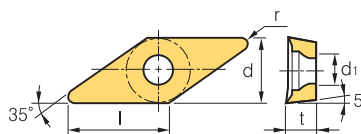


# B Aluminum Insert (Positive)

## VB ○○



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



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

|           |                                      |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |                                                                                                       |
|-----------|--------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------|
| Workpiece | Steel                                |  |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    | Machining types                                                                                       |
|           | Stainless steel                      |  |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |                                                                                                       |
|           | Cast iron                            |  |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |                                                                                                       |
|           | Non-ferrous metal                    |  |  |  |  |  |  |                                                                                                       |
|           | Heat resistant alloy, Titanium alloy |  |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |                                                                                                       |
|           | Hardened steel                       |  |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |                                                                                                       |
|           |                                      |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |                                                                                                       |
|           |                                      |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |  General cutting     |
|           |                                      |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |  Interrupted cutting |

| Inserts       | Designation | Coated |        |        | Uncoated |     | Cutting Condition          |                        |
|---------------|-------------|--------|--------|--------|----------|-----|----------------------------|------------------------|
|               |             | PC5040 | PD1000 | PD1010 | H01      | H05 | f <sub>n</sub><br>(mm/rev) | a <sub>p</sub><br>(mm) |
| <b>AK</b><br> | VBGT        |        |        |        |          |     |                            |                        |
|               | 110302-AK   |        |        |        | ●        | ●   | 0.02~0.15                  | 0.05~3.00              |
|               | 110304-AK   |        |        |        | ●        | ●   | 0.02~0.15                  | 0.10~4.00              |
|               | 110308-AK   |        |        |        |          | ●   | 0.03~0.18                  | 0.10~5.00              |
|               | 160402-AK   |        |        |        |          |     | 0.03~0.30                  | 0.05~4.00              |
|               | 160404-AK   |        |        |        | ●        | ●   | 0.03~0.40                  | 0.10~5.00              |
|               | 160408-AK   |        |        |        | ●        | ●   | 0.03~0.50                  | 0.10~5.00              |
|               | 160412-AK   |        |        |        |          | ●   | 0.05~0.60                  | 0.10~5.50              |
| <b>AR</b><br> | VBGT        |        |        |        |          |     |                            |                        |
|               | 110302-AR   |        |        |        |          |     | 0.02~0.35                  | 0.30~3.00              |
|               | 110304-AR   |        |        |        |          |     | 0.03~0.45                  | 0.30~4.00              |
|               | 110308-AR   |        |        |        |          |     | 0.03~0.50                  | 0.50~6.00              |
|               | 160402-AR   |        |        |        |          |     | 0.04~0.45                  | 0.30~5.00              |
|               | 160404-AR   |        |        |        | ●        | ●   | 0.04~0.50                  | 0.50~6.00              |
|               | 160408-AR   |        |        |        | ●        | ●   | 0.05~0.60                  | 0.50~6.00              |
|               | 160412-AR   |        |        |        |          |     | 0.05~0.70                  | 0.50~6.50              |

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 |

