BINDERLESS NPD10 / DA90

PCD tool for Carbide & hard brittle material turning

BINDERLESS NPD10
Ultimate High Precision Machining

DA90
For Carbide & Hard brittle material Roughing
Adopts Nano-polycrystalline Diamond for the cutting edge, which is binder-less, isotropic and harder than single crystal diamond.
Achieves long tool life and improved machining accuracy for carbide and hard brittle material machining compared to conventional diamond tools.

Best suited for finish machining of carbide and hard brittle material
Achieves high precision machining of carbide with nano-polycrystalline diamond, which has excellent wear resistance.

Maintains excellent dimensional accuracy over long periods
Greatly reduces the number of times that the tool must be indexed compared to previous diamond tools, improving work efficiency and reducing total cost.

Nano-polycrystalline Diamond
Nano-polycrystalline Diamond is a polycrystalline diamond that directly binds nanometer-level diamond particles at high strength without using binders. It is harder than single-crystal diamond and has no cleavability. Therefore, it enables machining of hard brittle materials such as carbides and enables new machining methods.

Hardness
Nano-polycrystalline Diamond
Single Crystal Diamond
Conventional PCD

No Anisotropy and Ultra Hard

Knoop Hardness HK(GPa)
DA90

A grade made by sintering rough-grained diamond which contains the highest amount of diamond, has excellent wear resistance for rough machining of carbide and hard brittle material. Achieves high cost performance as same performance as before through optimal design and development of mass production technology.

Best suited for rough machining of carbide and hard brittle material

Achieves stable tool life for rough machining of carbide and hard brittle material by the excellent wear resistance of rough-grained polycrystalline diamond.

Adopting NF Inserts

Achieves high cost performance as same performance as before through optimal design and development of mass production technology.

Expand stock items for carbide and hard brittle materials machining

<table>
<thead>
<tr>
<th>Grade line up</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Grade</strong></td>
</tr>
<tr>
<td>Microstructure</td>
</tr>
<tr>
<td>Bonding Material</td>
</tr>
<tr>
<td>Grain Size (µm)</td>
</tr>
<tr>
<td>CBN Content (%)</td>
</tr>
</tbody>
</table>
**Wear Resistance of NPD10**

NPD10 shows excellent wear resistance.

[Graph showing wear resistance comparison between NPD10 and Conventional PCD]

- Part Material: Carbide (87HRA), Insert: DCMA32.51RH
- Cutting Conditions: \( v_c = 66 \text{ SFM}, f = 0.004 \text{ IPR}, a_p = 0.004 \text{ in} \) Dry

**Wear Resistance of DA90**

DA90 shows excellent wear resistance under rough machining conditions.

[Graph showing wear resistance comparison between DA90 and Conventional PCD]

- Part Material: Carbide (87HRA)
- Insert: NF-DCMA21.51
- Cutting Conditions: \( v_c = 66 \text{ SFM}, f = 0.004 \text{ IPR}, a_p = 0.008 \text{ in} \) Wet

**Application Examples**

**Carbide Machining VC40 (89HRA) Die Metal Mold**

- NPD10 achieved more 5 times longer tool life than conventional PCD.

<table>
<thead>
<tr>
<th>No. of Workpieces/piece</th>
<th>NPD10</th>
<th>Conv. PCD</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5</td>
<td></td>
<td></td>
</tr>
<tr>
<td>10</td>
<td></td>
<td></td>
</tr>
<tr>
<td>15</td>
<td></td>
<td></td>
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</tbody>
</table>

- Insert: CCMW04X104RH (NPD10) Internal turning
- Cutting Conditions: \( v_c = 50 \text{ SFM}, f = 0.0006 \text{ IPR}, a_p = 0.003 \text{ in} \) Dry

**Carbide Machining VM30 (91HRA) Die Metal Mold**

- Reduced processing costs 33% by applying DA90 for roughing and NPD10 for finishing.

<table>
<thead>
<tr>
<th>Processing costs(%)</th>
<th>DA90</th>
<th>NPD10</th>
</tr>
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<tbody>
<tr>
<td>0</td>
<td></td>
<td></td>
</tr>
<tr>
<td>50</td>
<td></td>
<td></td>
</tr>
<tr>
<td>100</td>
<td></td>
<td></td>
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</tbody>
</table>

- Insert: Rough NF-CCMA21.50.5 (DA90) Internal turning
- Cutting Conditions: Rough \( v_c = 66 \text{ SFM}, f = 0.004 \text{ IPR}, a_p = 0.004 \text{ in} \) Dry
- Finishing \( v_c = 66 \text{ SFM}, f = 0.004 \text{ IPR}, a_p = 0.008 \text{ in} \) Dry
### Stock Items of NPD10

#### Negative Insert

<table>
<thead>
<tr>
<th>Shape</th>
<th>Cat. No.</th>
<th>Stock</th>
<th>Cutting Edge Length</th>
<th>Dimensions (mm)</th>
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<tbody>
<tr>
<td>DNMA 432RH</td>
<td>433RH</td>
<td>1.8</td>
<td>19</td>
<td>12.7 4.76 5.16 0.8</td>
<td>1.2</td>
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<tr>
<td>SNMA 432RH</td>
<td>433RH</td>
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<td>19</td>
<td>12.7 4.76 5.16 0.8</td>
<td>1.2</td>
</tr>
<tr>
<td>VNMA 432RH</td>
<td>433RH</td>
<td>1.8</td>
<td>19</td>
<td>9.525 4.76 3.81 0.8</td>
<td>1.2</td>
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</table>

#### Positive Insert

<table>
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<th>Shape</th>
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<tr>
<td>CCMA 03X102RH</td>
<td>03X104RH</td>
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<td>3.5</td>
<td>1.4 1.9 0.2</td>
<td>0.4</td>
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<tr>
<td>CCMA 04X102RH</td>
<td>04X104RH</td>
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<td>4.3</td>
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<td>0.4</td>
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<tr>
<td>CCMA 21.50.5RH</td>
<td>21.51RH</td>
<td>1.7</td>
<td>6.35</td>
<td>2.38 2.8 0.2</td>
<td>0.4</td>
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#### Shape of a rounded corner is cylindrical.

### Stock Items of DA90

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<tr>
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<td>19</td>
<td>12.7 4.76 5.16 0.8</td>
<td>1.2</td>
</tr>
<tr>
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<tr>
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<td>03X104</td>
<td>1.1</td>
<td>3.5</td>
<td>1.4 1.9 0.2</td>
<td>0.4</td>
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