

Application Guidelines

American Superabrasives Corp.

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PCBN

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Workpiece Material		Speed (m/min)	Feed rate (mm/rev)	DOC (mm)	Recommended Grade						
					SB100	SB95	SB90	SB80	SB70	SB60	SB50
Soft cast iron	Grey cast iron	200-1000	0.1-0.5	0.2-1.0	1	1	2				
	Alloyed cast iron	200-800	0.1-0.5	0.2-1.0	1	1	2				
Hard cast iron	White/Chill cast iron	100-350	0.1-0.4	0.1-0.5	1	1	2				
	NiCr cast iron, Ni-hard	100-350	0.1-0.4	0.1-0.5	1	1	2				
H a r d e e n l e s d	Tool steel	100-160	0.02-0.2	0.1-0.5				2	1	1	2
		120-200	0.02-0.2	0.1-0.3				1	2	2	1
	High speed steel	80-160	0.02-0.2	0.1-0.5				2	1	1	2
		100-180	0.02-0.2	0.1-0.3				1	2	2	1
	Bearing steels	100-180	0.02-0.2	0.1-0.5				2	1	1	2
		120-200	0.02-0.2	0.1-0.3				1	2	2	1
P M w e t d d a e l r s	Heat resistant sintered steel	80-200	0.03-0.2	0.1-1.0	2	2	1	2			
	Ferrous Sintered parts	100-220	0.03-0.2	0.1-1.0	2	2	1	2			
Superalloys	Co based	80-100	0.05-0.2	0.1-1.0		2	2	1			
	Ni based	120-150	0.05-0.2	0.1-1.0		2	2	1			
Cemented carbide	Tungsten carbide	20-40	0.1-0.25	0.1-1.5		2	1	2			

1 1st Choice

2 2nd Choice