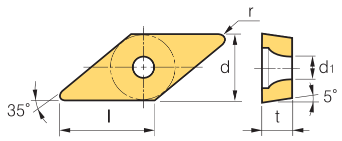
VB○○



Dimensions (mm)			
Size	d	t	d1
11	6.35	2.38~3.18	2.8~3.4
16	9.525	4.76	4.4

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

Workpiece		CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05
Steel	P	●	◐	✱	●	◐	●	◐	◐	✱	✱	●	●	◐		✱								
Stainless steel	M									◐	◐			●	◐	✱	◐	✱		●	◐	◐		
Cast iron	K	●	◐	✱	●	◐	◐				◐	◐	◐										●	◐
Non-ferrous metal	N																						●	◐
Heat resistant alloy, Titanium alloy	S										●				●	●	◐	✱	●	●	◐		●	◐
Hardened steel	H																			◐	✱		●	◐

Machining types
- ● Continuous cutting
- ◐ General cutting
- ✱ Interrupted cutting

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 VL  [Mild steel]	VBMT 110302-VL																								0.03~0.20	0.20~1.20
	110304-VL																								0.04~0.20	0.20~1.20
	110308-VL																								0.08~0.20	0.20~1.20
	160402-VL																								0.03~0.20	0.30~1.50
	160404-VL	●		●	●	●	●		●		●			●	●	●	●	●	●	●	●				0.05~0.20	0.30~1.50
	160408-VL	●		●	●	●	●		●		●			●	●	●	●	●	●	●	●				0.10~0.20	0.30~1.50
	160412-VL													●	●	●			●	●	●				0.10~0.25	0.30~1.50
Finishing VP1 	VBMT 160402-VP1																								0.04~0.20	0.16~1.50
	160404-VP1																								0.05~0.20	0.18~1.80
	160408-VP1																								0.06~0.20	0.20~1.80
Medium to finishing 	VBMT 160404		●					●		●		●										●			0.07~0.20	0.50~1.50
	160408							●	●	●			●									●			0.15~0.25	0.70~2.00
Medium to finishing HMP 	VBMT 110304-HMP							●														●			0.03~0.20	0.15~2.70
	110308-HMP							●																	0.05~0.25	0.40~2.70
	160404-HMP							●		●	●		●				●			●					0.07~0.20	0.20~2.70
	160408-HMP							●	●	●	●						●			●		●			0.09~0.27	0.50~2.70
	160412-HMP																								0.11~0.32	0.50~2.70
Medium to finishing MP new 	VBMT 110302-MP																								0.04~0.14	0.20~1.50
	110304-MP						●		●						●	●									0.05~0.15	0.20~1.50
	110308-MP						●		●																0.10~0.28	0.30~2.00
	160402-MP																								0.06~0.16	0.25~2.00
	160404-MP	●		●	●	●	●		●		●	●		●	●	●	●	●	●	●	●				0.08~0.20	0.30~2.00
	160408-MP	●		●	●	●	●		●		●	●	●	●	●	●	●	●	●	●	●				0.10~0.25	0.50~2.30
	160412-MP	●		●			●		●		●			●	●	●	●	●	●	●	●				0.10~0.35	0.50~2.30

Cutting edge geometry **A52~A61** Recommended chip breaker **B04~B11** Code system **B26~B27**

●: Stock item

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