

OF CASE HARDENED STEELS

Secomax Polycrystalline Cubic Boron Nitride inserts are highly wear-resistant and have the capability to maintain a consistent cutting edge while providing long tool life — two issues that can determine the ultimate productivity of any machining operation.

With the introduction of the new Secomax grade CBN050C, Seco extends your productivity in finishing of case-hardened steels between 45-65 Rc.

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SECO

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SECOMAX™ CBN050C
EXTENDS YOUR PRODUCTIVITY.

SECO

HIGH PRODUCTIVITY MACHINING WITH SECOMAX™ CBN050C.

CBN050C, 25% INCREASE IN SPEED CAPABILITY

To address the need for higher cutting speeds and improved tool life, SECO introduce CBN050C to meet the new standard of high productivity machining.

The combination of a new low cBN content substrate and a new PVD coating allows for machining in the range of 200 to 250 m/min.

When PCBN for finishing of hard steels was introduced to the market in the mid 1980's, conventional turning was made at relatively low cutting speed, typically 120-130 m/min. Through years of material and process development new standards, PCBN grades and methods such as plunging and wiper technology, have dramatically improved productivity for these applications.

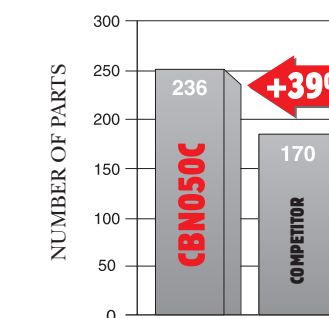
Today, the design of CBN050C inserts raises the bar by providing long and predictable tool life in high speed, high productivity machining applications.

CBN050C MULTIPLE FORMAT CHOICE

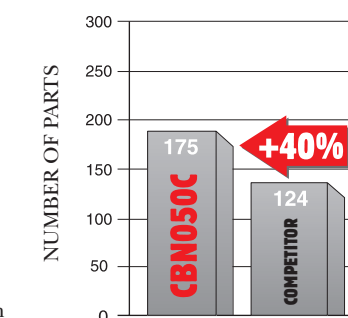
The new CBN050C has the widest range of format available on the market today.

With CBN050C offered in solid, full-face or brazed multi-corner and single tip shape there is a format to suit all hard finish machining techniques, operations and tooling.

Solid and multi-corner format has each edge marked with an identifying number, also round inserts, solid or full-faced, has the available cutting edges clearly marked.



GEARSHAFT
16MnCr5
HRc 58 ±4
Cutting Speed: 190 m/min
Feed rate: 0,30 mm/r
Depth of cut: 0,15/0,35 mm

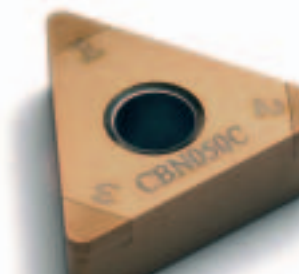
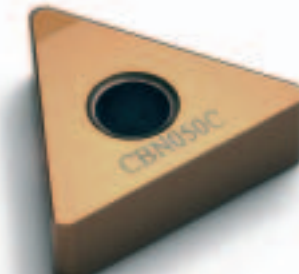
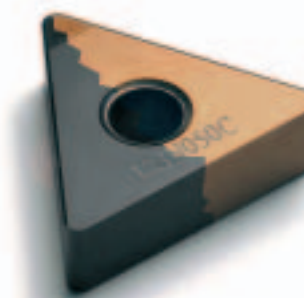


SOCKET (D=50 mm)
100Cr6
HRc 63 ±2
Cutting speed: 220 m/min
Feed rate: 0,11/0,15 mm/r
Depth of cut: 0,30 mm

COATED PCBN VISIBLY IMPROVES TOOL LIFE

The coated CBN050C (patent pending) brings a new level of performance to coated PCBN products used for finishing operations in hardened steel.

The lifetime of a CBN050C cutting tool is increased many times due to the much higher hardness, in combination with optimised pre-treatments and deposition conditions, of the unique (Ti, Si)N coating compared to traditional (Ti, Al)N coatings. In addition to the performance benefits of the (Ti,Si)N coating, the copper colour provides clear detection of worn edges to the operator. Both contribute to the reliability and confidence in cutting tool performance.



WIPER INSERTS, MAINTAIN SURFACE FINISH WITH INCREASED FEEDS

The use of a wiper geometry in combination with the high speed capability of the new CBN050C inserts is the final engineered design that permits true high productivity machining.

SECO wiper inserts combine the advantages of high feed/high quality surface finishes of round inserts with low cutting forces and flexibility in geometries.

The result is the ability to increase feed rates with no sacrifice to surface finish.