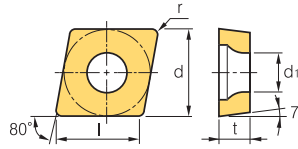


# B Turning Insert (Positive)



Dimensions (mm)			
Size	d	t	d <sub>1</sub>
06	6.35	2.38	2.8
09	9.525	3.97	4.4
12	12.7	4.76	5.5

Rhombic **80° Positive**  
Relief Angle: 7°

Workpiece	Machining types											
	P	M	K	N	S	H						
Steel	●	●	●	●	●	●	●	●	●	●	●	●
Stainless steel	●	●	●	●	●	●	●	●	●	●	●	●
Cast iron	●	●	●	●	●	●	●	●	●	●	●	●
Non-ferrous metal	●	●	●	●	●	●	●	●	●	●	●	●
Heat resistant alloy, Titanium alloy	●	●	●	●	●	●	●	●	●	●	●	●
Hardened steel	●	●	●	●	●	●	●	●	●	●	●	●

Inserts	Designation	Cermet		Coated		Coated										Uncoated		Cutting Condition											
		CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05	f <sub>n</sub> (mm/rev)	a <sub>p</sub> (mm)			
Medium to finishing 	CCGT	0602003R-KM																								0.01-0.06	0.04-1.30		
		060201R-KM																									0.02-0.08	0.05-1.50	
		060202R-KM																					●				0.03-0.11	0.06-1.70	
		09T3003R-KM																									0.02-0.08	0.06-1.50	
		09T301R-KM																									0.03-0.11	0.06-1.70	
		09T302R-KM																									0.04-0.15	0.08-2.00	
		0602003L-KM																									0.01-0.06	0.04-1.30	
		060201L-KM																										0.02-0.08	0.05-1.50
		060202L-KM																										0.03-0.11	0.06-1.70
		09T3003L-KM																										0.02-0.08	0.06-1.50
		09T301L-KM																										0.03-0.11	0.06-1.70
	09T302L-KM																										0.04-0.15	0.08-2.00	
Finishing 	CCMT	060202-VF						●								●			●							0.05-0.20	0.30-1.00		
		060204-VF	●		●				●							●			●								0.10-0.25	0.30-1.00	
		09T302-VF							●																		0.04-0.16	0.80-1.50	
		09T304-VF	●	●	●				●							●			●								0.05-0.20	0.30-1.50	
		09T308-VF	●		●				●	●						●												0.10-0.25	0.30-1.50
		120404-VF							●																			0.07-0.22	0.10-2.00
Finishing 	CCMT	060202-VL																								0.04-0.18	0.20-1.40		
		060204-VL	●		●	●	●	●	●	●			●	●	●	●	●	●	●	●	●	●					0.04-0.10	0.08-0.90	
		060208-VL						●	●	●				●	●												0.06-0.12	0.10-1.00	
		09T304-VL	●	●	●	●	●	●	●	●			●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.05-0.10	0.10-1.00	
		09T308-VL	●	●	●	●	●	●	●	●			●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.08-0.15	0.10-1.00	
		120404-VL																									0.06-0.12	0.30-1.50	
		120408-VL																									0.08-0.15	0.30-1.50	
	120412-VL																									0.08-0.15	0.30-1.50		
Finishing 	CCMT	060204-VP1																								0.06-0.12	0.10-1.50		
		09T304-VP1																									0.06-0.20	0.10-1.50	
		09T308-VP1																									0.08-0.20	0.50-2.00	
		120404-VP1																									0.08-0.22	0.20-2.00	
		120408-VP1																									0.10-0.25	0.50-2.00	
		120412-VP1																									0.10-0.30	0.80-2.50	

Cutting edge geometry A52~A61  
 Recommended chip breaker B04~B11  
 Code system B26~B27  
 ● : Stock item

Available tool holders			
Designation	Page	Designation	Page
SCACR/L	B113, 178	SCLCR/L	B113, 178, 204, 214

