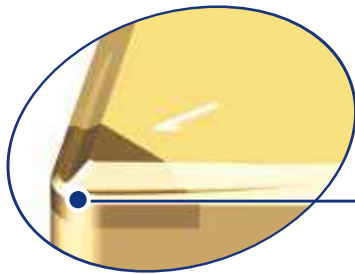


“Hard Breakers” for removing the carburized layer from case hardened shafts.

*Two types of chipbreaker provide excellent chip control in a wide application range !*

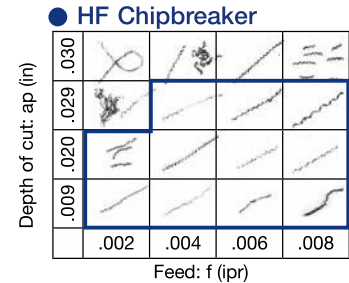
**HF** type **For finishing**



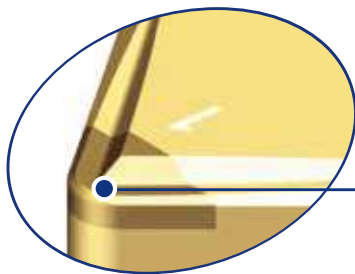
Single sided CBN insert provides higher stability in heavy machining.

Excellent chip control in small D.O.C due to the high functional nose. Delivers exceptional surface finishes.

Example of chips



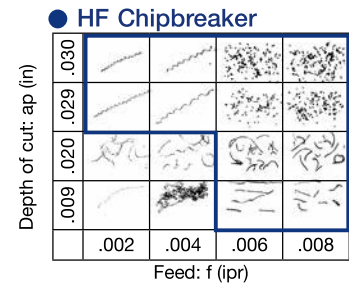
**HM** type **For medium cutting**



Single sided CBN insert provides higher stability in heavy machining.

Providing ideal chip control in large D.O.C due to the well designed chipbreaker. Suitable for medium cutting or roughing.

Example of chips



Standard cutting condition (for removing the carburized layer)

Application	Grades	Machining Mode	Cutting Speed Vc (SFM)	Depth of cut ap(in)	Feed f(ipr)
	BXM20	HF	230 - 720	.008 - .030	.002 - .008
		HM	230 - 720	.020 - .039	.002 - .008