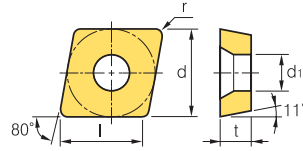


B Turning Insert (Positive)

CP



Dimensions (mm)			
Size	d	t	d ₁
06	6.35	2.38	2.8
08	7.94	2.38	3.4
09	9.525	3.18	4.4

Rhombic **80° Positive**
Relief Angle: 11°

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

● Continuous cutting
⊙ General cutting
⊛ Interrupted cutting

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		CPGT 080202																								0.06-0.20	0.10-2.00		
		080204	●	●																							0.08-0.20	0.30-2.00	
		080208																									0.10-0.25	0.50-2.00	
		090302																									0.04-0.20	0.30-1.50	
		090304	●	●																								0.06-0.25	0.50-2.00
		090308																										0.08-0.30	0.70-2.50
Medium to finishing		CPGT 090308-HMP																								0.05-0.20	0.70-2.00		
Finishing		CPMT 080204-VF																								0.05-0.20	0.30-1.20		
		080208-VF																									0.10-0.25	0.30-1.20	
		090304-VF								●																	0.05-0.20	0.30-1.50	
		090308-VF								●																		0.10-0.25	0.30-1.50
Finishing		CPMT 080204-VL																								0.03-0.08	0.08-1.00		
		080208-VL																									0.04-0.12	0.10-1.00	
		090304-VL																									0.05-0.10	0.10-1.00	
		090308-VL																									0.08-0.15	0.10-1.00	
Medium cutting		CPMT 060204-C25																								0.05-0.15	0.60-2.30		

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

Available tool holders			
Designation	Page	Designation	Page
SCLPR/L	B205		

