


**CNGA 120404, KBN25M, Type: MET**

**Order data**

Order number	255609 MET
GTIN	4960664507092
Item class	25H

**Description**
**Version:**

**MEGACOAT** coated CBN inserts. MultiEdge Tough; 2 or 3 cutting edges per insert, with special honing for optimisation in interrupted cutting.

Grade: KBN25M

Cutting edge version: MET

Cutting depth  $a_p$ : 0.1 - 0.3 mm

Feed  $f$ : 0.1 - 0.2 mm/rev.

Cutting speed  $v_c$  main application: 100 - 180 m/min

**Technical description**

Cutting speed $v_c$ main application	100 - 180 m/min
Cutting conditions	slightly interrupted
Cutting edge version	MET
Cutting depth $a_p$	0.1 - 0.3 mm
Feed $f$	0.1 - 0.2 mm/rev.

Corner radius	0.4 mm
Grade	KBN25M
Finishing/roughing assignment	Finishing
Tool material	CBN
ISO code indexable insert	CNGA 120404
Number of changes/inserts	2
Product name attribute	KBN25M
Type of product	Indexable insert for turning

### User data

	Suitability	$V_c$	ISO code
Steel < 55 HRC	suitable		
Steel < 60 HRC	suitable		
Steel < 67 HRC	suitable		
continuous	suitable only under restricted conditions		
irregular	suitable		
interrupted	suitable only under restricted conditions		
dry	suitable		