|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **Carbide Tube Scarfing Inserts****Standing Standard stock**

|  |
| --- |
| **Carbide Tube Scarfing Inserts** |
|
| **No.** | **ReferencePhoto** | **Type** | **Grade** | **Material** | **Coating** | **Work-pieceMaterials** |
| 1 |  | SPUB63A-R9 | TBC2005 | Carbide | PVD | Steel |
| 2 | SPUB63B-R12 | TBC2005 | Carbide | PVD | Steel |
| 3 | SPUB63C-R15 | TBC2005 | Carbide | PVD | Steel |
| 4 | SPUB63D-R20 | TBC2005 | Carbide | PVD | Steel |
| 5 | SPUB63E-R25 | TBC2005 | Carbide | PVD | Steel |
| 6 | SPUB63F-R30 | TBC2005 | Carbide | PVD | Steel |
| 7 | SPUB-63G | TBC2005 | Carbide | PVD | Steel |
| 8 | SPUB-63J | TBC2005 | Carbide | PVD | Steel |
| 9 | SPUB63-M | TBC2005 | Carbide | PVD | Steel |
| 10 | SPUB-86-F | TBC2005 | Carbide | PVD | Steel |
| 11 |  | HXMX2504-R14 | TBC2005 | Carbide | PVD | Steel |
| 12 | HXMX2504-R17 | TBC2005 | Carbide | PVD | Steel |
| 13 | HXMX2504-R22 | TBC2005 | Carbide | PVD | Steel |
| 14 | HXMX2504-R29 | TBC2005 | Carbide | PVD | Steel |
| 15 | HXMX2504-R40 | TBC2005 | Carbide | PVD | Steel |
| 16 | HXMX2504-R50 | TBC2005 | Carbide | PVD | Steel |
| 　 | 　 | 　 | 　 | 　 | 　 | 　 |

 |

**Grade: TBC2005**

**CVD (TiCN+Al203+TiN) coating is suitable for processing steel parts and has excellent resistance to breakage in light to medium interrupted processing.**

|  |
| --- |
| **Recommended Cutting Parameters** |
| **Insert Type** | **Ap** | **F** | **Vc** |
| **SPUB** | **0.5-3.0** | **0.15-0.5** | **150-230** |
| **HXMX** | **0.5-4.0** | **0.1-0.5** | **200-340** |