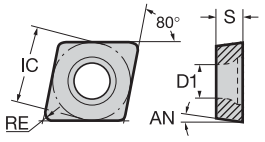
	MATERIAL	OPERATION	CONDITION	EDGE PREP.	GRADE	Vc (m/min)	fn (mm/rev)	COOLANT
H	Hardened steel	finishing ap < 0.5 mm	◯	SE	NBL050C	140 **190** 240	0.06 **0.14** 0.22	💧
			⟲	UE	NBL150C tool life	120 **170** 220	0.06 **0.15** 0.24	
					NBL250C reliability	100 **150** 200		
			⚙	RE	NBL350C	80 **120** 160	0.06 **0.16** 0.26	
	Bearing steel	finishing ap < 0.5 mm	◯	SE	NBL050C	120 **170** 220	0.05 **0.10** 0.15	💧
			⟲	UE	NBL150C tool life	100 **150** 200	0.06 **0.13** 0.20	
					NBL250C reliability	80 **130** 180		
			⚙	RE	NBL350C	60 **110** 160	0.06 **0.14** 0.22	
		roughing ap > 0.5 mm **SOLID PCBN**	◯ ⟲	UE	NBH900U	100 **140** 180	0.15 **0.30** 0.45	
			⚙	UE	NBH950U	80 **120** 160	0.10 **0.25** 0.40	
	Tool steel	finishing ap < 0.5 mm	◯	SE	NBL150C	100 **140** 180	0.04 **0.09** 0.14	💧
			⟲	UE	NBL250C	80 **120** 160	0.05 **0.12** 0.19	
			⚙	RE	NBL350C	60 **100** 140	0.06 **0.13** 0.20	
		roughing ap > 0.5 mm **SOLID PCBN**	◯ ⟲	UE	NBH900U	60 **100** 140	0.10 **0.30** 0.50	
			⚙	UE	NBH950U	40 **80** 120	0.10 **0.25** 0.40	
	High speed steel	finishing ap < 0.5 mm	◯	UE	NBL150C	100 **120** 140	0.05 **0.08** 0.11	
	White cast iron	finishing ap < 0.5 mm	◯ ⟲	UE	NBH500C	60 **120** 180	0.10 **0.30** 0.50	
			⚙	UE	NBH900U	40 **80** 120	0.10 **0.25** 0.40	
		roughing ap > 0.5 mm **SOLID PCBN**	◯ ⟲	UE	NBH500C	60 **90** 120	0.20 **0.40** 0.60	
			⚙	UE	NBH950U	40 **60** 80	0.20 **0.35** 0.50	
K	Gray cast iron	finishing ap < 0.5 mm	◯ ⟲	UE	NBH450C	400 **800** 1200	0.10 **0.25** 0.40	💧
			⚙	UE	NBH500C	600 **1000** 1400	0.10 **0.20** 0.30	
		roughing ap > 0.5 mm **SOLID PCBN**	◯ ⟲	UE	NBH500C	600 **1000** 1400	0.20 **0.40** 0.60	💧
			⚙	UE	NBH900U tool life	400 **800** 1200	0.20 **0.35** 0.50	
					NBH950U reliability	400 **700** 1000		
	ADI cast iron	finishing ap < 0.5 mm	◯ ⟲	UE	NBL150C	500 **600** 700	0.05 **0.15** 0.25	
			⚙	UE	NBL250C	400 **500** 600	0.05 **0.15** 0.25	
		roughing ap > 0.5 mm **SOLID PCBN**	◯ ⟲	UE	NBH500C	300 **400** 500	0.10 **0.25** 0.40	
			⚙	UE	NBH900U tool life	200 **250** 300	0.10 **0.25** 0.40	
					NBH950U reliability	180 **230** 280		
P	Sintered powder metal, high alloyed	finishing ap < 0.5 mm	◯	UE	NBL150C	80 **160** 240	0.05 **0.10** 0.15	
	Sintered powder metal, low alloyed	finishing ap < 0.5 mm	◯	UE	NBH450C	140 **220** 300	0.10 **0.20** 0.30	

◯ Stable machining, continuous cut ⟲ General machining, light interruption ⚙ Unstable machining, interrupted cut

nikkoTOOLS

CC

PCBN
Positive



2 edges

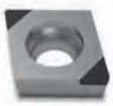
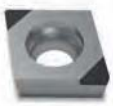
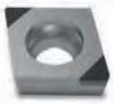
Size	IC	S	D1	AN
MICRO CC	3.50	1.40	1.90	7°
0602□□	6.35	2.38	2.80	7°
09T3□□	9.525	3.97	4.40	7°

GRADE APPLICATION AREA	Stable machining, continuous cut
■ main application	General machining, light interruption
■ applicable	Unstable machining, interrupted cut

Hardness: + / –; Toughness: – / +

ISO513	BL NBL050C	BL NBL150C	BL NBL250C	BL NBL350C	BH NBH450C	BH NBH500C	BH NBH900U	BH NBH950U
P		80 240			140 300			
M								
K					400 1200	300 1400	200 1200	180 1000
N								
S								
H	120 240	100 220	80 200	60 160	60 160	60 180	40 180	40 160

◀ SINTERED POWDER METAL

SHARP	SE H MICROBORING, full face	MICRO	CC.R02S-SE-FF	RE 0.2	a_p ▸ 0.05 **0.10** 0.15 f_n ▸ 0.04 **0.06** 0.08		▲																			
			CC.R04S-SE-FF	RE 0.4	a_p ▸ 0.05 **0.10** 0.15 f_n ▸ 0.04 **0.08** 0.12		▲																			
	SE H 	CCGW	060202S-SE-2S	RE 0.2	a_p ▸ 0.05 **0.10** 0.15 f_n ▸ 0.04 **0.06** 0.08	○	●																			
			060204S-SE-2S	RE 0.4	a_p ▸ 0.05 **0.10** 0.15 f_n ▸ 0.04 **0.08** 0.12	●	●																		
			060208S-SE-2S	RE 0.8	a_p ▸ 0.05 **0.10** 0.15 f_n ▸ 0.05 **0.10** 0.15		○																			
		CCGW	09T302S-SE-2S	RE 0.2	a_p ▸ 0.05 **0.10** 0.15 f_n ▸ 0.04 **0.06** 0.08	○	●																			
			09T304S-SE-2S	RE 0.4	a_p ▸ 0.05 **0.10** 0.15 f_n ▸ 0.04 **0.08** 0.12	●	●																			
			09T308S-SE-2S	RE 0.8	a_p ▸ 0.05 **0.10** 0.15 f_n ▸ 0.05 **0.10** 0.15		●																			
UNIVERSAL	UE H 	CCGW	060202S-UE-2S	RE 0.2	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.05 **0.10** 0.15	○	●																			
			060204S-UE-2S	RE 0.4	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.06 **0.12** 0.18	●	●	●																	
			060208S-UE-2S	RE 0.8	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.06 **0.13** 0.20		○	○																	
		CCGW	09T302S-UE-2S	RE 0.2	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.05 **0.10** 0.15	○	●																			
			09T304S-UE-2S	RE 0.4	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.06 **0.12** 0.18	●	●	●																	
			09T308S-UE-2S	RE 0.8	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.06 **0.13** 0.20		●	●																	
	UE K H  tip with carbide backed	CCGW	060204S-UE-2C	RE 0.4	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.06 **0.12** 0.18					●																
			060208S-UE-2C	RE 0.8	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.06 **0.13** 0.20					○																
		CCGW	09T304S-UE-2C	RE 0.4	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.06 **0.12** 0.18					●																
			09T308S-UE-2C	RE 0.8	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.06 **0.13** 0.20					●																
REINFORCED	RE H	CCGW	060204S-RE-2S	RE 0.4	a_p ▸ 0.08 **0.16** 0.25 f_n ▸ 0.06 **0.13** 0.20				●																	
			060208S-RE-2S	RE 0.8	a_p ▸ 0.08 **0.16** 0.25 f_n ▸ 0.06 **0.14** 0.22				○																	
		CCGW	09T304S-RE-2S	RE 0.4	a_p ▸ 0.08 **0.16** 0.25 f_n ▸ 0.06 **0.13** 0.20				●																	
			09T308S-RE-2S	RE 0.8	a_p ▸ 0.08 **0.16** 0.25 f_n ▸ 0.06 **0.14** 0.22				○																	
WIPER	WE H	CCGW	09T304S-WE-2S	RE 0.4	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.10 **0.15** 0.20	●	●																			
			09T308S-WE-2S	RE 0.8	a_p ▸ 0.06 **0.13** 0.20 f_n ▸ 0.10 **0.18** 0.26	●	●																			

● stock standard, ○ non-standard stock, ▲ upcoming introduction

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