


**DCMW 11T308, KBN25M, Type: MET**

**Order data**

Order number	265694 MET
GTIN	4960664529230
Item class	25H

**Description**
**Version:**

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

**Technical description**

Cutting conditions	slightly interrupted
Cutting speed $v_c$ main application	100 - 180 m/min
Cutting depth $a_p$	0.05 - 0.5 mm
Cutting edge version	MET
Feed $f$	0.1 - 0.2 mm/rev.
Corner radius	0.8 mm
Grade	KBN25M
Finishing/roughing assignment	Finishing
Tool material	CBN

ISO code indexable insert	DCMW 11T308
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		