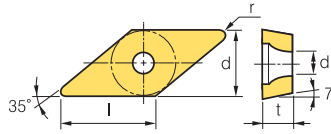


# B Turning Insert (Positive)

## VC



Dimensions (mm)			
Size	d	t	d <sub>1</sub>
11	6.35	3.18	2.8~3.4
16	9.525	4.76	4.4

Rhombic **35° 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	●	●	●	●	●	●	●	●	●	●	●	●

● 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 <sub>n</sub> (mm/rev)	a <sub>p</sub> (mm)			
Finishing  [High precision]	VCET	1103005MFR-KF														●										0.01~0.06	0.04~1.30		
		110301MFR-KF															●				●							0.02~0.08	0.05~1.50
		110302MFR-KF															●				●							0.03~0.11	0.06~1.70
		1103005MFL-KF															●											0.01~0.06	0.04~1.30
		110301MFL-KF															●											0.02~0.08	0.05~1.50
		110302MFL-KF															●					●						0.03~0.11	0.06~1.70
Medium to finishing  [High precision]	VCET	1103005MFR-KM																									0.02~0.08	0.05~1.50	
		110301MFR-KM															●				●							0.03~0.11	0.06~1.70
		110302MFR-KM																				●						0.04~0.15	0.08~2.00
		1103005MFL-KM															●											0.02~0.08	0.05~1.50
		110301MFL-KM																										0.03~0.11	0.06~1.70
		110302MFL-KM																										0.04~0.15	0.08~2.00
Finishing 	VCGT	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 	VCGT	110301-VP1														●	●	●	●	●	●	●	●	●	●	●	0.02~0.15	0.05~0.50	
		110302-VP1														●	●	●	●	●	●	●	●	●	●	●	0.02~0.18	0.10~1.00	
		110304-VP1														●	●	●	●	●	●	●	●	●	●	●	0.03~0.18	0.15~1.20	
		160404-VP1																										0.05~0.20	0.18~1.80
		160408-VP1																										0.06~0.20	0.20~1.80
Finishing  [High precision]	VCGT	110301MFN-VP1														●					●						0.02~0.15	0.05~0.50	
		110302MFN-VP1														●					●						0.02~0.18	0.10~1.00	
		110304MFN-VP1														●					●						0.03~0.18	0.15~1.20	
		1203008FN-VP1																										0.03~0.12	0.06~1.20
		120301FN-VP1																										0.04~0.13	0.08~1.20
		120302FN-VP1																										0.04~0.15	0.08~1.20
120304FN-VP1																										0.06~0.20	0.10~1.50		
Medium to finishing 	VCGT	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
		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

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

Available tool holders			
Designation	Page	Designation	Page
SVJCR/L	B115, 184, 211	SVQCR/L	B212
SVVCN	B184	SVUCR/L	B212

