



SOLID CBN: RECOMMENDED OPERATION REQUIREMENTS

MATERIAL	STINGRAY CBN GRADE 1 ST CHOICE	CBN PERCENTAGE	Vc(mm/min.)	f(mm/r)	Ap(mm)	STINGRAY CBN GRADE 2 ND CHOICE
MACHINING GRAY CAST IRON	BNS11	86-93%	400-1500mm	0.3-0.6	2.0-5.0	BNS25
HARDENED STEEL / CHILLED CAST IRON	BNS25	85-90%	400-1500mm	0.2-0.35	1.5-2.5	BNS11
DIE STEEL	BNS30	50-70%	200-300mm	0.03-0.15	0.1-0.5	BNS60
ALLOYED CAST IRON / STEEL	BNS50	90-95%	400-1500mm	0.35-0.5	1.5-3.5	BNS60
HARDENED STEEL / BEARING STEEL	BNS60	85-90%	80-200	0.25-0.35	1.0-2.0	-
HIGH TEMPERATURE ALLOY	BNS60	85-90%	80-140	0.1-0.2	0.5-1.0	BNS30
POWDERED METALS	BNS60	85-90%	150-300	0.2-0.35	1.0-2.5	BNS50

PCBN: RECOMMENDED OPERATION REQUIREMENTS

MATERIAL	STINGRAY PCBN GRADE 1 ST CHOICE	CBN PERCENTAGE	Vc(mm/min.)	f(mm/r)	Ap(mm)
HARDENED STEEL / BEARING STEEL	BNC601	55-65%	80-240mm	0.15-0.25	0.5-1.0
CERAMIC PRODUCTS	BNC901	85-90%			
GRAY CAST IRON / POWDERED METAL	BNC951	90-95%	400-1500mm	0.2-0.35	1.5-2.5
HARDENED STEEL / CHILLED CAST IRON	BNC952	90-95%	70-150mm	0.1-0.2	0.1-0.2