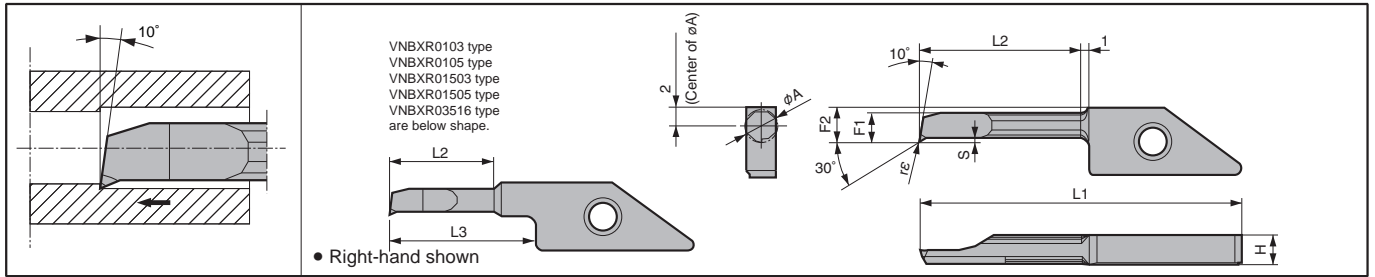


System Tip-Bar

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



Insert Dimensions (VNBX-S)

Description	Min. Bore Dia.	Dimension (mm)								Insert Grade																			
		φA	H	L1	L2	L3	F1	F2	S	rε	Cermet				PVD Coated Carbide		Carbide	CBN	PCD										
											TC60	PR630	PR915	PR930	KW10	KBN510	KPD001	KPD010											
VNBXR 0103-005S 0105-005S 01503-005S 01505-005S 0206-005S 0311-005S 03511-005S 03516-005S 0411-005S 0420-005S	1.0	3.9	26.5	3	7	0.85	2.5	0.2	0.05	+0 -0.02				●															
	1.5			5																									
				3																									
	2.0		5	30.8	6	-	1.8	3			0.25	0.05	+0 -0.02				●												
			3.0																										
	3.5		6	30.8	11	-	2.6	3.5			0.4	0.05	+0 -0.02				●												
			3.5																										
	4.0		3.1	30.8	11	-	3.1	3.75			0.45	0.05	+0 -0.02				●												
			3.5																										
4.0	3.5	39.8	16	21	3.1	3.75	0.45	0.05	+0 -0.02				●																
	4.0																												
VNBXR 01503-01S 01505-01S 0206-01S 0311-01S 03511-01S 03516-01S 0411-01S 0420-01S	1.5	3.9	26.5	3	7	1.3	2.75	0.2	0.1	+0 -0.03				●															
	2.0			5																									
				3.0							6																		
	3.5		3	30.8	11	-	2.6	3.5			0.4	0.1	+0 -0.03				●												
			3.5																										
	4.0		6	30.8	11	-	3.1	3.75			0.45	0.1	+0 -0.03				●												
			3.5																										
	4.0		3.1	39.8	11	-	3.1	3.75			0.45	0.1	+0 -0.03				●												
			4.0																										
4.0	3.5	39.8	16	21	3.1	3.75	0.45	0.1	+0 -0.03				●																
	4.0																												
VNBXR 0411-02S 0420-02S	4.0	3.9	30.8	11	-	3.5	4	0.5	0.2	+0 -0.04				●															
	4.0																												

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	

★ : 1st Recommendation

Attachment holder for VNBX-S System Tip-Bar

- There are three different types of attachment holders for the VNBX-S System Tip-Bar (See page F21).
 - 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 (SP3x4) are attached. Holders without Side Stopper can be used as a binding effect holder when removing the clamp screws and inserting screws (HS3x4: sold separately) with a wrench (LW-1.5: sold separately).

Spare Parts (Optional)

Screw (Side Stopper)	Wrench
HS3x4	LW-1.5

● : Std. Item □ : Check Availability