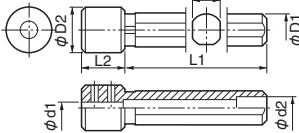


● Applicable Sleeve

This sleeve is for 1-Edge Tip-Bar. For 2-Edges Tip-Bar, use ➔ F19.

Shape	Description	(Previous Description)	Std.	Dimension (mm)								Spare Parts		Applicable Tip-Bar  F20
				$\varnothing$ D1	$\varnothing$ D2	$\varnothing$ d1	$\varnothing$ d2	H	L1	L2				
													Screw	
 (Tip-Bar installation side)	PH 0212-60	PH -0212	●	12	19	1.8	6	11	60	20	HS3 × 4	LW-1.5	PSB%0202-50S / NBS	
	0312-60	-0312	●			2.8							PSB%0303-50S / NBS	
	0412-60	-0412	●			3.8							PSB%0404-60S / NBS PSBT%0415-60S	
	0512-60	-0512	●			4.8							PSB%0505-70S / NBS PSBT%0515-70S	
	0612-60	-0612	●			5.8							PSB%0606-70S / NBS	
	0712-60	-0712	●			6.8							PSB%0707-80S / NBS	
	PH 0216-80	PH -0216	●	16	22	1.8	Rp ^{1/4} (PS ^{1/4})	14	80	20	HS3 × 4	LW-1.5	PSB%0202-50S / NBS	
	0316-80	-0316	●			2.8							PSB%0303-50S / NBS	
	0416-80	-0416	●			3.8							PSB%0404-60S / NBS PSBT%0415-60S	
	0516-80	-0516	●			4.8							PSB%0505-70S / NBS PSBT%0515-70S	
	0616-80	-0616	●			5.8							PSB%0606-70S / NBS	
	0716-80	-0716	●			6.8							PSB%0707-80S / NBS	

◆ Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade (Cutting Speed: m/min)							PSB02 Type	PSB03 Type		PSB04 PSBT04 Type		PSB05 PSB06 PSB07 PSBT05 Type		Remarks		
	Cermet		PVD Coated Carbide		Carbide	CBN	PCD										
	TC60	PR915	PR930	KW10	KBN510 KBN525	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		★ 30~100						-0.3	-0.03	-0.4	-0.04	-0.45	-0.07	-0.5	-0.1	Coolant
Stainless Steel	☆ 50~100		★ 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	
Hard Materials					★ ~100				-	-	-0.07	-0.03	-0.10	-0.05	-0.15	-0.07	

★ : 1st Recommendation ☆ : 2nd Recommendation