

## TURNING INSERTS [POSITIVE]



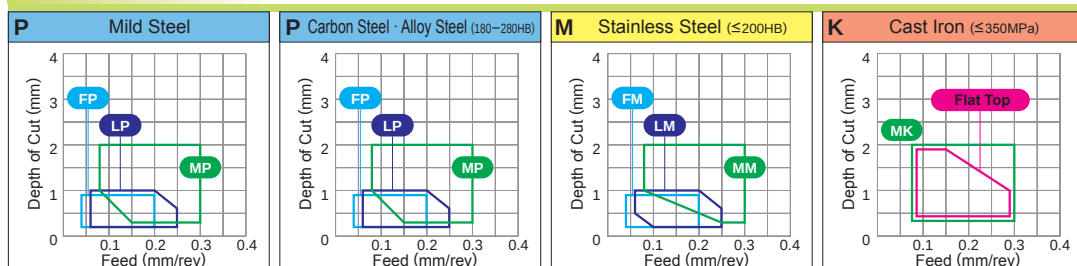
## 35° VC TYPE INSERTS WITH HOLE

VCMT 08 02 02- SV

Size Thickness Corner Radius Chip Breaker  
★ Please refer to page A002.

## CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting..... Light Cutting..... Medium Cutting..... Heavy Cutting.....



Cutting Conditions (Guide) : ● : Stable Cutting ● : General Cutting ✱ : Unstable Cutting

| Work Material                                                                                                                                | P             | Steel                                |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
|----------------------------------------------------------------------------------------------------------------------------------------------|---------------|--------------------------------------|--------|--------|--------|--------|--------|--------|--------|--------|-------|-------|--------|--------|--------|--------|--------|--------|--------|---------------|---------|------------------------|--------|--------|-------|-------|-------|--------|--------|-------|------------------------------|
|                                                                                                                                              | M             | Stainless Steel                      |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
|                                                                                                                                              | K             | Cast Iron                            |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
|                                                                                                                                              | N             | Non-ferrous Metal                    |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
|                                                                                                                                              | S             | Heat-resistant Alloy, Titanium Alloy |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
| Shape                                                                                                                                        | Order Number  | Corner R                             | Coated |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        | Cermet | Coated Cermet | Carbide | Applicable Holder Page |        |        |       |       |       |        |        |       |                              |
|                                                                                                                                              |               | Re (mm)                              | UE6105 | UE6110 | UE6020 | MC6025 | UH6400 | MC7025 | MP7035 | US7020 | US735 | US905 | MC5005 | MC5015 | UC5105 | UC5115 | VP05RT | VP10RT | VP15TF | UP20M         | NX2525  |                        | NX3035 | MP3025 | AP25N | VP25N | VP45N | UTi20T | HTi05T | HTi10 | RT9010                       |
| <div>SV</div> <div></div> <div>Light Cutting</div>          | VCMT080202-SV | 0.2                                  |        | ●      |        |        |        |        |        |        |       |       |        |        |        |        |        |        | ●      |               | ●       | ●                      |        |        |       |       |       |        |        |       | E012<br>E013                 |
|                                                                                                                                              | 080204-SV     | 0.4                                  |        | ●      |        |        |        |        |        |        |       |       |        |        |        |        |        |        | ●      |               | ●       | ●                      |        |        |       |       |       |        |        |       |                              |
|                                                                                                                                              |               |                                      |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
| <div>MP</div> <div></div> <div>Medium Cutting</div>       | VCMT160404-MP | 0.4                                  | ●      |        | ●      |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               | ●       | ●                      |        |        |       |       |       |        |        |       | C030<br>C031<br>E033<br>E034 |
|                                                                                                                                              | 160408-MP     | 0.8                                  | ●      |        | ●      |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               | ●       | ●                      |        |        |       |       |       |        |        |       |                              |
|                                                                                                                                              | 160412-MP     | 1.2                                  | ●      |        | ●      |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               | ●       | ●                      |        |        |       |       |       |        |        |       |                              |
|                                                                                                                                              |               |                                      |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
| <div>MM</div> <div></div> <div>Medium Cutting</div>       | VCMT160404-MM | 0.4                                  |        |        |        |        | ●      | ●      |        |        |       |       |        |        |        |        |        |        | ●      |               |         |                        |        |        |       |       |       |        |        |       | C030<br>C031<br>E033<br>E034 |
|                                                                                                                                              | 160408-MM     | 0.8                                  |        |        |        |        | ●      | ●      |        |        |       |       |        |        |        |        |        |        | ●      |               |         |                        |        |        |       |       |       |        |        |       |                              |
|                                                                                                                                              | 160412-MM     | 1.2                                  |        |        |        |        | ●      | ●      |        |        |       |       |        |        |        |        |        |        | ●      |               |         |                        |        |        |       |       |       |        |        |       |                              |
|                                                                                                                                              |               |                                      |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
| <div>MK</div> <div></div> <div>Medium Cutting</div>       | VCMT160404-MK | 0.4                                  |        |        |        |        |        |        |        |        |       | ●     | ●      |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       | C030<br>C031<br>E033<br>E034 |
|                                                                                                                                              | 160408-MK     | 0.8                                  |        |        |        |        |        |        |        |        |       | ●     | ●      |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
|                                                                                                                                              |               |                                      |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
| <div>Standard</div> <div></div> <div>Medium Cutting</div> | VCMT110304    | 0.4                                  |        | ●      | ●      |        |        |        |        | ●      |       |       |        |        |        |        |        | ★      |        | ●             | ●       | ●                      | ★      |        |       | ●     | ★     |        |        |       | C030<br>C031<br>E033<br>E034 |
|                                                                                                                                              | 160404        | 0.4                                  | ●      | ●      | ●      |        |        |        |        | ●      |       |       |        | ●      | ●      |        |        | ★      |        | ●             | ●       | ●                      | ★      |        |       | ●     | ★     |        |        |       |                              |
|                                                                                                                                              | 160408        | 0.8                                  | ●      | ●      | ●      |        |        |        |        | ●      |       |       |        |        | ●      |        |        | ★      |        | ●             | ●       | ●                      | ★      |        |       | ●     |       |        |        |       |                              |
|                                                                                                                                              | 160412        | 1.2                                  |        | ●      | ★      |        |        |        |        | ●      |       |       |        | ●      | ●      |        |        |        |        | ●             | ●       |                        |        |        |       |       |       |        |        |       |                              |
|                                                                                                                                              |               |                                      |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
| <div>MV</div> <div></div> <div>Medium Cutting</div>       | VCMT080202-MV | 0.2                                  |        | ●      | ●      |        |        |        | ●      | ●      |       |       |        |        |        |        |        |        | ●      |               | ●       | ●                      | ●      | ★      |       |       |       |        |        |       | E012<br>E013                 |
|                                                                                                                                              | 080204-MV     | 0.4                                  |        | ●      | ●      |        |        |        |        | ●      | ●     |       |        |        |        |        |        |        | ●      |               | ●       | ●                      | ●      | ●      |       |       |       |        |        |       |                              |
|                                                                                                                                              |               |                                      |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |
| <div>Flat Top</div> <div></div>                           | VCMW110304    | 0.4                                  |        |        |        |        |        |        |        |        |       |       |        | ●      | ●      |        |        |        |        |               |         |                        |        |        |       |       |       | ●      |        |       | C030<br>C031<br>E033<br>E034 |
|                                                                                                                                              | 160404        | 0.4                                  |        |        |        |        |        |        |        |        |       |       |        | ●      | ●      |        |        |        |        |               |         |                        |        |        |       |       |       | ●      |        |       |                              |
|                                                                                                                                              | 160408        | 0.8                                  |        |        |        |        |        |        |        |        |       |       |        | ●      | ●      |        |        |        |        |               |         |                        |        |        |       |       |       | ●      |        |       |                              |
|                                                                                                                                              |               |                                      |        |        |        |        |        |        |        |        |       |       |        |        |        |        |        |        |        |               |         |                        |        |        |       |       |       |        |        |       |                              |

● : Inventory maintained. ★ : Inventory maintained in Japan.