

● Insert Dimensions

Description		Min. Bore Dia.	Dimension (mm)								Insert Grade						
											Cermet	PVD Coated Carbide		Carbide	CBN	PCD	
		øA	H	L1	L2	F	S	rε			TC60	PR915	PR930	KW10	KBN510	KPD001	KPD010
VNBR	0206-003	2	3.9	26.5	6	1.8	0.25	0.03					●	●			
	0311-003	3		30.8	11	2.6	0.4						●	●			
	0411-003	4		30.8	11	3.5	0.5				●		●	●			
	0420-003			39.8	20						●		●	●			
	0511-003	5		30.8	11	4.5	0.7				●		●	●			
	0520-003	6		39.8	20	5.3	1.0				●		●	●			
	0620-003			39.8	20						●		●	●			
	0630-003			49.8	30						●		●	●			
	0720-003			39.8	20						6.2	1.0	●		●	●	
	0730-003	49.8		30	●		●						●				
VNBR	0206-02	2	3.9	26.5	6	1.8	0.25	0.2					●	●			
	0311-02	3		30.8	11	2.6	0.4					●	●				
	0411-02	4		30.8	11	3.5	0.5					●	●				
	0420-02			39.8	20						●		●	●			
	0511-02	5		30.8	11	4.5	0.7						●	●			
	0520-02	6		39.8	20	5.3	1.0						●	●			
	0620-02			39.8	20						●		●	●			
	0630-02			49.8	30						●		●	●			
	0720-02			39.8	20						6.2	1.0			●	●	
	0730-02	49.8		30	●		●						●				
VNBR	0206-01	2	3.9	26.5	6	1.8	0.25	0.1					●	●			
	0311-01	3		30.8	11	2.6	0.4					●	●				
	0411-01	4		30.8	11	3.5	0.5					●	●				
	0420-01			39.8	20						●		●	●			
	0511-01	5		30.8	11	4.5	0.7						●	●			
	0520-01	6		39.8	20	5.3	1.0						●	●			
	0620-01			39.8	20						●		●	●			
	0630-01			49.8	30						●		●	●			
	0720-01			39.8	20						6.2	1.0			●	●	
	0730-01	49.8		30	●		●						●				
VNBR	0206-003NB	2	3.9	26.5	6	1.8	0.25	0.03					●	●			
	0311-003NB	3		30.8	11	2.6	0.4					●	●				
	0411-003NB	4		30.8	11	3.5	0.5					●	●				
	0420-003NB			39.8	20						●		●	●			
	0511-003NB	5		30.8	11	4.5	0.7						●	●			
	0520-003NB	6		39.8	20	5.3	1.0						●	●			
	0620-003NB			39.8	20						●		●	●			
	0630-003NB			49.8	30						●		●	●			
	0720-003NB			39.8	20						6.2	1.0			●	●	
	0730-003NB	49.8		30	●		●						●				
VNBR	0206-02NB	2	3.9	26.5	6	1.8	0.25	0.2						●			
	0311-02NB	3		30.8	11	2.6	0.4						●				
	0411-02NB	4		30.8	11	3.5	0.5							●		●	●
	0420-02NB			39.8	20						●		●	●			
	0511-02NB	5		30.8	11	4.5	0.7							●		●	●
	0520-02NB	6		39.8	20	5.3	1.0							●		●	●
	0620-02NB			39.8	20						●		●	●			
	0630-02NB			49.8	30						●		●	●			
	0720-02NB			39.8	20						6.2	1.0			●	●	
	0730-02NB	49.8		30	●		●						●		●	●	
VNBTR	0411-003	4	3.9	30.8	11	3.6	1.0	0.03					●	●			
	0420-003			39.8	20							●	●				
	0511-003	5		30.8	11	4.6	1.3						●	●			
	0520-003			39.8	20						●		●	●			
VNBTR	0411-01	4	3.9	30.8	11	3.6	1.0	0.1					●	●			
	0420-01			39.8	20							●	●				
	0511-01	5		30.8	11	4.6	1.3						●	●			
	0520-01			39.8	20						●		●	●			

◆ Recommended Cutting Conditions (In the case of VNB / VNB-NB / VNBT)

Workpiece Material	Recommended Insert Grade (Cutting Speed: m/min)							VNB02 Type		VNB03 Type		VNB04 VNB04 Type		VNB05 VNB06 VNB07 VNB05 Type		Remarks
	Cermet	PVD Coated Carbide	Carbide	CBN	PCD											
	TC60	PR915	PR930	KW10	KBN510	KPD001	KPD010									
	Cut: ap(mm), Feed: f(mm/rev)							ap	f	ap	f	ap	f			
	ap	f	ap	f	ap	f										
Carbon Steel / Alloy Steel	☆ 60~120	☆ 50~150	★ 30~100					~0.3	~0.03	~0.4	~0.04	~0.45	~0.07	~0.5	~0.1	Coolant
Stainless Steel	☆ 50~100	☆ 50~150	★ 30~80					~0.3	~0.02	~0.4	~0.03	~0.45	~0.05	~0.5	~0.07	
Non-ferrous Metals				☆ ~100		★ ~300	☆ ~300	~0.3	~0.05	~0.4	~0.06	~0.45	~0.1	~0.5	~0.15	

★ : 1st Recommendation ☆ : 2nd Recommendation

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)

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System-Tip-Bars are sold in 5 piece boxes.