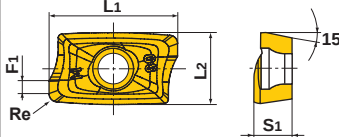
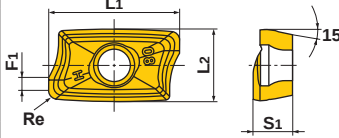


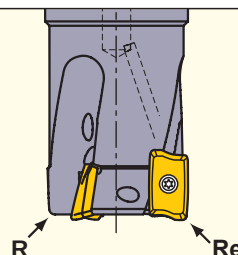
## INSERTS

| Work Material                                                                     | P                | Steel                                |  |  |  |  |  |  |  |  | Cutting Conditions (Guide): |                    |                     |     |     |      |                                                                                     |
|-----------------------------------------------------------------------------------|------------------|--------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------|--------------------|---------------------|-----|-----|------|-------------------------------------------------------------------------------------|
|                                                                                   | M                | Stainless Steel                      |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   | ●: Stable Cutting           | ●: General Cutting | ✖: Unstable Cutting |     |     |      |                                                                                     |
|                                                                                   | K                | Cast Iron                            |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                             |                    |                     |     |     |      |                                                                                     |
|                                                                                   | N                | Non-ferrous Metal                    |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                             |                    |                     |     |     |      |                                                                                     |
|                                                                                   | S                | Heat-resistant Alloy, Titanium Alloy |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                             |                    |                     |     |     |      |                                                                                     |
| H                                                                                 | Hardened Steel   |                                      |                                                                                   |                                                                                   | Honing:                                                                           |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                             |                    |                     |     |     |      |                                                                                     |
|                                                                                   |                  |                                      |                                                                                   |                                                                                   | E: Round F: Sharp T: Chamfer                                                      |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                             |                    |                     |     |     |      |                                                                                     |
| Shape                                                                             | Order Number     | Class                                | Honing                                                                            | Coated                                                                            |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                             | Dimensions (mm)    |                     |     |     |      | Geometry                                                                            |
|                                                                                   |                  |                                      |                                                                                   | MC5020                                                                            | MP6120                                                                            | MP6130                                                                            | MP7130                                                                            | MP9120                                                                            | MP9130                                                                            | VP15TF                                                                            | VP20RT                      | L1                 | L2                  | S1  | F1  | Re   |                                                                                     |
|  | AOMT184804PEER-M | M                                    | E                                                                                 |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                           | 18                 | 9                   | 4.8 | 1.8 | 0.4  |  |
|                                                                                   | 184808PEER-M     | M                                    | E                                                                                 |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                           | 18                 | 9                   | 4.8 | 1.4 | 0.8  |                                                                                     |
|                                                                                   | 184810PEER-M     | M                                    | E                                                                                 |                                                                                   | ●                                                                                 |                                                                                   |                                                                                   | ●                                                                                 | ●                                                                                 |                                                                                   |                             | 18                 | 9                   | 4.8 | 1.0 | 1.0  |                                                                                     |
|                                                                                   | 184812PEER-M     | M                                    | E                                                                                 |                                                                                   | ●                                                                                 |                                                                                   |                                                                                   | ●                                                                                 | ●                                                                                 |                                                                                   |                             | 18                 | 9                   | 4.8 | 0.8 | 1.2  |                                                                                     |
|                                                                                   | 184816PEER-M     | M                                    | E                                                                                 |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                           | 18                 | 9                   | 4.8 | 0.4 | 1.6  |                                                                                     |
|                                                                                   | 184820PEER-M     | M                                    | E                                                                                 |                                                                                   | ●                                                                                 |                                                                                   |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 |                             | 18                 | 9                   | 4.8 | 0.4 | 2.0  |                                                                                     |
|  | AOMT184804PEER-H | M                                    | E                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                           | 18                 | 9                   | 4.8 | 1.8 | 0.4  |  |
|                                                                                   | 184808PEER-H     | M                                    | E                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                           | 18                 | 9                   | 4.8 | 1.4 | 0.8  |                                                                                     |
|                                                                                   | 184816PEER-H     | M                                    | E                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                           | 18                 | 9                   | 4.8 | 0.4 | 1.6  |                                                                                     |
|                                                                                   | 184832PEER-H     | M                                    | E                                                                                 |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 |                                                                                   |                                                                                   | ●                                                                                 |                             | 18                 | 9                   | 4.8 | 0.4 | 3.2  |                                                                                     |
|                                                                                   | 184840PEER-H     | M                                    | E                                                                                 |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 |                                                                                   |                                                                                   | ●                                                                                 |                             | 18                 | 9                   | 4.8 | 0.4 | 4.0  |                                                                                     |
|                                                                                   | 184850PEER-H     | M                                    | E                                                                                 |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 |                                                                                   |                                                                                   | ●                                                                                 |                             | 18                 | 9                   | 4.8 | —   | 5.0  |                                                                                     |
|                                                                                   | 184864PEER-H     | M                                    | E                                                                                 |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 |                                                                                   |                                                                                   | ●                                                                                 |                             | 18                 | 9                   | 4.8 | —   | 6.35 |                                                                                     |



## NOTE ON USE OF INSERTS WITH LARGE CORNER RADII

When using inserts with corner radius  $R_{e} \geq R3.2$ , please machine the holder with a radius form as shown on the right.



| Re (mm) | R (mm) |
|---------|--------|
| 3.2     | 2.0    |
| 4.0     | 2.5    |
| 5.0     | 3.5    |
| 6.35    | 5.0    |

**R** : Holder end radius  
**Re** : Insert corner radius