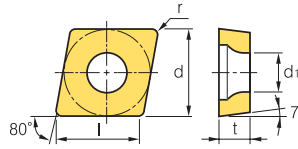


B Turning Insert (Positive)

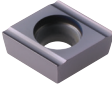
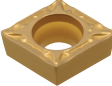
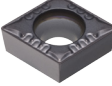
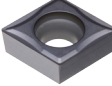
CC ○ ○



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



| Dimensions (mm) | | | |
|-----------------|-------|------|----------------|
| Size | d | t | d ₁ |
| 06 | 6.35 | 2.38 | 2.8 |
| 09 | 9.525 | 3.97 | 4.4 |
| 12 | 12.7 | 4.76 | 5.5 |

| 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 | 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 _n (mm/rev) | a _p (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 |



