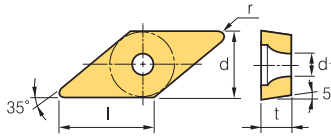


B Turning Insert (Positive)

VB ○○



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



Workpiece	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	fn (mm/rev)	ap (mm)
Finishing		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		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		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		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			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

