

PCD & PCBN New Grades

The best solutions for machining Non-ferrous and Hardened materials

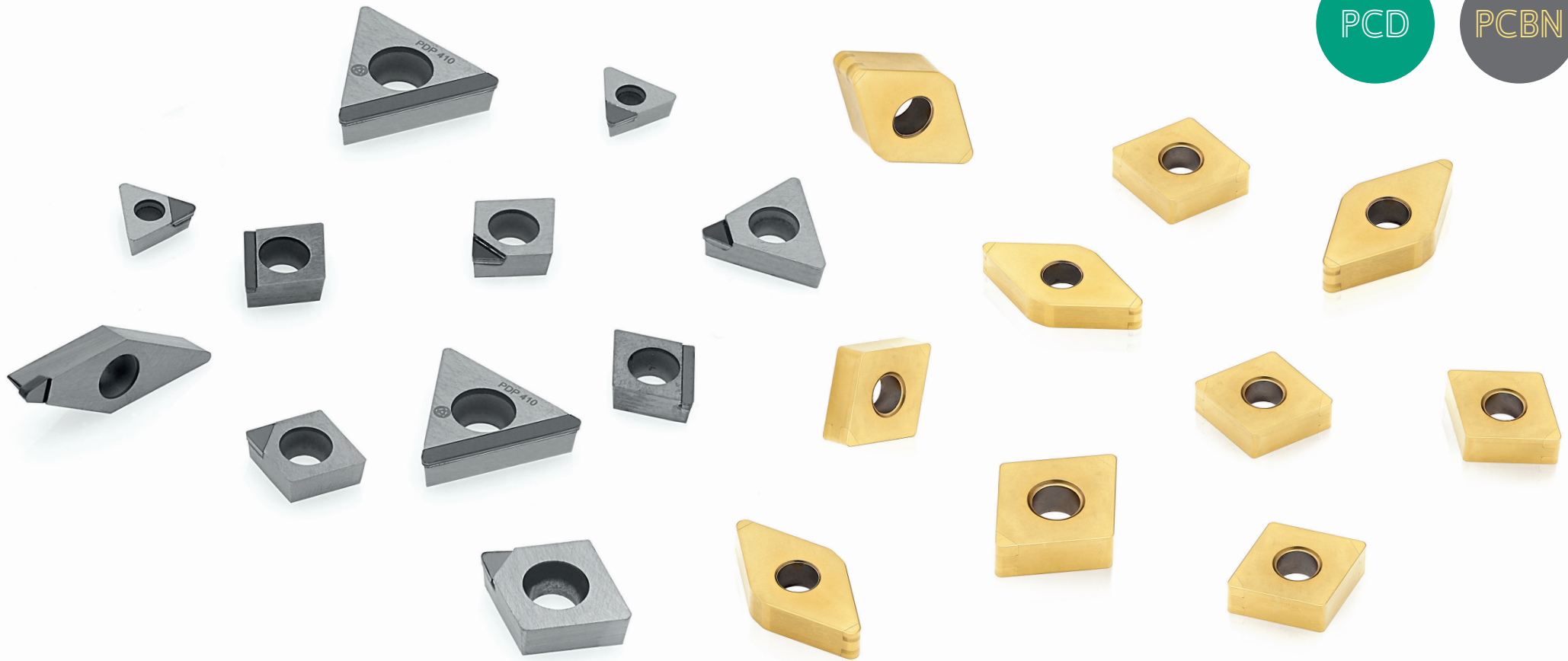


PCD & PCBN

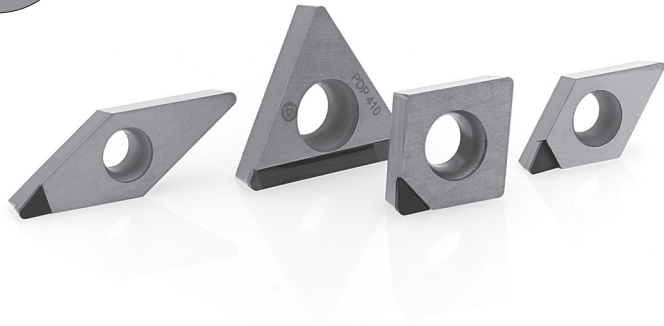
NEW

PCD

PCBN

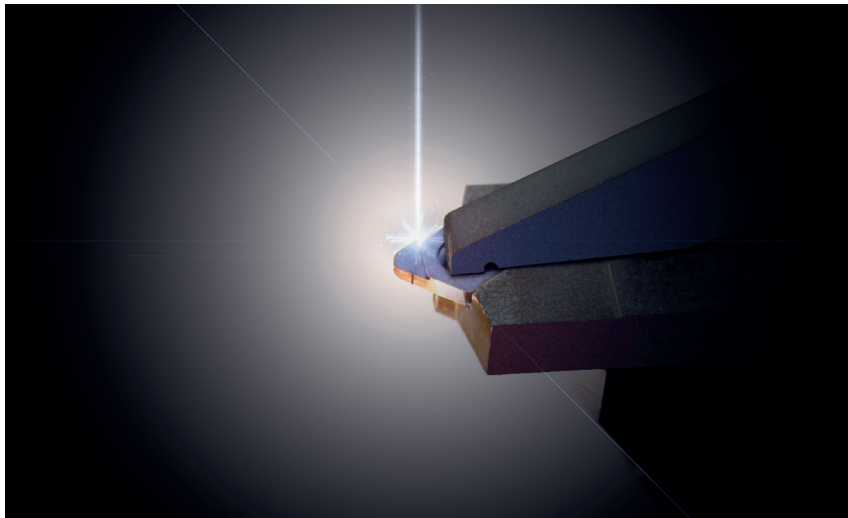


Higher performance achieved by laser machining



LASER MACHINING TECHNOLOGY

- **High cutting edge quality**
- **Customized chip-breaker according to our customers' needs**



PDP403
 >14% silicon
 aluminium
 alloy

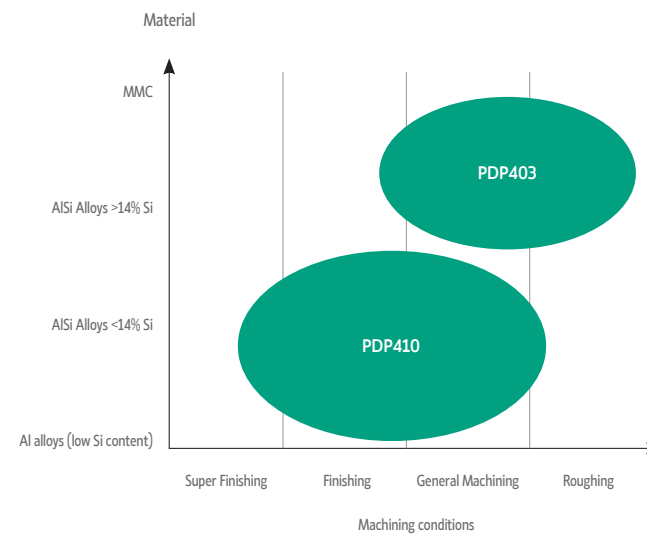
**Machining of Al/Si alloys
 with high Si content
 (Si ≥ 12%)**

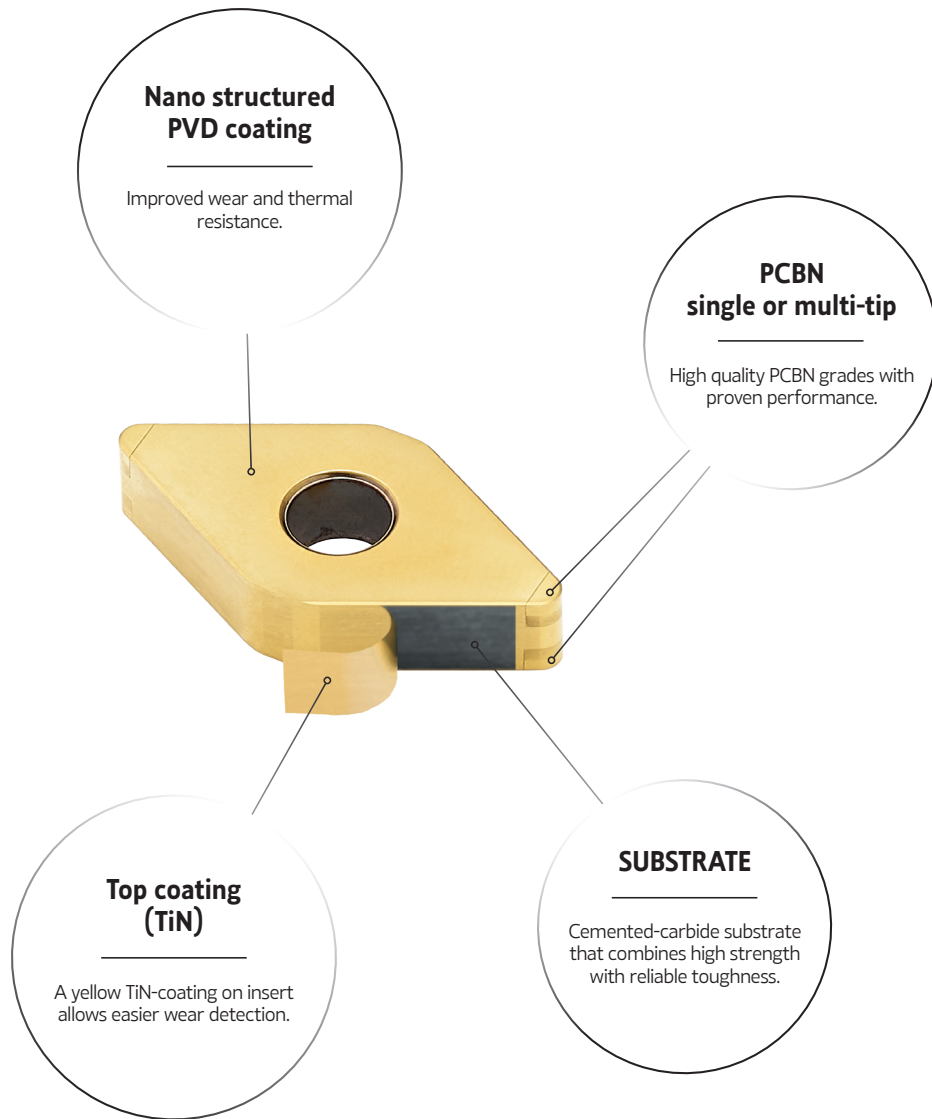
Excellent abrasion resistance
 and good thermal stability.

PDP410
 <14% silicon
 aluminium
 alloy

**Used in 90% of all
 applications in
 non-ferrous materials.
 Ideal for aluminium alloys
 (Si ≤ 12%), graphite and
 graphite composites**

Extreme edge
 sharpness/retention
 achieving a
 fine surface finishing.





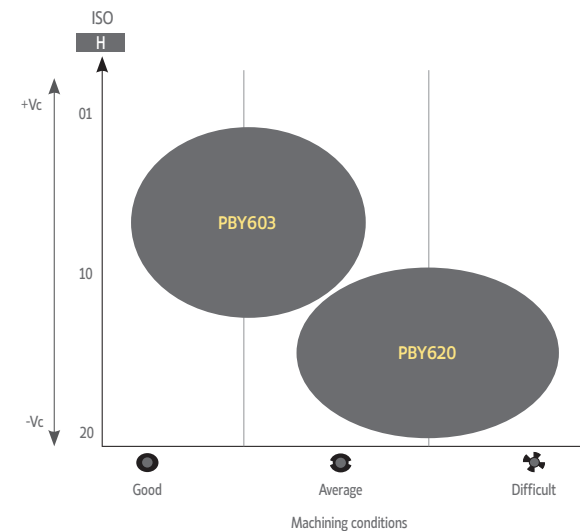
Machining of hardened materials in high continuous cut up to 180m/min cutting speed.

Can be used on high resistance alloys.
(New PVD coating for PCBN inserts with improved wear resistance.)



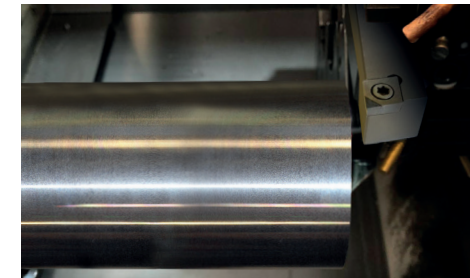
Machining of hardened materials in light to heavy interrupted cuts.

Enhanced crater and flank wear resistance with an excellent balance of toughness.





<p>Toolholder SCAC L 1616 H09</p> <p>Insert CCGT 09T308 Z1 (ISO) CCGT 32.25 Z1 (ANSI)</p> <p>Grade PDP410</p> <p>87% tool life improvement</p> <p>Machining pieces 316 (pieces)</p> <p>palbit TOOLING SOLUTIONS EXPERTS</p>	<p>Toolholder Competitor Equivalent product</p> <p>Insert Competitor Equivalent product</p> <p>Grade Competitor Equivalent product</p> <p>Machining pieces 169 (pieces)</p> <p>COMPETITOR</p>
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Workpiece material: Aw2007-T4 (95HBS)

Cutting speed: Vc	800 m/min	2 624 sfm
Feed per rev: fn	0,15 rev/r	0.15 rev/r
Depth of cut: ap	0,35 mm	0.014 in
Operation	External turning	
Coolant	Emulsion	



<p>Toolholder DCLN L 2525 M12</p> <p>Insert CNGA 120408-S2515 Z4 (ISO) CNGA 432-S2513 Z4 (ANSI)</p> <p>Grade PBY603</p> <p>54% tool life improvement</p> <p>Machining pieces 43 (pieces)</p> <p>palbit TOOLING SOLUTIONS EXPERTS</p>	<p>Toolholder Competitor Equivalent product</p> <p>Insert Competitor Equivalent product</p> <p>Grade Competitor Equivalent product</p> <p>Machining pieces 28 (pieces)</p> <p>COMPETITOR</p>
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Workpiece material: 34CrNiMo4 (60HRC)

Cutting speed: Vc	100 m/min	328 sfm
Feed per rev: fn	0,12 rev/r	0.12 rev/r
Depth of cut: ap	0,2 mm	0.008 in
Operation	External turning	
Coolant	Dry	