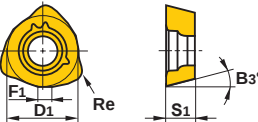
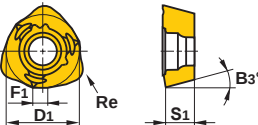
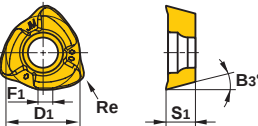


## INSERTS

| Work Material                                                                      | P                 | Steel                                |        |        |        |        |        |        |                 |                  |                | Cutting Conditions : |                     |                      |                                                                                      |    |
|------------------------------------------------------------------------------------|-------------------|--------------------------------------|--------|--------|--------|--------|--------|--------|-----------------|------------------|----------------|----------------------|---------------------|----------------------|--------------------------------------------------------------------------------------|----|
|                                                                                    | M                 | Stainless Steel                      |        |        |        |        |        |        |                 |                  |                | ● : Stable Cutting   | ■ : General Cutting | ✱ : Unstable Cutting |                                                                                      |    |
|                                                                                    | K                 | Cast Iron                            |        |        |        |        |        |        |                 |                  |                |                      |                     |                      |                                                                                      |    |
|                                                                                    | S                 | Heat-resistant Alloy, Titanium Alloy |        |        |        |        |        |        |                 |                  |                |                      |                     |                      |                                                                                      |    |
|                                                                                    | H                 | Hardened Materials                   |        |        |        |        |        |        |                 |                  |                |                      |                     |                      |                                                                                      |    |
| Shape                                                                              | Order Number      | Class                                | Coated |        |        |        |        |        | Dimensions (mm) |                  |                |                      |                     | Geometry             |                                                                                      |    |
|                                                                                    |                   |                                      | FH7020 | MP6120 | MP6130 | MP7130 | MP7140 | VP15TF | VP30RT          | B <sub>3</sub> ° | D <sub>1</sub> | S <sub>1</sub>       | F <sub>1</sub>      |                      |                                                                                      | Re |
|   | JOMW06T215ZZSR-FT | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 13°              | 6.35           | 2.78                 | 1.2                 | 1.5                  |   |    |
|                                                                                    | 080320ZZSR-FT     | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 13°              | 8              | 3.18                 | 1.4                 | 2                    |                                                                                      |    |
|                                                                                    | JDMW09T320ZDSR-FT | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 15°              | 9.525          | 3.97                 | 1.8                 | 2                    |                                                                                      |    |
|                                                                                    | 120420ZDSR-FT     | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 15°              | 12             | 4.76                 | 2.5                 | 2                    |                                                                                      |    |
|                                                                                    | 140520ZDSR-FT     | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 15°              | 14             | 5.56                 | 2.8                 | 2                    |                                                                                      |    |
|   | JDMT120420ZDSR-ST | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 15°              | 12             | 4.76                 | 2.5                 | 2                    |   |    |
|                                                                                    | 140520ZDSR-ST     | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 15°              | 14             | 5.56                 | 2.8                 | 2                    |                                                                                      |    |
|                                                                                    |                   |                                      |        |        |        |        |        |        |                 |                  |                |                      |                     |                      |                                                                                      |    |
|  | JOMT06T215ZZSR-JM | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 13°              | 6.35           | 2.78                 | 1.2                 | 1.5                  |  |    |
|                                                                                    | 080320ZZSR-JM     | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 13°              | 8              | 3.18                 | 1.4                 | 2                    |                                                                                      |    |
|                                                                                    | JDMT09T320ZDSR-JM | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 15°              | 9.525          | 3.97                 | 1.8                 | 2                    |                                                                                      |    |
|                                                                                    | 120420ZDSR-JM     | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 15°              | 12             | 4.76                 | 2.5                 | 2                    |                                                                                      |    |
|                                                                                    | 140520ZDSR-JM     | M                                    | ●      | ●      | ●      | ●      | ●      | ●      | ●               | 15°              | 14             | 5.56                 | 2.8                 | 2                    |                                                                                      |    |

(Note) Setting heights for ST chipbreaker and the other chipbreakers differ slightly.  
If an ST type chipbreaker is used, please check the tool length offset height.

