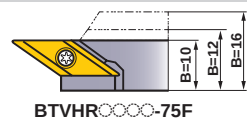
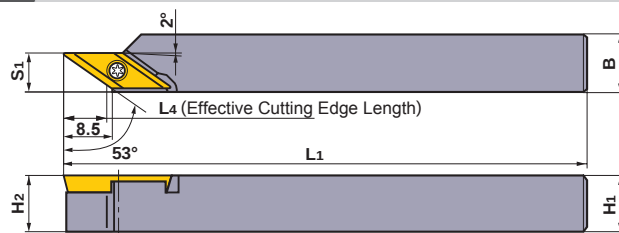
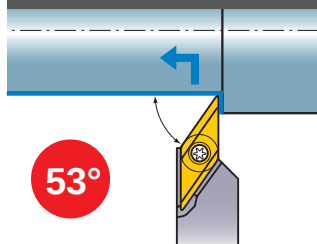


SMALL TOOLS

EXTERNAL BACK TURNING

BTVH



Right hand tool holder only.

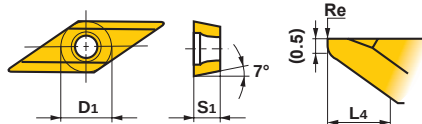
Order Number	Stock	Insert Number		Dimensions (mm)					* Clamp Screw	Wrench
	R			H1	B	L1	H2	S1		
BTVHR1010-75	★	BTVT	5375○○R-B	10	10	120	10	7.5	NS251	NKY15R
1212-75	★			12	12	120	12	7.5	NS251	NKY15R
1616-75	★			16	16	120	16	7.5	NS251	NKY15R
1010-75F	★			10	10	120	10	10.0	NS251	NKY15R
1212-75F	★			12	12	120	12	10.0	NS251	NKY15R
1616-75F	★			16	16	120	16	10.0	NS251	NKY15R

(Note 1) Set the maximum depth of cut at under 30% of the effective cutting edge length.

(Note 2) For high load machining, F type is recommended.

★ Clamp Torque (N • m) : NS251=1.0

INSERTS

Order Number	Hand	Coated	Dimensions (mm)			Effective Cutting Edge Length L4 (mm)	Geometry
		VP15TF	D1	S1	Re		
BTVT5375V5R-B	R	★	6.35	3.18	0.05	7.5	With Breaker 
537501R-B	R	★	6.35	3.18	0.1	7.5	

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180HB—280HB	VP15TF	100 (50—150)	0.08 (0.01—0.15)
	Free Cutting Steel	—	VP15TF	110 (30—180)	0.08 (0.01—0.15)
M	Stainless Steel	≤200HB	VP15TF	80 (50—120)	0.06 (0.02—0.1)
N	Non-Ferrous Metal	—	VP15TF	150 (70—230)	0.09 (0.03—0.15)

★ : Inventory maintained in Japan.

SPARE PARTS > M001

TECHNICAL DATA > N001