NEW

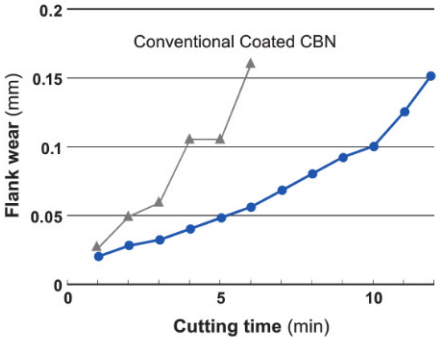
BC8110

MIRACLE SIGMA

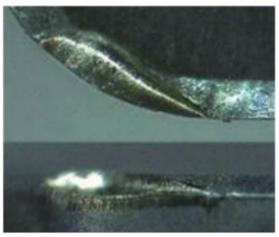
Longer tool life when machining hardened steels.

CUTTING PERFORMANCE

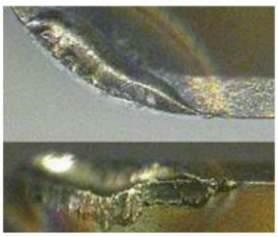
Flank wear during continuous cutting.



<Cutting Conditions>
Workpiece : SCr420 (60HRC)
Insert : NP-CNGA120408GS2
Cutting Speed: 250 m/min
Feed : 0.10 mm/rev
Depth of Cut : 0.2 mm
Cutting Mode : Dry Cutting



BC8110



Conventional Coated CBN

NEW

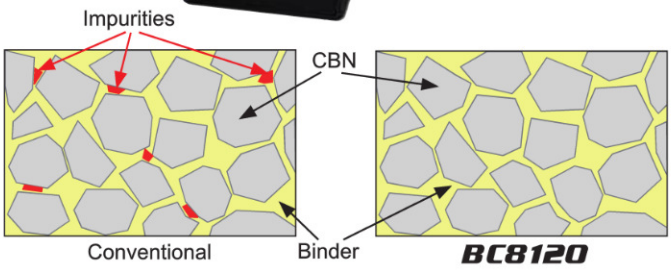
BC8120

MIRACLE SIGMA

Long tool life over a wide application area

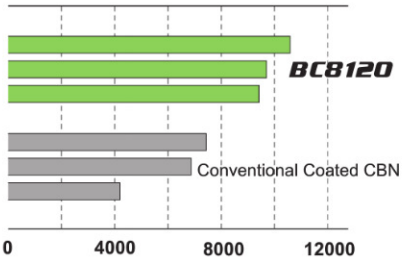
Highly reliable cutting edge strength

1. Contains high toughness CBN particles.
2. Uses Mitsubishi's unique "Particle-activated Sintering" Method".

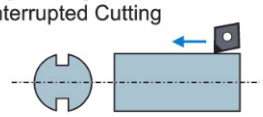


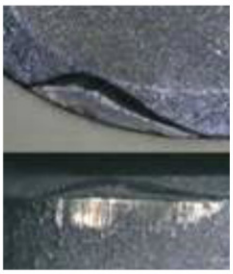
CUTTING PERFORMANCE

Interrupted cutting - BC8120 achieved 1.4 x tool life

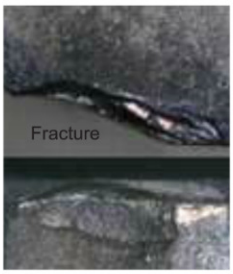


<Cutting Conditions>
Workpiece : SCr420 2 Slit
Insert : NP-CNGA120408GA2
Cutting Speed: vc=250m/min
Feed : 0.15mm/rev
Depth of Cut : 0.1mm
Cutting Mode : Dry Cutting
Interrupted Cutting





BC8120



Conventional Coated CBN

RECOMMENDED CUTTING CONDITIONS

BC8110

Workpiece	Cutting Mode	Cutting Speed (m/min) 50 100 200 300	Feed (mm/rev)	Depth of Cut (mm)	Coolant
Hardened Steel (Heat treated steel etc)	Continuous Cutting		−0.2	−0.2	Dry, Wet

BC8120

Workpiece	Cutting Mode	Cutting Speed (m/min) 100 150 200 250 300	Feed (mm/rev)	Depth of Cut (mm)	Coolant
Hardened Steel (Heat treated steel etc)	Continuous Cutting		−0.3	−0.5	Dry, Wet
	Interrupted Cutting		−0.2	−0.3	Dry, Wet

HONING SELECTION

NP-CNGA120404 GS 4

GS Normal Type

FS Low Cutting Resistence Type

TS Strong Edge Type