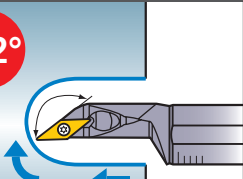
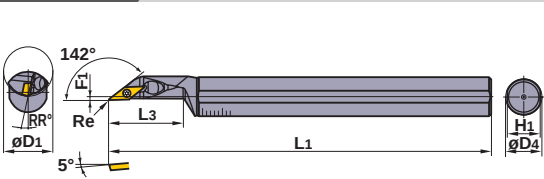


FSVJB/C				VC $\odot$ inserts, VB $\odot$ inserts							Finish		Finish		Light		Light	
142° 				 Right hand tool holder shown.							FP	FM	LP	LM				
																		
											(11)	(11)	(11)	(11)				
											Finish	Medium						
											FV	MV						
																		
											(08,11)	(08,11)						
Order Number		Stock		Insert Number		Dimensions (mm)						Min. Cutting Diameter	Standard Corner Radius	Maximum Recommendation l/d Ratio				
		R	L			D4	L1	L3	F1	H1	RR°	D1	Re		Clamp Screw	Wrench		
FSVJC1612R/L-08S		●	●	VCGT VCMT	0802 $\odot$	12	150	26	2	11	5	16	0.4	4	TS202	TKY06F		
2016R/L-08S		●	●		0802 $\odot$	16	180	36	2	15	5	20	0.4	5	TS202	TKY06F		
FSVJB2520R/L-11S		●	●	VBET VBGT VBMT	1103 $\odot$	20	200	37.5	2	19	5	25	0.4	5	TS255	TKY08F		
3025R/L-11S		●	●		1103 $\odot$	25	250	45	3.5	23.4	5	30	0.4	5	TS255	TKY08F		

* Clamp Torque (N • m) : TS202=0.6, TS255=1.0

RECOMMENDED CUTTING CONDITIONS

Work Material		Cutting Mode	Breaker	Recom- mendation	Grade	Cutting Speed (m/min)	l/d ≤ 3 (Steel shank) l/d ≤ 6 (Carbide shank)		l/d = 4–5 (Steel shank) l/d = 7–8 (Carbide shank)	
							Feed (mm/rev)	Depth of Cut (mm)	Feed (mm/rev)	Depth of Cut (mm)
P	Mild Steel ≤180HB	Finish	FV	①	NX2525	170 (120–220)	0.10 (0.05–0.15)	–0.5	0.10 (0.05–0.15)	–0.5
		Light	SV	①	NX3035	150 (100–200)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
				②	NX2525	160 (110–210)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
		Medium	MV	①	NX3035	140 (90–190)	0.25 (0.15–0.35)	–2.0	0.20 (0.15–0.25)	–1.5
				②	NX2525	150 (100–200)	0.25 (0.15–0.35)	–2.0	0.20 (0.15–0.25)	–1.5
	Carbon Steel Alloy Steel 180–350HB	Finish	FV	①	VP15TF	140 (90–190)	0.10 (0.05–0.15)	–0.5	0.10 (0.05–0.15)	–0.5
				②	NX2525	130 (80–180)	0.10 (0.05–0.15)	–0.5	0.10 (0.05–0.15)	–0.5
		Light	SV	①	UE6020	140 (90–190)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
				②	NX3035	110 (60–160)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
		Medium	MV	①	UE6020	130 (80–180)	0.25 (0.15–0.35)	–2.0	0.20 (0.15–0.25)	–1.5
②	NX3035			100 (60–150)	0.25 (0.15–0.35)	–2.0	0.20 (0.15–0.25)	–1.5		
M	Stainless Steel ≤200HB	Finish	FV	①	VP15TF	150 (110–190)	0.10 (0.05–0.15)	–0.5	0.10 (0.05–0.15)	–0.5
		Light	SV	①	US735	125 (85–165)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
				②	VP15TF	130 (90–170)	0.20 (0.10–0.25)	–1.0	0.15 (0.05–0.20)	–1.0
		Medium	MV	①	US735	105 (70–135)	0.20 (0.15–0.25)	–2.0	0.20 (0.15–0.25)	–1.0
				②	VP15TF	120 (80–160)	0.20 (0.15–0.25)	–2.0	0.20 (0.15–0.25)	–1.0
K	Cast Iron Tensile Strength ≤350MPa	Finish	F, FS	①	HTi10	130 (90–160)	0.15 (0.10–0.20)	–0.5	0.15 (0.10–0.20)	–0.5
		Medium	MV	①	VP15TF	90 (60–120)	0.20 (0.15–0.25)	–2.0	0.20 (0.15–0.25)	–1.5
N	Aluminium Alloy	Finish	F, FS	①	HTi10	300 (200–400)	0.10 (0.05–0.15)	–0.5	0.10 (0.05–0.15)	–0.5
			Flat Top	①	MD220	200 (150–250)	0.10 (0.05–0.15)	–2.0	0.10 (0.05–0.15)	–1.0
H	Heat Treated Steel 35–65HRC	Finish	Flat Top	①	MB825	100 (80–200)	0.10 (0.05–0.15)	–0.15	0.10 (0.05–0.15)	–0.1

(Note 1) When vibrations occur, reduce cutting speed by 30%.

(Note 2) The depth of cut needs to be less than the nose diameter when using the FSVJ type.

VB $\odot$ type inserts	➤ A150–A152
VC $\odot$ type inserts	➤ A153, A154
CBN & PCD inserts	➤ B041, B055
SPARE PARTS	➤ M001
TECHNICAL DATA	➤ N001