### INITIAL PRODUCT RANGE

**Turning CBN Inserts**

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**Turning CBN Solid Inserts**

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**Other Geometries are available as special request.**

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**CBN HARD TURNING**
NEW CBN LINE

Lamina Technologies is proud to launch our new CBN line.

Cubic Boron Nitride, CBN, is the second hardest known material after diamond and combined with its chemical inertness towards iron it is very suitable for high speed machining of hard materials.

60% CBN

90% CBN

APPLICATION

- Finishing of hardened steels up to 68 HRC and super alloys
- Roughing and finishing of cast iron

CBN BENEFITS

Longer tool life
Compared with Carbide and Ceramics inserts, the CBN provides more tool life.

Higher cutting speeds
Due to the microstructure and higher hardness of the CBN, the applicable cutting speed for hardened materials (68 HRC) is up to 250 m/min.

Excellent surface finishing
Due to the peripheral grinding and the edge preparation profile, the insert will give a better surface finish.

Dimensions stability
Due to the high thermal conductivity of CBN, the heat generated goes into the chips and not to the part. As a result the machined part has better dimensional stability.

DESIGNATION CODE

CNGA 120408 T 4 - 012 15 LT CBN55H

ISO Description 1 2 3 4 5


E - Honing S - Chamfer and Honing

Ex: 0.12 Ex: 15° Ex: 25° Ex: 35°

% of CBN Crystals

WEAR RESISTANCE

LT CBN55H

- Continuous Cutting
- Hardened steel: 45 up to 68 HRC

LT CBN70H

- Interrupted Cutting
- Hardened steel: 45 up to 68 HRC

LT CBN90K

- Continuous Cutting
- Cast Iron with higher cutting speed, up to 1200 m/min.
- High density CBN