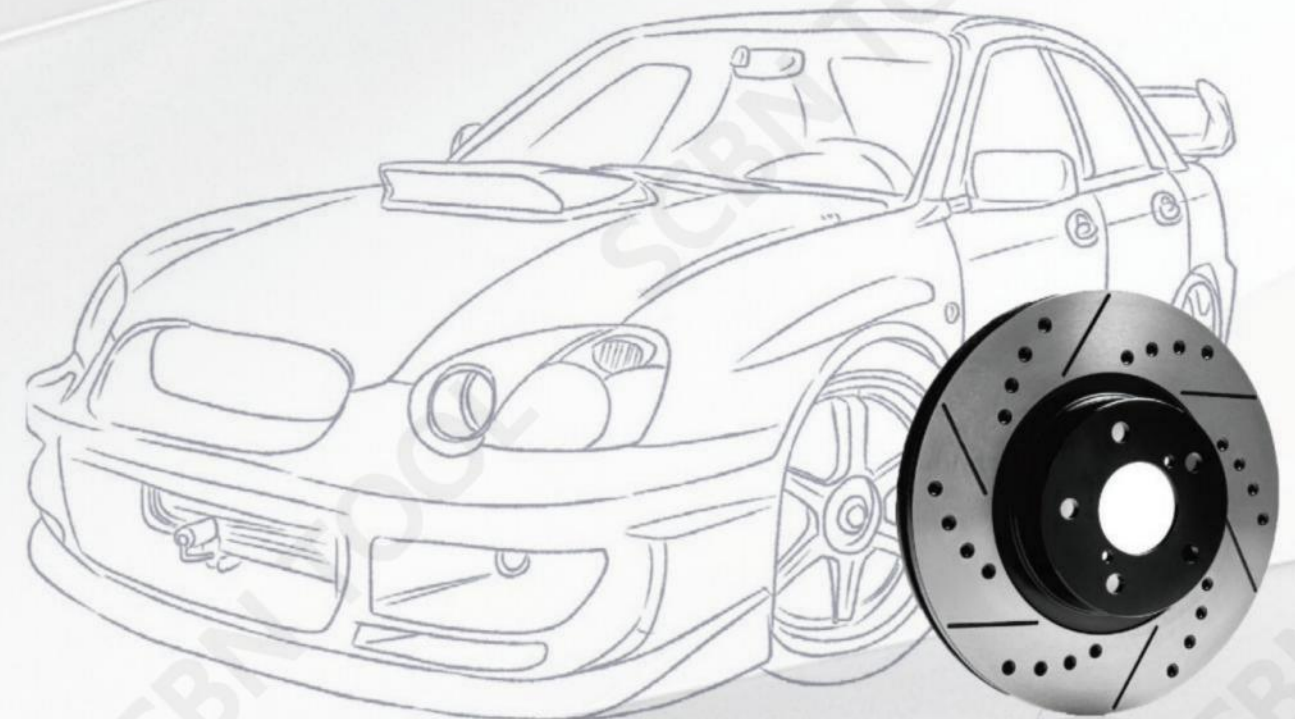




BRAKE DISC CBN CUTTING TOOLS

BEST CHOICE TO
REPLACE CERAMIC INSERTS



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CURRENT ADVANCED BRAKE DISC PROCESSING SCHEME



I.COMMON CBN INSERTS FOR BRAKE DISC



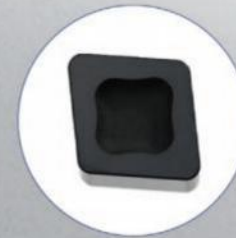
- ◆ CNGN1204
- ◆ CNGN1207



- ◆ CNGX1204
- ◆ CNGX1207



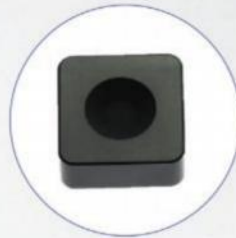
- ◆ CNGL1204
- ◆ CNGL1207



- ◆ CNGS1204
- ◆ CNGS1207



- ◆ SNGN1204
- ◆ SNGN1207



- ◆ SNGX1204
- ◆ SNGX1207



- ◆ SNGS1204
- ◆ SNGS1207

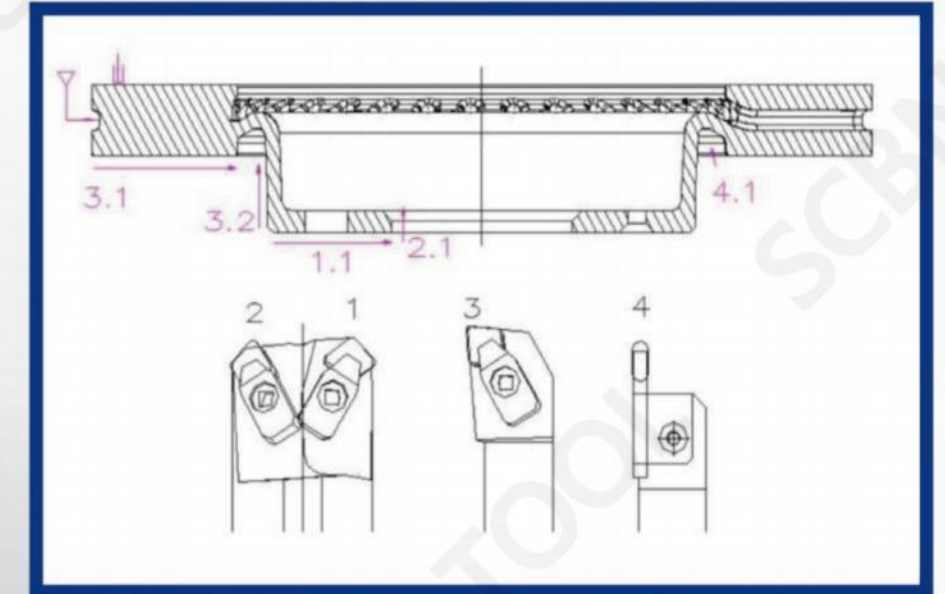


- ◆ SCGN0904
- ◆ SCGN0904W

All above models can be offered with wiper, different dimple and coating service. Specific for Brake Disc Industry, can replace various brands of ceramic blades with advantages.

01 FIRST PROCESS

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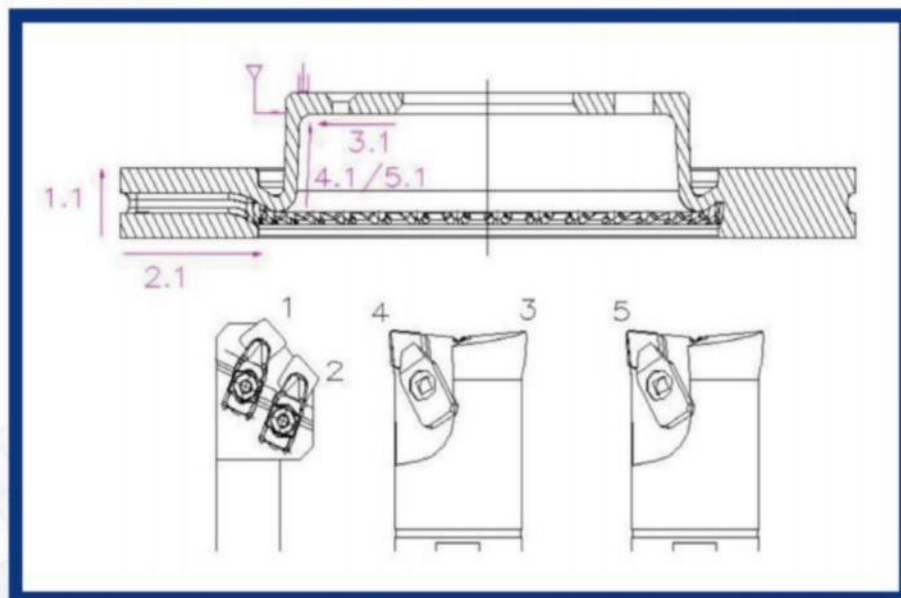
Proces No.	Machining part	CBN Inserts	Too Holder	Vc m/min	Fr (mm/r)	Ap (mm)	Insert Image
01	wheel face facingRoughing	SBN850 CNGN120412 S02020	F27R-CCSN-D50* 150CN1204	400-500	0.3~0.5	1.5~2	
02	Internal roughing	SBN850 CNGN120412 S02020	S40-260-CCLNL1204	400~750	0.3~0.5	1.5~2	
03	pad face roughing	SBN850 CNGN120412 S02020	CCLNL 2525M1204	400-500	0.3~0.5	1.5~2	
04	wheel external roughing	SBN850 CNGN120412 S02020	CCLNL 2525M1204	400~750	0.3~0.5	1.5~2	
05	groove roughing	SBN850 RCMX060500 S02020	CRDCN 2525M0605	550~700	0.1~0.3	0.2~0.5	

CURRENT ADVANCED BRAKE DISC PROCESSING SCHEME



02 SECOND PROCESS

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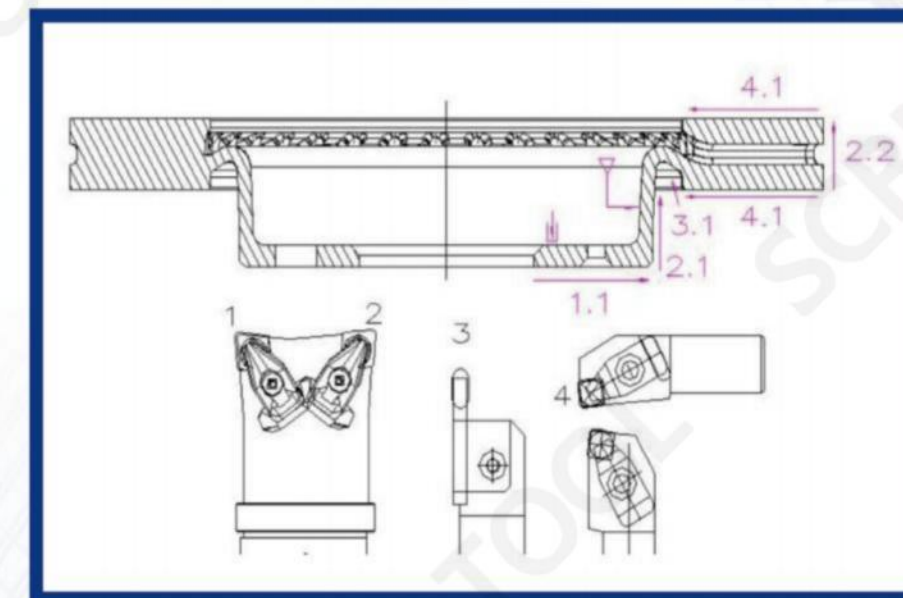
Proces No.	Machining part	CBN Inserts	Too Holder	Vc m/min	Fr (mm/r)	Ap (mm)	Insert Image
01	external roughing	SBN850 CNGN120412 S02020	CCSNR2525P 1204*2	400~750	0.3~0.5	1.5~2	
02	pad face roughing	SBN850 CNGN120412 S02020	CCSNR2525P 1204*2	400-500	0.3~0.5	1.5~2	
03	starting point roughing	SBN850 CNGN120412 S02020	F27L-D50*150 CCLN1204	400-500	0.3~0.5	1.5~2	
04	internal roughing	SBN850 CNGN120412 S02020	F27L-D50*150 CCLN1204	400~750	0.3~0.5	1.5~2	
05	internal finishing	SBN850 CNGN120412 S02020	F27L-D50*150 CCLN1204-1	550~750	0.1~0.3	1.5~2	

CURRENT ADVANCED BRAKE DISC PROCESSING SCHEME



03 THIRD PROCESS

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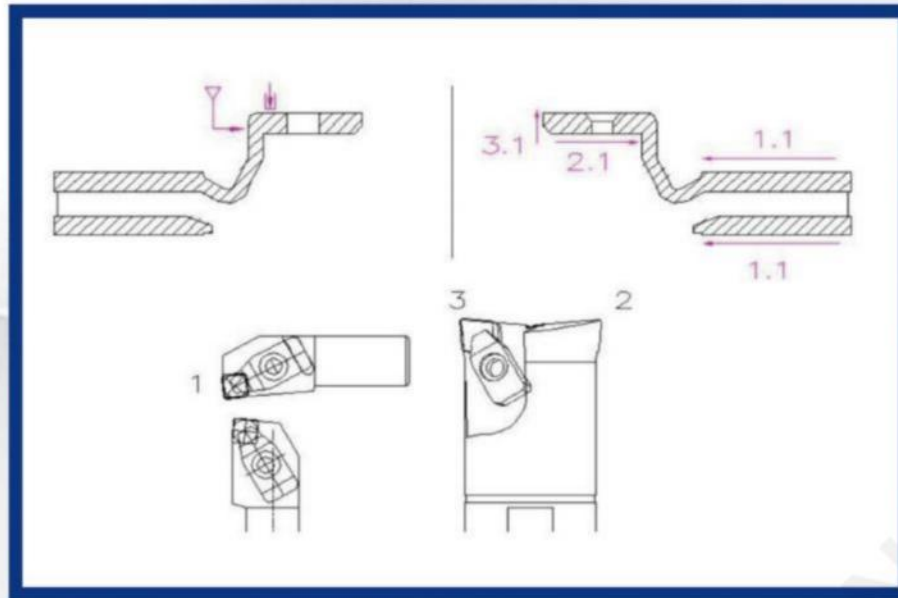
Proces No.	Machining part	CBN Inserts	Too Holder	Vc m/min	Fr (mm/r)	Ap (mm)	Insert Image
01	wheel facefinishing	SBN850 CNGN120412 S02020	F27L-D50* 150CCLN1207-1	650~750	0.2~0.3	0.2~0.5	
02	wheel externalfinishig	SBN850 CNGN120412 S02020	F27L-D50* 150CCLN1207-1	650~750	0.2~0.3	0.2~0.5	
03	external finishing	SBN850 CNGN120412 S0202	F27L-D50* 150CCLN1207-1	650~750	0.2~0.3	0.2~0.5	
04	Groove finishing	SBN850 RCMX060500 S02020	CRDCN 2525M0605	550-700	0.1~0.2	0.2~0.5	
05	pad face semi finishing	SBN850 SCGN090408W	CSLCR 2020K0904	650~750	0.2~0.3	0.2~0.5	

CURRENT ADVANCED BRAKE DISC PROCESSING SCHEME



04 FORTH PROCESS

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EXTERNAL TURNING TOOL HOLDER FOR SOLID CBN INSERTS



Proces No.	Machining part	CBN Inserts	Too Holder	Vc m/min	Fr (mm/r)	Ap (mm)	Insert Image
01	padface finishing	SBN850 SCGN090408W	CSLCR 2020K0904	650~750	0.2~0.3	0.2~0.5	
02	starting point finishing	SBN850 CNGN120412 S02020	F27L-D50* 150-CCLN1204	650~750	0.2~0.3	0.2~0.5	
03	internal finishing	SBN850 CNGN120412 S02020	F27L-D50* 150-CCLN1204	650~750	0.2~0.3	0.2~0.5	

Recommend Cutting Parameters for Cutting Brake Disc



Cutting Process	Vc (m/min)	Ap (mm)	Fr (mm/r)
Roughing	400~600	<2.0	<0.5
Finishing	500~700	<0.5	<0.2