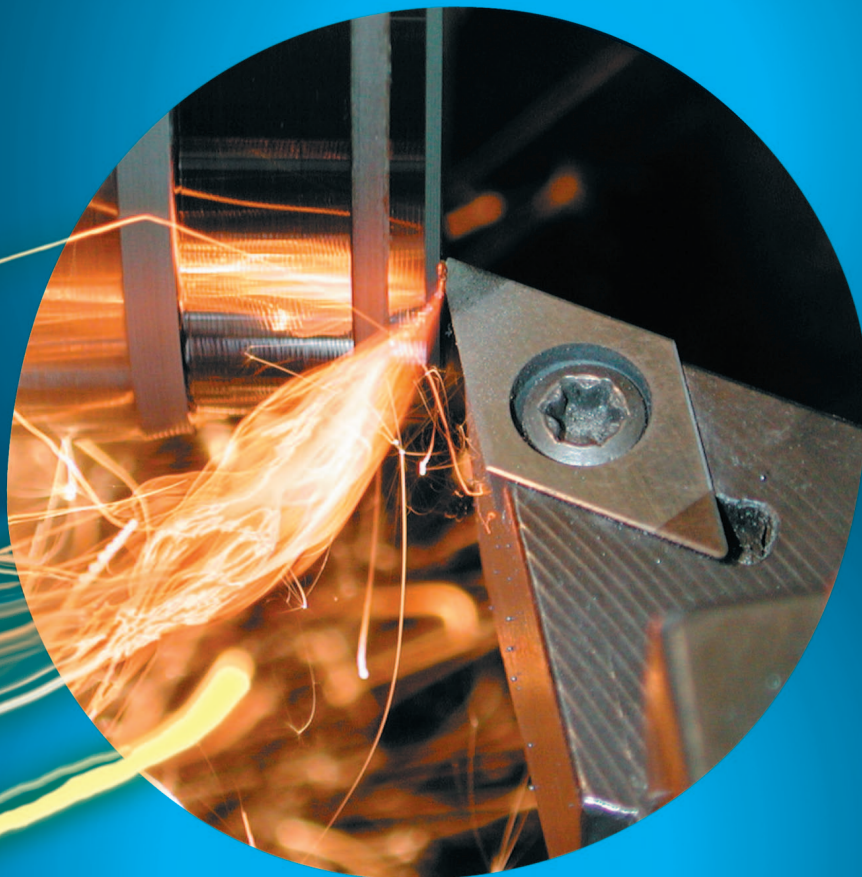


LACH DIAMANT[®]

»CBN-DUO-power«

***for the finishing of hardened steels
and cast iron***



**Power-CBN for maximum efficiency
...now also with »chipbreaker« !**

» CBN-DU

CBN insert

» CBN-power« grade B610

for tool and case-hardened steels, components such as universal joint-shafts, valves and similar

Recommended cutting values:

interrupted cut $v_c =$ up to 230 m/min
 continuous cut $v_c =$ up to 300 m/min
 $f_n =$ up to 0,4 mm/R
 $a_p =$ up to 0,8 mm

» CBN-power« grade B600

for high alloy, quenched and tempered and hardened steels

Recommended cutting values:

interrupted cut $v_c =$ up to 140 m/min
 continuous cut $v_c =$ up to 220 m/min
 $f_n =$ up to 0,4 mm/R
 $a_p =$ up to 0,8 mm

With cast iron: components such as gear boxes, rollings and similar $v_c =$ up to 900 m/min

Type	Ordering description	CBN grade	Art No.	Net price/pc.
negative CBN-DUO inserts				
	CNMA 120404S-DUO	B610	43220050	47,50 €
		B600	43211008	47,50 €
	CNMA 120408S-DUO	B610	43220051	47,50 €
		B600	43210969	47,50 €
	DNMA 150604S-DUO	B610	43220061	47,50 €
		B600	43220130	47,50 €
	DNMA 150608S-DUO	B610	43220062	47,50 €
		B600	43220131	47,50 €
positive CBN-DUO inserts				
	CCMW 09T304S-DUO	B610	43220083	47,50 €
		B600	43220132	47,50 €
	CCMW 09T308S-DUO	B610	43220085	47,50 €
		B600	43220133	47,50 €
	DCMW 11T304S-DUO	B610	43220059	47,50 €
		B600	43220134	47,50 €
	DCMW 11T308S-DUO	B610	43220060	47,50 €
		B600	43220135	47,50 €
	VBMW 160404S-DUO	B610	43220057	47,50 €
		B600	43220136	47,50 €
	VBMW 160408S-DUO	B610	43220058	47,50 €
		B600	43220137	47,50 €

O-power



CBN insert with »chipbreaker« type CO*

*European Patent EP1 023 961

»CBN-power« grade B610

for tool and case-hardened steels for cuts free of burrs of thin and especially unstable elements – also with different hardness

Recommended cutting values:

interrupted cut $v_c =$ up to 180 m/min
continuous cut $v_c =$ up to 240 m/min
 $f_n =$ up to 0,2 mm/R
 $a_p =$ up to 0,5 mm

»CBN-power« grade B600




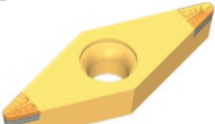
for high alloy, quenched and tempered and hardened steels – especially medium hardness – for cuts free of burrs

Recommended cutting values:

interrupted cut $v_c =$ up to 80 m/min
continuous cut $v_c =$ up to 140 m/min
 $f_n =$ up to 0,2 mm/R
 $a_p =$ up to 0,5 mm

With cast iron: components such as gear boxes, rollings and similar

$v_c =$ up to 900 m/min
 $f_n =$ up to 0,5 mm/R
 $a_p =$ up to 1,0 mm

Type	Ordering description	CBN grade	Art No.	Net price/pc.
negative CBN-DUO inserts				
 CNMM	CNMM 120404S-DUO-CO	B610	43220300	78,50 €
		B600	43220310	78,50 €
	CNMM 120408S-DUO-CO	B610	43220320	78,50 €
		B600	43220330	78,50 €
 DNMM	DNMM 150604S-DUO-CO	B610	43220340	78,50 €
		B600	43220350	78,50 €
	DNMM 150608S-DUO-CO	B610	43220360	78,50 €
		B600	43220370	78,50 €
positive CBN-DUO inserts				
 CCMT	CCMT 09T304S-DUO-CO	B610	43220380	78,50 €
		B600	43220390	78,50 €
	CCMT 09T308S-DUO-CO	B610	43220400	78,50 €
		B600	43220410	78,50 €
 DCMT	DCMT 11T304S-DUO-CO	B610	43220420	78,50 €
		B600	43220430	78,50 €
	DCMT 11T308S-DUO-CO	B610	43220440	78,50 €
		B600	43220450	78,50 €
 VBMT	VBMT 160404S-DUO-CO	B610	43220460	78,50 €
		B600	43220470	78,50 €
	VBMT 160408S-DUO-CO	B610	43220480	78,50 €
		B600	43220490	78,50 €

»CBN-DUO-power«

CBN inserts with »chipbreaker«* – another innovation of LACH DIAMANT

*European Patent EP1 023 961

With the development of the »chipbreaker« for the turning of hardened steels and cast iron, entirely new possibilities were opened up. This began at LACH DIAMANT already 10 years ago and led to several patents.

The question „turning or grinding?“ has now another option which goes in favour of CBN turning.

With this development LACH DIAMANT draws from 35 years of experience in the manufacturing and application of polycrystalline synthetic cutting materials diamond (PCD) and CBN (PCBN). This started with their availability of PCD in 1973 respectively 1974 for CBN.

LACH DIAMANT employs 150 people with plants in Hanau and Lichtenau near Chemnitz in Germany as well as in Grand Rapids, Michigan, USA and is considered a pioneer in this type of industry.

Even the grinding and spark erosion processing of polycrystalline materials had its origin in the „think tank“ of LACH DIAMANT, as proven by the universal grinding machines according to the original spark erosion process by LACH DIAMANT.

Today in the year 2008 LACH DIAMANT has its rightful place in the group of system providers for turning, milling and drilling.

Challenge us! We would like to be of service and advise you!



Headquarter Hanau/Frankfurt/M.



Plant Lichtenau/Chemnitz/Sachsen



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**LACH
Diamant®**

