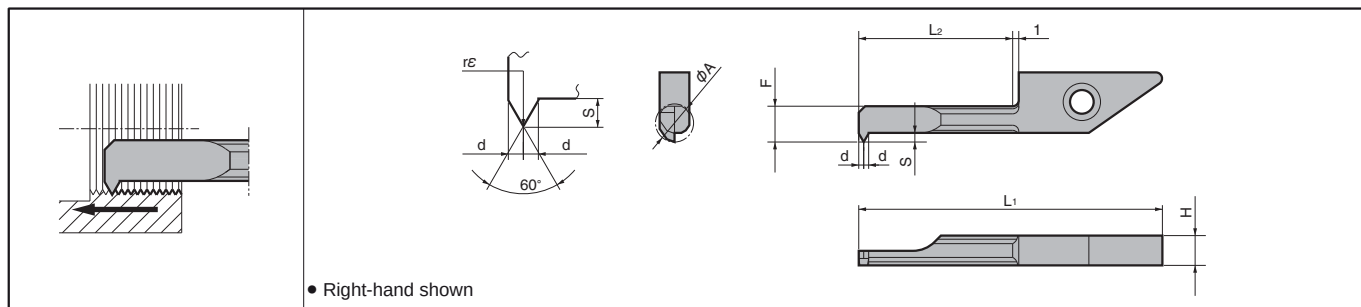


System Tip-Bar for Micro Threading

VNT (System Tip-Bar)



Insert Dimensions

Description		Min. Bore Dia.	Dimension (mm)								Insert Grade			Applicable Thread			
											Cermet	PVD Coated Carbide	Carbide	Metric		Unified	
		∅A	H	L1	L2	F	S	d	rε			TC60	PR930	KW10	Nominal Thread	Pitch (mm)	Nominal Thread
VNTR	045-11	4.5	3.9	30.8	11	3.6	1.3	0.6	0.05			●	●	M6 and over	P0.75 ~P1.25	1/4-20UNC, 1/4-28UNF and over	28~20
	060-11	6.0				4.6	1.6	0.8					●	●	M8 and over	P0.75 ~P1.50	5/16-18UNC, 5/16-24UNF and over

● For applicable Toolholder, see page **F12~F14**.

◆ Depth of Cut & Number of Passes (Metric)

Pitch (mm)	Total ap (mm)	No. of Passes	1 Pass	2 Pass	3 Pass	4 Pass	5 Pass	6 Pass	7 Pass	8 Pass	9 Pass	10 Pass	11 Pass	12 Pass	13 Pass	14 Pass	15 Pass	16 Pass	17 Pass
0.75	0.44	10	0.06	0.06	0.05	0.05	0.05	0.04	0.04	0.03	0.03	0.03							
1.00	0.60	12	0.07	0.07	0.06	0.06	0.06	0.05	0.05	0.04	0.04	0.04	0.03	0.03					
1.25	0.76	14	0.07	0.07	0.07	0.07	0.06	0.06	0.06	0.05	0.05	0.05	0.04	0.04	0.04	0.03			
1.50	0.92	17	0.07	0.07	0.07	0.07	0.06	0.06	0.06	0.06	0.05	0.05	0.05	0.05	0.04	0.04	0.04	0.04	0.03

<Note> 1) The standard cutting speed is $V_c=30\sim50\text{m/min}$. The table feed may not follow the expected conditions when machining small diameter workpieces at high speeds.
2) Coolant is recommended.