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tipped pcbn inserts with brazed cbn cutting edges are used for machining ferrous hard metals such as nodular cast iron, hardened steel, high speed steel, die steel, bearing steel, cemented steel, heat resisting steel, carbon tool steel, chromium and nickel molybdenum alloy, the working tips of cbn inserts are made by pure polycrystalline cubic boron nitride, cbn tipped inserts are mainly for ...