



VC

07/ 11/ 13/ 16

CARBIDE INSERTS

VC GT	VC GW	VC GX	VC MT	VC MW
186	189	189	190	191

PCD INSERTS

VC MW PCD
192

MATCH THE RIGHT SIZE (example)

Insert	Tool Holder
VC GT 070204E-FF2	SVGCR 1010 M 07

ISO TURNING – EXTERNAL

SVAC(RL)-DC EXT	SVGC(RL) EXT	SVHB(C)(RL) EXT	SVJB(C)(RL) EXT
90° VC.. 13 193 10×10 25×25 186 – 192	90° VC.. 07 194 08×08 16×16 186 – 192	107°30' VB, VC.. 11 16 195 16×16 25×25 168 – 171 186 – 192	93° VB, VC.. 11 13 16 196 12×12 32×25 168 – 171 186 – 192
SVJC(RL)-DC EXT	SVPB(C)(RL) EXT	SVVB(C)N EXT	SVXB(C)(RL) EXT
93° VC.. 13 197 10×10 25×25 186 – 192	117°30' VB, VC.. 11 16 198 16×16 32×25 168 – 171 186 – 192	72°30' VB, VC.. 11 13 16 199 12×12 32×25 168 – 171 186 – 192	98° VB, VC.. 11 13 16 200 12×12 32×25 168 – 171 186 – 192



VC

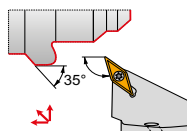
07/ 11/ 13/ 16

C.-SVHB(RL) EXT**107°30'**

VB, VC..



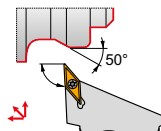
16

C4
C6

201

168 – 171
186 – 192**C.-SVJB(RL) EXT****93°**

VB, VC..

11
16C3
C6

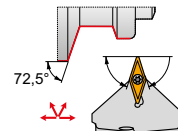
202

168 – 171
186 – 192**C.-SVVBN EXT****72°30'**

VB, VC..



16

C4
C6

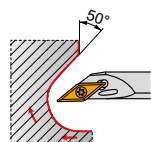
203

168 – 171
186 – 192**ISO TURNING – INTERNAL****SVJB(RL) INT****93°**

VB, VC..



11

25
32

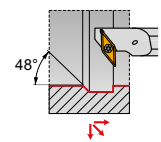
204

168 – 171
186 – 192**SVLC(RL) INT****95°**

VC..



13

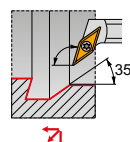
27
43

205

186 – 192

SVQB(C)(RL) INT**107°30'**

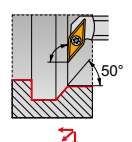
VB, VC..

11
13
1620
50

206

168 – 171
186 – 192**SVUB(C)(RL) INT****93°**

VB, VC..

11
13
1620
50

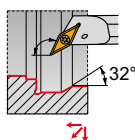
207

168 – 171
186 – 192**SVXC(RL) INT****113°**

VC..



07

12,5
17,5

208

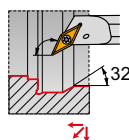
186 – 192

SVXC(RL)-E INT**113°**

VC..



07

12,5
17,5

209

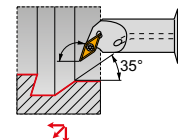
186 – 192

C.-SVQB(C)(RL) INT**108°**

VB, VC..



16



33



210

168 – 171
186 – 192

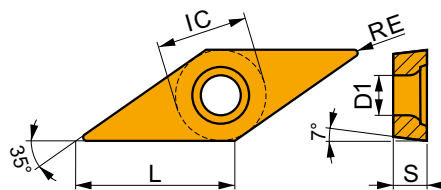
CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----



VCGT

PRAMET

	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
0702	3.970	2.20	6.90	2.38
1102-SF3	6.350	2.80	11.10	2.58
1103	6.350	2.80	11.10	3.18
1103-SF3	6.350	2.80	11.10	3.43
1303	7.940	3.40	13.80	3.18
1303-AL	7.940	3.40	13.80	3.43
1303-SF3	7.940	3.40	13.80	3.43
1604	9.525	4.40	16.60	4.76
1604-SF3	9.525	4.40	16.60	5.01



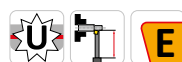
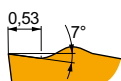
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



AL geometry with highly positive design for fine-finish to rough machining, and continuous to slightly interrupted cuts.

VCGT 070202F-AL	HF7	0.2	—	—	—	—	—	—	—	—	315	0.12	1.0	—	—	—	—	—	—
VCGT 110302F-AL	HF7	0.2	—	—	—	—	—	—	—	—	300	0.12	1.5	—	—	—	—	—	—
	T0315	0.2	—	—	—	—	—	—	—	—	465	0.12	0.8	—	—	—	—	—	—
VCGT 110304F-AL	HF7	0.4	—	—	—	—	—	—	—	—	240	0.24	1.5	—	—	—	—	—	—
	T0315	0.4	—	—	—	—	—	—	—	—	375	0.24	0.8	—	—	—	—	—	—
VCGT 130302F-AL	HF7	0.2	—	—	—	—	—	—	—	—	285	0.12	1.7	—	—	—	—	—	—
	T0315	0.2	—	—	—	—	—	—	—	—	420	0.12	1.7	—	—	—	—	—	—
VCGT 130304F-AL	HF7	0.4	—	—	—	—	—	—	—	—	240	0.24	1.7	—	—	—	—	—	—
	T0315	0.4	—	—	—	—	—	—	—	—	345	0.24	1.7	—	—	—	—	—	—
VCGT 130308F-AL	HF7	0.8	—	—	—	—	—	—	—	—	210	0.48	1.7	—	—	—	—	—	—
	T0315	0.8	—	—	—	—	—	—	—	—	315	0.48	1.7	—	—	—	—	—	—
VCGT 160402F-AL	HF7	0.2	—	—	—	—	—	—	—	—	285	0.12	2.4	—	—	—	—	—	—
	T0315	0.2	—	—	—	—	—	—	—	—	420	0.12	2.4	—	—	—	—	—	—
VCGT 160404F-AL	HF7	0.4	—	—	—	—	—	—	—	—	225	0.24	2.4	—	—	—	—	—	—
	T0315	0.4	—	—	—	—	—	—	—	—	330	0.24	2.4	—	—	—	—	—	—
VCGT 160408F-AL	HF7	0.8	—	—	—	—	—	—	—	—	210	0.48	2.4	—	—	—	—	—	—
	T0315	0.8	—	—	—	—	—	—	—	—	300	0.48	2.4	—	—	—	—	—	—
VCGT 160412F-AL	HF7	1.2	—	—	—	—	—	—	—	—	180	0.72	2.4	—	—	—	—	—	—
	T0315	1.2	—	—	—	—	—	—	—	—	270	0.72	2.4	—	—	—	—	—	—



FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

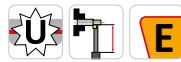
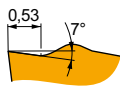
VCGT 070202E-FF2	T8315	0.2	150	0.05	0.8	—	—	—	140	0.05	0.8	—	—	—	—	—	—	—	—
	T8330	0.2	145	0.05	0.8	—	—	—	135	0.05	0.8	—	—	—	—	—	—	—	—
	T8430	0.2	190	0.05	0.8	—	—	—	155	0.05	0.8	—	—	—	—	—	—	—	—
VCGT 070204E-FF2	T8315	0.4	125	0.12	0.8	—	—	—	115	0.12	0.8	—	—	—	—	—	—	—	—
	T8330	0.4	120	0.12	0.8	—	—	—	110	0.12	0.8	—	—	—	—	—	—	—	—
	T8430	0.4	145	0.12	0.8	—	—	—	120	0.12	0.8	—	—	—	—	—	—	—	—
VCGT 130302E-FF2	T5315	0.2	250	0.05	1.0	—	—	—	235	0.05	1.0	—	—	—	—	—	—	—	—
	T7325	0.2	165	0.05	1.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.2	140	0.05	1.0	—	—	—	130	0.05	1.0	—	—	—	—	—	—	—	—
	T8430	0.2	185	0.05	1.0	—	—	—	150	0.05	1.0	—	—	—	—	—	—	—	—
	T9315	0.2	265	0.05	1.0	—	—	—	250	0.05	1.0	—	—	—	—	—	—	—	—
	T9325	0.2	240	0.05	1.0	—	—	—	225	0.05	1.0	—	—	—	—	—	—	—	—
	TT010	0.2	240	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----



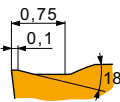
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

VCGT 130304E-FF2	T5315	0.4	195	0.12	1.0	—	—	—	185	0.12	1.0	—	—	—	—	—	—	—	—	—
	T7325	0.4	135	0.12	1.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	115	0.12	1.0	—	—	—	105	0.12	1.0	—	—	—	—	—	—	—	—	—
	T8430	0.4	140	0.12	1.0	—	—	—	115	0.12	1.0	—	—	—	—	—	—	—	—	—
	T9315	0.4	195	0.12	1.0	—	—	—	185	0.12	1.0	—	—	—	—	—	—	—	—	—
	T9325	0.4	175	0.12	1.0	—	—	—	165	0.12	1.0	—	—	—	—	—	—	—	—	—
VCGT 130308E-FF2	TT010	0.4	245	0.06	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T7325	0.8	145	0.17	1.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9315	0.8	200	0.17	1.0	—	—	—	190	0.17	1.0	—	—	—	—	—	—	—	—	—
	T9325	0.8	180	0.17	1.0	—	—	—	170	0.17	1.0	—	—	—	—	—	—	—	—	—
	TT010	0.8	245	0.10	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



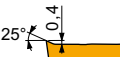
FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

VCGT 130308E-FM2	T8330	0.8	125	0.17	1.0	75	0.15	1.0	115	0.17	1.0	—	—	—	—	—	—	—	—	—
	T8430	0.8	145	0.17	1.0	80	0.15	1.0	120	0.17	1.0	—	—	—	—	—	—	—	—	—
	T9325	0.8	180	0.17	1.0	105	0.15	1.0	170	0.17	1.0	—	—	—	—	—	—	—	—	—



NF2 geometry with positive design for fine-finish to semi-rough machining, and continuous cuts.

VCGT 130302E-NF2	H07	0.2	—	—	—	60	0.09	1.0	95	0.10	1.0	310	0.12	1.0	30	0.07	0.8	—	—	—
	T6310	0.2	125	0.07	1.0	90	0.06	1.0	100	0.07	1.0	375	0.08	1.0	35	0.06	0.8	—	—	—
	T7325	0.2	150	0.07	1.0	115	0.06	1.0	—	—	—	—	—	—	45	0.06	0.8	—	—	—
	T7335	0.2	150	0.07	1.0	115	0.06	1.0	—	—	—	—	—	—	45	0.06	0.8	—	—	—
	T9315	0.2	200	0.10	1.0	—	—	—	190	0.10	1.0	—	—	—	—	—	—	—	—	—
	T9325	0.2	210	0.07	1.0	125	0.06	1.0	195	0.07	1.0	—	—	—	45	0.06	0.8	—	—	—
	T9335	0.2	155	0.10	1.0	90	0.09	1.0	—	—	—	—	—	—	30	0.07	0.8	—	—	—
	TT010	0.2	240	0.05	0.5	140	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—
VCGT 130304E-NF2	H07	0.4	—	—	—	60	0.11	1.0	95	0.12	1.0	310	0.14	1.0	30	0.11	0.8	—	—	—
	T5315	0.4	195	0.12	1.0	—	—	—	185	0.12	1.0	—	—	—	—	—	—	—	—	—
	T6310	0.4	115	0.12	1.0	80	0.11	1.0	90	0.12	1.0	345	0.14	1.0	30	0.11	0.8	—	—	—
	T7325	0.4	135	0.12	1.0	105	0.11	1.0	—	—	—	—	—	—	40	0.08	0.8	—	—	—
	T7335	0.4	135	0.12	1.0	105	0.11	1.0	—	—	—	—	—	—	40	0.08	0.8	—	—	—
	T9315	0.4	210	0.10	1.0	—	—	—	195	0.10	1.0	—	—	—	—	—	—	—	—	—
	T9325	0.4	175	0.12	1.0	105	0.11	1.0	165	0.12	1.0	—	—	—	35	0.08	0.8	—	—	—
	T9335	0.4	150	0.12	1.0	90	0.11	1.0	—	—	—	—	—	—	30	0.11	0.8	—	—	—
	TT010	0.4	245	0.06	0.5	145	0.06	0.5	—	—	—	—	—	—	—	—	—	—	—	—
VCGT 130308E-NF2	T5315	0.8	205	0.17	1.0	—	—	—	190	0.17	1.0	—	—	—	—	—	—	—	—	—
	T6310	0.8	125	0.17	1.0	90	0.15	1.0	100	0.17	1.0	375	0.20	1.0	35	0.12	0.8	—	—	—
	T7325	0.8	145	0.17	1.0	110	0.15	1.0	—	—	—	—	—	—	45	0.12	0.8	—	—	—
	T7335	0.8	140	0.17	1.0	105	0.15	1.0	—	—	—	—	—	—	45	0.12	0.8	—	—	—
	T9315	0.8	200	0.17	1.0	—	—	—	190	0.17	1.0	—	—	—	—	—	—	—	—	—
	T9325	0.8	180	0.17	1.0	105	0.15	1.0	170	0.17	1.0	—	—	—	40	0.12	0.8	—	—	—
	T9335	0.8	155	0.18	1.0	90	0.16	1.0	—	—	—	—	—	—	30	0.16	0.8	—	—	—
	TT010	0.8	245	0.10	0.8	145	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—



SF2 geometry with highly positive design for fine to finish machining, and continuous cuts.

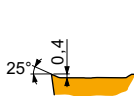
VCGT 130301E-SF2	H07	0.1	—	—	—	80	0.05	1.0	—	—	—	405	0.06	1.0	40	0.04	0.8	—	—	—
	T6310	0.1	140	0.05	1.0	100	0.05	1.0	—	—	—	420	0.06	1.0	40	0.04	0.8	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----



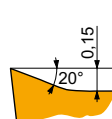
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



SF2 geometry with highly positive design for fine to finish machining, and continuous cuts.

VCGT 130302E-SF2	H07	0.2	—	—	—	80	0.05	1.0	—	—	—	405	0.06	1.0	40	0.04	0.8	—	—	—
	HF7	0.2	—	—	—	90	0.05	1.0	—	—	—	450	0.06	1.0	—	—	—	—	—	—
	T6310	0.2	140	0.05	1.0	100	0.05	1.0	—	—	—	420	0.06	1.0	40	0.04	0.8	—	—	—
VCGT 130304E-SF2	H07	0.4	—	—	—	65	0.09	1.0	—	—	—	335	0.12	1.0	30	0.07	0.8	—	—	—
	HF7	0.4	—	—	—	75	0.09	1.0	—	—	—	375	0.12	1.0	—	—	—	—	—	—
	T6310	0.4	125	0.10	1.0	90	0.09	1.0	—	—	—	375	0.12	1.0	35	0.07	0.8	—	—	—
VCGT 130308E-SF2	H07	0.8	—	—	—	75	0.09	1.0	—	—	—	390	0.12	1.0	35	0.08	0.8	—	—	—
	HF7	0.8	—	—	—	85	0.09	1.0	—	—	—	435	0.12	1.0	—	—	—	—	—	—
	T6310	0.8	145	0.10	1.0	100	0.09	1.0	—	—	—	435	0.12	1.0	40	0.08	0.8	—	—	—



SF3 geometry with highly positive design for fine to finish machining, and continuous cuts.

VCGT 070202E-SF3	H07	0.2	—	—	—	80	0.05	0.8	130	0.05	0.8	415	0.06	0.8	40	0.04	0.6	—	—	—
	T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.15	1.0
VCGT 070204E-SF3	T6310	0.4	125	0.10	0.8	90	0.09	0.8	100	0.10	0.8	375	0.12	0.8	35	0.07	0.6	25	0.15	1.0
VCGT 110201E-SF3	T6310	0.1	140	0.05	0.5	100	0.05	0.5	110	0.05	0.5	420	0.06	0.5	40	0.04	0.4	25	0.15	1.0
VCGT 110202E-SF3	H07	0.2	—	—	—	80	0.05	0.8	130	0.05	0.8	415	0.06	0.8	40	0.04	0.6	—	—	—
	T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.15	1.0
	T8315	0.2	150	0.05	0.8	90	0.05	0.8	140	0.05	0.8	450	0.06	0.8	35	0.04	0.6	30	0.15	1.0
VCGT 110204E-SF3	H07	0.4	—	—	—	65	0.09	0.8	105	0.10	0.8	335	0.12	0.8	30	0.07	0.6	—	—	—
	T6310	0.4	125	0.10	0.8	90	0.09	0.8	100	0.10	0.8	375	0.12	0.8	35	0.07	0.6	25	0.15	1.0
	T8315	0.4	135	0.10	0.8	80	0.09	0.8	125	0.10	0.8	405	0.12	0.8	30	0.07	0.6	25	0.15	1.0
VCGT 110301E-SF3	T6310	0.1	140	0.05	0.5	100	0.05	0.5	110	0.05	0.5	420	0.06	0.5	40	0.04	0.4	25	0.15	1.0
VCGT 110302E-SF3	T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.15	1.0
VCGT 110304E-SF3	T6310	0.4	125	0.10	0.8	90	0.09	0.8	100	0.10	0.8	375	0.12	0.8	35	0.07	0.6	25	0.15	1.0
VCGT 130302E-SF3	H07	0.2	—	—	—	80	0.05	0.8	130	0.05	0.8	415	0.06	0.8	40	0.04	0.6	—	—	—
	T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.15	1.0
	T8315	0.2	150	0.05	0.8	90	0.05	0.8	140	0.05	0.8	450	0.06	0.8	35	0.04	0.6	30	0.15	1.0
VCGT 130304E-SF3	H07	0.4	—	—	—	65	0.09	1.0	105	0.10	1.0	335	0.12	1.0	30	0.07	0.8	—	—	—
	T6310	0.4	125	0.10	1.0	90	0.09	1.0	100	0.10	1.0	375	0.12	1.0	35	0.07	0.8	25	0.15	1.0
	T8315	0.4	130	0.10	1.0	75	0.09	1.0	120	0.10	1.0	390	0.12	1.0	30	0.07	0.8	25	0.15	1.0
VCGT 130308E-SF3	H07	0.8	—	—	—	75	0.09	1.0	120	0.10	1.0	390	0.12	1.0	35	0.08	0.8	—	—	—
	T6310	0.8	145	0.10	1.0	100	0.09	1.0	115	0.10	1.0	435	0.12	1.0	40	0.08	0.8	25	0.15	1.0
	T8315	0.8	155	0.10	1.0	90	0.09	1.0	145	0.10	1.0	465	0.12	1.0	35	0.08	0.8	30	0.15	1.0
VCGT 160402E-SF3	T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.15	1.0
VCGT 160404E-SF3	H07	0.4	—	—	—	65	0.09	1.0	105	0.10	1.0	335	0.12	1.0	30	0.07	0.8	—	—	—
	T6310	0.4	125	0.10	1.0	90	0.09	1.0	100	0.10	1.0	375	0.12	1.0	35	0.07	0.8	25	0.15	1.0
	T8315	0.4	130	0.10	1.0	75	0.09	1.0	120	0.10	1.0	390	0.12	1.0	30	0.07	0.8	25	0.15	1.0
VCGT 160408E-SF3	H07	0.8	—	—	—	75	0.09	1.2	120	0.10	1.2	390	0.12	1.2	35	0.08	1.0	—	—	—
	T6310	0.8	145	0.10	1.2	100	0.09	1.2	115	0.10	1.2	435	0.12	1.2	40	0.08	1.0	25	0.15	1.0
	T8315	0.8	155	0.10	1.2	90	0.09	1.2	145	0.10	1.2	465	0.12	1.2	35	0.08	1.0	30	0.15	1.0
VCGT 160412E-SF3	H07	1.2	—	—	—	60	0.18	1.2	95	0.20	1.2	310	0.24	1.2	30	0.14	1.0	—	—	—
	T6310	1.2	125	0.20	1.2	90	0.18	1.2	100	0.20	1.2	375	0.24	1.2	35	0.14	1.0	25	0.15	1.0

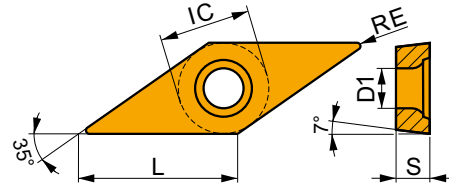
CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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VCGW

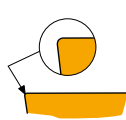


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1303	7.940	3.40	13.80	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



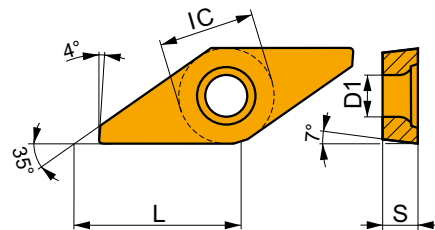
For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

VCGW 130302	T5305	0.2	—	—	—	—	—	—	170	0.08	1.3	—	—	—	—	—	—	35	0.15	1.0
VCGW 130304	T5305	0.4	—	—	—	—	—	—	165	0.10	1.3	—	—	—	—	—	—	35	0.15	1.0
VCGW 130308	T5305	0.8	—	—	—	—	—	—	160	0.18	1.3	—	—	—	—	—	—	30	0.15	1.0

VCGX

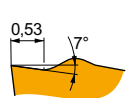


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1303	7.940	3.40	13.80	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



FR-FF2 geometry with positive right-handed design for fine-finish to finish machining, and continuous cuts.

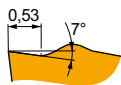
VCGX 130300FR-FF2	T6310	0.0	■	140	0.05	1.0	—	—	—	■	110	0.05	1.0	—	—	—	—	—	—	—
	T8315	0.0	■	150	0.05	1.0	—	—	—	■	140	0.05	1.0	—	—	—	—	—	—	—
	TT010	0.0	■	240	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—
VCGX 130301FR-FF2	T6310	0.1	■	140	0.05	1.0	—	—	—	■	110	0.05	1.0	—	—	—	—	—	—	—
	T8315	0.1	■	150	0.05	1.0	—	—	—	■	140	0.05	1.0	—	—	—	—	—	—	—
	TT010	0.1	■	240	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



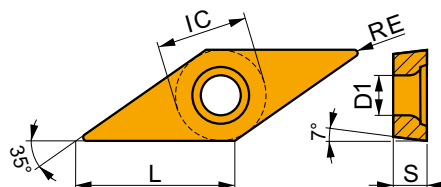
FL-FF2 geometry with positive left-handed design for fine-finish to finish machining, and continuous cuts.

VCGX 130300FL-FF2	T6310	0.0	140	0.05	1.0	—	—	—	110	0.05	1.0	—	—	—	—	—	—	—	—	—
	T8315	0.0	150	0.05	1.0	—	—	—	140	0.05	1.0	—	—	—	—	—	—	—	—	—
	TT010	0.0	240	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
VCGX 130301FL-FF2	T6310	0.1	140	0.05	1.0	—	—	—	110	0.05	1.0	—	—	—	—	—	—	—	—	—
	T8315	0.1	150	0.05	1.0	—	—	—	140	0.05	1.0	—	—	—	—	—	—	—	—	—

VCMT

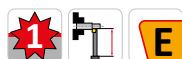
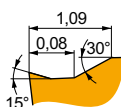


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



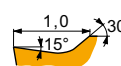
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

VCMT 160404E-FM	T7325	0.4	125	0.19	1.2	95	0.17	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	130	0.12	1.2	75	0.11	1.2	120	0.12	1.2	390	0.14	1.2	—	—	—	—	—	—
	T8430	0.4	150	0.12	1.2	80	0.11	1.2	125	0.12	1.2	420	0.14	1.2	—	—	—	—	—	—
	T9315	0.4	210	0.12	1.2	—	—	—	195	0.12	1.2	—	—	—	—	—	—	—	—	—
	T9325	0.4	155	0.19	1.2	90	0.17	1.2	145	0.19	1.2	—	—	—	—	—	—	—	—	—
VCMT 160408E-FM	T7325	0.8	155	0.17	1.2	120	0.15	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	135	0.17	1.2	80	0.15	1.2	125	0.17	1.2	405	0.20	1.2	—	—	—	—	—	—
	T8430	0.8	155	0.17	1.2	85	0.15	1.2	130	0.17	1.2	435	0.20	1.2	—	—	—	—	—	—
	T9315	0.8	220	0.17	1.2	—	—	—	205	0.17	1.2	—	—	—	—	—	—	—	—	—
	T9325	0.8	195	0.17	1.2	115	0.15	1.2	185	0.17	1.2	—	—	—	—	—	—	—	—	—



UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

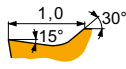
VCMT 110304E-UR	T7325	0.4	110	0.19	0.8	85	0.17	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	110	0.12	0.8	65	0.11	0.8	100	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	135	0.12	0.8	75	0.11	0.8	110	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	190	0.12	0.8	—	—	—	180	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	140	0.19	0.8	80	0.17	0.8	130	0.19	0.8	—	—	—	—	—	—	—	—	—
VCMT 110308E-UR	T7325	0.8	140	0.17	0.8	105	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	125	0.17	0.8	75	0.15	0.8	115	0.17	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.8	140	0.17	0.8	75	0.15	0.8	115	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.8	195	0.17	0.8	—	—	—	185	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	175	0.17	0.8	105	0.15	0.8	165	0.17	0.8	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



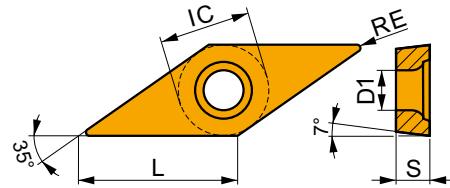
UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

VCMT 160404E-UR	T7325	0.4	110	0.19	1.2	85	0.17	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	110	0.12	1.2	65	0.11	1.2	100	0.12	1.2	—	—	—	—	—	—	—	—	—
	T8430	0.4	130	0.12	1.2	70	0.11	1.2	105	0.12	1.2	—	—	—	—	—	—	—	—	—
	T9315	0.4	180	0.12	1.2	—	—	—	170	0.12	1.2	—	—	—	—	—	—	—	—	—
	T9325	0.4	135	0.19	1.2	80	0.17	1.2	125	0.19	1.2	—	—	—	—	—	—	—	—	—
VCMT 160408E-UR	T7325	0.8	135	0.17	1.2	105	0.15	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	115	0.17	1.2	65	0.15	1.2	105	0.17	1.2	—	—	—	—	—	—	—	—	—
	T8430	0.8	135	0.17	1.2	75	0.15	1.2	110	0.17	1.2	—	—	—	—	—	—	—	—	—
	T9315	0.8	190	0.17	1.2	—	—	—	180	0.17	1.2	—	—	—	—	—	—	—	—	—
	T9325	0.8	170	0.17	1.2	100	0.15	1.2	160	0.17	1.2	—	—	—	—	—	—	—	—	—

VCMW

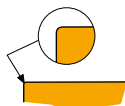


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

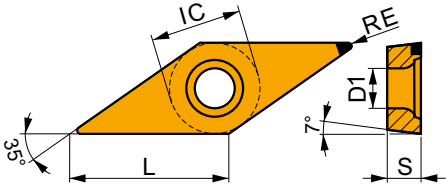
VCMW 110302	T5305	0.2	—	—	—	—	—	—	170	0.08	1.2	—	—	—	—	—	—	35	0.15	1.0
	T5315	0.2	—	—	—	—	—	—	145	0.08	1.2	—	—	—	—	—	—	30	0.15	1.0
	T6310	0.2	—	—	—	—	—	—	70	0.08	1.2	—	—	—	—	—	—	15	0.15	1.0
VCMW 110304	T5305	0.4	—	—	—	—	—	—	165	0.10	1.2	—	—	—	—	—	—	35	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	145	0.10	1.2	—	—	—	—	—	—	30	0.15	1.0
	T6310	0.4	—	—	—	—	—	—	70	0.10	1.2	—	—	—	—	—	—	15	0.15	1.0
VCMW 160404	T5305	0.4	—	—	—	—	—	—	165	0.10	1.5	—	—	—	—	—	—	35	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	140	0.10	1.5	—	—	—	—	—	—	30	0.15	1.0
	T6310	0.4	—	—	—	—	—	—	70	0.10	1.5	—	—	—	—	—	—	15	0.15	1.0
VCMW 160408	T5305	0.8	—	—	—	—	—	—	155	0.18	1.5	—	—	—	—	—	—	30	0.15	1.0
	T5315	0.8	—	—	—	—	—	—	135	0.18	1.5	—	—	—	—	—	—	25	0.15	1.0
	T6310	0.8	—	—	—	—	—	—	70	0.18	1.5	—	—	—	—	—	—	15	0.15	1.0



VCMW PCD

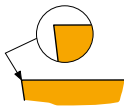


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1604	9.525	4.40	16.60	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE [mm]	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



PCD tipped for finish to semi-rough machining, high speeds and stable cutting conditions.

VCMW 160404FN	PD1	0.4	—	—	—	—	—	—	—	—	—	900	0.12	0.5	—	—	—	—	—	—
VCMW 160408FN	PD1	0.8	—	—	—	—	—	—	—	—	—	1050	0.12	1.0	—	—	—	—	—	—