

35° Diamond

Positive Insert with Hole

Part Number	Applicable Toolholder Page	Part Number	A	T	Ød	α
VB..22_	C17,C17,C17,C17,C17	VBGW 22_	1/4	1/8	0.110	5°
VB..33_	C17,C17,C17,C17	33_	3/8	3/16	0.173	5°
VC..15_	E36, F58, F61~ F63	VCGW 1515_	3/16	3/32	0.091	7°

Symbol	Cutting Edge Spec.	Example	Edge Prep.	Material	MEGACOAT CBN												Toolholder Page				
					Dimensions (in)		CBN														
Insert				ANSI Part Number	ISO Part Number	rε	S	No. of Edges										Reference Table Below			
				Edge Prep (in)				KBN05M	KBN10M	KBN25M	KBN30M	KBN35M	KBN60M	KBN65M	KBN70M	KBN510	KBN525		KBN475	KBN65B	KBN570
NEW	Sharp Edge		F	Gray Cast Iron (with Scale)	VBGW 221MEF	VBGW 110304MEF	1/64	0.079													D
					222MEF	110308MEF	1/32	0.067	2												
	Rounded Cutting Edge (Hone)		T00315	Nodular Cast Iron (without Scale)	VBGW 331MEF	VBGW 160404MEF	1/64	0.079													E
332MEF					160408MEF	1/32	0.067	2													
	Chamfered Cutting Edge		T00315	Hard Materials (Roughing)	VBGW 2205T00315ME	VBGW 110302T00815ME	0.008	3/32													F
221T00315ME					110304T00815ME	1/64	0.079	2													
	Chamfered and Honed Cutting Edge		S00525	Hard Materials (Finishing)	VBGW 222T00315ME	110308T00815ME	1/32	0.067													G
3305T00315ME					160402T00815ME	0.008	3/32	2													
	Hard Materials (Chip Control)		S00525	Powdered Steel	VBGW 331T00315ME	160404T00815ME	1/64	0.079													H
332T00315ME					160408T00815ME	1/32	0.067	2													
NEW	General Purpose		S00525	Hard Materials (Chip Control)	VBGW 221S00525MES	110304S01225MES	1/64	0.079													I
					222S00525MES	110308S01225MES	1/32	0.067	2												
	Tough		S00435	Hard Materials (Chip Control)	VBGW 331S00525MES	160404S01225MES	1/64	0.079													J
332S00525MES					160408S01225MES	1/32	0.067	2													
	Tough		S00435	Hard Materials (Chip Control)	VBGW 2205S00435MET	VBGW 110302S01035MET	0.008	3/32													K
221S00435MET					110304S01035MET	1/64	0.079	2													
	Tough		S00435	Hard Materials (Chip Control)	222S00435MET	110308S01035MET	1/32	0.067													L
3305S00435MET					160402S01035MET	0.008	3/32	2													
	Tough		S00435	Hard Materials (Chip Control)	331S00435MET	160404S01035MET	1/64	0.079													M
332S00435MET					160408S01035MET	1/32	0.067	2													
	Small Edge		T00315	Hard Materials (Chip Control)	VBGW 2205T00315SE	VBGW 110302T00815SE	0.008	0.110													N
221T00315SE					110304T00815SE	1/64	3/32	1													
	Small Edge		T00315	Hard Materials (Chip Control)	222T00315SE	110308T00815SE	1/32	0.067													O
3305T00315SE					160402T00815SE	0.008	3/32	1													
	Small Edge		T00315	Hard Materials (Chip Control)	331T00315SE	160404T00815SE	1/64	0.079													P
332T00315SE					160408T00815SE	1/32	0.067	1													
	Small Edge		S00435	Hard Materials (Chip Control)	VBGW 221S00435SET	VBGW 110304S01035SET	1/64	0.079													Q
222S00435SET					110308S01035SET	1/32	0.067	1													
	Small Edge		S00435	Hard Materials (Chip Control)	331S00435SET	160404S01035SET	1/64	0.079													R
332S00435SET					160408S01035SET	1/32	0.067	1													
	Multi-Edge		T00315	Hard Materials (Chip Control)	VCGW 151505T00315ME	VCGW 080202T00815ME	0.008	0.079													S
15151T00315ME					080204T00815ME	1/64	0.079	2													
	Multi-Edge		T00315	Hard Materials (Chip Control)	15152T00315ME	080208T00815ME	1/32	0.067													T
					080208T00815ME	1/32	0.067	2													
	Tough		S00435	Hard Materials (Chip Control)	VCGW 151505S00435MET	VCGW 080202S01035MET	0.008	0.079													U
15151S00435MET					080204S01035MET	1/64	0.079	2													
	Tough		S00435	Hard Materials (Chip Control)	15152S00435MET	080208S01035MET	1/32	0.067													V
					080208S01035MET	1/32	0.067	2													
	Small Edge		T00315	Hard Materials (Chip Control)	VCGW 151505T00315SE	VCGW 080202T00815SE	0.008	3/32													W
15151T00315SE					080204T00815SE	1/64	0.079	1													
	Small Edge		S00435	Hard Materials (Chip Control)	VCGW 15151S00435SET	VCGW 080204S01035SET	1/64	0.079													X
15152S00435SET					080208S01035SET	1/32	0.071	1													

Part Number	Applicable Toolholder Page
VB..22_	E30, E31, E36, F60, F63
VB..33_	E30, E31, F60, F63