

# VBMT

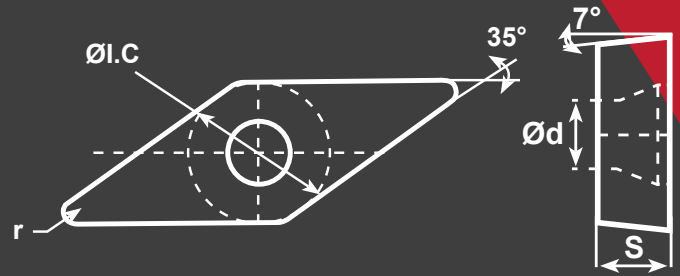
Compatible  
Workpiece Materials



Steel



Stainless Steel



SKU#	ANSI#	ISO#	L	Ø.I.C	S	Ød	r	START SPEED	START FEED
424-1874	VBMT331-EM	VBMT160404EM	0.654	0.375	0.187	0.173	0.016	<b>M</b> Vc: 720sfm (490-980)	fz: 0.004in/z (0.002-0.008)
424-1875	VBMT332-EM	VBMT160408EM	0.654	0.375	0.187	0.173	0.031	<b>M</b> Vc: 720sfm (980-1640)	fz: 0.004in/z (0.003-0.012)

Material	Coated cemented carbide																Cermets	Coated Cermets	Cemented Carbide												
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103				YBD052	YBD102	YBD151	YBD152	YBD252							
<b>P</b> Steel	+	+	○	○	-	-	+		○	○																+	+				
<b>M</b> Stainless Steel							+		○	○		+	○	○	○												+	+			
<b>K</b> Cast Iron																															
<b>N</b> Ferrite Materials																															
<b>S</b> Heat-resistant steel							+	+				+					+														
<b>SKU#</b>	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YD101	YD201						
424-1874										●																					
424-1875										●																					

+ Good Working Conditions     
 ○ General Working Conditions     
 - Adverse Working Conditions

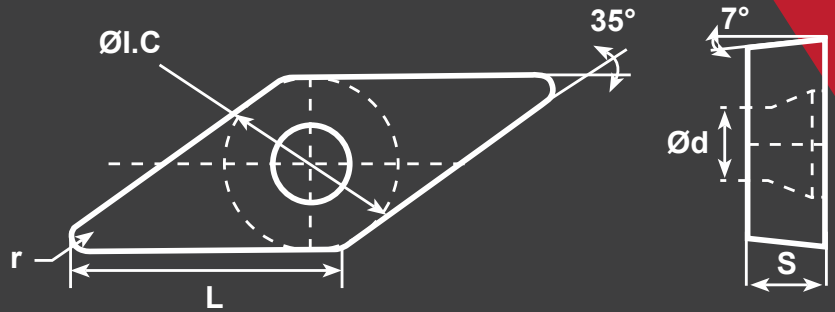
## EM CHIP BREAKER

The EM chip breaker is the preferred choice chip breaker on M category material Medium. EM chip breaker is designed with sharp cutting edge which is required for machining highly adhesive material such as stainless steel while reinforced the impact resistance on the edge, which makes it suitable for semi-finishing and intermittent



# VBMT

Compatible  
Workpiece Materials



**SKU#** **ANSI#** **ISO#** **L** **ØI.C** **S** **Ød** **r** **START SPEED** **START FEED**  
 424-1860 VBMT-2(1.5)1-HF VBMT110204HF 0.433 0.25 0.094 0.11 0.016 **P** Vc: 1050sfm (850-1310) fz: 0.004in/z (0.002-0.012)

Material	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052	YBD102	YBD151	YBD152	YBD252	Cermet	Coated Cermet	Cemented Carbide	
<b>P</b> Steel	+	+	○	○	-	-	+		○	○												+	+		
<b>M</b> Stainless Steel							+		○	○		+	○	○	○							+	+		
<b>K</b> Cast Iron																	+	○	○	-	-			-	
<b>N</b> Ferrite Materials																								○	-
<b>S</b> Heat-resistant steel							+	+			+					+								+	
	<b>Coated cemented carbide</b>																				<b>Cermet</b>	<b>Coated Cermet</b>	<b>Cemented Carbide</b>		
<b>SKU#</b>	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YD101	YD201
424-1860			●																						

**+** Good Working Conditions      **○** General Working Conditions      **-** Adverse Working Conditions



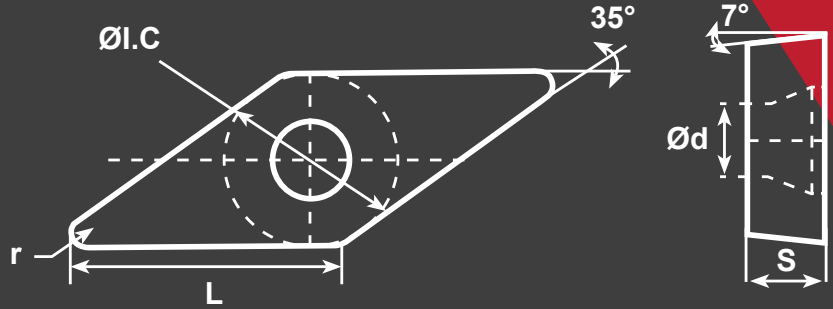
## HF CHIP BREAKER

The HF chip breaker is the preferred choice chip breaker on General Purpose Finishing. M Class tolerance double sided chip breaker, suitable for alloy steel and cast iron's boring and outside turning in finishing cut.



# VBMT

## Compatible Workpiece Materials



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1861	VBMT331-HM	VBMT160404HM	0.654	0.375	0.187	0.173	0.016	<b>P</b> Vc: 1050sfm (850-1310) fz: 0.006in/z (0.004-0.012)	
424-1862	VBMT332-HM	VBMT160408HM	0.654	0.375	0.187	0.173	0.031	<b>P</b> Vc: 1050sfm (850-1310) fz: 0.008in/z (0.004-0.016)	
424-1867	VBMT331-HM	VBMT160404HM	0.654	0.375	0.187	0.173	0.016	<b>P</b> Vc: 1120sfm (920-1440) fz: 0.006in/z (0.004-0.012)	
424-1868	VBMT332-HM	VBMT160408HM	0.654	0.375	0.187	0.173	0.031	<b>P</b> Vc: 1120sfm (920-1440) fz: 0.008in/z (0.004-0.016)	

Material	Coated cemented carbide																Cermets	Coated Cermets	Cemented Carbide							
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103				YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C
<b>P</b> Steel	+	+	○	○	-	-	+		○	○													+	+		
<b>M</b> Stainless Steel							+		○	○		+	○	○	○								+	+		
<b>K</b> Cast Iron																	+	○	○	-	-					-
<b>N</b> Ferrite Materials																								○		-
<b>S</b> Heat-resistant steel							+	+				+				+								+		

+ Good Working Conditions    
 ○ General Working Conditions    
 - Adverse Working Conditions

## HM CHIP BREAKER

The HM chip breaker is the preferred choice chip breaker for General Purpose M Class tolerance double sided chip breaker, suitable for inside boring and outside turning semi-finish/medium on alloy steel and cast iron.

