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| **Carbide Tube Scarfing Inserts**  **Standing Standard stock**   |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | | **Carbide Tube Scarfing Inserts** | | | | | | | | | **No.** | **Reference Photo** | **Type** | **Grade** | **Material** | **Coating** | **Work-piece Materials** | | 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.**

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| **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** |