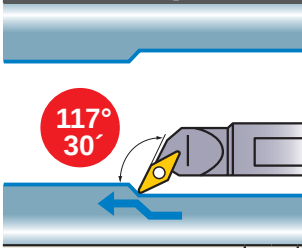
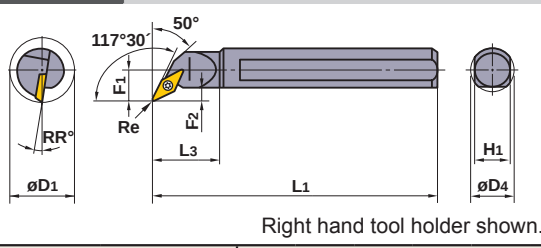
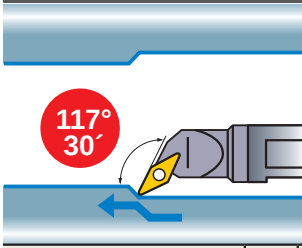
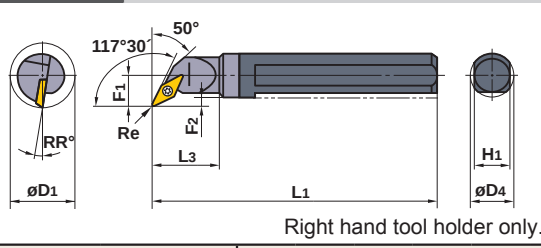


SVQC			VC $\odot$ inserts								Finish		Finish		Light		Light	
											FP	FM	LP	LM				
																		
											(11,16)	(11,16)	(11,16)	(11,16)				
											Medium	Medium	Medium	Flat Top				
											MP	MM	Standard					
Right hand tool holder shown.																		
												(16)	(16)	(11,16)	(11,16)			
Order Number	Stock		Insert Number	Dimensions (mm)								Min. Cutting Diameter	Standard Corner Radius					
	R	L		D4	L1	L3	F1	F2	H1	RR°	D1					Re	Clamp Screw	Wrench
S16MSVQCR/L11	●	●	VCMW VCMT	1103 $\odot$	16	150	25	11	3.9	14	7	20	0.4	TS25	TKY08F			
S20QSVQCR/L11	●	●		1103 $\odot$	20	180	32	13	4.4	18	7	25	0.4	TS25	TKY08F			
S25RSVQCR/L16	●	●		1604 $\odot$	25	200	40	17	6.9	23	5	32	0.8	TS4	TKY15F			
S32SSVQCR/L16	●	●		1604 $\odot$	32	250	50	22	8.4	30	5	40	0.8	TS4	TKY15F			
S40TSVQCR/L16	●	●		1604 $\odot$	40	300	63	27	9.4	37	5	50	0.8	TS4	TKY15F			

* Clamp Torque (N • m) : TS25=1.0, TS4=3.5

SVQC		Carbide shank VC $\odot$ inserts										Finish		Finish		Light		Light	
												FP	FM	LP	LM				
												(11,16)	(11,16)	(11,16)	(11,16)				
												Medium	Medium	Medium	Flat Top				
												MP	MM	Standard					
												(16)	(16)	(11,16)	(11,16)				
Right hand tool holder only.																			
Order Number	Stock	Insert Number		Dimensions (mm)								Min. Cutting Diameter D1	Standard Corner Radius Re	 ★					
	R			D4	L1	L3	F1	F2	H1	RR°	Clamp Screw					Wrench			
C16RSVQCR11	●	VCMT VCMT	1103 $\odot$	16	200	25	11	3.1	14	7	20	0.4	TS25	TKY08F					
C20SSVQCR11	★		1103 $\odot$	20	250	32	13	3.1	18	7	25	0.4	TS25	TKY08F					
C25TSVQCR16	★		1604 $\odot$	25	300	40	17	4.9	23	5	32	0.8	TS4	TKY15F					

* Clamp Torque (N • m) : TS25=1.0, TS4=3.5

RECOMMENDED CUTTING CONDITIONS

Steel Shank			l/d≤3			l/d=3—4 (Shank Diameter≥25mm)			
Carbide Shank			l/d≤5			l/d=6—7			
Work Material	Hardness	Cutting Mode	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	
P	Carbon Steel Alloy Steel	180—350HB	Light Cutting	130 (90—160)	0.1 (0.05—0.15)	0.2	120 (80—150)	0.1 (0.05—0.15)	0.2
			Medium Cutting	90 (60—120)	0.25 (0.15—0.35)	—3.0	80 (50—110)	0.15 (0.1—0.2)	—1.5
M	Stainless Steel	≤200HB	Light Cutting	140 (100—180)	0.1 (0.05—0.15)	0.2	140 (100—180)	0.1 (0.05—0.15)	0.2
			Medium Cutting	70 (50—90)	0.2 (0.15—0.25)	—2.0	60 (40—80)	0.15 (0.1—0.2)	—1.0
N	Aluminium Alloy	—	Light Cutting	300 (200—400)	0.1 (0.05—0.15)	0.2	300 (200—400)	0.1 (0.05—0.15)	0.2
			Medium Cutting	200 (150—250)	0.1 (0.05—0.15)	—2.0	200 (150—250)	0.1 (0.05—0.15)	—1.5

VC $\odot$ type inserts > A153, A154

CBN & PCD inserts > B042, B055

SPARE PARTS > M001

TECHNICAL DATA > N001