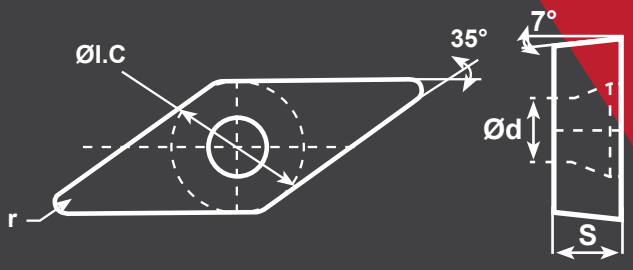
VCGX

Compatible Workpiece Materials

K Cast Iron

N Ferrite Materials

S Heat-Resistant Steel



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1953	VCGX-222-LH	VCGX110308LH	0.433	0.25	0.125	0.11	0.031	N Vc: 3950sfm (980-4920)	fz: 0.006in/z (0.002-0.014)
424-1955	VCGX-331-LH	VCGX160404LH	0.654	0.375	0.187	0.173	0.016	N Vc: 3950sfm (980-4920)	fz: 0.006in/z (0.002-0.012)
424-1956	VCGX-332-LH	VCGX160408LH	0.654	0.375	0.187	0.173	0.031	N Vc: 3950sfm (980-4920)	fz: 0.008in/z (0.004-0.016)
424-1780	VCGX-332-LH	VCGX160408LH	0.654	0.375	0.187	0.173	0.031	K Vc: 3280sfm (1310-4920)	fz: 0.010in/z (0.002-0.020)

	Coated cemented carbide																		Cermet	Coated Cermet	Cemented Carbide				
SKU#	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM151	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201
P Steel	+	+	o	o	−	−	+		o	o										+	+	+	−			
M Stainless Steel							+		o	o		o	o	o						+	+					
K Cast Iron															+	o	o	−	−					+	o	−
N Ferrite Materials																									o	−
S Heat-resistant steel							+	+			+														+	
424-1953																									●	
424-1955																									●	
424-1956																									●	
424-1780																									●	

+ Good Working Conditions o General Working Conditions − Adverse Working Conditions

LH CHIP BREAKER

G class tolerance with big rake angle, polish and ground on surface, LH geometry is resistant to chip built-up on the insert edge, maximize surface finish on aluminum machining and insert tool life.

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