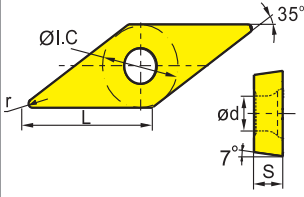


VC (Positive inserts)



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

General turning

Cemented carbide and cermet inserts

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet Coated cermet	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				
 For extra finishing	USF VCGT080201R-USF	8	4.76	2.38	2.3	0.1										○	○																						
	VCGT080202R-USF	8	4.76	2.38	2.3	0.2										●	○																						
	VCGT110301R-USF	11	6.35	3.18	2.8	0.1										●	○																						
	VCGT110302R-USF	11	6.35	3.18	2.8	0.2										●	○																						
 For extra finishing	USF VCGT080201L-USF	8	4.76	2.38	2.3	0.1										○	○																						
	VCGT080202L-USF	8	4.76	2.38	2.3	0.2										○	○																						
	VCGT110301L-USF	11	6.35	3.18	2.8	0.1										○	○																						
	VCGT110302L-USF	11	6.35	3.18	2.8	0.2										●	○																						
 For extra finishing	SF VCGT110302-SF	11	6.35	3.18	2.8	0.2											○																					○	★
	VCGT110304-SF	11	6.35	3.18	2.8	0.4											○																				○	★	
 For finishing	HF VCGT110304-HF	11	6.35	3.18	2.8	0.4										●																							
 For finishing	NF VCGT160408-NF	16.5	9.525	4.76	4.4	0.8											●	★																					
 For finishing	NGF VCGT160408-NGF	16.5	9.525	4.76	4.4	0.8											○	●			○																		

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

Applicable tool



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Insert code key

A50-A51

Grade selection reference

A19/A36-A48

Chipbreaker selection reference

A22-A35

Recommended cutting parameters

A241-A244

