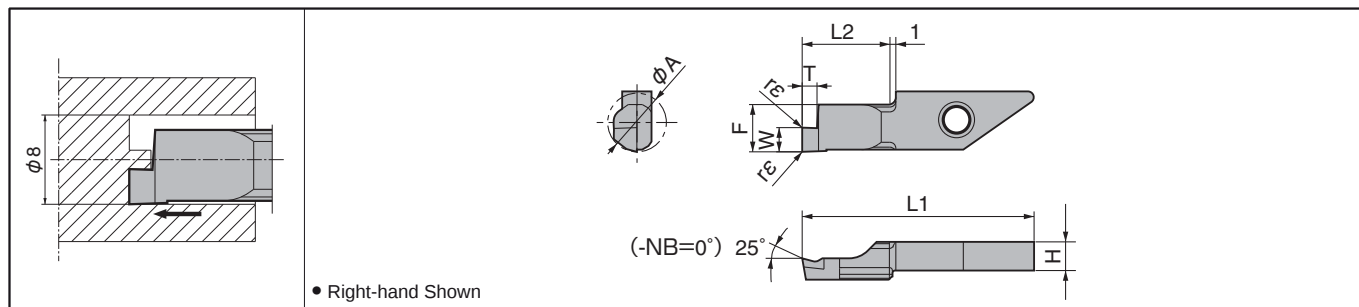


Small Diameter Face Grooving

VNFG (System Tip-Bar)



Insert Dimensions

Classification of usage	P	Carbon Steel / Alloy Steel				●					
	M	Stainless Steel				○					
● : Continuous / 1st Choice	K	Cast Iron					●				
○ : Continuous / 2nd Choice	N	Non-ferrous Metals					○	●			
	S	Titanium Alloy					○	●			
	H	Hard materials (under 40HRC)					●				
		Hard materials (over 40HRC)									

Description		Min. Cutting Dia.	Dimension (mm)							Cermet	PVD Coated Carbide			Carbide	PCD		Ref. Page for Toolholder
			øA	W ^{±0.03}	rε	H	L1	L2	F		T	TC60	PR630		PR915	PR930	
VNFR	0810-10	8	1.0	0.05	3.9	29.6	10	7.3	2.0	●	●		●	●			F12 F13 F14
	0820-10	8	2.0						●	●		●	●				
	0830-10	8	3.0						●	●		●	●				
VNFR	0820-10NB	8	2.0	0.05	3.9	29.6	10	7.3	2.0						○	○	
	0830-10NB	8	3.0						3.0						3.0	○	

* Dimension T shows available grooving depth.

Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade (Cutting Speed: m/min)				VNFG0810	VNFG0820	VNFG0830	Remarks
	Cermet		PVD Coated Carbide					
	TC60	PR630	PR930	KW10				
					f (mm/rev)			
Carbon Steel / Alloy Steel	☆ 60~120	☆ 30~100	★ 30~100		~0.02	~0.04	~0.05	Coolant
Stainless Steel	☆ 50~100	☆ 30~80	★ 30~80		~0.01	~0.02	~0.03	
Non-ferrous Metals				★ ~300	~0.04	~0.06	~0.08	

★ : 1st Recommendation ☆ : 2nd Recommendation

System Tip-Bars are sold in 5 piece boxes.

CBN & PCD Tools are sold in 1 piece boxes. kyocera@kyocera-tools.ru
www.kyocera-tools.ru

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