



P Steel	H Hardened Steel	M Stainless Steel	S HRSA's	K Cast Iron	N Non-Ferrous
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CBN TURN HIGH PERFORMANCE TURNING OF HEAT TREATED ALLOY

Korloy CBN turning inserts are specifically designed for cutting high hardness materials such as hardened steel HRc50-70 and hard HRSA's such as Inconel.

CBN inserts give an exceptional surface finish and can be used for continuous or intermittent cutting.

- **DNC250:** coated CBN grade for continuous or low intermittent cutting of hardened steel at high speeds (120-220m/min).
- **DBN250:** uncoated CBN grade for medium or intermittent cutting of hardened steel at low speeds (80-120m/min) & cast iron at high speeds.
- **DB7000:** uncoated CBN grade for high speed FINISH turning of HRSA's (100-300m/min).

1ST CHOICE FOR PERFORMANCE TURNING OF HARD METALS

COATED CBN



MULTI-EDGE
Non-Regrindable
Grade DNC250

UNCOATED CBN



SINGLE & MULTI-EDGE
Non-Regrindable
(regrindable on request)
Grades DBN250 & DB7000

MULTI-EDGE COATED CBN (DNC250) TURNING INSERTS

ISO	RAD	No. EDGES	ORDER CODE DNC250	PRICE	FEED fn (mm/rev)	DEPTH OF CUT ap (mm)
(2NU) CCGW060202	0.2	2	6-01-025092		0.05-0.3	0.05-0.3
(2NU) CCGW060204	0.4	2	6-01-025095			
(2NU) CCGW09T302	0.2	2	6-01-027380			
(2NU) CCGW09T304	0.4	2	6-01-015558			
(2NU) CCGW09T308	0.8	2	6-01-016407			
(2NU) CNGA120404	0.4	2	6-01-015554			
(2NU) CNGA120408	0.8	2	6-01-015555			
(2NU) CNGA120412	1.2	2	6-01-023763			
(2NU) DCGW070202	0.2	2	6-01-030792			
(2NU) DCGW070204	0.4	2	6-01-028123			
(2NU) DCGW070208	0.8	2	6-01-028129			
(2NU) DCGW11T302	0.2	2	6-01-029051			
(2NU) DCGW11T304	0.4	2	6-01-015559			
(2NU) DCGW11T308	0.8	2	6-01-015876			
(2NU) DNGA150404	0.4	2	6-01-015566			
(2NU) DNGA150408	0.8	2	6-01-015567			
(2NU) DNGA150412	1.2	2	6-01-017080			
(2NU) DNGA150604	0.4	2	6-01-026918			
(2NU) DNGA150608	0.8	2	6-01-026919			
(3NU) TNGA160404	0.4	3	6-01-015568			
(3NU) TNGA160408	0.8	3	6-01-015561			
(3NU) TNGA160412	1.2	3	6-01-023771			
(2NU) VBGW160404	0.4	2	6-01-016371			
(2NU) VBGW160408	0.8	2	6-01-023769			
(2NU) VCGW160404	0.4	2	6-01-015923			
(2NU) VCGW160408	0.8	2	6-01-015563			
(2NU) VNGA160404	0.4	2	6-01-015569			
(2NU) VNGA160408	0.8	2	6-01-015626			

UNCOATED CBN (DBN250) TURNING INSERTS

ISO	RAD	No. EDGES	ORDER CODE DBN250	PRICE	FEED fn (mm/rev)	DEPTH OF CUT ap (mm)
(2NU) CCGW09T304	0.4	2	6-01-014224		0.05-0.2	0.05-0.3
(2NU) CCGW09T308	0.8	2	6-01-009955			
(NU) CNGA120404	0.4	1	6-01-021536			
(NU) CNGA120408	0.8	1	6-01-014784			
(NU) CNGA120412	1.2	1	6-01-021544			
(2NU) DCGW11T302	0.2	2	6-01-017201			
(2NU) DCGW11T304	0.4	2	6-01-013837			
(2NU) DCGW11T308	0.8	2	6-01-020655			
(2NU) DNGA150404	0.4	2	6-01-006278			
(2NU) DNGA150408	0.8	2	6-01-014275			
(NU) TNGA160404	0.4	1	6-01-021586			
(NU) TNGA160408	0.8	1	6-01-004965			
(NU) TNGA160412	1.2	1	6-01-021588			
(2NU) VBGW160404 DBN250	0.4	2	6-01-021593			
(2NU) VBGW160408 DBN250	0.8	2	6-01-021594			
(2NU) VNGA160404 DBN250	0.4	2	6-01-005999			
(2NU) VNGA160408 DBN250	0.8	2	6-01-010671			

UNCOATED CBN (DB7000) TURNING INSERTS

ISO	RAD	No. EDGES	ORDER CODE DB7000	PRICE	FEED fn (mm/rev)	DEPTH OF CUT ap (mm)
(2NU) CCGW060204	0.4	2	6-01-042822		0.05-0.2	0.1-1.0
(2NU) CCGW09T304	0.4	2	6-01-045412			
(2NU) CCGW09T308	0.8	2	6-01-045413			
(NU) CNGA120404	0.4	1	6-01-045416			
(NU) CNGA120408	0.8	1	6-01-045417			
(NU) CNGA120412	1.2	1	6-01-045419			
(2NU) DCGW11T302	0.2	2	6-01-042635			
(2NU) DCGW11T304	0.4	2	6-01-036570			
(2NU) DCGW11T308	0.8	2	6-01-038614			
(2NU) DNGA150404	0.4	2	6-01-045423			
(2NU) DNGA150408	0.8	2	6-01-036457			
(3NU) TNGA160404	0.4	3	6-01-045998			
(3NU) TNGA160408	0.8	3	6-01-046126			
(3NU) TNGA160412	1.2	3	6-01-045999			

RECOMMENDED CUTTING CONDITIONS

Material Group	DNC250 (m/min)	DBN250 (m/min)	DB7000 (m/min)
High Hardened Steel	120-220	70-130	-
HRSA's	-	-	100-300