

## CBN ROTARY TOOLS

### ORIGINAL DIPROFIL ROTARY CBN TOOLS

Diprofil CBN Rotary Tools are made from carefully selected CBN (Cubic Boron Nitride), precisely bonded to obtain the best physical properties for added strength and resistance to wear. CBN tools are excellent for use on Tool Steels, Stainless Steels and Cast Iron.

Electroplated cylindrical CBN pins are excellent for general grinding applications in hardened steel. They are normally used without cooling agent but in stationary applications cooling is often required. Maximum temperature for CBN is 1200° C.

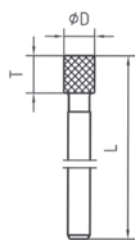
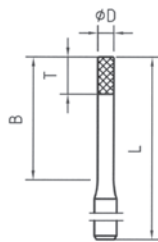


#### Recommended speeds:

Recommend speed for dry cutting: CBN: 15 – 30 m/s  
 Recommended speed for wet cutting: CBN: 20 – 45 m/s

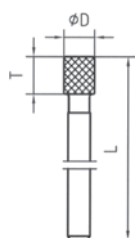
Cooling normally enhances the lifetime of the tools. In addition it also generates a better surface. The risk for damage on thin or sharp edges of the grinding tool is reduced when using coolant. For CBN tools cooling is performed preferable with a mineral oil.

#### Shank Diameter: Ø 3,0 mm



	Shape	Dimensions	Grit Size	Item number
Cylinder		D 0,8, T 4,0, B 7, L 46	B 107	B-0308L-H3
		D 1,0, T 4,0, B 8, L 46	B 107	B-0310L-H3
		D 1,5, T 4,0, B 10, L 46	B 107	B-0315L-H3
		D 2,0, T 5,0, B 14, L 46	B 151	B-0320L-H3
		D 2,5, T 5,0, B 19, L 46	B 151	B-0325L-H3
		D 3,0, T 5,0, B 19, L 46	B 151	B-0330L-H3
	Cylinder		D 3,5, T 5,0, L 44	B 151
		D 4,0, T 5,0, L 44	B 151	B-0340L-H3
		D 4,5, T 5,0, L 44	B 151	B-0345L-H3
		D 5,0, T 6,0, L 45	B 151	B-0350L-H3
		D 5,5, T 6,0, L 45	B 151	B-0352L-H3
		D 6,0, T 6,0, L 45	B 151	B-0354L-H3

#### Shank Diameter: Ø 6,0 mm



	Shape	Dimensions	Grit Size	Item number
Cylinder		D 6, T 8, L 60	B 151	B-0354L-H6
		D 7, T 8, L 60	B 151	B-0358L-H6
		D 8, T 8, L 60	B 151	B-0362L-H6
		D 10, T 10, L 60	B 151	B-0370L-H6
		D 12, T 10, L 60	B 151	B-0374L-H6
		D 15, T 10, L 60	B 151	B-0380L-H6

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