BESCO®
SUPERABRASIVES

超硬切削刀具

用专注的心 做专业的事

BESCO®
SUPERABRASIVES

贝斯科超硬材料有限公司
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本企业已通过
ISO9001国际质量体系认证 ISO14001环境管理体系认证
State of the enterprise through
The ISO9001quality system certification、ISO14001environmental management system certification

BESCO®
SUPERABRASIVES

超 硬 切 削 刀 具 行 业 领 先 践 行 者

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公司简介 >>> Company Profile

贝斯科超硬材料有限公司成立于2007年，位于河南开封市国家经济技术开发区，是一家引进国外高端技术，专业生产超硬材料，集研发、生产、销售、服务为一体的国际领先企业。公司注册资本300万美元，占地约30亩，拥有国际一流的研发中心和管理完善的生产工厂。经过数年发展，贝斯科公司已建立起多晶金刚石、单晶金刚石、立方氮化硼、立方氮化硼刀具、实验室培育钻石五大完整的生产链，并拥有相关所有核心技术。

凭借多年的专业经验，贝斯科的目标是用最具有竞争力的价格，为客户提供质量最可靠，最具稳定性的产品。为了实现这一目标，贝斯科配备了完备的生产和质量检测设备，建立了独具特色的贝斯科质量控制系统。所有贝斯科制造的产品，全部在这一质量系统监控下进行，并在“贝斯科实验室”拥有详细的追踪档案，从而确保客户的利益得到最大程度的保障。

Besco Superabrasives Co., Ltd is a leading and professional manufacturer of superabrasives in the world who was established in Kaifeng Economy & Technology Development Zone in 2007 and includes R&D, manufacturing, sales and service. Besco′ s registered funds are 3 million US dollars and Besco factory covers an area of twenty thousand square meters. After several years development, Besco has established five product lines, including multinano–crystal diamond, single crystal diamond, CBN, CBN cutting tools, Laboratory–grown Diamond and already mastered all relating core technology.

With many years professional experience, Besco′ s target is to offer the reliable quality products and competitive price to clients. To achieve this goal, Besco created their Quality Control System. The System is fully equipped with advanced prodution and quality testing equipments . All the products are manufactured base on the strict procedure standards and each lot has detail files at Besco Lab, so that Besco has the ability to track different lots to guarantee the maximum interests of clients.

企业荣誉 >>> Enterprise Honor

>> 连续11年获得 出口创汇先进企业

>> 连续6年出口创汇突出贡献企业

>> 2015年通过 ISO9001体系认证

>> 2015年通过 ISO14001体系认证

>> 2019年荣获 高新技术企业

>> 2019年荣获 科技小巨人（培育）企业

>> 2019年荣获 科技型中小企业

>> 2022河南省 专精特新中小企业

>> 2022年开封市“人造金刚石工程技术研究中心”

>> 2022年通过 ISO45000体系认证

理念

忠诚 / 敬业 / 务实 / 创新 >>> Concepts

用专注的心 做专注的事

With focus heart Do professional things

为什么选用CBN刀具

Why select CBN inserts >>>

立方氮化硼（CBN）在1957年制造成功，成为一种新型人造超硬材料，CBN的硬度仅次于金刚石， CBN单晶的显微硬度为HV8000~9000，是目前已知的第二高硬度的物质，CBN的硬度一般为HV2500~5000。因此用于加工高硬度材料时具有比硬质合金及陶瓷更高的耐磨性， CBN具有很高的抗氧化能力，在1000℃时也不产生氧化现象，与铁系材料在1200~1300℃时也不发生化学反应，所以使用CBN刀具时往往采用干切方式因此CBN材料在加工黑色金属材料方面具有独到之处。现在已经成为难加工材料的首选材料，其应用加工领域为：淬火钢，铸铁，高温合金和粉末冶金。

Cubic boron nitride is the second hardest material in the world invented successfully in 1957; the microhardness of CBN's single crystal is HV8000–9000 while the hardness of CBN is HV2500–5000, so it is considerably better abrasive resistance than tungsten carbide and ceramics. With a higher ability of oxidation resistance within 1000℃, CBN wil do not have any chemical reaction together with ferrous material in 1200–1300℃. So it is unique for CBN material dry cutting ferrous materials. The principal application areas for CBN cutting tools are hardened steels, cast irons and sintered irons as wel as powder metalurgy components.

PCBN刀具的优点及特征

1.能够加工高质量的工件
2.提高工件加工效率
3.加工灵活性更强
4.设备投资减少
5.无需使用冷却液
6.切屑容易回收处理
7.使切屑更容易断屑排出

使用PCBN刀具的注意事项

1.选择更大的刀柄尺寸
2.选择最短的刀具悬伸量
3.选择高强度的夹具
4.选择更大的工件装夹面积（薄壁零件）
5.选择PCBN刀具断续切削是无需使用切削液
6.硬车削合理选用切削液
7.切削过程保持切削液流量一致
8.控制被切削零件的热稳定性

Benefits and Features

1. Excellent surface finish
2. High speed turning , high performance
3. More flexibility in machining
4. Less investment in machines
5. Not required coolant
6. Easier in recycling and treatment of chips
7. Easier in removal of outlet of chips

PCBN tools instruction

1.Required larger dimension of holders
2. Required shorter extended length of inserts holder
3. Required high–duty of fixtures
4.Required larger clamping area of workpiece
5 No need use coolant in interrupted cutting
6. Properly applied coolant in turning hard steel
7. Keept the consistency of cutting fluid flow in machining
8. Controlled the thermal stability of work piece

工件材料分类 IS0513标准
Material Group (IS0513 Standard)

把工件材质分为六大类，由字母和不同的颜色表示。

P 非合金钢（如AIS1040），低合金钢（ISI4340），高合金钢（如AISID3），铸钢和长屑可锻铸铁
P : Steel

M 马氏体不锈钢，锰钢，合金钢，合金铸铁
M : Stainless Steel

K 白口铸铁，冷硬铸铁，灰口铸铁和球磨铸铁
K : Cast Iron

N 非铁金属，铝合金
N : Non – Ferrous Materials

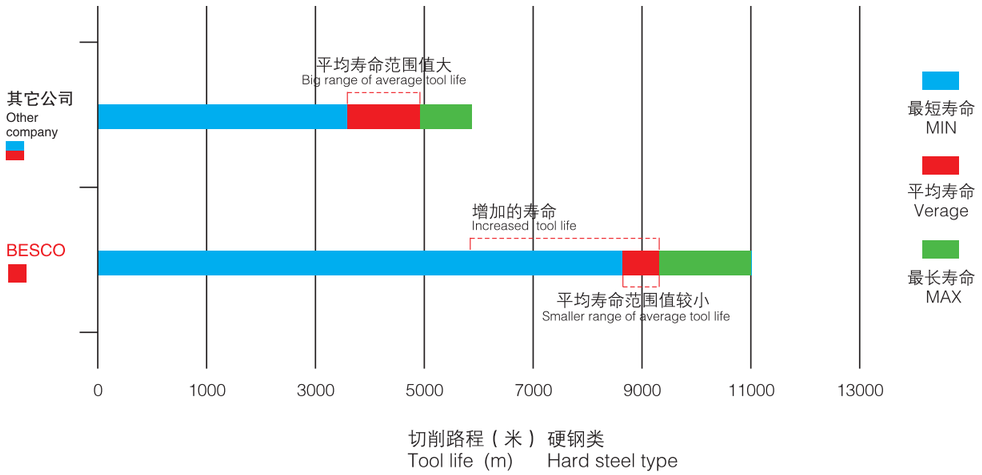
S 高温合金，（钴基高温合金，镍基高温合金）
S : High – Temp Aloys

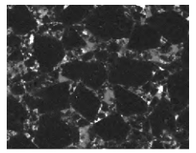
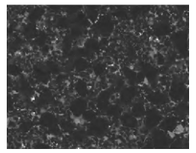
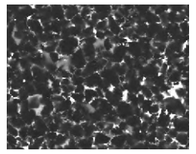
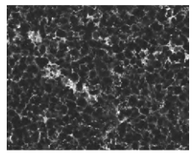
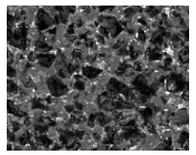
H 淬硬材料，淬硬钢和难加工材料
H : Hardend Materials

贝斯科PCBN刀具比其它品牌刀具寿命提高30%
Besco's PCBN inserts can offer you at least 30% much longer life than the other brand one.

测试工况： ISO 513
测试结果： 1.贝斯科PCBN刀具比其它品牌刀具寿命大幅增长；
2.贝斯科PCBN刀具比其它品牌刀具平均寿命范围值更小，稳定性更高。

Testing results :
1. Besco PCBN inserts life is much longer than the other brand's.
2. The average life range of Besco PCBN inserts is much concentrated than the other's.



牌号	显微形貌	特点	适用领域
SBN630		80%～85%CBN，25μm混合粒度，Al–Ni相。 80%~85% CBN, 25μm mixed CBN grain size and Al–Ni binder.	适用于灰铸铁、球墨铸铁以及高硬合金铸铁、高镍铬及高铬铸铁、高锰钢等难加工材料的粗到半精加工和断续加工。 Suitable for rough to semi–finishing and intermittent cutting of gray cast iron, ductile iron, high alloy cast iron, high nickel and chromium cast iron, high manganese steel, etc.
SBN680		85%~90%CBN，20μm，具有优异的耐磨性与抗冲击韧性以及较高的化学稳定性与热稳定性。 85%~90%CBN,20μm, with unique combination of abrasive wear resistance, heat and chemical wear resistance and impact toughness.	用于高铬/镍铸钢轧辊的切削加工，同时可用于高速钢、淬硬钢类材质加工。在高速高效切削时，具有更长的刀具寿命。 Specifically designed for machining high Cr and Ni iron alloys and turning steel rolls. for higher machining speeds and longer tool life in these applications.
SBN500		85%~90%CBN，12μm，具有优异的耐磨性与抗冲击韧性以及较高的化学稳定性与热稳定性 85%~90%CBN,12μm, with unique combination of abrasive wear resistance, heat and chemical wear resistance and impact toughness.	用于高铬/镍铸钢轧辊的切削加工，同时可用于高速钢、淬硬钢类材质加工。在高速高效切削时，具有更长的刀具寿命。 Specifically designed for machining high Cr and Ni iron alloys and turning steel rolls. for higher machining speeds and longer tool life in these applications.
SBN2080		90%CBN高含量，4μm结构金属相黏结剂，具有优异的耐磨性与高导热率 90%CBN High content,4μm submicro CBN and metal binder. With excellent wear resistance and high thermal conductivity.	应用于灰铸铁、粉末冶金及部分淬硬钢材质的连续及轻断续切削加工。 Designed for continous and moderately interrupted hard turning cast iron, PM and hard steel.
SBN910		50%～65% CBN，精控CBN颗粒与TiN陶瓷相结构分布。耐磨性、抗冲击性以及化学惰性均衡 SBN910 compacts consist of extremely tightly controlled CBN crystals in a TiN–based matrix. The combination of high abrasion resistance, good impact strength and chemical stability.	加工过程中可以实现高切除率、良好的表面光洁度以及较长的工具寿命。适合于淬火钢连续及中等断续车削应用。 Higher material removal rates, good surface finish and long tool life. A multi–purpose hard turning product that delivers excellent results in continuous and moderately interrupted cut of hardened steels.

常用切削参数推荐 Common cutting parameters recommendation

工件	材料	工件硬度	主偏角 Kr	切削速度 (m/min)	切削深度 (mm)	进给量 (mm/r)
淬火钢	Gr15	HRC60	45~95°	70~200	0.50~3.00	0.10~0.30
合金铸铁	高铬铁	HSD80	10~45°	15~200	0.50~10.00	0.30~3.00
球墨铸铁	QT450	HB220	45~95°	300~700	0.50~5.00	0.30~1.50
灰铸铁	HT200–300	HB180–260	45~95°	300~1100	0.30~4.00	0.25~1.00
淬火齿轮	40Cr	HRC58	45~95°	60~120	0.30~300	0.10~0.50
滚珠丝杠	Gr15	HRC55	45~95°	80~120	0.50~8.00	0.10~0.30
轧辊	高镍铬	HSD78	10~45°	15~50	1.00~10.00	0.50~1.5
轧辊	高铬铁	HSD75	10~45°	15~45	1.00~10.00	0.50~1.5
轧辊	高铬钢	HSD75	10~45°	20~60	1.00~10.00	0.50~1.5
轧辊	高铬钢	HSD88	10~45°	10~30	1.00~10.00	0.50~1.5
轧辊	高碳半钢	HSD70	10~45°	25~80	1.00~10.00	0.50~1.5
冷硬轧辊	冷硬铸铁	HSD67	10~45°	20~50	1.00~10.00	0.50~1.5
渣浆泵护板	高铬钢	HRC58	45~95°	60~90	0.50~4.00	0.10~0.50
渣浆泵叶轮	高铬钢	HRC60	45~95°	50~90	0.50~4.00	0.10~0.51
渣浆泵壳体	高铬钢	HRC55	45~95°	60~90	0.50~4.00	0.10~0.52
制动鼓	HT200–300	HB190–220	45~90°	300~1200	0.25~4.00	0.25~1.00
制动盘	HT200–300	HB190–220	45~90°	300~1200	0.25~4.00	0.25~1.00
减速机壳体	HT250	HB200	45~95°	100~180	0.50~4.00	0.50~0.80

Workpiece	Materials	Hardness	Angle Kr	Cutting speed (m/min)	Cutting depth (mm)	Cutting feed(mm/r)
Hardened steel	Gr15	HRC60	45~95°	70~200	0.50~3.00	0.10~0.30
Alloy cast iron	High chrome iron	HSD80	10~45°	15~200	0.50~10.00	0.30~3.00
Ductile iron	QT450	HB220	45~95°	300~700	0.50~5.00	0.30~1.50
Gray cast iron	HT200–300	HB180–260	45~95°	300~1100	0.30~4.00	0.25~1.00
Hardened gear	40Cr	HRC58	45~95°	60~120	0.30~300	0.10~0.50
Ball screw	Gr15	HRC55	45~95°	80~120	0.50~8.00	0.10~0.30
Roller	High nickel chrome	HSD78	10~45°	15~50	1.00~10.00	0.50~1.5
Roller	High chrome iron	HSD75	10~45°	15~45	1.00~10.00	0.50~1.5
Roller	High chrome steel	HSD75	10~45°	20~60	1.00~10.00	0.50~1.5
Roller	High chrome steel	HSD88	10~45°	10~30	1.00~10.00	0.50~1.5
Roller	High carbon semi–sreel	HSD70	10~45°	25~80	1.00~10.00	0.50~1.5
Chill roller	Chill cast iron	HSD67	10~45°	20~50	1.00~10.00	0.50~1.5
Slurry pump guard	High chrome steel	HRC58	45~95°	60~90	0.50~4.00	0.10~0.50
Slurry pump impeller	High chrome steel	HRC60	45~95°	50~90	0.50~4.00	0.10~0.51
Slurry pump housing	High chrome steel	HRC55	45~95°	60~90	0.50~4.00	0.10~0.52
Brake drum	HT200–300	HB190–220	45~90°	300~1200	0.25~4.00	0.25~1.00
Brake disc	HT200–300	HB190–220	45~90°	300~1200	0.25~4.00	0.25~1.00
Reducer housing	HT250	HB200	45~95°	100~180	0.50~4.00	0.50~0.80

刀片磨损原因和解决方案 Common Tools wear causes and solutions

切削中的问题	问题项目	对策：工具材质的选定				切削条件						工具形状							安装		机械
		变更为更硬材质	变更为有韧性的材质	变更为耐热冲击性良好的材质	变更为耐熔着性良好的材质	切削速度 高↑低↓	进给量（大）↑（小）↓	切深	改变走刀路线	冷却液 湿式	冷却液 干式	改变刀片断屑槽	前角 变大↑变小↓	刀尖角R 变大↑变小↓	侧切刃角 变大↑变小↓	切刃强度・珩磨	刀片精度提高（M级–G级）	刀杆刚性	工件・工具的安装	刀杆的伸出长度	动力・机械松动情况
加工尺寸的偏差	工件尺寸的偏差	刀片精度不适当															●				
		工件・工具的偏离										●	●↑	●↓	●↓			●	●	●	●
	切削中偏心设定多	后角面磨损增大	●											●↑							
		切削条件不适当				●↓	●↑														
		刃口积屑瘤的影响			●	●↑															
完成面粗糙度劣化	完成面表面粗糙度比要求低	工具磨损大引起的锋利度降低	●			●	●↓				●		●	●↑	●↑		●↓	●			
		切刃的崩刃		●				●↓	●↓				●		●↑		●↑			●	●	●
		熔着、刃口积屑瘤				●	●↑				●		●	●↑			●↓	●				
		切削条件不适当					●↑	●↓	●↓		●											
		工具、刀尖形状不适当											●		●↑		●↓	●				
		振动・振刀		●			●↓	注1 ●↓	●↓				●	●↑	●↓	●↓	●↓		●	●	●	●
	切削热引起的加工精度恶化以及工具寿命下降	切削条件不适当					●↓	●↓	●↓		●											
		工具切刃形状不适当	●										●	●↑			●↓					
毛刺、欠损、起毛	发生毛刺	切削条件不适当					●↓	●↑		●	●											
		工具材质、刀尖形状不适当	●										●	●↑	●↓	●↓	●↓					
	欠损	切削条件不适当						●↓	●↓	●												
		工具材质、刀尖形状不适当	●										●	●↑	●↑	●↑	●↓		●	●	●	●
	起毛	切削条件不适当					●↑	注2 ●↓			●											
		工具材质、刀尖形状不适当	●			●							●	●↑			●↓					
切刃的损伤	后角面、前角面磨损增大	后角面磨损	●				●↓				●		●	●↑	●↑		●↓					
		前角面磨损	●				●↓	●↓	●↓		●		●	●↑		●↑						
	境界磨损增大	境界磨损				●	●↓				●											
	欠损	振动・冲击		●				●↓	●↓				●			●↑	●↑		●	●	●	●
	崩刃	材质、切削条件不适当		●	●			●↓	●↓				●		●↑	●↑	●↑		●	●	●	●
	热龟裂	工件硬度与材质以及切削条件不适当			●		●↓	●↓	●↓			●	●	●↑			●↓					
	切刃刀尖角部变形	断续切削时刀尖角部变形	●				●↓	●↓	●↓				●	●↓	●↑	●↑	●↑					
	刃口积屑瘤	工件硬度与材质以及切削条件不适当				●	●↑	●↑			●		●	●↑			●↓	●				
切屑处理	伸长、缠绕	切削条件不适当					注3 ●↓	●↑	●↑	●		●										
		工具、刀尖形状不适当											●		●↓	●↓						
	急剧分散	切削条件不适当						●↓	●↓			●										
		工具、刀尖形状不适当											●		●↑	●↑						

注：1.为防止振刀，有时可提高进给；2.为避免毛边，有时可提高进给；3.当使用软钢、低碳钢加工用（X系列）时，较高的切削速度可使切屑较短。

ISO	C	N	G	N	12	04	08	S	020	20	20	SS	ST	S	4
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
ANSI	C	N	G	N	4	3	2	S	020	20	20	SS	ST	S	4
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

1 刀片形状 Shape

H	正六边形	120°	C	菱形	80°
O	正八边形	135°	D		55°
P	正五边形	108°	E		75°
R	圆形		M		86°
S	正方形	90°	V		35°
T	正三角形	60°	W	六边形	80°
			L	长方形	90°
			A	平行四边形	85°
			B		82°
			K		55°

2 刀片后角 Clearance Angle

A		E		P
B		F		O
C		G		
D		N		

3 公差 ISO Tolerance–ANSL

代号	允差mm			Code	Inch		
级	刀尖高m	厚度s	内切圆ic		m	ic	s
C	±0.013	±0.025	±0.025	C	±0.0005	±0.001	±0.001
H	±0.013	±0.025	±0.013	H	±0.0005	±0.0005	±0.001
E	±0.025	±0.025	±0.025	E	±0.001	±0.001	±0.001
G	±0.025	±0.13	±0.025	G	±0.001	±0.001	±0.005
K	±0.013	±0.025	±0.05~±0.13	K	±0.0005	±0.002~0.005	±0.005
M	±0.08~±0.18	±0.13	±0.05~±0.13	M	±0.002~0.005	±0.002~0.005	±0.005
U	±0.13~±0.38	±0.13	±0.08~±0.25	U	±0.005~0.012	±0.005~0.010	±0.005

4 固定、断削槽 Standard、Chipreaker

N	G	B
R	W	H
F	T	C
A	Q	J
M	U	其它异形 X

5 内切圆直径 Inscribed Circle Dia.

ISO								ANSI	
切刃长度（按刀片形状）							内切圆径	Code	IC Size
C	D	R	S	T	V	W	mm		Inch
S4	04	03	03	06	–	–	3.97	(1.2)	5/32
04	05	04	04	08	08	S3	4.76	(1.5)	3/16
05	06	05	05	09	09	03	5.56	(1.8)	7/32
–	–	06	–	–	–	–	6	–	–
06	07	06	06	11	11	04	6.35	2	1/4
08	09	07	07	13	13	05	7.94	(2.5)	5/16
–	–	08	–	–	–	–	8	–	–
09	11	09	09	16	16	06	9.525	3	3/8
–	–	10	–	–	–	–	10	–	–
–	–	12	–	–	–	–	12	–	–
12	15	12	12	22	22	08	12.7	4	1/2
16	19	15	15	27	27	10	15.875	5	5/8
–	–	16	–	–	–	–	16	–	–
19	23	19	19	33	33	13	19.05	6	3/4
–	–	20	–	–	–	–	20	–	–
22	27	22	22	38	38	15	22.225	7	7/8
–	–	25	–	–	–	–	25	–	–
25	31	25	25	44	44	17	25.4	8	1
32	38	31	31	54	54	21	31.75	10	1–1/4
–	–	32	–	–	–	–	32	–	–

6 刀片厚度 Thickness

ISO		ANSI	
代号	尺寸	Code	Size
S	mm	S	inch
01	1.59	1	1/16
02	2.38	(1.5)	3/32
T2	2.78	–	–
03	3.18	2	1/8
T3	3.97	(2.5)	5/32
04	4.76	3	3/16
05	5.56	(3.5)	7/32
06	6.35	4	1/4
07	7.94	5	5/16
09	9.525	6	3/8

7 刀片R角 Nose radius

ISO		ANSI	
代号	尺寸	Code	Size
Re	mm	Re	inch
00	锋利	00	.000
003	0.03	(0.1)	.001
01	0.1	(0.2)	.004
02	0.2	(0.5)	.008
04	0.4	1	1/64
08	0.8	2	1/32
12	1.2	3	3/64
16	1.6	4	1/16
20	2.0	5	5/64
24	2.4	6	3/32
28	2.8	7	7/64
32	3.2	8	1/8
MO	圆形刀片	0	circular

8 主切刃形状 Cutting Edge Design

E	T	S	F
钝化	倒棱	倒棱+钝化	锋利刃口
Honed	Chamfered	Chamfered+Honed	Sharp Edge

9 倒棱宽度 Chamfered Width

代号	Code	000	005	010	015	020	030
尺寸	Size	–	0.05	0.1	0.15	0.2	0.3

10 倒棱角度 Chamfered Angle

代号	Code	α	00	10	15	20	25	30	35	45
尺寸	Size	°	–	10	15	20	25	30	35	45

11 钝化 Honed

代号	Code	00	02	05	10	20	30
尺寸	Size	–	0.002	0.005	0.01	0.02	0.03

12 刀片结构 Insert type

SF	SL	SS	CB	CS	SWW	SWU
整面复合片	整体CBN局部	整体CBN	CBN复合片标准	CBN复合片整条边	整体CBN(W形)贯穿	整体CBN(U形)贯穿
Full Face	Solid Tipped Comer	Solid CBN	Standard Tipped Comers	Standard Full Edge	Solid Tipped Comers Type"W"	Solid Tipped Comers Type"U"

13 刃口形状 Cutting Edge Design

ST	WG	SV
圆角R刀片	修光刃	断屑槽刀片
Nose Radius	Wiper	Chip Breaker

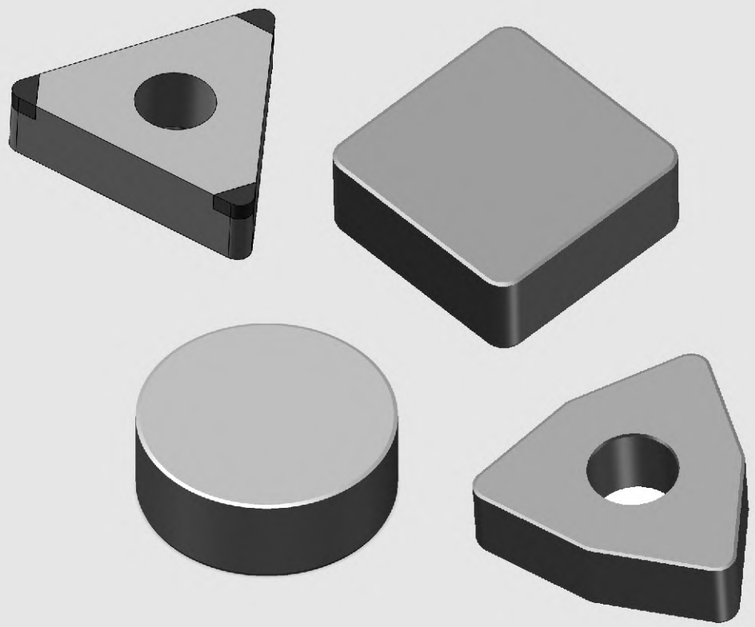
14 表面处理形式 Surface Treatment

S	标准未涂层	C1	涂层
	Uncoated		Coated
		R&D 研发中	

15 刃数 Edges

代号 Code	1	2	3	4	5	6	7	8
含义	一刃	二刃	三刃	四刃	五刃	六刃	七刃	八刃
notes	1 edge	2 edge	3 edge	4 edge	5 edge	6 edge	7 edge	8 edge

PCBN 数控刀具
PCBN CNC CUTTING TOOL

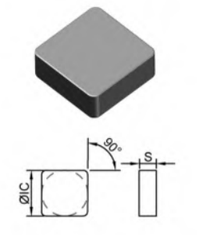


BESCO SUPERABRASIVES

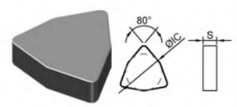
RN 圆形・无孔・ CBN整体刀片 Solid PCBN inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm				应用材料 Application Materials				
						SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	R	H	MKS	MKSH	MKSH	MKSH
	RNGN250700	25.4	25.4	7.94	0			●	●	
	RNGN201000	20	20	10	0		●	●	●	●
	RNGN200700	20	20	7.94	0		●	●	●	●
	RNGN150700	15.875	15.875	7.94	0	●	●	●	●	●
	RNGN120700	12.7	12.7	7.94	0	●	●	●	●	●
	RNGN120400	12.7	12.7	4.76	0	●	●	●	●	●
	RNGN090400	9.525	9.525	4.76	0	●	●	●	●	●

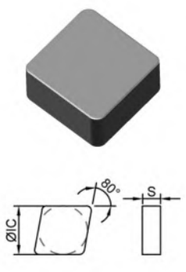
SN 90° 正方形・无孔・CBN整体刀片 Solid PCBN inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm				应用材料 Application Materials				
						SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	R	H	MKS	MKSH	MKSH	MKSH
	SNGN201012	20	20	10	1.2		●	●	●	●
	SNGN200712	20	20	7.94	1.2		●	●	●	●
	SNGN150716	15.875	15.875	7.94	1.6	●	●	●	●	●
	SNGN120712	12.7	12.7	7.94	1.2	●	●	●	●	●
	SNGN120408	12.7	12.7	4.76	0.8	●	●	●	●	●
	SNGN090404	9.525	9.525	4.76	0.4	●	●	●	●	●

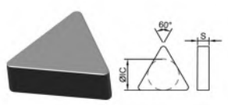
WN 80° 六边形・无孔・CBN整体刀片 Solid PCBN inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm				应用材料 Application Materials				
						SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	R	H	MKS	MKSH	MKSH	MKSH
	WNGN080404	8.79	12.7	4.76	0.4	●	●	●	●	●
	WNGN080408	8.79	12.7	4.76	0.8	●	●	●	●	●
	WNGN080412	8.79	12.7	4.76	1.2	●	●	●	●	●

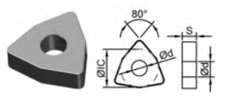
CN 80° 菱形・无孔・CBN整体刀片 Solid PCBN inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm				应用材料 Application Materials				
						SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	R	H	MKS	MKSH	MKSH	MKSH
	CNGN120404	12.9	12.7	4.76	0.4	●	●	●	●	●
	CNGN120408	12.9	12.7	4.76	0.8	●	●	●	●	●
	CNGN120412	12.9	12.7	4.76	1.2	●	●	●	●	●
	CNGN120708	12.9	12.7	7.94	0.8	●	●	●	●	●
	CNGN120712	12.9	12.7	7.94	1.2	●	●	●	●	●
	CNGN160708	16.1	15.875	7.94	0.8		●	●	●	●
	CNGN160712	16.1	15.875	7.94	1.2		●	●	●	●

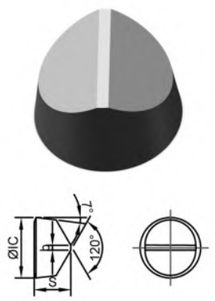
TN 60° 三角形・无孔・CBN整体刀片 Solid PCBN inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm				应用材料 Application Materials				
						SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	R	H	MKS	MKSH	MKSH	MKSH
	TNGN110404	11	6.35	4.76	0.4	●	●	●	●	●
	TNGN160404	16	9.525	4.76	0.4	●	●	●	●	●
	TNGN160408	16	9.525	4.76	0.8	●	●	●	●	●
	TNGN220408	22	12.7	4.76	0.8	●	●	●	●	●

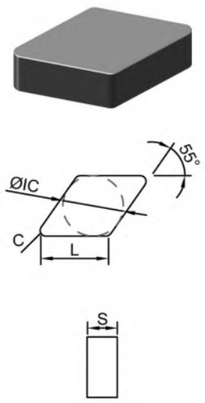
WN 80° 六边形・有孔・CBN整体刀片 Solid PCBN inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm				应用材料 Application Materials				
						SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	R	H	MKS	MKSH	MKSH	MKSH
	WNGA080404	8.79	12.7	4.76	0.4	●	●	●	●	●
	WNGA080408	8.79	12.7	4.76	0.8	●	●	●	●	●
	WNGA080412	8.79	12.7	4.76	1.2	●	●	●	●	●

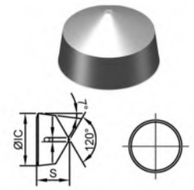
RC 圆形・7° 后角・V型底座・CBN整体刀片 Solid PCBN inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm				应用材料 Application Materials				
						SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	B	H	MKS	MKSH	MKSH	MKSH
	RCGX060400V	6.35	6.35	4.76	0.8	●	●	●	●	●
	RCGX060600V	6.35	6.35	6.35	0.8	●	●	●	●	●
	RCGX090700V	9.525	9.525	7.94	1	●	●	●	●	●
	RCGX120700V	12.7	12.7	7.94	2	●	●	●	●	●
	RCGX151000V	15.875	15.875	10.0	2	●	●	●	●	●
	RCGX191000V	19.05	19.05	10.0	2			●	●	●
	RCGX201200V	20.0	20.0	12.0	2			●	●	●
	RCGX251200V	25.4	25.4	12.0	2			●	●	●

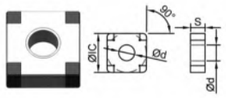
DN 55° 菱形・无孔・CBN整体刀片 Solid PCBN inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm				应用材料 Application Materials				
						SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	R	H	MKS	MKSH	MKSH	MKSH
	DNGN110404	11.0	9.525	4.76	0.4	●	●	●	●	●
	DNGN110408	11.0	9.525	4.76	0.8	●	●	●	●	●
	DNGN110412	11.0	9.525	4.76	1.2	●	●	●	●	●
	DNGN110604	11.0	9.525	6.35	0.4	●	●	●	●	●
	DNGN110608	11.0	9.525	6.35	0.8	●	●	●	●	●
	DNGN110612	11.0	9.525	6.35	1.2	●	●	●	●	●
	DNGN150604	15.5	12.7	6.35	0.4	●	●	●	●	●
	DNGN150608	15.5	12.7	6.35	0.8	●	●	●	●	●
	DNGN150612	15.5	12.7	6.35	1.2			●	●	●
	DNGN150704	15.5	12.7	7.94	0.4	●	●	●	●	●
	DNGN150708	15.5	12.7	7.94	0.8	●	●	●	●	●
	DNGN150712	15.5	12.7	7.94	1.2			●	●	●

RC 圆形・7° 后角・圆锥Y形底座・CBN整体刀片 Solid PCBN inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm				应用材料 Application Materials				
						SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	B	H	MKS	MKSH	MKSH	MKSH
	RCGX060400Y	6.35	6.35	4.76	0.6	●	●	●	●	●
	RCGX060500Y	6.35	6.35	5.0	0.6	●	●	●	●	●
	RCGX060700Y	6.35	6.35	7.94	0.6	●	●	●	●	●
	RCGX090700Y	9.525	9.525	7.94	1	●	●	●	●	●
	RCGX120700Y	12.7	12.7	7.94	1.2	●	●	●	●	●

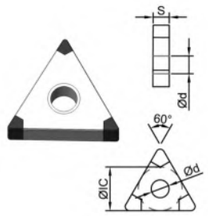
SN 90° 正方形・有孔・CBN数控刀片 Solid PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	∅d	R	H	MKS	MKSH	MKSH	MKSH
	SNGA120404–8S	12.7	12.7	4.76	5.16	0.4	●	●	●	●	●
	SNGA120408–8S	12.7	12.7	4.76	5.16	0.8	●	●	●		●
	SNGA120412–8S	12.7	12.7	4.76	5.16	1.2	●	●		●	●

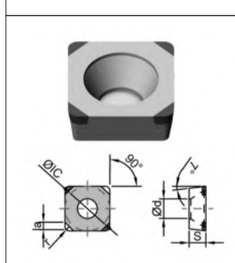
WN 80° 六边形・有孔・CBN数控刀片 Solid PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	∅d	R	H	MKS	MKSH	MKSH	MKSH
	WNGA060404–6S	6.5	9.525	4.76	3.81	0.4	●	●	●	●	●
	WNGA060408–6S	6.5	9.525	4.76	3.81	0.8	●	●	●	●	●
	WNGA060412–6S	6.5	9.525	4.76	3.81	1.2	●	●	●		●
	WNGA080404–6S	8.79	12.7	4.76	5.16	0.4	●	●	●	●	●
	WNGA080408–6S	8.79	12.7	4.76	5.16	0.8	●	●	●	●	●
	WNGA080412–6S	8.79	12.7	4.76	5.16	1.2	●	●		●	●

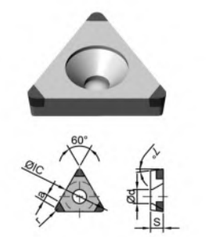
TN 60° 三角形・有孔・CBN数控刀片 Solid PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		L	∅IC	S	∅d	R	H	MKS	MKSH	MKSH	MKSH
	TNGA160404–6S	16.5	9.525	4.76	3.81	0.4	●	●	●	●	●
	TNGA160408–6S	16.5	9.525	4.76	3.81	0.8	●	●	●	●	●
	TNGA160412–6S	16.5	9.525	4.76	3.81	1.2	●	●	●	●	●
	TNGA220404–6S	22	12.7	4.76	5.16	0.4	●	●	●	●	●
	TNGA220408–6S	22	12.7	4.76	5.16	0.8	●	●	●	●	●
	TNGA220412–6S	22	12.7	4.76	5.16	1.2	●	●	●	●	●

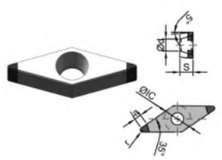
SC 90° 正方形・有孔・CBN数控刀片 Compound PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		∅IC	S	∅d	R	La	H	MKS	MKSH	MKSH	MKSH
	SCGW120404–2	12.7	4.76	5.56	0.4	2.5	●	●	●	●	●
	SCGW120408–2	12.7	4.76	5.56	0.8	2.3	●	●	●	●	●
	SCGW120412–2	12.7	4.76	5.56	1.2	2.1	●	●	●	●	●
	SCGW120404–4	12.7	4.76	5.56	0.4	2.5	●	●	●	●	●
	SCGW120408–4	12.7	4.76	5.56	0.8	2.3	●	●	●	●	●
	SCGW120412–4	12.7	4.76	5.56	1.2	2.1	●	●	●	●	●

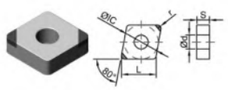
TC 60° 三角形・有孔・CBN数控刀片 Compound PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		∅IC	S	∅d	R	La	H	MKS	MKSH	MKSH	MKSH
	TCGW110204–1	6.35	2.38	2.8	0.4	2.5	●	●	●	●	●
	TCGW110304–1	6.35	3.18	2.8	0.4	2.5	●	●	●	●	●
	TCGW16T308–1	9.525	3.97	4.4	0.8	2.2	●	●	●	●	●
	TCGW110204–3	6.35	2.38	2.8	0.4	2.5	●	●	●	●	●
	TCGW110304–3	6.35	3.18	2.8	0.4	2.5	●	●	●	●	●
	TCGW16T308–3	9.525	3.97	4.4	0.8	2.2	●	●	●	●	●

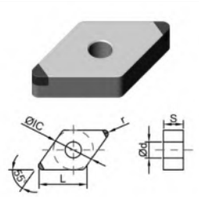
VB 35° 菱形・有孔・CBN数控刀片 Compound PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		∅IC	S	∅d	R		H	MKS	MKSH	MKSH	MKSH
	VBGW160404–1	9.525	4.76	4.4	0.4	2.8	●	●	●	●	●
	VBGW160408–1	9.525	4.76	4.4	0.8	2.5	●	●	●	●	●
	VBGW160404–2	9.525	4.76	4.4	0.4	2.8	●	●	●	●	●
	VBGW160408–2	9.525	4.76	4.4	0.8	2.5	●	●	●	●	●

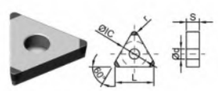
CN 80° 菱形・有孔・CBN数控刀片 Compound PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		∅IC	S	∅d	R	La	H	MKS	MKSH	MKSH	MKSH
	CNGA120404	12.7	4.76	5.16	0.4	12.9	●	●	●	●	●
	CNGA120408	12.7	4.76	5.16	0.8	12.9	●	●	●	●	●
	CNGA120412	12.7	4.76	5.16	1.2	12.9	●	●	●	●	●

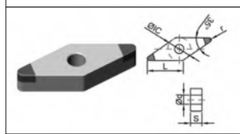
DN 55° 菱形・有孔・CBN数控刀片 Compound PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		∅IC	S	∅d	R	La	H	MKS	MKSH	MKSH	MKSH
	DNGA110404	9.525	4.76	3.81	0.4	11.6	●	●	●	●	●
	DNGA110408	9.525	4.76	3.81	0.8	11.6	●	●	●	●	●
	DNGA150408	12.7	4.76	5.16	0.8	15.5	●	●	●	●	●
	DNGA150412	12.7	4.76	5.16	1.2	15.5	●	●	●	●	●
	DNGA150612	12.7	4.76	5.16	1.2	15.5	●	●	●	●	●

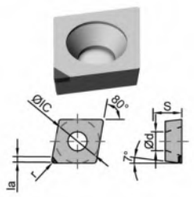
TN 60° 三角形・有孔・CBN数控刀片 Compound PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		∅IC	S	∅d	R	La	H	MKS	MKSH	MKSH	MKSH
	TNGA110304	6.35	3.18	2.26	0.4	11	●	●	●	●	●
	TNGA160408	9.525	4.76	3.81	0.8	16.5	●	●	●	●	●
	TNGA160412	9.525	4.76	3.81	1.2	16.5	●	●	●	●	●
	TNGA220412	12.7	4.76	5.16	1.2	22	●	●	●	●	●

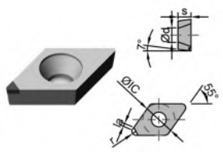
VN 35° 菱形・有孔・CBN数控刀片 Compound PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		∅IC	S	∅d	R	La	H	MKS	MKSH	MKSH	MKSH
	VNGA160404	9.525	4.76	3.81	0.4	16.6	●	●	●	●	●
	VNGA160408	9.525	4.76	3.81	0.8	16.6	●	●	●	●	●
	VNGA160412	9.525	4.76	3.81	1.2	16.6	●	●	●	●	●

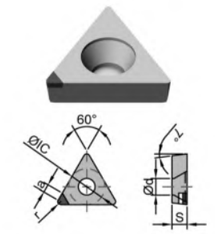
CC 80° 菱形・有孔・CBN数控刀片 Compound PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		∅IC	S	∅d	R	La	H	MKS	MKSH	MKSH	MKSH
	CCGW060204	6.35	2.38	2.8	0.4	2.5	●	●	●	●	●
	CCGW060208	6.35	2.38	2.8	0.8	2.4	●	●	●	●	●
	CCGW09T304	9.525	3.97	4.4	0.4	2.5	●	●	●	●	●
	CCGW09T308	9.525	3.97	4.4	0.8	2.4	●	●	●	●	●
	CCGW120408	12.7	4.76	5.5	0.8	2.4	●	●	●	●	●

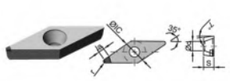
DC 55° 菱形・有孔・CBN数控刀片 Compound PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		∅IC	S	∅d	R	La	H	MKS	MKSH	MKSH	MKSH
	DCGW070202	6.35	2.38	2.8	0.2	2.7	●	●	●	●	●
	DCGW070204	6.35	2.38	2.8	0.4	2.5	●	●	●	●	●
	DCGW11T304	9.525	3.97	4.4	0.4	2.5	●	●	●	●	●
	DCGW11T308	9.525	3.97	4.4	0.8	2.3	●	●	●	●	●

TC 60° 三角形・有孔・CBN数控刀片 Compound PCBN welding inserts series

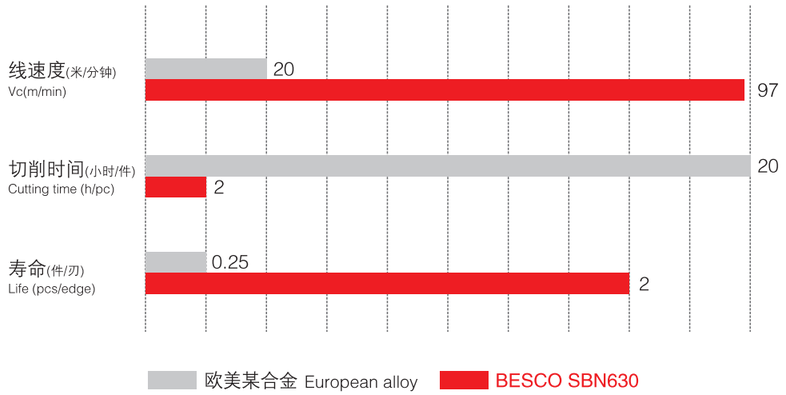
图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		∅IC	S	∅d	R	La	H	MKS	MKSH	MKSH	MKSH
	TCGW110202	6.35	2.38	2.8	0.2	2.5	●	●	●	●	●
	TCGW110204	6.35	2.38	2.8	0.4	2.5	●	●	●	●	●
	TCGW110208	6.35	2.38	2.8	0.8	2.0	●	●	●	●	●
	TCGW110304	6.35	3.18	2.8	0.4	2.5	●	●	●	●	●
	TCGW16T304	9.525	3.97	4.4	0.4	2.5	●	●	●	●	●
	TCGW16T308	9.525	3.97	4.4	0.8	2.0	●	●	●	●	●

VC 35° 菱形・有孔・CBN数控刀片 Compound PCBN welding inserts series

图示 Shape	国际标准 ISO	刀片参数 Dimensions in mm					应用材料 Application Materials				
							SBN910	SBN2080	SBN680	SBN630	SBN500
		∅IC	S	∅d	R	La	H	MKS	MKSH	MKSH	MKSH
	VCGW160404	9.525	4.76	4.4	0.4	2.8	●	●	●	●	●
	VCGW160408	9.525	4.76	4.4	0.8	2.5	●	●	●	●	●
	VCGW160412	9.525	4.76	4.4	1.2	2.0	●	●	●	●	●

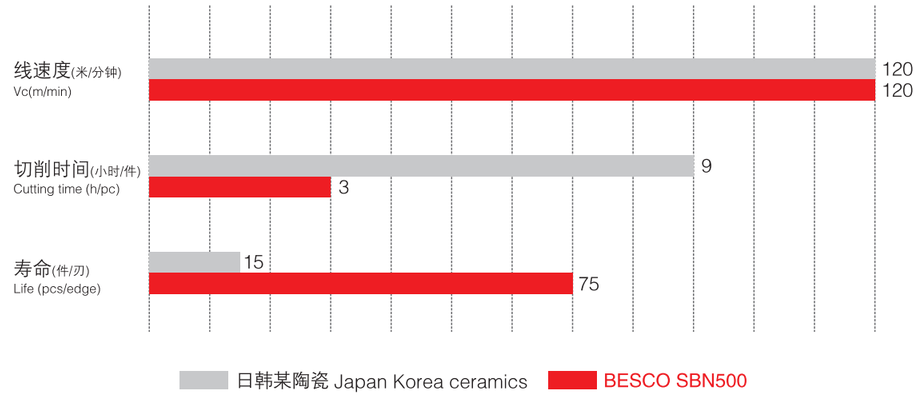
PCBN刀具应用领域
PCBN INSERTS APPLICATION

工件名称 Workpiece name	齿轮 Large gear	切　深 ap	ap=4mm
工件材质 Workpiece material	42CrMo	线 速 度 Vc	Vc=97m/min
工件硬度 Workpiece hardness	HRC45–55	进 给 量 F	f=0.7mm/r
加工类型 Machining type	重断续、粗加工 Heavy interrupted, rough machining	刀片材质 Inserts grade	SBN630
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	SNMN160816



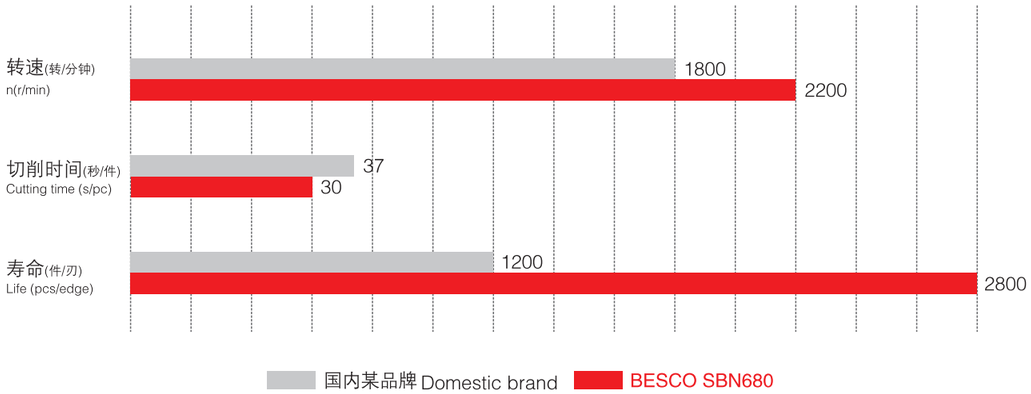
贝斯科CBN刀具寿命：耐用度提高7倍、效率提升90%。
CBN cutting life：The tool durability is increased by 7 times，The efficiency is promoted by 90%

工件名称 Workpiece name	轴承 Bearing	切　深 ap	ap=0.5mm
工件材质 Workpiece material	65Mn	线 速 度 Vc	Vc=120m/min
工件硬度 Workpiece hardness	HRC58–62	进 给 量 F	f=0.15mm/r
加工类型 Machining type	连续、精加工 Continuous, finishing	刀片材质 Inserts grade	SBN500
加工方式 Cutting type	湿式切削 Wet cutting	刀片型号 Inserts specification	RCGX090700Y



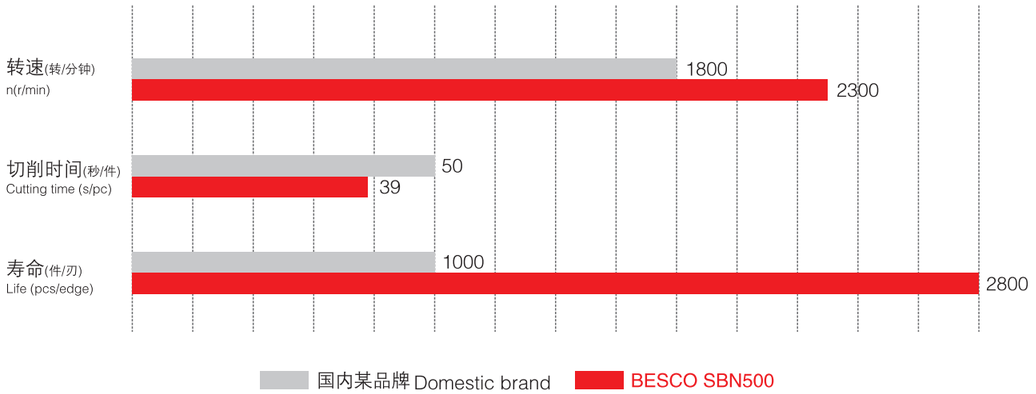
贝斯科CBN刀具寿命：耐用度提高4倍、效率提升67%。
CBN cutting life：The tool durability is increased by 4 times，The efficiency is promoted by 67%

工件名称 Workpiece name	气缸 Air cylinder	切　深 ap	ap=0.5–1.5mm
工件材质 Workpiece material	HT250	线 速 度 Vc	Vc=800m/min
工件硬度 Workpiece hardness	HB190–210	进 给 量 F	f= 0.4mm/r
加工类型 Machining type	粗加工 Rough machining	刀片材质 Inserts grade	SBN680
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	SNGN120412



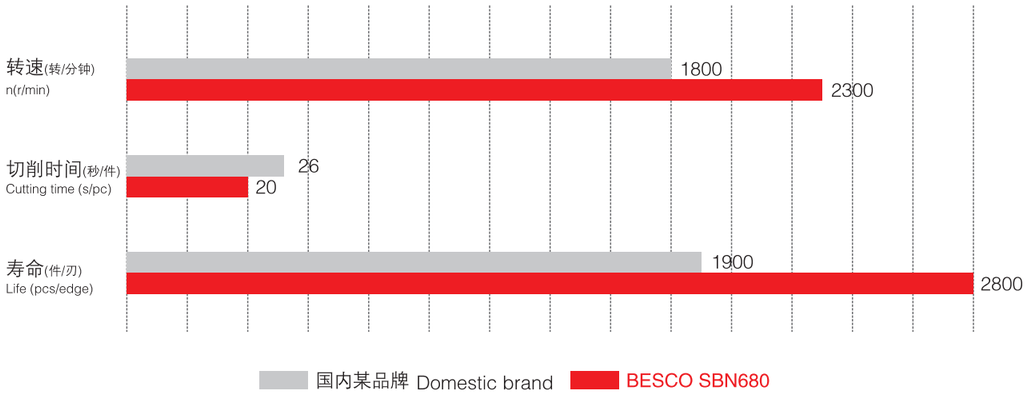
贝斯科CBN刀具寿命：耐用度提高1–2倍、效率提升20%。
CBN cutting life：The tool durability is increased by 1–2 times，The efficiency is promoted by 20%

工件名称 Workpiece name	上轴承 Upper bearing	切　深 ap	ap=0.3–0.5mm
工件材质 Workpiece material	HT250	线 速 度 Vc	Vc=450m/min
工件硬度 Workpiece hardness	HB190–210	进 给 量 F	f= 0.3mm/r
加工类型 Machining type	精加工 Finishing	刀片材质 Inserts grade	SBN500
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	WNGN080412



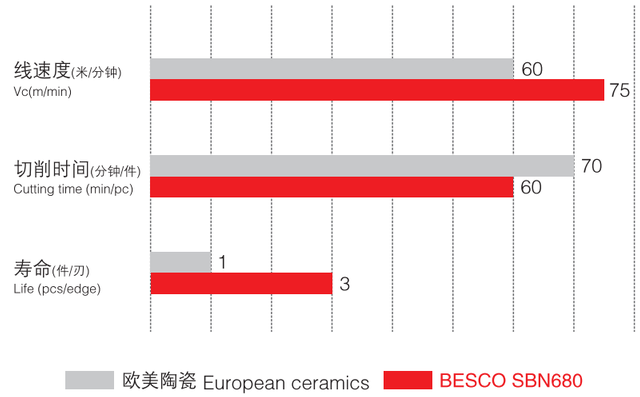
贝斯科CBN刀具寿命：耐用度提高2–3倍、效率提升20%。
CBN cutting life：The tool durability is increased by 2–3 times，The efficiency is promoted by 20%

工件名称 Workpiece name	下轴承 Lower bearing	切　深 ap	ap=0.8–1mm
工件材质 Workpiece material	HT250	线 速 度 Vc	Vc=510m/min
工件硬度 Workpiece hardness	HB190–210	进 给 量 F	f= 0.4mm/r
加工类型 Machining type	粗加工 Rough machining	刀片材质 Inserts grade	SBN680
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	WNGN080412

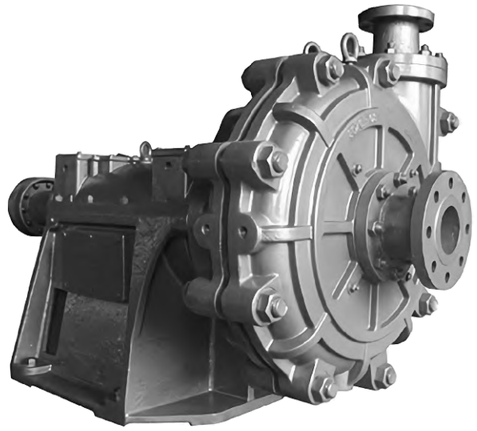


贝斯科CBN刀具寿命：耐用度提高47%、效率提升23%。
CBN cutting life：The tool durability is increased by 47%，The efficiency is promoted by 23%

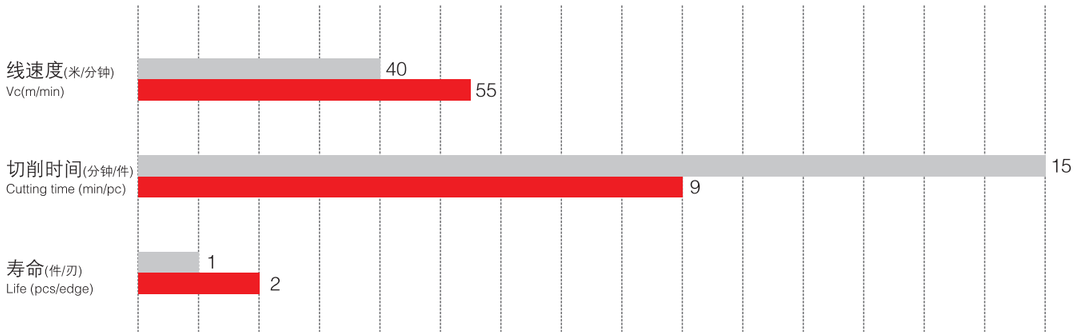
工件名称 Workpiece name	轧臼壁 Rolling mortar wall	切　深 ap	ap=6mm
工件材质 Workpiece material	高锰钢 High manganese steel	线 速 度 Vc	Vc=60m/min
工件硬度 Workpiece hardness	HB240	进 给 量 F	f= 0.4mm/r
加工类型 Machining type	连续、粗加工 Continuous, rough machining	刀片材质 Inserts grade	SBN680
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	SNMN160816



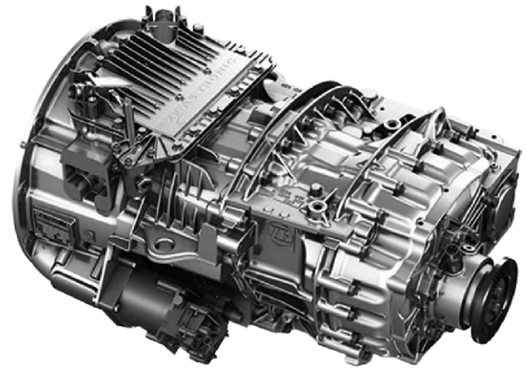
贝斯科CBN刀具寿命：耐用度提高2倍、效率提升14%。
CBN cutting life：The tool durability is increased by 2 times，The efficiency is promoted by 14%



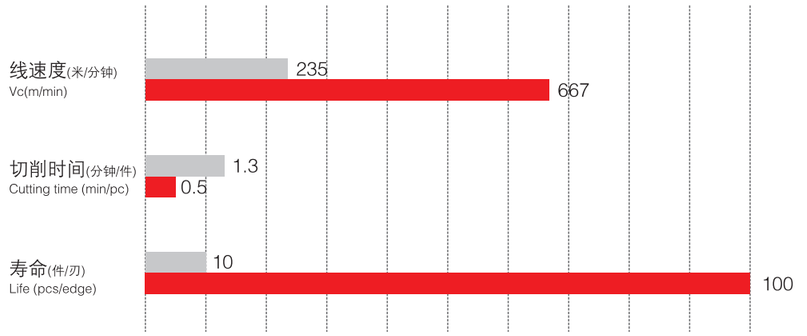
工件名称 Workpiece name	渣浆泵-叶轮 Impeller	切　深 ap	ap=2-3mm
工件材质 Workpiece material	耐磨白口铸铁 Wear resistant white cast iron	线 速 度 Vc	Vc=55m/min
工件硬度 Workpiece hardness	HRC50	进 给 量 F	f= 0.3mm/r
加工类型 Machining type	重断续、粗加工 Heavy interrupted, rough machining	刀片材质 Inserts grade	SBN680
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	SNGN120712



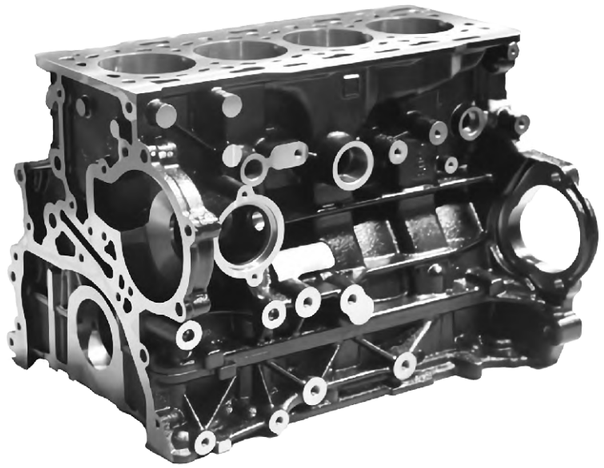
贝斯科CBN刀具寿命：耐用度提高1倍、效率提升40%。
CBN cutting life：The tool durability is increased by 1 times，The efficiency is promoted by 40%



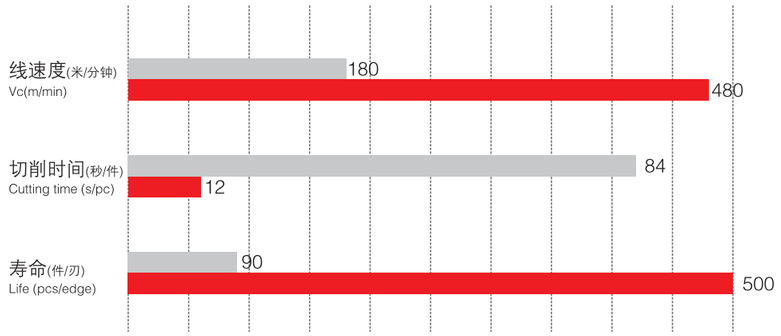
工件名称 Workpiece name	变速箱壳体-球墨铸铁 Gearbox shel-Ductile ironl	切　深 ap	ap=2~3mm
工件材质 Workpiece material	QT450	线 速 度 Vc	Vc=667m/min
工件硬度 Workpiece hardness	HB200~300	进 给 量 F	f=0.1mm/tooht
加工类型 Machining type	精加工 Finishing	刀片材质 Inserts grade	SBN500
加工方式 Cutting type	湿式切削 Wet cutting	刀片型号 Inserts specification	SNEN090412ENS



贝斯科CBN刀具寿命：耐用度提高9倍、效率提升62%。
CBN cutting life：The tool durability is increased by 9 times，The efficiency is promoted by 62%

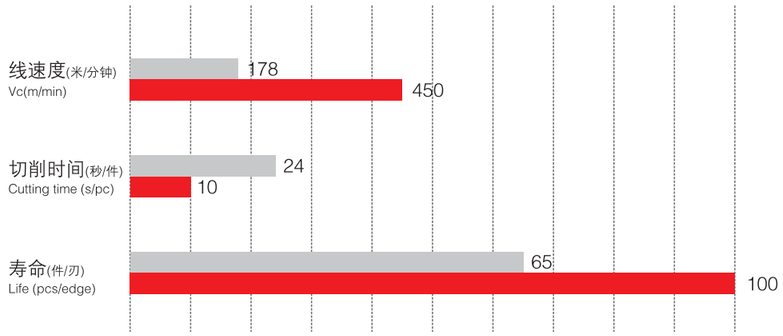


工件名称 Workpiece name	发动机缸体 Engine cylinder block	切　深 ap	ap=0.5mm
工件材质 Workpiece material	HT250	线 速 度 Vc	Vc=550~1100m/min
工件硬度 Workpiece hardness	HB200~300	进 给 量 F	f= 2000mm/min
加工类型 Machining type	断、精加工 Interrupted, finishing	刀片材质 Inserts grade	SBN500/2080
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	SNEN090412



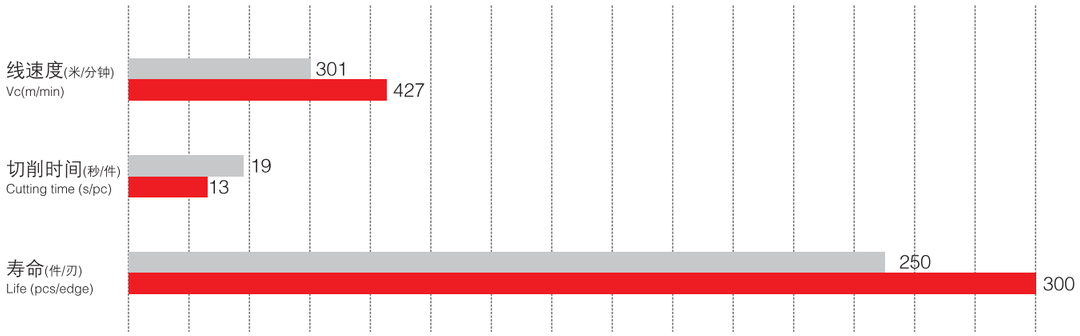
贝斯科CBN刀具寿命：耐用度提高4–5倍、效率提升86%。
CBN cutting life：The tool durability is increased by 4–5 times，The efficiency is promoted by 86%

工件名称 Workpiece name	飞轮 Flywheel	切　深 ap	ap=0.5mm
工件材质 Workpiece material	HT250	线 速 度 Vc	Vc=450m/min
工件硬度 Workpiece hardness	HB190	进 给 量 F	f=0.2–0.5mm/r
加工类型 Machining type	精加工 Finishing	刀片材质 Inserts grade	SBN500 / SBN2080
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	RCMX090700Y



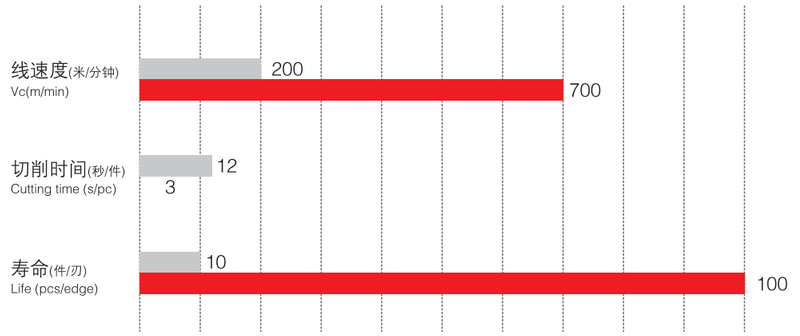
贝斯科CBN刀具寿命：耐用度提高1倍、效率提升54%。
CBN cutting life：The tool durability is increased by 1 times，The efficiency is promoted by 54%

工件名称 Workpiece name	皮带轮 Belt pulley	切　深 ap	ap=0.2mm
工件材质 Workpiece material	HT250	线 速 度 Vc	Vc=450~600m/min
工件硬度 Workpiece hardness	HB200~300	进 给 量 F	f=0.05mm/r
加工类型 Machining type	连续、精加工 Continuous, finishing	刀片材质 Inserts grade	SBN500 / SBN2080
加工方式 Cutting type	湿式切削 Wet cutting	刀片型号 Inserts specification	DNGA150408



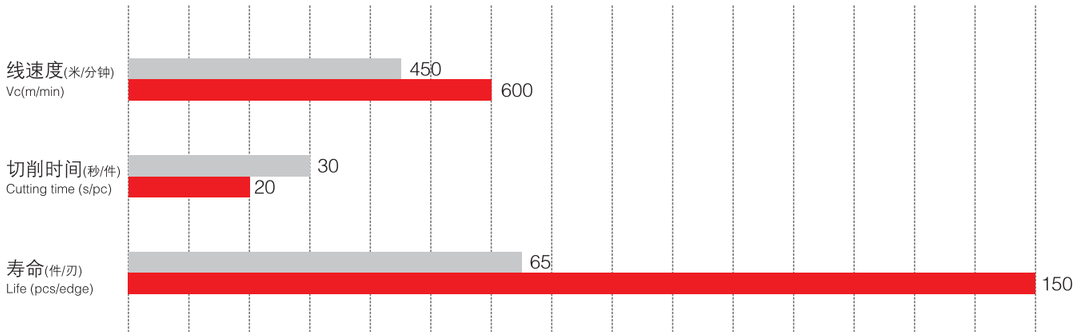
贝斯科CBN刀具寿命：耐用度提高20%、效率提升32%。
CBN cutting life：The tool durability is increased by 20%，The efficiency is promoted by 32%

工件名称 Workpiece name	制动鼓 Brake drum	切　深 ap	ap=2~3mm
工件材质 Workpiece material	HT200–300	线 速 度 Vc	Vc=450~800m/min
工件硬度 Workpiece hardness	HB200~300	进 给 量 F	f=0.2–0.8mm/r
加工类型 Machining type	连续、粗加工 Continuous, rough machining	刀片材质 Inserts grade	SBN680
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	CNGN120712/716



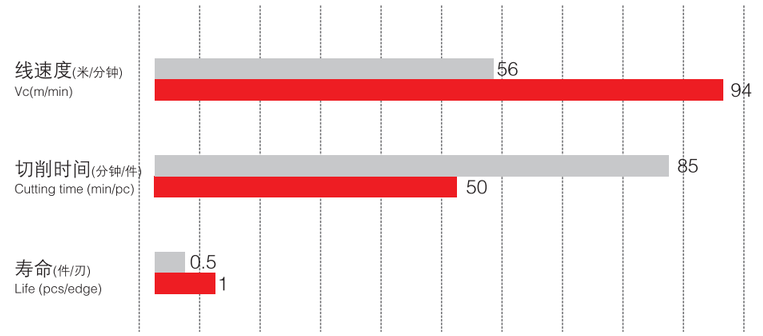
贝斯科CBN刀具寿命：耐用度提高9倍、效率提升75%。
CBN cutting life：The tool durability is increased by 9 times，The efficiency is promoted by 75%

工件名称 Workpiece name	制动盘 Brake disc	切　深 ap	ap=0.2~0.5mm
工件材质 Workpiece material	HT200-300	线 速 度 Vc	Vc=450~1100m/min
工件硬度 Workpiece hardness	HB200~300	进 给 量 F	f=0.15-0.3mm/r
加工类型 Machining type	连续、精加工 Continuous, finishing	刀片材质 Inserts grade	SBN500/SBN2080
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	SCGN090412/08-N



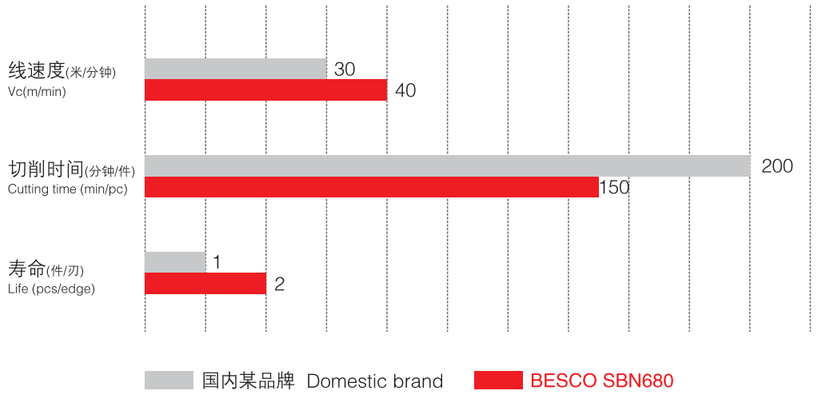
贝斯科CBN刀具寿命：耐用度提高2倍、效率提升30%。
CBN cutting life：The tool durability is increased by 2 times，The efficiency is promoted by 30%

工件名称 Workpiece name	H钢轧辊 H-shaped steel roll	切　深 ap	ap=6-10mm
工件材质 Workpiece material	高碳半钢 High carbon semi-steel	线 速 度 Vc	Vc=100m/min
工件硬度 Workpiece hardness	HSD55-65	进 给 量 F	f= 0.5-1mm/r
加工类型 Machining type	粗加工 Rough machining	刀片材质 Inserts grade	SBN680
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	RNMN2010



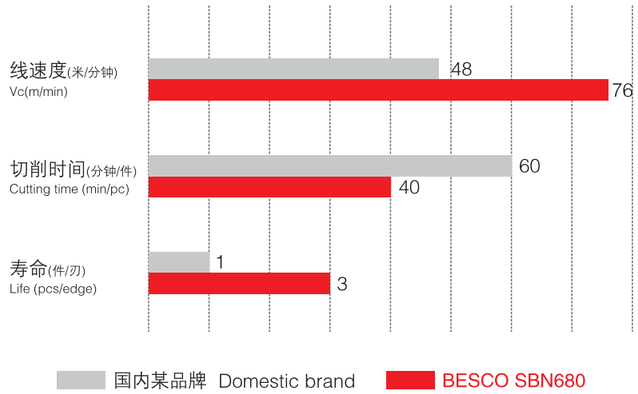
贝斯科CBN刀具寿命：耐用度提高1倍、效率提升40%。
CBN cutting life：The tool durability is increased by 1 times，The efficiency is promoted by 40%

工件名称 Workpiece name	板带轧辊 Strip roll	切　深 ap	ap=6–10mm
工件材质 Workpiece material	高NiCr High NiCr	线 速 度 Vc	Vc=40–60m/min
工件硬度 Workpiece hardness	HSD75–85	进 给 量 F	f= 0.5–1mm/r
加工类型 Machining type	粗加工 Rough machining	刀片材质 Inserts grade	SBN680
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	RNMN2010



贝斯科CBN刀具寿命：耐用度提高1倍、效率提升25%。
CBN cutting life：The tool durability is increased by 1 times，The efficiency is promoted by 25%

工件名称 Workpiece name	高速钢轧辊 High–speed steel rolls	切　深 ap	ap=2mm
工件材质 Workpiece material	高速钢 High speed steel	线 速 度 Vc	Vc=72m/min
工件硬度 Workpiece hardness	HSD80–85	进 给 量 F	f= 0.4mm/r
加工类型 Machining type	粗加工 Rough machining	刀片材质 Inserts grade	SBN680/SBN500
加工方式 Cutting type	干式切削 Dry cutting	刀片型号 Inserts specification	RCMX120700Y



贝斯科CBN刀具寿命：耐用度提高2倍、效率提升33%。
CBN cutting life：The tool durability is increased by 2 times，The efficiency is promoted by 33%