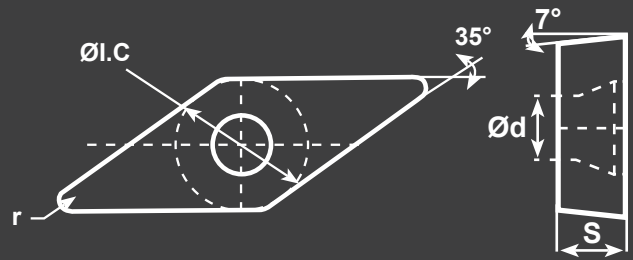


VCGX



Ferrite Materials



Compatible Workpiece Materials

SKU#	ANSI#	ISO#	L	Ø.I.C	S	Ød	r	START SPEED	START FEED
424-1950	VCGX-21.51-LH	VCGX110204LH	0.433	0.250	0.094	0.110	0.016	N Vc: 3940sfm (980-4920)	fz: 0.006in/z (0.002-0.012)
424-1951	VCGX-220-LH	VCGX110302LH	0.433	0.250	0.125	0.110	0.004	N Vc: 4590sfm (980-4920)	fz: 0.003in/z (0.002-0.006)
424-1952	VCGX-221-LH	VCGX110304LH	0.433	0.250	0.125	0.110	0.016	N Vc: 3940sfm (980-4920)	fz: 0.006in/z (0.002-0.012)
424-1953	VCGX-222-LH	VCGX110308LH	0.433	0.250	0.125	0.110	0.031	N Vc: 3280sfm (980-4920)	fz: 0.008in/z (0.004-0.016)
424-1954	VCGX-330-LH	VCGX160402LH	0.654	0.375	0.187	0.173	0.008	N Vc: 4590sfm (980-4920)	fz: 0.003in/z (0.002-0.006)
424-1955	VCGX-331-LH	VCGX160404LH	0.654	0.375	0.187	0.173	0.016	N Vc: 3940sfm (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: 3280sfm (980-4920)	fz: 0.008in/z (0.004-0.016)
424-1957	VCGX-333-LH	VCGX160412LH	0.654	0.375	0.187	0.173	0.047	N Vc: 3280sfm (980-4920)	fz: 0.010in/z (0.002-0.020)

Material	Coated cemented carbide																		Germet	Coated Germet	Cemented Carbide							
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052	YBD102				YBD151	YBD152	YBD252				
P Steel	+	+	○	○	-	-	+		○	○														+	+			
M Stainless Steel							+		○	○		+	○	○	○										+	+		
K Cast Iron																	+	○	○	-	-							-
N Ferrite Materials																										○	-	
S Heat-resistant steel							+	+			+						+									+		
SKU#	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			
424-1950																										●		
424-1951																										●		
424-1952																										●		
424-1953																										●		
424-1954																										●		
424-1955																										●		
424-1956																										●		
424-1957																										●		

+ Good Working Conditions

○ 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.

