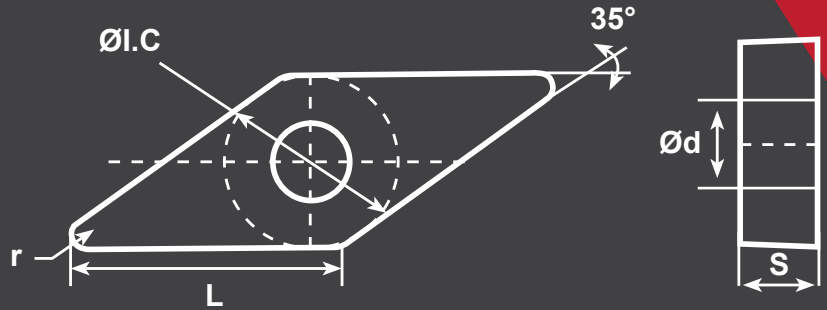


VNMG

Compatible
Workpiece Materials

P
Steel



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1894	VNMG331-DF	VNMG160404DF	0.654	0.375	0.187	0.15	0.016	P Vc: 1310sfm (980-1640) fz: 0.004in/z (0.002-0.008)	
424-1895	VNMG332-DF	VNMG160408DF	0.654	0.375	0.187	0.15	0.031	P Vc: 1310sfm (980-1640) fz: 0.004in/z (0.002-0.008)	
424-1884	VNMG332-DF	VNMG160408DF	0.654	0.375	0.187	0.15	0.031	P Vc: 1180sfm (920-1580) fz: 0.006in/z (0.002-0.012)	

Material	Coated cemented carbide																Cermet	Coated Cermet	Cemented Carbide							
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBC102	YBC105	YBC202	YBC205	YBC212	YBM215	YBM151	YBM251	YBM253	YBS103				YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C
P Steel	+	+	○	○	-	-	+		○	○													+	+		
M Stainless Steel							+		○	○		+	○	○	○								+	+		
K Cast Iron																	+	○	○	-	-					-
N Ferrite Materials																								○	-	
S Heat-resistant steel							+	+			+					+								+		

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



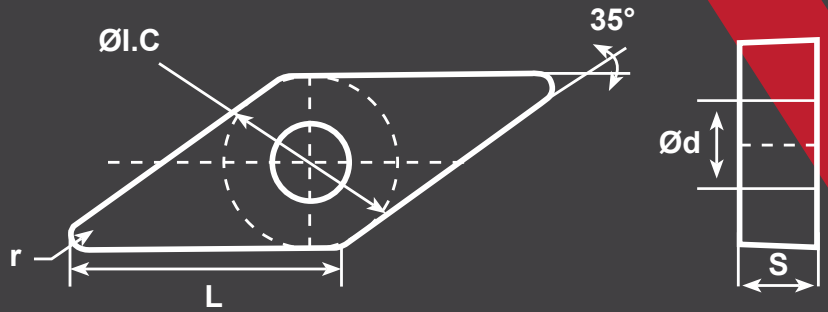
DF CHIP BREAKER

The DF chip breaker is the preferred choice chip breaker on P category material finish. M Class tolerance double sided chip breaker, excellent chip flow in finishing cut range while producing excellent surface finish on work material.



VNMG

Compatible
Workpiece Materials



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1917	VNMG332-DM	VNMG160408DM	0.654	0.375	0.187	0.15	0.031	P Vc: 920sfm (720-1180) fz: 0.008in/z (0.004-0.012)	
424-1918	VNMG333-DM	VNMG160412DM	0.654	0.375	0.187	0.15	0.047	P Vc: 850sfm (720-1120) fz: 0.010in/z (0.004-0.016)	

Material	Coated cemented carbide																Cermet	Coated Cermet	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
P Steel	+	+	○	○	-	-	+		○	○														+	+	
M Stainless Steel							+		○	○		+	○	○	○									+	+	
K Cast Iron																			+	○	○	-	-			-
N Ferrite Materials																								○	-	
S Heat-resistant steel							+	+			+						+							+		

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

DM CHIP BREAKER

The DM chip breaker is the preferred choice chip breaker on P category material semi-finish. M Class tolerance double sided chip breaker, light cutting force with wide chipping range, can achieve better result on high adhesive alloy steels.



VNMG

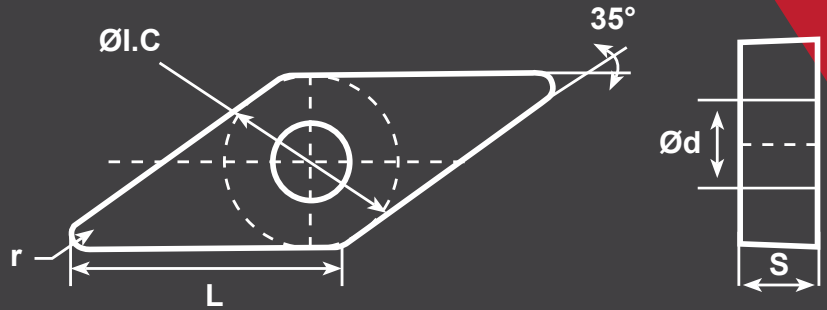


Steel



Cast Iron

Compatible Workpiece Materials



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1905	VNMG331-PM	VNMG160404PM	0.654	0.375	0.187	0.15	0.016	P Vc: 980sfm (850-1250)	fz: 0.006in/z (0.004-0.012)
424-1906	VNMG332-PM	VNMG160408PM	0.654	0.375	0.187	0.15	0.031	P Vc: 920sfm (790-1180)	fz: 0.008in/z (0.004-0.012)
424-1916	VNMG331-PM	VNMG160404PM	0.654	0.375	0.187	0.15	0.016	P Vc: 1120sfm (920-1440)	fz: 0.010in/z (0.004-0.020)
424-1910	VNMG331-PM	VNMG160404PM	0.654	0.375	0.187	0.15	0.016	K Vc: 1050sfm (790-1250)	fz: 0.004in/z (0.002-0.008)
424-1911	VNMG332-PM	VNMG160408PM	0.654	0.375	0.187	0.15	0.031	K Vc: 980sfm (720-1180)	fz: 0.006in/z (0.003-0.010)

	Coated cemented carbide																Cermet	Coated Cermet	Cemented Carbide						
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
424-1905			●																						
424-1906			●																						
424-1916				●																					
424-1910																				●					
424-1911																				●					

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

PM CHIP BREAKER

The preferred choice chip breaker on P category material semi-finish M Class tolerance double sided chip breaker has a stronger cutting edge than DM chip breaker. This insert is suitable for turning semi-finish/medium on alloy steel under unstable cutting conditions and is also the preferred choice on cast iron.



VNMG



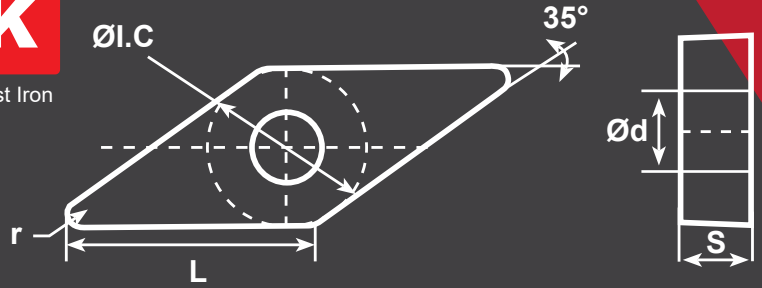
Steel



Cast Iron



Stainless Steel



Compatible Workpiece Materials

SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
427-3070	WNMG332-SF	WNMG160408SF	0.654	0.375	0.187	0.15	0.031	P Vc: 1310sfm (1050-1575) fz: 0.008in/z (0.002-0.014)	
								M Vc: 720sfm (530-920) fz: 0.008in/z (0.002-0.014)	
								K Vc: 690sfm (530-850) fz: 0.008in/z (0.002-0.014)	

	P Steel	M Stainless Steel	K Cast Iron	N Ferrite Materials	S Heat-resistant steel	Coated cemented carbide															Cermet	Coated Cermet	Cemented Carbide		
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
427-3070																							●		

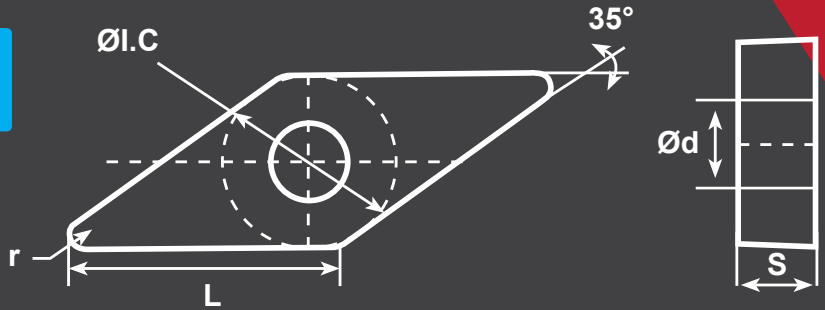
+ Good Working Conditions
 ○ General Working Conditions
 - Adverse Working Conditions

SF CHIP BREAKER

Extra Fine Finishing on P soft steel. Unique nose design and sharp cutting edge lead to small cutting resistance and reduce vibration. Outstanding performance of chip breaking and chip flowing on machining P soft steel and medium carbon steel to ensure high quality surface finish.



VNMG



Compatible
Workpiece Materials

SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
428-1419	VNMG332-XF	VNMG160408XF	0.654	0.375	0.187	0.15	0.031	P Vc: 720sfm (460-1500)	fz: 0.008in/z (0.004-0.012)

	Coated cemented carbide																	Cermet	Coated Cermet	Cemented Carbide							
SKU#	YBC103	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	
428-1419	+	+	+	○	○	-	-	+		○	○													+	+		

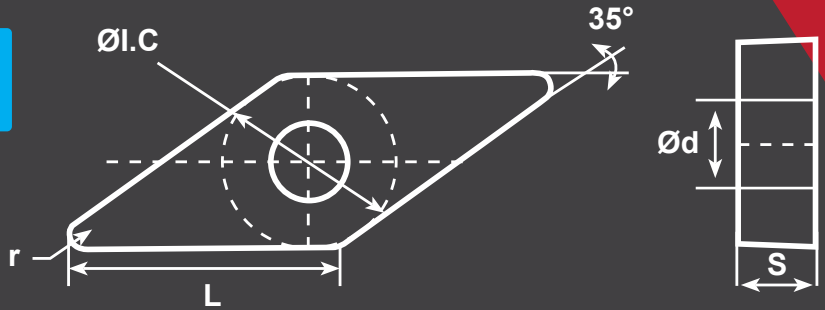
+ Good Working Conditions
 ○ General Working Conditions
 - Adverse Working Conditions

XF CHIP BREAKER

New generation chip breaker for finishing P type steel. Curved edge inclination ensures the strength of the cutting edge and reduces cutting resistance, special chip breaker design ensures improved chip control performance within the finishing range.



VNMG



Compatible Workpiece Materials

SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
428-1422	VNMG332-XM	VNMG160408XM	0.654	0.375	0.187	0.15	0.031	P Vc: 720sfm (460-1500)	fz: 0.012in/z (0.006-0.018)

Material	Coated cemented carbide																				Cermet	Coated Cermet	Cemented Carbide					
	YBC103	YBC203	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									+	+			+					+								+		

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

XM CHIP BREAKER

New generation chip breaker for semi-finishing P type steel. With optimal cutting-edge structure to ensure its sharpness and strength, the newly designed chip breaker geometry, and innovative coating grades, the cutting edge is superior in its strength and wear resistance.

