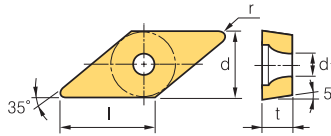


B Turning Insert (Positive)

VB





Dimensions (mm)			
Size	d	t	d ₁
11	6.35	3.18	2.8
16	9.525	4.76	4.4

 Rhombic **35° Positive**
Relief Angle: 5°

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	Cermets		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 _n (mm/rev)	a _p (mm)			
Finishing	KF	VBGT 1103003R-KF																								0.01-0.06	0.04-1.30		
		110301R-KF																									0.02-0.08	0.05-1.50	
		110302R-KF																						●			0.03-0.13	0.06-1.70	
		1103003L-KF																									0.01-0.06	0.04-1.30	
		110301L-KF																										0.02-0.08	0.05-1.50
		110302L-KF																										0.03-0.13	0.06-1.70
Finishing	VP1	VBGT 110302-VP1																								0.03-0.10	0.08-1.50		
		160402-VP1																								0.04-0.20	0.16-1.50		
		160404-VP1																								0.05-0.20	0.18-1.80		
Medium to finishing		VBGT 160404																								0.07-0.20	0.50-1.50		
		160408																								0.15-0.25	0.70-2.00		
Medium to finishing	KM	VBGT 1103003R-KM																								0.01-0.06	0.04-1.30		
		110301R-KM																									0.02-0.08	0.05-1.50	
		110302R-KM																									0.03-0.13	0.06-1.70	
		160404R-KM																									0.05-0.15	0.50-2.00	
		1103003L-KM																									0.01-0.06	0.04-1.30	
		110301L-KM																									0.02-0.08	0.05-1.50	
		110302L-KM																									0.03-0.13	0.06-1.70	
		160404L-KM																									0.05-0.15	0.50-2.00	
Finishing	VB	VBMT 110302-VB																								0.05-0.15	0.20-1.20		
		110304-VB																								0.06-0.18	0.20-1.20		
		110308-VB																								0.08-0.20	0.60-1.20		
		160402-VB																								0.06-0.20	0.05-1.00		
		160404-VB	●	●						●																	0.08-0.20	0.20-1.50	
		160408-VB	●	●						●																	0.10-0.23	0.50-1.50	
		160412-VB																									0.12-0.25	0.80-1.50	
Finishing	VF	160404-VF	●	●	●				●	●						●			●							0.05-0.20	0.30-1.00		
		160408-VF	●	●	●												●									0.10-0.25	0.30-1.00		

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

Available tool holders			
Designation	Page	Designation	Page
SVABR/L	B183	SVVBN	B184
SVHBR/L	B183	SVQBR/L	B211
SVJBR/L	B115, 183	SVUBR/L	B212

