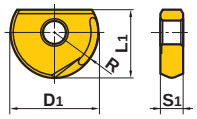
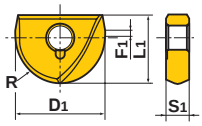
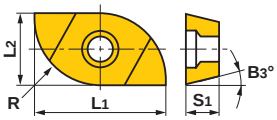
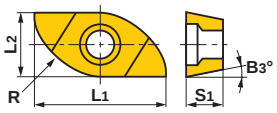
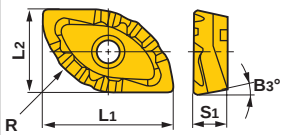
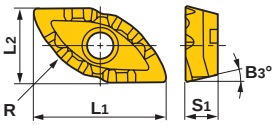
Work Material		EP6120	VP15TF	VP20RT	VP30RT	MP8010
P	Steel	◐	◐	◐	✠	
M	Stainless Steel		◔	◔	✠	
K	Cast Iron		✠	✠		●
N	Non-ferrous Metal	◐				
S	Heat-resistant Alloy, Titanium Alloy		◐			
H	Hardened Materials		◔			●

Cutting Conditions (Guide):
●: Stable Cutting ◐: General Cutting ✠: Unstable Cutting

Honing:
E: Round F: Sharp

Shape	Order Number	Class	Honing	EP6120	VP15TF	VP20RT	VP30RT	MP8010	L1	L2	D1	S1	F1	R	B3	Geometry
				Coated					Dimensions (mm)							
SRB ➲K092	SRBT10	–	F		●				8.5	–	10	2.6	–	5	–	
	12	–	F		●				10	–	12	3	–	6	–	
	16	–	F		●				12	–	16	4	–	8	–	
	20	–	F		●				15	–	20	5	–	10	–	
	25	–	F		●				18.5	–	25	6	–	12.5	–	
	30	–	F		●				22.5	–	30	7	–	15	–	
	32	–	F		●				23.5	–	32	7	–	16	–	
SRF ➲K092	* SRFT10	–	F	●	●			●	8.5	–	10	2.6	0.5	5	–	
	* 12	–	F	●	●			●	10	–	12	3	0.5	6	–	
	* 16	–	F	●	●			●	12	–	16	4	1	8	–	
	* 20	–	F	●	●			●	15	–	20	5	1	10	–	
	* 25	–	F	●	●			●	18.5	–	25	6	1	12.5	–	
	* 30	–	F	●	●			●	22.5	–	30	7	1	15	–	
	* 32	–	F	●	●			●	23.5	–	32	7	1	16	–	
SRM2 ➲K100	SRG16C	G	E		●				16	8.2	–	3.5	–	8	11°	
	20C	G	E		●				19	10.2	–	4.6	–	10	10°	
	25C	G	E		●				24	12.8	–	5.5	–	12.5	10°	
	30C	G	E		●				28	15.3	–	7	–	15	10°	
	32C	G	E		●				28	16.3	–	7	–	16	10°	
SRM2 ➲K100	SRG16E	G	E		●				13.5	6.7	–	3.5	–	8	11°	
	20E	G	E		●				15.5	8.5	–	4.6	–	10	9°	
	25E	G	E		●				20.5	10.2	–	5.5	–	12.5	9°	
	30E	G	E		●				25.2	12.2	–	7	–	15	9°	
	32E	G	E		●				26.1	13.1	–	7	–	16	9°	
SRM2ϕ40 ϕ50 ➲K104	* SRG40C	G	E		●	●	●		36	20.5	–	8	–	20	11°	
	* 50C	G	E		●	●	●		40	26	–	8.5	–	25	11°	
SRM2ϕ40 ϕ50 ➲K104	* SRG40E	G	E		●	●	●		32	16.6	–	8	–	20	11°	
	* 50E	G	E		●	●	●		35.8	20	–	8.5	–	25	11°	

* 2 inserts in one case.

= MIRACLE SIGMA

ROTATING INSERTS