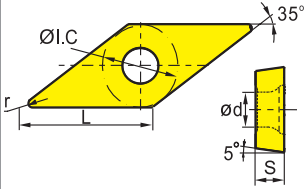




Cemented carbide and cermet inserts

VB □ □ (Positive inserts)

😊 Good working condition 😐 Normal working condition 😞 Bad working condition



P Steel	😊 😊 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐
M Stainless steel	😊 😊 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐
K Cast iron	😊 😊 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐
N Non-ferrous metal	😊 😊 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐
S Heat resistant alloy, Ti alloy	😊 😊 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐 😐

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide															Cermet Coated cermet	Cemented carbide										
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBG302	YBM151	YBM153	YBM215			YBM251	YBM253	YBS103	YBD052	YBD102	YBD152	YBD252			
	SF VBGT110302-SF	11	6.35	3.18	2.8	0.2								○																○	○		
	VBGT110304-SF	11	6.35	3.18	2.8	0.4								○																	○	○	
For extra finishing																																	
	EF VBMT110302-EF	11	6.35	3.18	2.8	0.2							○	●	★						★	○											
	VBMT110304-EF	11	6.35	3.18	2.8	0.4							○	●	★						★	○											
	VBMT110308-EF	11	6.35	3.18	2.8	0.8							○	●	★						○	○											
	VBMT160404-EF	16.5	9.525	4.76	4.4	0.4							○	●	★						★	●											
	VBMT160408-EF	16.5	9.525	4.76	4.4	0.8							○	●	★						○	●											
For finishing																																	
	HF VBMT110202-HF	11	6.35	2.38	2.8	0.2								●	○		●																
	VBMT110204-HF	11	6.35	2.38	2.8	0.4								●	○		○										○						
	VBMT110208-HF	11	6.35	2.38	2.8	0.8								●	○		○																
For finishing																																	
	NF VBET160404-NF	16.5	9.525	4.76	4.4	0.4								●	★																		
	VBET160408-NF	16.5	9.525	4.76	4.4	0.8								●	★																		
For finishing																																	
	NGF VBET160404-NGF	16.5	9.525	4.76	4.4	0.4								○	●																		
	VBET160408-NGF	16.5	9.525	4.76	4.4	0.8								○	●																		
	VBET160412-NGF	16.5	9.525	4.76	4.4	1.2								○	●																		
For finishing																																	

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool

SVJBR/L
Kr:93°



Page A189

SVABR/L
Kr:90°



A190

SVVBN
Kr:72°30'



A191

SVQBR/L
Kr:107°30'



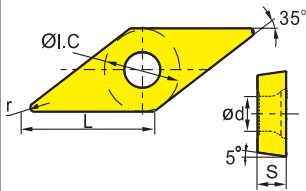
A226

SVUBR/L
Kr:93°



A227

VB□□ (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material	P Steel	M Stainless steel	K Cast iron	N Non-ferrous metal	S Heat resistant alloy, Ti alloy
	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide												Cermet	Coated cermet	Cemented carbide																
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBG302				YBM151	YBM153	YBM215	YBM251	YBM253	YBS103	YBD052	YBD102	YBD152	YBD252	YNG151	YNG151C	YD101	YD201		
EM For semi-finishing	VBMT110304-EM	11	6.35	3.18	2.8	0.4									●	★					○		★														
	VBMT110308-EM	11	6.35	3.18	2.8	0.8									●	★					○		★														
HM For semi-finishing	VBMT160404-HM	16.5	9.525	4.76	4.4	0.4	★	●	★	●				●							●				●											○	
	VBMT160408-HM	16.5	9.525	4.76	4.4	0.8	★	●	★	●				●							●				●	●										○	
	VBMT160412-HM	16.5	9.525	4.76	4.4	1.2				●				○							○						○									○	
HR For roughing	VBMT160404-HR	16.5	9.525	4.76	4.4	0.4	★	●	○	●																											
	VBMT160408-HR	16.5	9.525	4.76	4.4	0.8	○	●	○	●																	○										
	VBMT160412-HR	16.5	9.525	4.76	4.4	1.2																															
SNR For roughing	VBMT160408-SNR	16.5	9.525	4.76	4.4	0.8								○	●										●												
	VBMT160412-SNR	16.5	9.525	4.76	4.4	1.2								○	●										○												

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool



Page A189

A190

A191

A226

A227

Insert code key
A50-A51

Grade selection reference
A19/A36-A48

Chipbreaker selection reference
A22-A35

Recommended cutting parameters
A241-A244