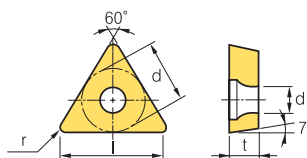


B Turning Insert (Positive)

TC

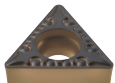
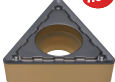


Triangular 60° Positive
Relief Angle: 7°



Dimensions (mm)			
Size	d	t	d ₁
06	6.35	2.38	2.8
09	5.56	2.38	2.5
11	6.35	2.38	2.8
16	9.523	3.97	4.4
22	12.7	4.76	-

Workpiece	Steel																																																																																																																																																																																																																																																																																																																																																														
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Inserts	Designation	Cermet		Coated	Coated														Uncoated		Cutting Condition							
		CN1500	CN2500	CC1500	CC2500	NC3215	NC3225	NC3120	NC3030	NC3235	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05	fn (mm/rev)	ap (mm)		
Finishing	 [Mild steel]	TCMT	060201-FP																						0.00~0.08	0.05~0.07		
			110202-FP		●		●																			0.01~0.10	0.05~0.08	
			110204-FP		●		●																				0.01~0.10	0.10~0.90
Finishing		TCMT	110202-VF																						0.03~0.13	0.06~0.70		
			110204-VF															●								0.05~0.20	0.30~1.20	
			110208-VF															●									0.10~0.25	0.30~1.20
			16T302-VF															●									0.05~0.15	0.10~1.30
			16T304-VF					●				●						●									0.05~0.20	0.30~1.50
Finishing		TCMT	090208-VL																						0.08~0.20	0.10~1.20		
			110204-VL																							0.05~0.15	0.10~1.30	
			110208-VL																							0.08~0.20	0.10~1.30	
			16T304-VL	●	●	●	●	●	●						●	●	●	●	●	●	●	●	●			0.05~0.20	0.30~1.50	
			16T308-VL	●	●	●	●	●	●			●			●	●		●	●	●	●	●	●			0.05~0.20	0.30~1.50	
Medium to finishing		TCMT	090204-HMP						●													●			0.06~0.17	0.20~2.30		
			090208-HMP																							0.08~0.23	0.40~2.30	
			110202-HMP																							0.03~0.15	0.10~1.50	
			110204-HMP		●			●	●	●		●						●			●		●			0.06~0.19	0.20~2.50	
			110208-HMP						●									●					●			0.09~0.26	0.40~2.50	
			16T304-HMP		●				●	●								●			●		●			0.08~0.23	0.30~3.00	
			16T308-HMP						●	●		●						●					●			0.10~0.30	0.50~3.00	
Medium to finishing		TCMT	090204-MP											●	●	●									0.05~0.18	0.10~1.00		
			090208-MP												●	●	●									0.08~0.20	0.10~1.20	
			110202-MP					●	●			●			●	●	●			●	●					0.03~0.12	0.20~1.50	
			110204-MP					●	●			●			●	●	●			●	●					0.05~0.15	0.20~1.50	
			110208-MP					●	●			●			●	●	●	●		●	●					0.10~0.28	0.25~2.00	
			16T302-MP																							0.08~0.25	0.20~1.50	
			16T304-MP	●	●	●	●	●	●			●		●	●	●	●	●	●	●	●	●	●			0.08~0.20	0.30~2.50	
			16T308-MP	●	●	●	●	●	●			●	●	●	●	●	●	●	●	●	●	●	●			0.10~0.30	0.50~2.50	
			16T312-MP					●	●			●				●					●					0.20~0.40	0.50~2.50	
			220408-MP																							0.20~0.40	0.50~3.50	

➡ Cutting edge geometry A52~A61

➡ Recommended chip breaker B04~B14

➡ Code system B34~B35

● : Stock item

Available tool holders			
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STFCR/L	B194, 245	STWCR/L	B246
STGCR/L	B194		

