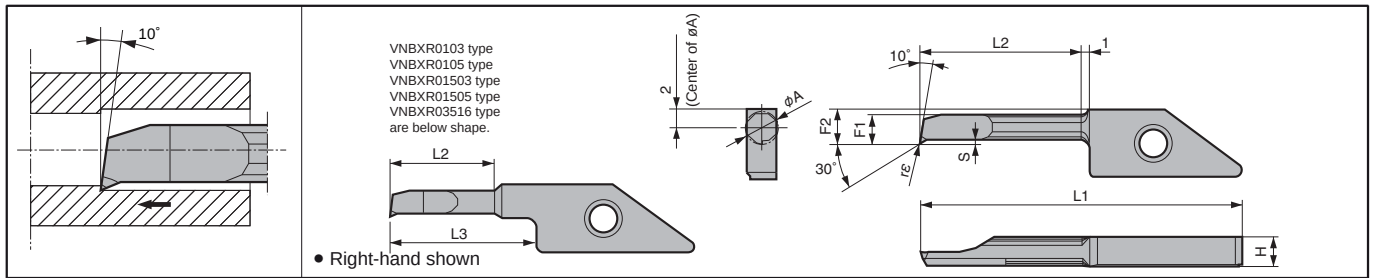


System Tip-Bar

VNBX-S (Boring) [Corner-R (rε) Tolerance: + 0/-0.025mm]



Insert Dimensions (VNBX-S)

Description		Min. Bore Dia.	Dimension (mm)								Insert Grade							
											Cermet		PVD Coated Carbide		Carbide	CBN	PCD	
			∅A	H	L1	L2	L3	F1	F2	S	rε ⁺⁰ _{-0.025}	TC60	PR630	PR915	PR930	KW10	KBN510	KPD001
VNBXR	0103-005S	1.0	3.9	26.5	3	7	0.85	2.5	0.2	0.05				●				
	0105-005S				5						●							
	01503-005S	1.5			3		1.3	2.75				●						
	01505-005S				5						●							
	0206-005S	2.0			6		1.8	3			0.25		●					
	0311-005S	3.0		30.8	11	-	2.6	3.5	0.4			●						
	03511-005S	3.5			39.8	16	21	3.1	3.75		0.45		●					
	03516-005S					30.8	11	-	3.5		4	0.5		●				
	0411-005S	4.0		39.8	20				●									
	0420-005S						●											
VNBXR	01503-01S	1.5	3.9	26.5	3	7	1.3	2.75	0.2	0.1				●				
	01505-01S				5				●									
	0206-01S	2.0			6		1.8	3	0.25			●						
	0311-01S	3.0		30.8	11	-	2.6	3.5	0.4			●						
	03511-01S	3.5			39.8	16	21	3.1	3.75		0.45		●					
	03516-01S			30.8		11	-	3.5	4		0.5		●					
	0411-01S	4.0		39.8	20				●									
	0420-01S						●											
VNBXR	0411-02S	4.0	3.9	30.8	11	-	3.5	4	0.5	0.2				●				
	0420-02S			39.8	20						●							

Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade (Cutting Speed: m/min)								VNBX01-S Type VNBX015-S Type		VNBX02-S Type } VNBX04-S Type		Remarks
	Cermet	PVD Coated Carbide			Carbide	CBN	PCD						
	TC60	PR630	PR915	PR930	KW10	KBN510	KPD001	KPD010					
	Cut: ap (mm), Feed: f (mm/rev)												
	ap	f		ap	f								
Carbon Steel / Alloy Steel				★ 30~100					~0.1	~0.01	~0.2	~0.03	Coolant
Stainless Steel				★ 30~80					~0.1	~0.01	~0.2	~0.02	

Attachment holder for VNBX-S System Tip-Bar

★ : 1st Recommendation

- Attachment holder of VNBX-S System Tip-Bar is below three types (See page F17).
 - SVNS-XN Type (without Side Stopper)
 - S...SVN-XN Type (without Side Stopper)
 - S...SVN-SXN Type (without Side Stopper)
- Above holders assure high index accuracy by easy restraint.
- Clamp screws (SP3×4) are attached. Holders without Side Stopper can be used as a binding effect holder when removing the clamp screws and inserting screws (HS3×4: sold separately) with a wrench (LW-1.5: sold separately).