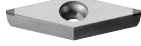


ラインナップ:高硬度材加工用〈ネガティブ〉

| 形状                                                                                  | 品番                 | BHN320 | BH320 | BHN330 | BH330 | BH340 | ワイバー | 切刃長さ | コーナR | コーナ数 | 内接円   | 厚さ   |
|-------------------------------------------------------------------------------------|--------------------|--------|-------|--------|-------|-------|------|------|------|------|-------|------|
|                                                                                     |                    |        |       |        |       |       |      | mm   | mm   | mm   | mm    | mm   |
|    | CNGA120402PQS01015 |        | ●     |        |       |       |      | 2.3  | 0.2  | 4    | 12.7  | 4.76 |
|                                                                                     | CNGA120404PQS01015 | ●      | ●     |        |       |       |      | 2.3  |      |      |       |      |
|                                                                                     | CNGA120404PQS01325 | ●      |       | ●      | ●     | ●     |      | 2.3  |      |      |       |      |
|                                                                                     | CNGA120404PQS01535 |        |       |        |       | ●     |      | 2.3  |      |      |       |      |
|                                                                                     | CNGA120404QWS01015 | ●      |       |        |       |       | 有り   | 2.3  |      |      |       |      |
|                                                                                     | CNGA120404QWS01535 |        | ●     |        |       |       | 有り   | 2.3  |      |      |       |      |
|                                                                                     | CNGA120408PQS01015 | ●      | ●     |        |       |       |      | 2.2  |      |      |       |      |
|                                                                                     | CNGA120408PQS01325 | ●      |       | ●      | ●     | ●     |      | 2.2  |      |      |       |      |
|                                                                                     | CNGA120408PQS01535 |        |       | ●      |       | ●     |      | 2.2  |      |      |       |      |
|                                                                                     | CNGA120408QWS01015 | ●      | ●     |        |       |       | 有り   | 2.2  |      |      |       |      |
|                                                                                     | CNGA120412PQS01015 | ●      | ●     | ●      |       |       |      | 2.4  |      |      |       |      |
|                                                                                     | CNGA120412PQS01325 |        |       | ●      | ●     |       |      | 2.4  |      |      |       |      |
|                                                                                     | CNGA120412PQS01535 |        |       |        |       | ●     |      | 2.4  |      |      |       |      |
|                                                                                     | CNGA120412QWS01015 | ●      |       |        |       |       | 有り   | 2.4  |      |      |       |      |
|                                                                                     | CNGA120416PQS01325 |        |       | ●      |       |       |      | 3.3  | 1.6  |      |       |      |
|    | DNGA150402PQS01015 |        | ●     |        |       |       |      | 2.7  | 0.2  | 4    | 12.7  | 4.76 |
|                                                                                     | DNGA150404PQS01325 |        | ●     | ●      | ●     |       |      | 2.5  |      |      |       |      |
|                                                                                     | DNGA150404PQS01015 | ●      | ●     |        |       |       |      | 2.5  |      |      |       |      |
|                                                                                     | DNGA150404PQS01535 |        |       |        |       | ●     |      | 2.5  |      |      |       |      |
|                                                                                     | DNGA150408PQS01015 | ●      | ●     |        |       |       |      | 2.1  |      |      |       |      |
|                                                                                     | DNGA150408PQS01325 |        |       | ●      | ●     |       |      | 2.1  |      |      |       |      |
|                                                                                     | DNGA150408PQS01535 |        |       | ●      |       | ●     |      | 2.1  |      |      |       |      |
|                                                                                     | DNGA150412PQS01015 | ●      | ●     | ●      |       |       |      | 2    |      |      |       |      |
|                                                                                     | DNGA150412PQS01325 | ●      |       | ●      | ●     |       |      | 2    |      |      |       |      |
|                                                                                     | DNGA150412PQS01535 | ●      |       | ●      |       | ●     |      | 2    |      |      |       |      |
|                                                                                     | DNGA150416PQS01325 |        |       |        | ●     |       |      | 3.4  | 1.6  |      |       |      |
|                                                                                     | DNGA150612PQS01015 |        | ●     |        |       |       |      | 2    | 1.2  |      |       |      |
|  | SNGA120408PES01015 |        | ●     |        |       | ●     |      | 2.4  | 0.8  | 8    | 12.7  | 6.35 |
|                                                                                     | SNGA120412PES01535 |        | ●     |        |       |       |      | 2.4  | 1.2  |      |       |      |
|  | TNGA160401PHS01015 | ●      |       |        |       |       |      | 2.4  | 0.1  | 6    | 9.525 | 4.76 |
|                                                                                     | TNGA160401PHS01535 |        |       |        |       | ●     |      | 2.4  |      |      |       |      |
|                                                                                     | TNGA160402PHS01015 |        | ●     |        |       |       |      | 2.3  |      |      |       |      |
|                                                                                     | TNGA160402PHS01325 |        |       |        |       | ●     |      | 2.3  |      |      |       |      |
|                                                                                     | TNGA160402PHS01535 | ●      |       |        |       |       |      | 2.3  |      |      |       |      |
|                                                                                     | TNGA160404PHS01015 | ●      | ●     |        |       | ●     |      | 2.2  |      |      |       |      |
|                                                                                     | TNGA160404PHS01325 | ●      | ●     | ●      | ●     |       |      | 2.2  |      |      |       |      |
|                                                                                     | TNGA160404PHS01535 |        |       | ●      |       | ●     |      | 2.2  |      |      |       |      |
|                                                                                     | TNGA160408PHS01015 | ●      | ●     | ●      |       | ●     |      | 1.9  |      |      |       |      |
|                                                                                     | TNGA160408PHS01325 |        |       | ●      | ●     |       |      | 1.9  |      |      |       |      |
|                                                                                     | TNGA160408PHS01535 | ●      |       |        |       | ●     |      | 1.9  |      |      |       |      |
|                                                                                     | TNGA160412PHS01015 | ●      |       |        |       |       |      | 2.4  |      |      |       |      |
|                                                                                     | TNGA160412PHS01325 | ●      |       | ●      |       |       |      | 2.4  |      |      |       |      |
|                                                                                     | TNGA160412PHS01535 |        |       |        |       | ●     |      | 2.4  |      |      |       |      |
|  | VNGA160401PQS01015 |        | ●     |        |       |       |      | 3.7  | 0.1  | 4    | 9.525 | 4.76 |
|                                                                                     | VNGA160401PQS01535 |        |       |        |       | ●     |      | 3.7  |      |      |       |      |
|                                                                                     | VNGA160402PQS01015 | ●      | ●     |        |       |       |      | 3.5  |      |      |       |      |
|                                                                                     | VNGA160402PQS01325 | ●      |       | ●      | ●     |       |      | 3.5  |      |      |       |      |
|                                                                                     | VNGA160402PQS01535 |        |       |        |       | ●     |      | 3.5  |      |      |       |      |
|                                                                                     | VNGA160404PQS01015 | ●      | ●     | ●      |       |       |      | 3.1  |      |      |       |      |
|                                                                                     | VNGA160404PQS01325 | ●      |       | ●      | ●     | ●     |      | 3.1  |      |      |       |      |
|                                                                                     | VNGA160404PQS01535 |        |       |        |       | ●     |      | 3.1  |      |      |       |      |
|                                                                                     | VNGA160408PQS01015 | ●      | ●     |        |       |       |      | 2.2  |      |      |       |      |
|                                                                                     | VNGA160408PQS01325 | ●      |       | ●      | ●     |       |      | 2.2  |      |      |       |      |
|                                                                                     | VNGA160408PQS01535 |        |       |        |       | ●     |      | 2.2  |      |      |       |      |



ラインナップ:高硬度材加工用〈ポジティブ〉 ● ● H H H

| 形状                                                                                  | 品番                 | BHN320 | BH320 | BHN330 | BH330 | BH340 | ワイバー | 切刃長さ | コーナ R | コーナ数 | 内接円   | 厚さ   |
|-------------------------------------------------------------------------------------|--------------------|--------|-------|--------|-------|-------|------|------|-------|------|-------|------|
|                                                                                     |                    |        |       |        |       |       |      | mm   | mm    | mm   | mm    | mm   |
|    | CCGW060204PDS01015 |        | ●     |        | ●     | ●     |      | 2.3  | 0.4   | 2    | 6.35  | 2.38 |
|                                                                                     | CCGW09T302PDS01515 |        | ●     |        |       |       |      | 2.3  | 0.2   |      | 9.525 | 3.97 |
|                                                                                     | CCGW09T304PDS01015 |        | ●     |        |       |       |      | 2.3  | 0.4   |      |       |      |
|                                                                                     | CCGW09T304PDS01535 |        |       |        | ●     |       | 2.3  |      |       |      |       |      |
|                                                                                     | CCGW09T308PDS01535 |        |       |        | ●     |       | 2.2  | 0.8  |       |      |       |      |
|    | DCGW070202PDS01015 |        | ●     |        |       |       |      | 2.7  | 0.2   | 2    | 6.35  | 2.38 |
|                                                                                     | DCGW070204PDS01015 |        | ●     |        |       |       |      | 2.5  | 0.4   |      | 9.525 | 3.97 |
|                                                                                     | DCGW070204PDS01535 |        |       |        | ●     |       | 2.5  |      |       |      |       |      |
|                                                                                     | DCGW11T302PDS01015 |        | ●     |        |       |       | 2.7  | 0.2  | 0.4   |      |       |      |
|                                                                                     | DCGW11T304PDS01015 |        | ●     |        |       |       | 2.5  |      |       |      |       |      |
|                                                                                     | DCGW11T304PDS01535 |        |       |        | ●     |       | 2.5  |      |       |      |       |      |
|                                                                                     | DCGW11T308PDS01015 |        | ●     |        |       |       | 2.1  | 0.8  |       |      |       |      |
|    | TPGN160304PTS01535 |        |       |        |       | ●     |      | 2.2  | 0.4   | 3    |       |      |
|    | TPGW110304PTS01015 |        | ●     |        |       |       |      | 2.2  | 0.4   | 3    | 6.35  | 3.18 |
|                                                                                     | TPGW110304PTS01325 |        | ●     |        | ●     | ●     |      | 2.2  |       |      |       |      |
|                                                                                     | TPGW110304PTS01535 |        |       |        | ●     |       | 2.2  |      |       |      |       |      |
|                                                                                     | TPGW110308PTS01015 |        | ●     |        |       |       |      | 1.9  | 0.8   |      |       |      |
|                                                                                     | TPGW110308PTS01325 |        |       |        | ●     | ●     |      | 1.9  |       |      |       |      |
|                                                                                     | TPGW110308PTS01535 |        | ●     |        | ●     |       | 1.9  |      |       |      |       |      |
|                                                                                     | TPGW110312PTS01325 |        | ●     |        |       |       | 2.4  | 1.2  |       |      |       |      |
|  | VBGW160404PDS01325 |        | ●     |        |       |       |      | 3.1  | 0.4   | 2    | 9.525 | 4.76 |
|                                                                                     | VCGW080204PDS01015 |        | ●     |        |       |       |      | 3.1  |       |      | 4.76  | 2.38 |
|                                                                                     | VCGW110304PDS01015 |        | ●     |        |       |       |      | 3.1  |       |      | 6.35  | 3.18 |
|                                                                                     | VCGW110304PDS01535 |        |       |        | ●     |       | 3.1  |      |       |      |       |      |
|                                                                                     | VCGW110308PDS01535 |        |       |        | ●     |       | 2.2  | 0.8  |       |      |       |      |
|                                                                                     | VCGW110312PDS01535 |        | ●     |        |       |       |      | 3    | 1.2   |      |       |      |
|                                                                                     | VCGW160404PDS01015 |        | ●     |        |       |       |      | 3.1  | 0.4   |      | 9.525 | 4.76 |

● 連続 H 弱断続 H 強断続



鑄鉄

For Cast Iron

K

焼結合金

For Sintered Alloy

K

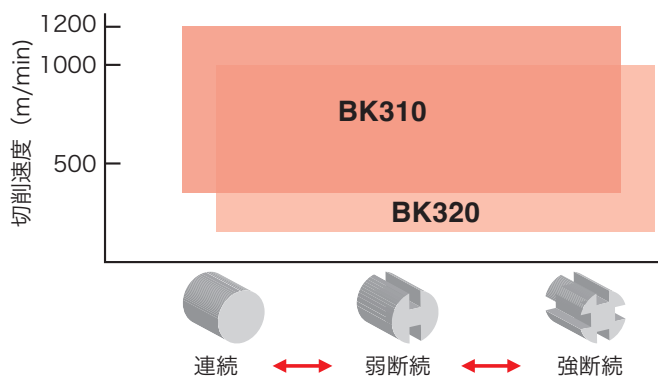
良好な刃立性で優れた加工面品位と加工精度を獲得！  
高含有量CBNが優れた耐摩耗性能による長寿命を実現



ノンコートCBN

**BK310 / BK320 / BK350**

## 普通鋳鉄(仕上げ)

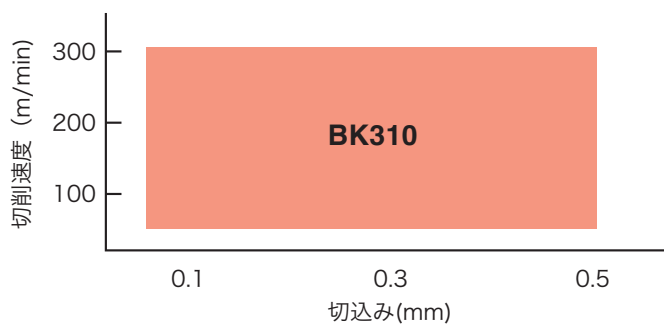


### 推奨加工条件

●:第一推奨

| 推奨材質           | 切削速度        | 送り       | 切込み   | 切削油 |     |
|----------------|-------------|----------|-------|-----|-----|
|                | (m/min)     | (mm/rev) | (mm)  | DRY | WET |
| BK310<br>BK320 | 400 ~ 1,200 | ~ 0.5    | ~ 2.0 | △   | ●   |

## 焼結合金

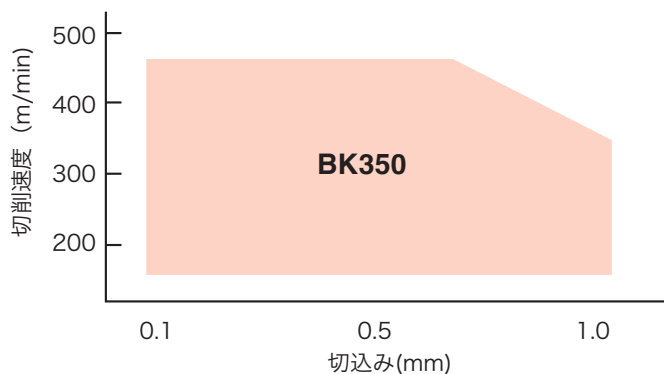


### 推奨加工条件

●:第一推奨

| 推奨材質  | 切削速度     | 送り       | 切込み   | 切削油 |     |
|-------|----------|----------|-------|-----|-----|
|       | (m/min)  | (mm/rev) | (mm)  | DRY | WET |
| BK310 | 40 ~ 300 | ~ 0.5    | ~ 0.5 | △   | ●   |

## ダクタイル鋳鉄(仕上げ)

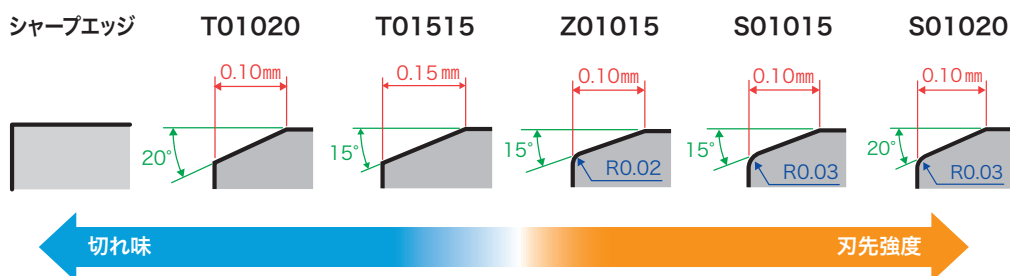


### 推奨加工条件

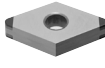
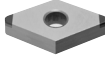
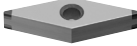
●:第一推奨

| 推奨材質  | 切削速度      | 送り       | 切込み   | 切削油 |     |
|-------|-----------|----------|-------|-----|-----|
|       | (m/min)   | (mm/rev) | (mm)  | DRY | WET |
| BK350 | 100 ~ 450 | ~ 0.4    | ~ 1.0 | ●   | △   |

### 加工用途に応じた刃先処理



ラインナップ: 鋳鉄・焼結合金加工用〈ネガティブ〉

| 形状                                                                                                                                                                         | 品番                      | BK310 | BK320 | BK350 | ワイバー | 切刃長さ | コーナ R | コーナ数 | 内接円   | 厚さ   |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|-------|-------|-------|------|------|-------|------|-------|------|--|
|                                                                                                                                                                            |                         |       |       |       |      | mm   | mm    | mm   | mm    | mm   |  |
|                                                                                           | CNGA120404PQT01020      | ●     |       | ●     |      | 2.3  | 0.4   | 4    | 12.7  | 4.76 |  |
|                                                                                                                                                                            | CNGA120404PQF (シャープエッジ) | ●     |       |       |      | 2.3  |       |      |       |      |  |
|                                                                                                                                                                            | CNGA120408PQT01020      | ●     |       | ●     |      | 2.2  | 0.8   |      |       |      |  |
|                                                                                                                                                                            | CNGA120408PQS01020      |       | ●     |       |      | 2.2  |       |      |       |      |  |
|                                                                                                                                                                            | CNGA120408PQF (シャープエッジ) | ●     |       |       |      | 2.2  |       |      |       |      |  |
|                                                                                                                                                                            | CNGA120408QWS01015      |       |       | ●     | 有り   | 2.2  |       |      |       |      |  |
|                                                                                                                                                                            | CNGA120412PQT01020      | ●     |       | ●     |      | 2.4  | 1.2   |      |       |      |  |
|                                                                                                                                                                            | CNGA120412PQS01020      |       | ●     |       |      | 2.4  |       |      |       |      |  |
|                                                                                                                                                                            | CNGA120412PQF (シャープエッジ) | ●     |       |       |      | 2.4  |       |      |       |      |  |
| CNGA120416PQT01020                                                                                                                                                         | ●                       |       |       |       | 3.3  | 1.6  |       |      |       |      |  |
|                                                                                           | DNGA150404PQT01020      | ●     |       | ●     |      | 2.5  | 0.4   | 4    | 12.7  | 6.35 |  |
|                                                                                                                                                                            | DNGA150404PQF (シャープエッジ) | ●     |       |       |      | 2.5  |       |      |       |      |  |
|                                                                                                                                                                            | DNGA150408PQT01020      | ●     |       | ●     |      | 2.1  | 0.8   |      |       |      |  |
|                                                                                                                                                                            | DNGA150408PQS01020      |       | ●     |       |      | 2.1  |       |      |       |      |  |
|                                                                                                                                                                            | DNGA150408PQF (シャープエッジ) | ●     |       |       |      | 2.1  |       |      |       |      |  |
|                                                                                                                                                                            | DNGA150412PQT01020      | ●     |       | ●     |      | 2    | 1.2   |      |       |      |  |
|                                                                                                                                                                            | DNGA150612PQT01020      | ●     |       |       |      | 2    |       |      |       |      |  |
|                                                                                           | DNGA150412PDF (シャープエッジ) | ●     |       |       |      | 2    | 1.2   | 2    |       |      |  |
|                                                                                           | SNGA120408PET01020      | ●     |       |       |      | 2.4  | 0.8   | 8    |       |      |  |
|                                                                                                                                                                            | SNGA120412PET01020      | ●     |       |       |      | 2.4  | 1.2   |      |       |      |  |
| <br> | TNGA160404PHT01020      | ●     |       | ●     |      | 2.2  | 0.4   | 6    | 9.525 | 4.76 |  |
|                                                                                                                                                                            | TNGA160404PTF (シャープエッジ) | ●     |       |       |      | 2.2  |       | 3    |       |      |  |
|                                                                                                                                                                            | TNGA160408PFT01020      | ●     |       | ●     |      | 1.9  | 0.8   | 6    |       |      |  |
|                                                                                                                                                                            | TNGA160408PTF (シャープエッジ) | ●     |       |       |      | 1.9  |       | 3    |       |      |  |
|                                                                                                                                                                            | TNGA160412PHT01020      | ●     |       | ●     |      | 2.4  | 1.2   | 6    |       |      |  |
|                                                                                                                                                                            | TNGA160412PHF (シャープエッジ) | ●     |       |       |      | 2.4  |       |      |       |      |  |
|                                                                                         | VNGA160404PQT01020      | ●     |       | ●     |      | 3.1  | 0.4   | 4    |       |      |  |
|                                                                                                                                                                            | VNGA160408PQT01020      | ●     |       | ●     |      | 2.2  | 0.8   |      |       |      |  |
|                                                                                                                                                                            | VNGA160412PQT01020      | ●     |       | ●     |      | 3    | 1.2   |      |       |      |  |



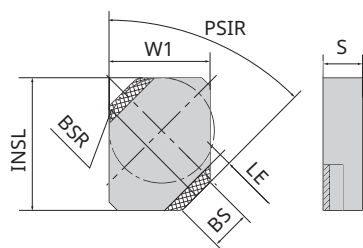
ラインナップ: 鑄鉄・焼結合金加工用〈ポジティブ〉

| 形状                                                                                | 品番                      | BK310 | BK320 | BK350 | ワイバー | 切刃長さ | コーナ R | コーナ数 | 内接円   | 厚さ   |
|-----------------------------------------------------------------------------------|-------------------------|-------|-------|-------|------|------|-------|------|-------|------|
|                                                                                   |                         |       |       |       |      | mm   | mm    | mm   | mm    | mm   |
|  | CCGW060204PDF (シャープエッジ) | ●     |       |       |      | 2.3  | 0.4   | 2    | 6.35  | 2.38 |
|  | SCGW09T304PQZ01015      | ●     |       |       |      | 2.4  | 0.4   | 4    | 9.525 | 3.97 |
|  | TPGN110304PTT01020      | ●     |       |       |      | 2.2  | 0.4   | 3    | 6.35  | 3.18 |
|                                                                                   | TPGN110308PTT01020      | ●     |       |       |      | 2.2  | 0.8   |      | 9.525 |      |
|                                                                                   | TPGN160308PTT01020      | ●     |       |       |      | 2.2  |       |      |       |      |
|  | TPGW110304PTT01020      | ●     |       |       |      | 2.2  | 0.4   | 3    | 6.35  |      |
|                                                                                   | TPGW110304PTT01515      | ●     |       |       |      | 2.2  |       |      |       |      |
|                                                                                   | TPGW110308PTT01020      | ●     |       |       |      | 1.9  | 0.8   |      |       |      |

ラインナップ: JFDXカッタ搭載用ワイパーインサート ※1枚もしくは2枚ご使用下さい

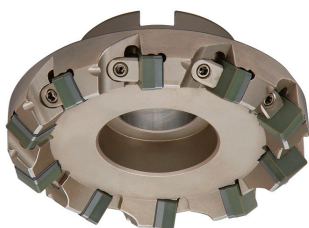
| 形状                                                                                                      | 品番                   | BK310 | BK320 | BK350 | ワイパー | BS    | BSR | INSL  | LE  | PSIRL | RE  | S    | W1   | コーナ数 | 図番 |
|---------------------------------------------------------------------------------------------------------|----------------------|-------|-------|-------|------|-------|-----|-------|-----|-------|-----|------|------|------|----|
|                                                                                                         |                      |       |       |       |      | mm    | mm  | mm    | mm  | °     | mm  | mm   | mm   |      |    |
| <br>For JFDX45° ワイパー   | FDX1204-45-50RS01020 | ●     |       | ●     | 有り   | (4.8) | 250 | 16    | 1.5 | 45    | -   | 4.76 | 12.2 | 2    | 1  |
| <br>For JFDX75° ワイパー | FDX1204-75-50RS01020 | ●     |       | ●     | 有り   | (4.5) | 250 | 13.8  | 1.5 | 75    | 1.2 | 4.76 | 12.2 | 2    | 2  |
| <br>For JFDX88° ワイパー | FDX1204-88-50RS01020 | ●     |       | ●     | 有り   | 6.15  | 250 | 12.95 | 1.5 | 88    | 1.2 | 4.76 | 12.2 | 2    | 3  |

No.1

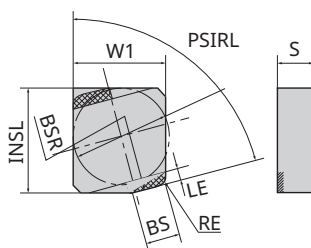


リード角 45°

JFDX-45

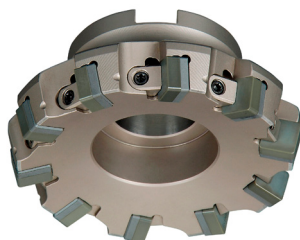


No.2

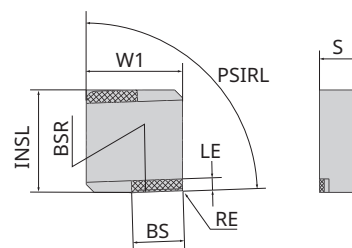


リード角 75°

JFDX-75



No.3

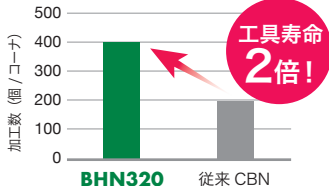


リード角 88°

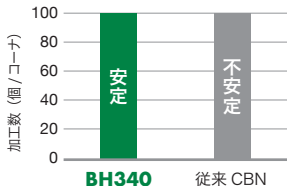
JFDX-88



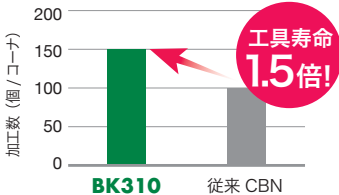
## BHN320 / BHN330

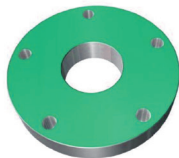
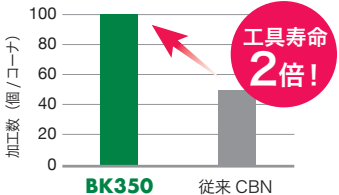
|       |                                                                                                                                                                     |      |
|-------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|
| 加工部品名 | 自動車部品                                                                                                                                                               |      |
| インサート | VNGA160408PQS01015                                                                                                                                                  |      |
| 材種    | <b>BHN320</b>                                                                                                                                                       |      |
| 被削材   | S43C (HRc60)                                                                                                                                                        |      |
| ワーク図  |                                                                                    |      |
| 切削条件  | 切削速度 (m/min)                                                                                                                                                        | 150  |
|       | 送り (mm/rev)                                                                                                                                                         | 0.12 |
|       | 切込み量 (mm)                                                                                                                                                           | 0.2  |
|       | 切削油                                                                                                                                                                 | WET  |
| 結果    |  <p>従来 CBN は加工面粗さ悪化により寿命に至っていたが、<b>BHN320</b> は境界摩耗が抑制され <b>2 倍の寿命</b> を達成した。</p> |      |

## BH320 / BH330 / BH340

|       |                                                                                                                                                     |     |
|-------|-----------------------------------------------------------------------------------------------------------------------------------------------------|-----|
| 加工部品名 | 自動車部品                                                                                                                                               |     |
| インサート | DNGA150412PQS01535                                                                                                                                  |     |
| 材種    | <b>BH340</b>                                                                                                                                        |     |
| 被削材   | SCM440 (HRc62)                                                                                                                                      |     |
| ワーク図  |                                                                  |     |
| 切削条件  | 切削速度 (m/min)                                                                                                                                        | 100 |
|       | 送り (mm/rev)                                                                                                                                         | 0.1 |
|       | 切込み量 (mm)                                                                                                                                           | 0.1 |
|       | 切削油                                                                                                                                                 | DRY |
| 結果    |  <p>従来 CBN は突発欠損が多発していたが、<b>BH340</b> は安定して定数まで加工できるようになった。</p> |     |

## BK310 / BK320 / BK350

|       |                                                                                                                                                                        |     |
|-------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|
| 加工部品名 | 農機部品                                                                                                                                                                   |     |
| インサート | TNGA160408PHT01020                                                                                                                                                     |     |
| 材種    | <b>BK310</b>                                                                                                                                                           |     |
| 被削材   | FC250                                                                                                                                                                  |     |
| ワーク図  |                                                                                     |     |
| 切削条件  | 切削速度 (m/min)                                                                                                                                                           | 700 |
|       | 送り (mm/rev)                                                                                                                                                            | 0.1 |
|       | 切込み量 (mm)                                                                                                                                                              | 0.2 |
|       | 切削油                                                                                                                                                                    | WET |
| 結果    |  <p>従来 CBN は隅 R 部にビバリが発生し寿命に至っていたが、<b>BK310</b> は切れ味を維持し <b>1.5 倍の寿命</b> を達成した。</p> |     |

|       |                                                                                                                                                                    |      |
|-------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|
| 加工部品名 | 機械部品                                                                                                                                                               |      |
| インサート | CNGA120408PQT01020                                                                                                                                                 |      |
| 材種    | <b>BK350</b>                                                                                                                                                       |      |
| 被削材   | FCD450                                                                                                                                                             |      |
| ワーク図  |                                                                               |      |
| 切削条件  | 切削速度 (m/min)                                                                                                                                                       | 400  |
|       | 送り (mm/rev)                                                                                                                                                        | 0.05 |
|       | 切込み量 (mm)                                                                                                                                                          | 0.5  |
|       | 切削油                                                                                                                                                                | WET  |
| 結果    |  <p>従来 CBN は穴部にバリが発生し寿命に至っていたが、<b>BK350</b> は切れ味を維持し <b>2 倍の寿命</b> を達成した。</p> |      |

# MEMO





NTKカuttingツールズ株式会社  
〒485-8510 愛知県小牧市大字岩崎2808



[www.ntkcuttingtools.com/jp/contact/](http://www.ntkcuttingtools.com/jp/contact/)  
サンプル依頼 お問い合わせはこちら



LINE 技術相談 @ntktech

