

VB	CARBIDE Positive					ISO513	HC-CVD						HC-PVD		HW		HT						
	Size	IC	S	D1	AN		P	JC7010	JC7020	JC8005	JC8015	JC8025	JC9010	JC9025	JPS015	JPS025	JPS010	JU6010	JU6020	JU4015	JP4020		
	1103□	6.35	3.18	2.80	5°		M			200 380	180 360	140 300			80 220	60 180				200 380	200 400		
	1604□	9,525	4,76	4,40	5°	K	180 380	150 300				150 280	120 240	80 170	60 120				160 280	160 300			
						N										600 2200	600 2000	500 1500					
						S								40 80									
						H																	
GRADE APPLICATION AREA		Stable machining, continuous cut																					
main application		General machining, light interruption																					
applicable		Unstable machining, interrupted cut																					

  

	PPF P M	VBET	110302%-PPF	RE 0.2	a <sub>p</sub> 0.10 f <sub>n</sub> 0.04	0.40 0.07	0.70 0.10	Hardness		Toughness		Application												
								-	+	-	+	TURNING	THREADING	GROOVING	MILLING	DRILLING	ACCESSORIES							
FINISHING	ground chipbreaker, picture: right-hand		110304%-PPF	RE 0.4	a <sub>p</sub> 0.10 f <sub>n</sub> 0.04	0.40 0.08	0.70 0.12																	
		sharp edge	VBMT	110304-PFU	RE 0.4	a <sub>p</sub> 0.20 f <sub>n</sub> 0.05	0.80 0.11	1.40 0.17																
VBMT	160404-PFU		RE 0.4	a <sub>p</sub> 0.30 f <sub>n</sub> 0.06	1.00 0.14	1.70 0.22																		
VBMT	160408-PFU		RE 0.8	a <sub>p</sub> 0.30 f <sub>n</sub> 0.08	1.00 0.16	1.70 0.24																		
MEDIUM	ground chipbreaker, picture: right-hand	VBET	110302%-PPM	RE 0.2	a <sub>p</sub> 0.40 f <sub>n</sub> 0.03	1.00 0.05	1.60 0.07																	
			110304%-PPM	RE 0.4	a <sub>p</sub> 0.40 f <sub>n</sub> 0.03	1.00 0.06	1.60 0.09																	
	general purpose	VBMT	160404-PMU	RE 0.4	a <sub>p</sub> 0.60 f <sub>n</sub> 0.07	1.80 0.16	3.00 0.25																	
			160408-PMU	RE 0.8	a <sub>p</sub> 0.60 f <sub>n</sub> 0.08	1.80 0.19	3.00 0.30																	
ROUGHING	reinforced edge	VBMT	160408-PRU	RE 0.8	a <sub>p</sub> 1.50 f <sub>n</sub> 0.12	2.50 0.22	3.50 0.32																	

● stock standard

