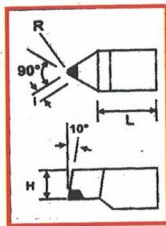
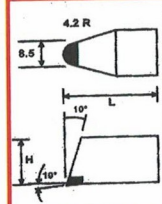


External Machining Tools

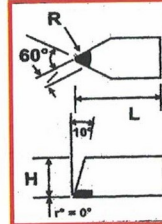
Square External Machining Tool



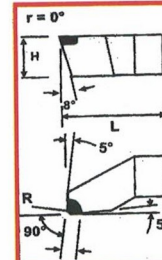
Round Nose Tool



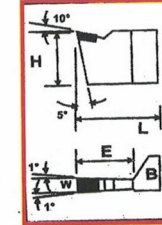
External Grooving



External RH-LH

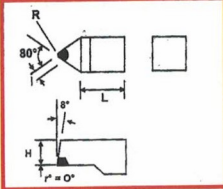


Parting & Grooving

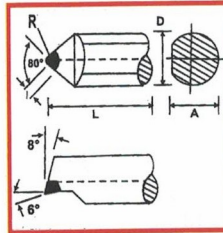


Internal Machining Tools

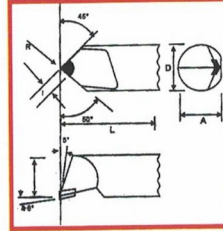
Square Boring Tool



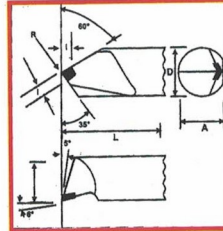
Round Boring Tool



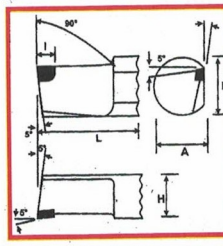
LH Round Boring Tool



Type 2 LH Round Boring Tool



Type 3 LH Round Boring Tool



PCD General Machining Parameters

Material	Grade	Operation	Speed mm/min	Feed mm/rev	DOC mm
Aluminium	RM10	Turning	427	0.64	0.51
	RC30X	Milling	434	2.54	0.76
	RM10	Boring	232	0.10	0.25
	RC30X	Grooving	198	0.13	3.81
Bronze Alloy	RM10	Turning	198	0.08	0.25
		Boring	189	0.05	0.18
Copper Alloy	RM10	Turning	149	0.05	1.27
	RM10	Boring	479	0.08	1.52
		Grooving	159	0.13	0.38
Rubber	RM10	Boring	668	0.18	0.64
Fibreglass	RM10	Drilling	125	0.08	0.08
Plastic	RM05	Turning	425	0.10	0.64
	RM05	Facing	747	0.25	0.13
Tungsten	RC30X	Turning	18	0.10	3.05

CBN General Machining Parameters

Material	Grade	Operation	Speed mm/min	Feed mm/rev	DOC mm
Super alloys	RN90	Turning	189	0.13	2.29
	RN90	Facing	129	0.13	1.27
Hardened Tool Steels	RN90	Turning	93	0.13	2.54
	RN50	Boring	67	0.13	0.15
Hardened Alloy Steel	RN50	Boring	98	0.10	0.18
	RN50	Grooving	104	0.13	0.28
	RN50	Milling	91	0.20	0.10
	RN50	Turning	107	0.23	0.08
Stainless Steels	RN90	Grooving	111	0.06	0.18
	RN90	Facing	107	0.03	0.13
Grey Cast Irons	RN100	Facing	488	0.25	2.79
	RN100	Turning	488	0.48	2.03
	RN100	Boring	67	0.25	2.29
Ni-Hard	RN90	Turning	101	0.23	1.91
	RN90	Facing	67	0.25	2.79
	RN90	Boring	67	0.38	2.19