

TURNING

THREADING

GROOVING

MILLING

DRILLING

ACCESSORIES

BGF	DIAMOND-PCBN External grooving				ISO513	DP	BH										
	Size	IC	S	CDX		ND120	NBR4500	◀ SINTERED POWDER METAL									
	100	12.70	4.76	1.8	P	140											
	150	12.70	4.76	2.6	M	400											
	200	12.70	4.76	3.0	K	1200											
	250	12.70	4.76	3.5	N	500											
	300÷400	12.70	4.76	4.5	S	2000											
GRADE APPLICATION AREA	Stable machining, continuous cut						60										
main application	General machining, light interruption						160										
applicable	Unstable machining, interrupted cut																

BGF N H	BGF%/L	Size	IC	S	CDX	ISO513	Hardness		Toughness											
							+	-	+	-										
FLAT 	100-010	N	CW	1.00	RE	0.10			○*											
		H	f _n ▶	0.04	0.08	0.12			○											
	150-010	N	CW	1.50	RE	0.10				○*										
		H	f _n ▶	0.04	0.05	0.06			○											
	200-020	N	CW	2.00	RE	0.20				○*										
		H	f _n ▶	0.06	0.10	0.14			○											
	250-020	N	CW	2.50	RE	0.20				○*										
		H	f _n ▶	0.04	0.06	0.08			○											
	300-020	N	CW	3.00	RE	0.20				○*										
		H	f _n ▶	0.06	0.10	0.14			○											
	350-020	N	CW	3.50	RE	0.20				○*										
		H	f _n ▶	0.08	0.12	0.16			○											
400-020	N	CW	4.00	RE	0.20				○*											
	H	f _n ▶	0.06	0.08	0.10			○												
FULL RADIUS 	100-050FR	N	CW	1.00	RE	0.50				○*										
		H	f _n ▶	0.04	0.05	0.06			○											
	150-075FR	N	CW	1.50	RE	0.75				○*										
		H	f _n ▶	0.04	0.05	0.06			○											
	200-100FR	N	CW	2.00	RE	1.00				○*										
		H	f _n ▶	0.06	0.10	0.14			○											
	250-125FR	N	CW	2.50	RE	1.25				○*										
		H	f _n ▶	0.06	0.10	0.14			○											
	300-150FR	N	CW	3.00	RE	1.50				○*										
		H	f _n ▶	0.06	0.10	0.14			○											
	350-175FR	N	CW	3.50	RE	1.75				○*										
		H	f _n ▶	0.08	0.12	0.16			○											
	400-200FR	N	CW	4.00	RE	2.00				○*										
		H	f _n ▶	0.08	0.12	0.16			○											

○ non-standard stock

*Only right-hand available