

CBN Turning Grade

MB710/MB730



Efficient and high speed machining of cast iron and sintered parts

■ G-class multi-corner inserts now included in the range of **MB710** and **MB730** CBN grades.

MB710 For General Cutting

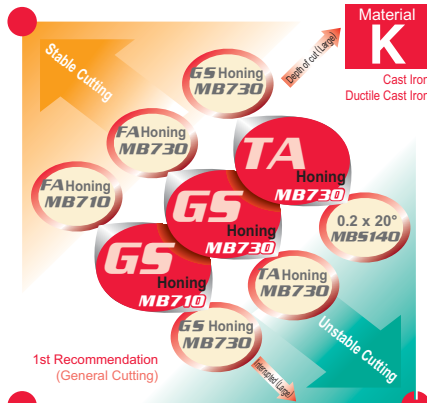
General purpose grade with well balanced wear and fracture resistance.

MB730 For High Speed Continuous to Interrupted Cutting

High fracture-resistant grade with a high CBN brazing strength due to the use of a metal binder.

General Cast Iron Machining

● Selecting the insert grade and honing type

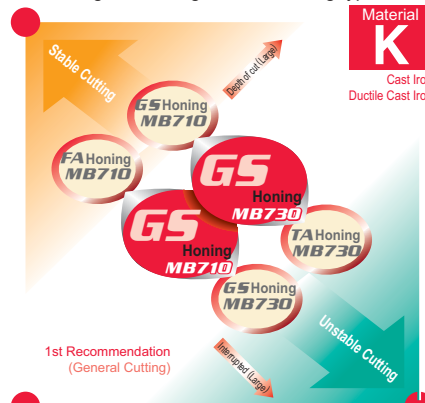


★ For MB710 and MB730 inserts that are not available in TA or FA type, select T or F type respectively.

Recommended cutting speed: MB710: 500–950m/min
MB730: 900–1500m/min
Depth of cut : ≤0.5mm

Ductile Cast Iron Machining

● Selecting the insert grade and honing type

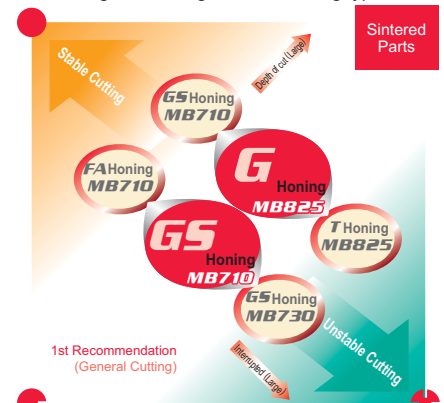


★ For MB710 and MB730 inserts that are not available in TA or FA type, select T or F type respectively.

Recommended cutting speed: MB710: 120–500m/min
MB730: 80–350m/min
Depth of cut : ≤0.5mm

Sintered Parts Machining

● Selecting the insert grade and honing type



Recommended cutting speed: MB710: 150–250m/min
MB730: 150–250m/min
Depth of cut : ≤0.1mm

Inserts

● Negative Inserts


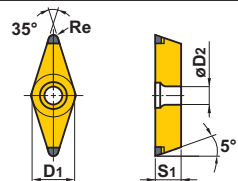

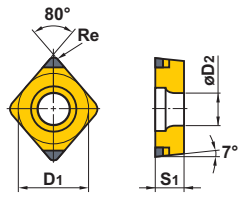
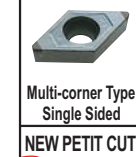
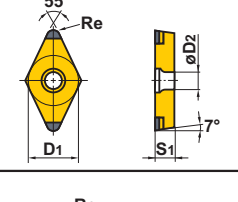
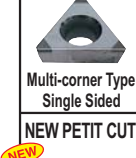
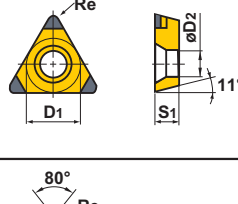

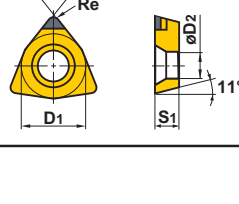
Shape	Order Number	Stock		Dimensions (mm)				Geometry
		MB710	MB730	D1	S1	Re	D2	
 Multi-corner Type Single Sided	NEW PETIT CUT NP-CNGA120404GS2	●	●	12.7	4.76	0.4	5.16	
	120408GS2	●	●	12.7	4.76	0.8	5.16	
	120412GS2	●	●	12.7	4.76	1.2	5.16	
	120404TA2		●	12.7	4.76	0.4	5.16	
	120408TA2		●	13.7	4.76	0.8	5.16	
	120412TA2		●	12.7	4.76	1.2	5.16	
 Multi-corner Type Single Sided	NEW PETIT CUT NP-DNGA150404GS2	●	●	12.7	4.76	0.4	5.16	
	150408GS2	●	●	14.7	4.76	0.8	5.16	
	150412GS2	●	●	12.7	4.76	1.2	5.16	
 Multi-corner Type Single Sided	NEW PETIT CUT NP-SNGA120408GS2	●	●	12.7	4.76	0.8	5.16	
	120412GS2	●	●	12.7	4.76	1.2	5.16	
 Multi-corner Type Single Sided	NEW PETIT CUT NP-TNGA160408GS3	●	●	12.7	4.76	0.8	5.16	
	160412GS3	●	●	12.7	4.76	1.2	5.16	

● : Inventory maintained.

MB710/MB730

Inserts

● Positive Inserts

Shape	Order Number	Stock		Dimensions (mm)				Geometry
		MB710	MB730	D1	S1	Re	D2	
 Multi-corner Type Single Sided	NP-VBGW110304GS2		●	6.35	3.18	0.4	2.85	
	110308GS2		●	6.35	3.18	0.8	2.85	
	160404GS2	●	●	9.525	4.76	0.4	4.43	
	160408GS2	●	●	9.525	4.76	0.8	4.43	
 Multi-corner Type Single Sided	NP-CCGW060202GS2	●	●	6.35	2.38	0.2	2.8	
	060204GS2	●	●	6.35	2.38	0.4	2.8	
	060208GS2	●	●	6.35	2.38	0.8	2.8	
	09T304GS2	●	●	9.525	3.97	0.4	4.4	
	09T308GS2	●	●	9.525	3.97	0.8	4.4	
	060202FA2	●	●	6.35	2.38	0.2	2.8	
	060204FA2	●	●	6.35	2.38	0.4	2.8	
	060208FA2	●	●	6.35	2.38	0.8	2.8	
	09T304FA2	●	●	9.525	3.97	0.4	4.4	
09T308FA2	●	●	9.525	3.97	0.8	4.4		
 Multi-corner Type Single Sided	NP-DCGW11T304GS2	●	●	9.525	3.97	0.4	4.4	
	11T308GS2	●	●	9.525	3.97	0.8	4.4	
	11T304FA2	●	●	9.525	3.97	0.4	4.4	
	11T308FA2	●	●	9.525	3.97	0.8	4.4	
 Multi-corner Type Single Sided	NP-TCGW110204FA3	●	●	9.525	2.38	0.4	2.8	
	110208FA3	●	●	9.525	2.38	0.8	2.8	
 Multi-corner Type Single Sided	NP-WCMWL30204FA		●	4.76	2.38	0.4	2.3	
	30208FA		●	4.76	2.38	0.8	2.3	

● : Inventory maintained.

For Your Safety

●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When attaching inserts or spare parts, please use only the correct wrench or spanner.

MITSUBISHI MATERIALS CORPORATION



The Scope of the Registration:
Design, Development and
Production of Cemented
Carbide Tools and Carbide
Blanks



The Scope of the Registration:
Design, Development and
Production of Cutting Tools,
Wear-resistant Tools, Rock
Drilling Tools, Cemented
Carbide Blanks and Coated
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(Tools specifications subject to change without notice.)