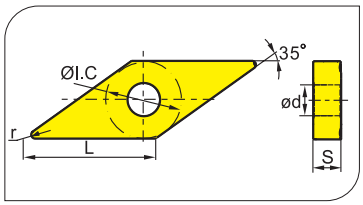
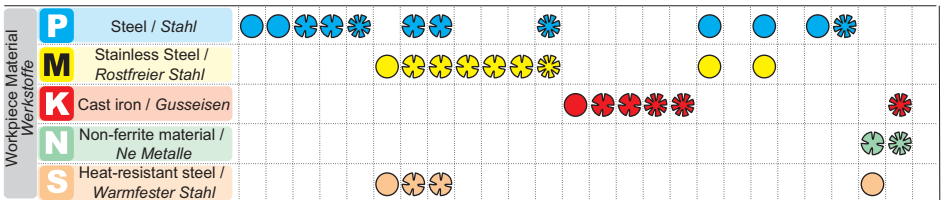
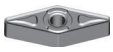
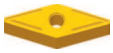
VN** Negative Insert·Negative WSP

Ideal Machining Condition / Gute Bearbeitungsbedingungen
Normal Machining Condition / Normale Bearbeitungsbedingungen
Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen





Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall																Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall			
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD101	YD201
PM Medium Cut/ Mittl. Bearb.	**VNMG160404-PM**	16.6	9.525	4.76	3.81	0.4	●	●	●	●	●									●											○
	VNMG160408-PM	16.6	9.525	4.76	3.81	0.8	●	○	●	○	●								●	●		●									○
	VNMG160412-PM	16.6	9.525	4.76	3.81	1.2			●		○								●	●		○									
DM Medium Cut/ Mittl. Bearb.	**VNMG160408-DM**	16.6	9.525	4.76	3.81	0.8	●	●	●	●							○	○													
	VNMG160412-DM	16.6	9.525	4.76	3.81	1.2		●	●	●	○																				
EM Medium Cut/ Mittl. Bearb.	**VNMG160404-EM**	16.6	9.525	4.76	3.81	0.4							○	●																	
	VNMG160408-EM	16.6	9.525	4.76	3.81	0.8							○	●																	
NM  Medium Cut/ Mittl. Bearb.	**VNMG160412-NM**	16.6	9.525	4.76	3.81	1.2						○																	○		
Basic 	**VNMG160404**	16.6	9.525	4.76	3.81	0.4	○		○																						
	VNMG160408	16.6	9.525	4.76	3.81	0.8	○		○																						

Tool holder / Klemmhalter

DVVNN
Kr:72°30'

DVJNR/L
Kr:93°

MVVNN
Kr:72°30'

MVJNR/L
Kr:93°

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Insert code key ISO Code A50-A51
Grade selection reference Sortenauswahl A16/A37-A47
chip breaker selection reference Spanbrecherauswahl A28-A36
Recommended cutting parameters Empfohlene Schnittparameter A261-A263