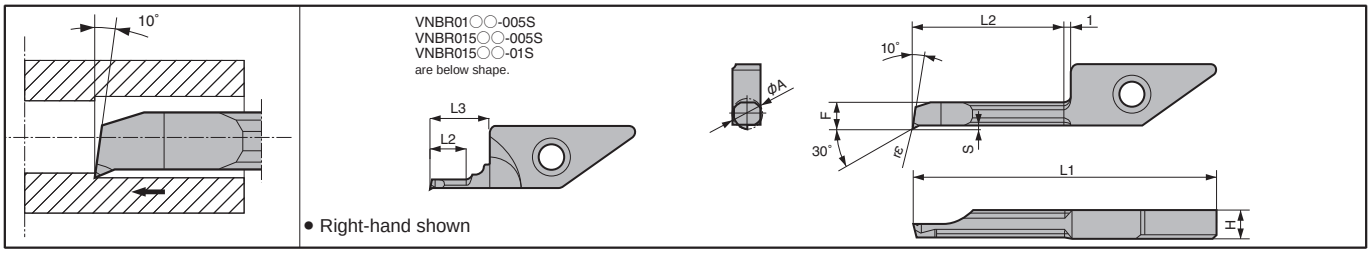
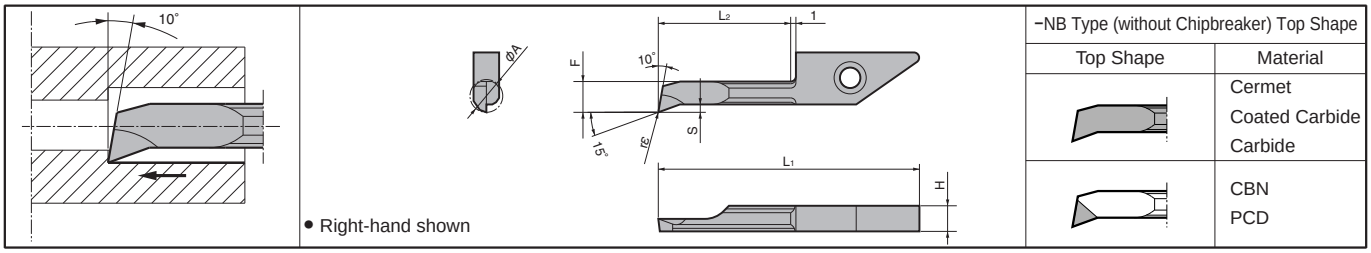
VNB-S (Boring) [Corner-R (rε): Minus tolerance]



● Right-hand shown

VNB (Boring)

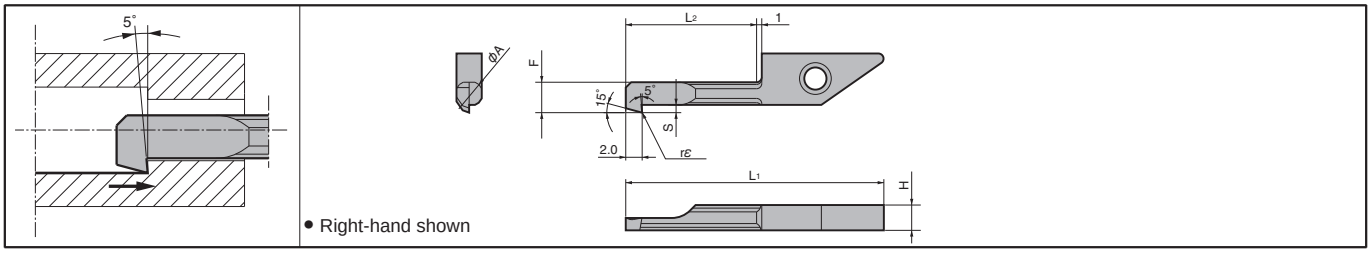


● Right-hand shown

−NB Type (without Chipbreaker) Top Shape

Top Shape	Material
	Cermet Coated Carbide Carbide
	CBN PCD

VNBT (Back Boring)



● Right-hand shown

● Insert Dimensions

Description		Min. Bore Dia.	Dimension (mm)								Insert Grade						
											Cermet	PVD Coated Carbide		Carbide	CBN	PCD	
		øA	H	L1	L2	L3	F	S	rε		TC60	PR915	PR930	KW10	KBN510	KPD001	KPD010
VNBR	0103-005S	1.0	3.9	26.5	3	7	0.85	0.2	+0 -0.02 0.05				●				
	0105-005S				5								●				
	01503-005S	1.5			3		1.3						●				
	01505-005S				5								●				
	0206-005S	2.0			6	-	1.8	0.25					●				
	025075-005S	2.5		28.1	7.5		2.1	0.4					●				
	0311-005S	3.0		30.8	11		2.6	0.4					●				
	03515-005S	3.5		34.8	15		2.9	0.5					●				
	0411-005S	4.0		30.8	11		3.5	0.5					●				
	0420-005S			39.8	20								●				
VNBR	01503-01S	1.5	3.9	26.5	3	7	1.3	0.2	+0 -0.03 0.1				●				
	01505-01S				5								●				
	0206-01S	2.0			6	-	1.8	0.25					●				
	025075-01S	2.5		28.1	7.5		2.1	0.4					●				
	0311-01S	3.0		30.8	11		2.6	0.4					●				
	03515-01S	3.5		34.8	15		2.9	0.5					●				
	0411-01S	4.0		30.8	11		3.5	0.5					●				
	0420-01S			39.8	20								●				
VNBR	0411-02S	4.0	3.9	30.8	11	-	3.5	0.5	+0 -0.04 0.2				●				
	0420-02S			39.8	20								●				

◆ Recommended Cutting Conditions (In the case of VNB-S)

Workpiece Material	Recommended Insert Grade (Cutting Speed: m/min)							VNB01-S Type VNB015-S Type		VNB02-S Type ⟆ VNB04-S Type		Remarks
	Cermet	PVD Coated Carbide		Carbide	CBN	PCD		Cut: ap (mm), Feed: f (mm/rev)				
	TC60	PR915	PR930	KW10	KBN510	KPD001	KPD010	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	

★ : 1st Recommendation
● : Std. Item □ : Check Availability

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