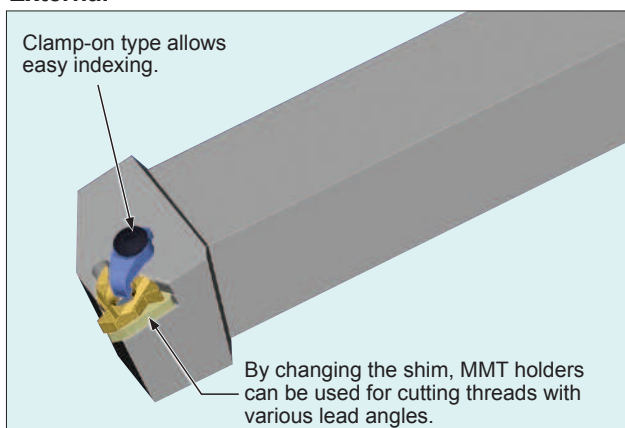
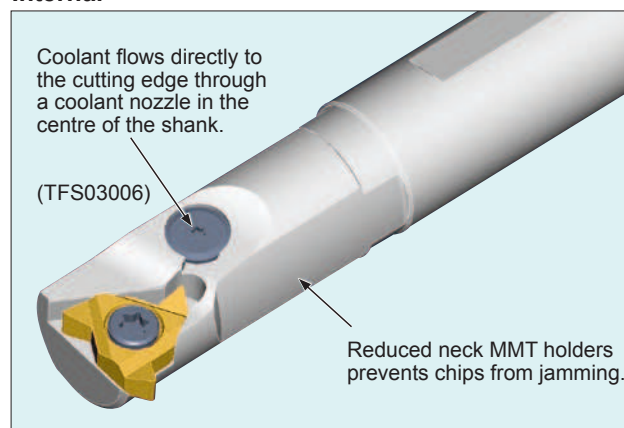


HOLDER (Use of special surface treatment)

External

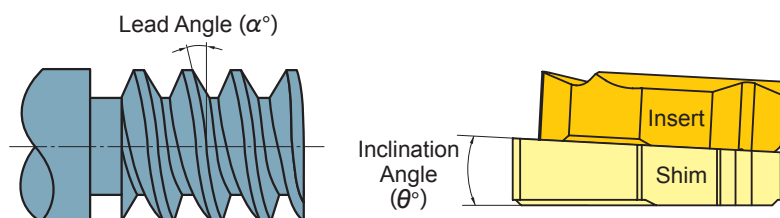


Internal



★ Order number of coolant guide screw: TFS03006
(Except MMTIR1316/MMTIR1516)

SUITABLE FOR THREADING WITH A LARGE LEAD ANGLE



By changing only the shim, MMT holders can be used for turning of threads with various lead angles as well as the turning of left hand threads.
(Please refer to page G032 and page G035)

Lead Angle (α°)	Inclination Angle (θ°)
-1.5°	-3°
-0.5°	-2°
0.5°	-1°
1.5°	0°
2.5°	1°
3.5°	2°
4.5°	3°

Standard shim delivered with the holder.

VP10MF (G-class ground inserts only)

Superior wear and plastic deformation resistance

- High wear and plastic deformation resistance for threading when maintaining the thread form is important. Suitable for continuous high precision machining with extensive tool life.
- Effective in combination with G-class inserts for high precision threading.

VP15TF (G-class ground inserts, M-class inserts with 3-D chip breakers)

Wide versatility

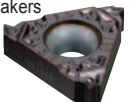
- High fracture resistance during low rigidity applications such as bar feed machining. Able to withstand harsh conditions for long periods where conventional inserts would be liable to breakage.
- Effective combination of high cost performance M-class inserts with 3-D chip breakers.

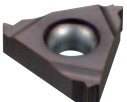
VP20RT (G-class ground inserts, M-class inserts with 3-D chip breakers)

Excellent fracture resistance

- Suitable for stainless steel boring and unstable machining where inserts are vulnerable to fracturing.
- Effective combination of high cost performance M-class inserts with 3-D chip breakers.

CHOOSING M-CLASS INSERTS WITH 3-D CHIP BREAKERS OR G-CLASS INSERTS

Insert	Chip control	Precision of thread
M-class inserts with 3-D chip breakers 	◎	○

Insert	Chip control	Precision of thread
G-class inserts 	○	◎

- For ideal chip control and a high cost performance ratio, M-class inserts with 3-D chip breakers are recommended.
- G-class inserts are recommended where higher precision is required.