CoroTurn® 107 screw clamping system

External tools for positive basic-shape inserts with 7° clearance angle

Component diameter 6-32 mm

For light roughing to finishing of small, long and slender components, ideal for copy machining

A system of holders, designed for small part machining, for all insert shapes and different entering angles. Available in conventional shank design and the newly introduced QS™ holding system.

- For the QS holding system, see page B22

Accuracy

Tool holders with ground shank and with zero offset. Available in shank sizes from 0808 to 1616 for sliding head machines.

High feed machining

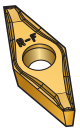
Sandvik Coromant's productivity booster

The highly productive Wiper insert for semi-finishing and finish turning will half your cycle time or give twice as good surface finish.

CoroTurn® 107 inserts

CoroTurn 107 includes a large variety of geometries and grades dedicated for various materials.

VCEX inserts



Sharp edges for excellent cutting action when turning and back turning
Nose radii of 0 and 0.1 mm
Super finish due to wiper effect and good chip control
Polished for better chip flow

E-tolerance for precision machining of small components.

UM geometry

Sharp edges to meet high performance demands in copying and longitudinal turning
Ground insert with small nose radii

G-tolerance ensures high indexing tolerance.

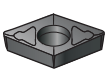
PF/PM geometries

For finishing and medium operations where a sharp edge is not a necessity
Available in a large range of radii 0.2-1.2 mm

M-tolerance in all the latest grades for all materials.

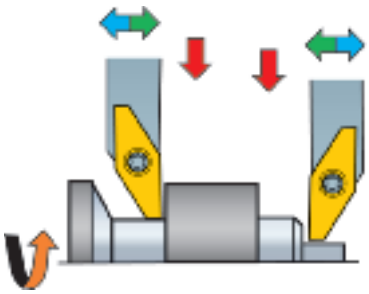
ER- treated edge for long consistent tool life

AL geometry



Sharp edges for aluminium, titanium and other non-ferrous materials.

G-tolerance ensures high indexing security



For back turning, holder SVABR/L with 90° entering angle is recommended for best chip flow.

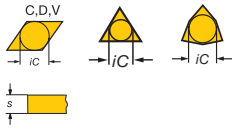
Choosing the right tolerance will provide you with the right level of precision

Tolerances on s (thickness) and iC (inscribed circle)
Example:

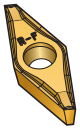
VCEX 11 03 01R-F

E = Tolerance class

Class	*s*	*iC*
G	±0.13	±0.025
M	±0.13	±0.05-±0.15
U	±0.13	±0.08-±0.25
E	±0.025	±0.025



Practical hints



VCEX inserts

External turning

- The VCEX insert, due to its design, has a very high edge strength, which enables machining in one pass, resulting in increased stability of the component and reduced cycle time.
- We recommend you run with a cutting speed higher than 60 m/min as this will increase the tool life radically.
- The good chip control provided by the VCEX insert geometry makes it possible to generate an extremely good surface finish.
- We recommend you use grade GC1020 as first choice, but for prolonging tool life and for finishing cuts cermet grade CT5015 should be used.

External back turning

- To ensure low radial forces use a holder with 90° entering angle e.g. SVABR 1212M11-SB1.
- To ensure best edge strength choose grade GC1020. However, if a shiny surface is the prime consideration, choose the cermet grade CT5015.
- For components with finish diameters less than 12 mm we recommend you use the CoroCut XS back-turning insert as this is designed to be closer to the guide-bush or chuck.

DCMX inserts

TECHNOLOGY Wiper

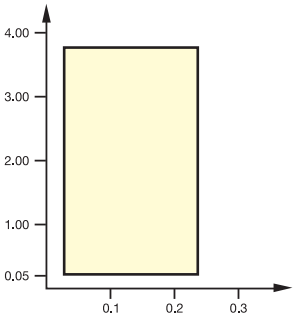
External turning

- DCMX wiper inserts can be used in side-turning and copying operations where a minimum nose radius of 0.4 mm is adequate.
- If a smaller nose radius is needed choose an insert from the CoroTurn 107 G-tolerance range, e.g. DCGT 110301-UM in grade GC1025.
- Do not run with too small a cutting depth as it can generate a grey surface. Always apply the insert to a larger cutting depth than the nose radius.

Quick start cutting data

External turning

Depth of cut (a_p), mm



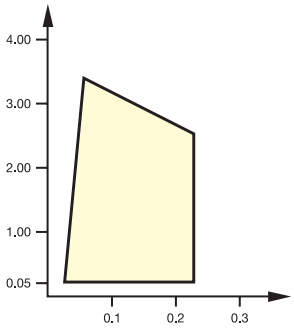
Cutting speed

P	M	N	S
95-125	95-115	95-200	10-15

Grade GC1020, (v_c) m/min

External back turning

Depth of cut (a_p), mm

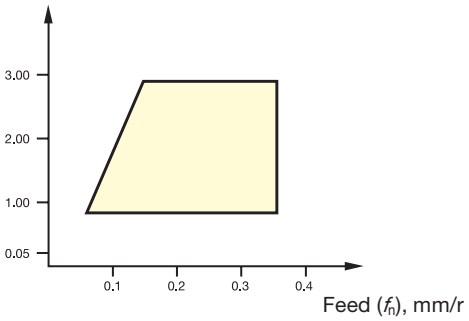


P	M	N	S
95-125	95-115	95-200	10-15

Grade GC1020, (v_c) m/min

External turning

Depth of cut (a_p), mm

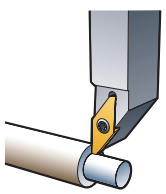


P	M	N	S
60-200	60-180	90-400	20-50

Grade GC1025, (v_c) m/min

Machining example

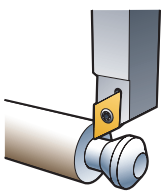
Component diameter 1-32 mm



CoroTurn® 107 VCEX inserts
Side-turning (not copying)

Insert:	VCEX 11 03 01R-F 1020
Holder:	SVJBR 1212K-S-B1
Material:	low alloy steel
v_c m/min:	150
a_p mm:	2
f_n mm/rev:	0.1

Component diameter 6-32 mm



CoroTurn® 107 DCMX inserts
Side-turning (copying)

Insert:	DCMX 11 T3 04-WF 4015
Holder:	SDJCR 1212K-S
Material:	low alloy steel
v_c m/min:	150
a_p mm:	1.5
f_n mm/rev:	0.1

For more specific cutting data, see pages F1, F2, F3

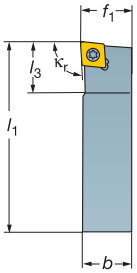
Shank tools

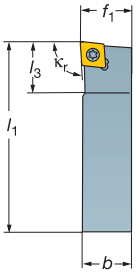
General turning

CoroTurn® 107 screw clamp design

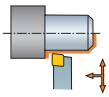
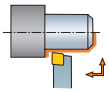
CCMT, CCGT
CCGX
CCMW

Entering angle: **SCLCR/L** κ_r 95° **SCACR/L** κ_r 90°





Right hand style shown when nothing else is stated

κ_r	Main application	□	Ordering code	Dimensions, mm b	f_1	h	h_1	l_1	l_3	γ [1]	λ_s [2]	Gauge inserts	Nm [3]
95°		06	SCLCR/L 0808K 06-S	8	8.0	8	8	125	8.0	0°	0°	CCMT 06 02 04	0.9
			SCLCR/L 1010K 06-S	10	10.0	10	10	125	10.0	0°	0°	CCMT 06 02 04	0.9
			SCLCR/L 1212K 06-S	12	12.0	12	12	125	12.0	0°	0°	CCMT 06 02 04	0.9
			SCLCR/L 1616K 06-S	16	16.0	16	16	125	16.0	0°	0°	CCMT 06 02 04	0.9
		09	SCLCR/L 1212K 09-S	12	12.0	12	12	125	12.0	0°	0°	CCMT 09 T3 08	3.0
			SCLCR/L 1616K 09-S	16	16.0	16	16	125	16.0	0°	0°	CCMT 09 T3 08	3.0
90°		06	SCACR/L 0808K 06-S	8	8.0	8	8	125	8.0	0°	0°	CCMT 06 02 04	0.9
			SCACR/L 1010K 06-S	10	10.0	10	10	125	10.0	0°	0°	CCMT 06 02 04	0.9
			SCACR/L 1212K 06-S	12	12.0	12	12	125	12.0	0°	0°	CCMT 06 02 04	0.9
		09	SCACR/L 1212K 09-S	12	12.0	12	12	125	12.0	0°	0°	CCMT 09 T3 08	3.0
			SCACR/L 1616K 09-S	16	16.0	16	16	125	16.0	0°	0°	CCMT 09 T3 08	3.0

[1] γ = Rake angle.
[2] λ_s = Angle of inclination.
[3] Insert tightening torque Nm.

R = Right hand, L = Left hand

Main spare parts

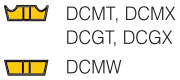
Insert size □	Insert screw (thread)	Key (Torx Plus)
06	5513 020-03 (M2.5)	5680 051-02 (7IP)
09	5513 020-09 (M3.5)	5680 049-01 (15IP)

B8

Shank tools

General turning

CoroTurn® 107 screw clamp design

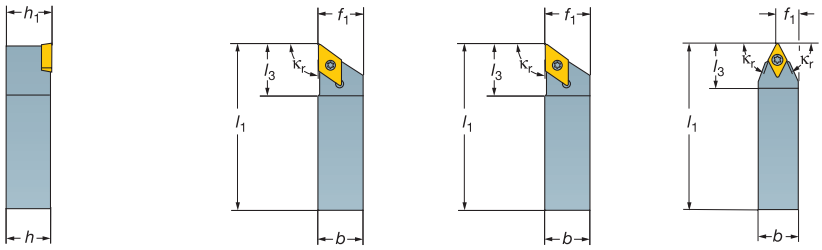


Entering angle:

SDJCR/L κ_r 93°

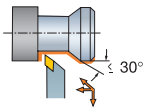
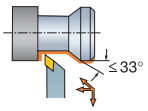
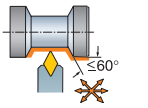
SDACR/L κ_r 90°

SDNCN κ_r 62.5°



(neutral)

Right hand style shown when nothing else is stated

κ_r	Main application		Ordering code	Dimensions, mm b	f_1	h	h_1	l_1	l_3	γ [1]	λ_s [2]	Gauge inserts	Nm [3]
93°		07	SDJCR/L 0808K 07-S	8	8.0	8	8	125	12.7	0°	0°	DCMT 07 02 04	0.9
		07	SDJCR/L 1010K 07-S	10	10.0	10	10	125	15.0	0°	0°	DCMT 07 02 04	0.9
			SDJCR/L 1212K 07-S	12	12.0	12	12	125	15.0	0°	0°	DCMT 07 02 04	0.9
			SDJCR/L 1616K 07-S	16	16.0	16	16	125	16.0	0°	0°	DCMT 07 02 04	0.9
		11	SDJCR/L 1212K 11-S	12	12.0	12	12	125	18.0	0°	0°	DCMT 11 T3 08	3.0
			SDJCR/L 1616K 11-S	16	16.0	16	16	125	20.0	0°	0°	DCMT 11 T3 08	3.0
90°		07	SDACR/L 0808K 07-S	8	8.0	8	8	125	12.7	0°	0°	DCMT 07 02 04	0.9
			SDACR/L 1010K 07-S	10	10.0	10	10	125	15.0	0°	0°	DCMT 07 02 04	0.9
			SDACR/L 1212K 07-S	12	12.0	12	12	125	15.0	0°	0°	DCMT 07 02 04	0.9
		11	SDACR/L 1212K 11-S	12	12.0	12	12	125	18.0	0°	0°	DCMT 11 T3 08	3.0
			SDACR/L 1616K 11-S	16	16.0	16	16	125	20.0	0°	0°	DCMT 11 T3 08	3.0
62.5°		07	SDNCN 1010K 07-S	10	5.2	10	10	125	15.0	0°	0°	DCMT 07 02 04	0.9
		11	SDNCN 1212K 11-S	12	6.2	12	12	125	21.0	0°	0°	DCMT 11 T3 08	3.0
			SDNCN 1616K 11-S	16	8.5	16	16	125	21.0	0°	0°	DCMT 11 T3 08	3.0

[1] γ = Rake angle (valid with flat insert).
[2] λ_s = Angle of inclination.
[3] Insert tightening torque Nm.

N = Neutral, R = Right hand, L = Left hand

Main spare parts

Insert size	Insert screw (thread)	Key (Torx Plus)
07	5513 020-03 (M2.5)	5680 051-02 (7IP)
11	5513 020-09 (M3.5)	5680 049-01 (15IP)

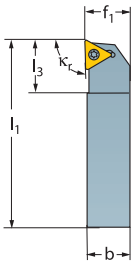
B10

Shank tools

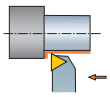
General turning

CoroTurn® 107 screw clamp design

Entering angle: **STJCR/L** κ_r 93°



Right hand style shown when nothing else is stated

κ_r	Main application	△	Ordering code	Dimensions, mm b	f_1	h	h_1	l_1	l_3	γ [1]	λ_s [2]	Gauge inserts	Nm [3]
93°		11	**STJCR/L 1010K 11-S**	10	10.0	10	10	125	16.0	0°	0°	TCMT 11 02 04	0.9
			STJCR/L 1212K 11-S	12	12.0	12	12	125	16.0	0°	0°	TCMT 11 02 04	0.9
			STJCR/L 1616K 11-S	16	16.0	16	16	125	16.0	0°	0°	TCMT 11 02 04	0.9

[1] γ = Rake angle (valid with flat insert).
[2] λ_s = Angle of inclination.
[3] Insert tightening torque Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size △	Insert screw (thread)	Key (Torx Plus)
11	5513 020-03 (M2.5)	5680 051-02 (7IP)

B10

Shank tools

General turning

CoroTurn® 107 screw clamp design

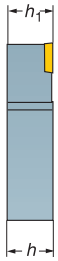
VBMT, VBGT
VCGX, VCEX,
VCGT
VBMW, VCMW

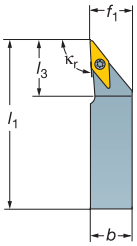
Entering angle:

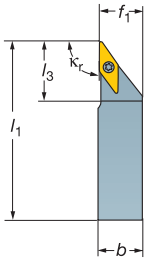
SVJBR/L
κ_r 93°

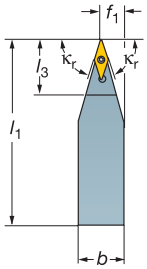
SVABR/L
κ_r 90°

SVVBN
κ_r 72.5°



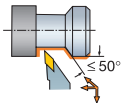
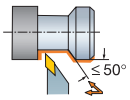
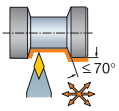






(neutral)

Right hand style shown when nothing else is stated

κ_r	Main application		Ordering code	Dimensions, mm b	f_1	h	h_1	l_1	l_3	γ[1]	λ_s[2]	Gauge inserts	Nm[3]
93°		11	**SVJBL 1616K 11-S**	16	16.0	16	16	125	26.0	0°	0°	VBMT 11 02 04	0.9
			SVJBR/L 0810K 11-S-B1[4]	10	10.0	8	8	125	26.0	0°	0°	VBMT 11 03 04	0.9
			SVJBR/L 1010K 11-S	10	10.0	10	10	125	26.0	0°	0°	VBMT 11 02 04	0.9
			SVJBR/L 1010K 11-S-B1[4]	10	10.0	10	10	125	26.0	0°	0°	VBMT 11 03 04	0.9
			SVJBR/L 1212K 11-S	12	12.0	12	12	125	26.0	0°	0°	VBMT 11 02 04	0.9
			SVJBR/L 1212K 11-S-B1[4]	12	12.0	12	12	125	26.0	0°	0°	VBMT 11 03 04	0.9
			SVJBR/L 1616K 11-S-B1[4]	16	16.0	16	16	125	26.0	0°	0°	VBMT 11 03 04	0.9
		16	**SVJBL 1616K 16-S**	16	16.0	16	16	125	40.0	0°	0°	VBMT 16 04 08	3.0
			SVJBR/L 1212K 16-S	12	12.0	12	12	125	30.0	0°	0°	VBMT 16 04 08	3.0
90°		11	**SVABR/L 0810K 11-S**	10	10.0	8	8	125	26.0	0°	0°	VBMT 11 02 04	0.9
			SVABR/L 0810K 11-S-B1[4]	10	10.0	8	8	125	26.0	0°	0°	VBMT 11 03 04	0.9
			SVABR/L 1010K 11-S	10	10.0	10	10	125	26.0	0°	0°	VBMT 11 02 04	0.9
			SVABR/L 1010K 11-S-B1[4]	10	10.0	10	10	125	26.0	0°	0°	VBMT 11 03 04	0.9
			SVABR/L 1212K 11-S	12	12.0	12	12	125	26.0	0°	0°	VBMT 11 02 04	0.9
			SVABR/L 1212K 11-S-B1[4]	12	12.0	12	12	125	26.0	0°	0°	VBMT 11 03 04	0.9
			SVABR/L 1616K 11-S	16	16.0	16	16	125	26.0	0°	0°	VBMT 11 02 04	0.9
			SVABR/L 1616K 11-S-B1[4]	16	16.0	16	16	125	26.0	0°	0°	VBMT 11 03 04	0.9
		16	**SVABR/L 1212K 16-S**	12	12.0	12	12	125	40.0	0°	0°	VBMT 16 04 08	3.0
			SVABR/L 1616K 16-S	16	16.0	16	16	125	40.0	0°	0°	VBMT 16 04 08	3.0
72.5°		11	**SVVBN 0808K 11-S-B1**[4]	8	4.3	8	8	125	21	0°	0°	VBMT 11 03 04	0.9
			SVVBN 1010K 11-S-B1[4]	10	5.3	10	10	125	21	0°	0°	VBMT 11 03 04	0.9
			SVVBN 1212K 11-S-B1[4]	12	6.3	12	12	125	21	0°	0°	VBMT 11 03 04	0.9
			SVVBN 1616K 11-S-B1[4]	16	8.3	16	16	125	21	0°	0°	VBMT 11 03 04	0.9

[1] γ = Rake angle (valid with flat insert).
[2] λ_s = Angle of inclination.
[3] Insert tightening torque Nm.
[4] B1 = For insert with thickness 03 = 3.18 mm.

N = Neutral, R = Right hand, L = Left hand

Main spare parts

Insert size	Insert screw (thread)	Key (Torx Plus)
11	5513 020-03 (M2.5)	5680 051-02 (9IP)
16	5513 020-09 (M3.5)	5680 049-01 (15IP)

B15

Shank tools for internal positions

General turning

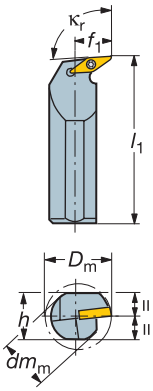
CoroTurn® 107 screw clamp design

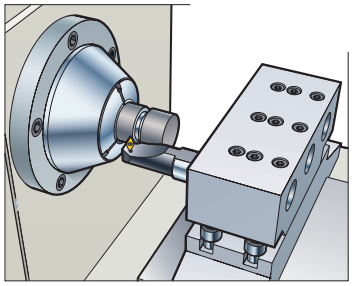
Cylindrical with flats

Entering angle: **SVUBL** κ_r 93°

VBMT, VBGT
VCGX, VCEX,
VCGT

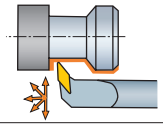
VBMW, VCMW





Boring bars for external machining with diameters 19.05 and 25.4 mm to be used in Swiss machines where inch sleeves are commonly used.

Left hand style shown

Machine type	κ_r		Ordering code	Dimensions, mm/inch dm_m	D_m min	f_1	h	l_1	γ[1]	λ[2]	Gauge inserts	Nm[3]
Citizen	93°		11	**A12S-SVUBL 2-EB1**	19.05 .750	25.7 1.012	14.7 .580	18.03 .710	254 10	0°	-5°	VBMT 11 03 04	0.9
				A16T-SVUBL 2-DB1	25.4 1.000	31.5 1.240	17.3 .680	23.11 .910	304.8 12	0°	-4°	VBMT 11 03 04	

1) γ = Rake angle (valid with flat insert).
2) λ_s = Angle of inclination.
3) Insert tightening torque Nm.

R = Right hand, L = Left hand

Main spare parts

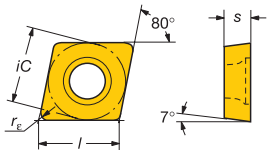
Insert size	Insert screw	Key (Torx Plus)
11	5513 020-03	5680 051-02 (7IP)

B15

Positive basic-shape inserts

General turning

Rhombic 80°



For ISO application areas, see bottom of the page.

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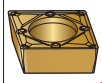
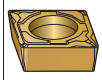
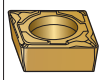
Finishing		06	CCMT 06 02 04-WF	☆		★			☆	☆	★							★			
			CCMT 06 02 08-WF	☆		★			☆	☆	★							★			
		09	CCMT 09 T3 04-WF	☆		★			☆	☆	★							★			
			CCMT 09 T3 08-WF	☆		★			☆	☆	★							★			
		06	CCMT 06 02 02-PF					★	☆												
			CCMT 06 02 04-PF			★			☆												
		09	CCMT 09 T3 02-PF					★	☆												
			CCMT 09 T3 04-PF			★		☆	☆												
			CCMT 09 T3 08-PF			★		☆	☆												
		06	CCMT 06 02 02-MF							★								★			
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			CCMT 09 T3 04-MF							☆	★	☆					☆	☆	★		
			CCMT 09 T3 08-MF							☆	★	☆						★			
		06	CCMT 06 02 02-UF						☆	☆								☆			
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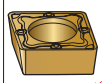
Medium		06	CCMT 06 02 08-WM			★		☆		★								★			
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			CCMT 09 T3 08-WM	☆	☆	★		☆		☆	★							★			
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		09	CCMT 09 T3 04-PM	☆	☆	☆	☆	★	☆												
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	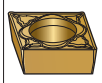	06	CCMT 06 02 04-MM							☆	★						☆	☆	★		
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			CCMT 09 T3 08-MM							☆	☆	★	☆				☆	☆	★		
		06	CCGT 06 02 01-UM							☆								★			☆
			CCGT 06 02 02-UM							☆								★			☆
			CCGT 06 02 04-UM						☆				☆					★			☆
		09	CCGT 09 T3 01-UM						☆	☆			☆					☆	★		☆
			CCGT 09 T3 02-UM						☆	☆			☆					☆	★		☆
			CCGT 09 T3 04-UM						☆	☆			☆				☆	☆	★		☆
			CCGT 09 T3 08-UM						☆	☆			☆				☆	☆	★		☆
				P15	P05	P15	P35	P25	P10	M15	M15	M25	M35	M35	N10	N15	S15	S15	S15	S10	S15

★= First choice

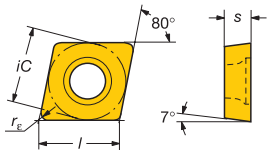
For dimensions, see code key on page H2.

B3 B25 C3 F1 G2

Positive basic-shape inserts

General turning

Rhombic 80°



For ISO application areas, see bottom of the page.

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		09	CCMW 09 T3 04						☆												
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		09	CCMT 09 T3 04-UM					☆		☆		☆		☆				☆			
			CCMT 09 T3 08-UM	☆				☆	☆	☆		☆		☆				☆			
Roughing		06	CCMT 06 02 08-PR			★	☆														
		09	CCMT 09 T3 08-PR			☆	☆	★													
			CCMT 09 T3 12-PR				☆	★													
		06	CCMT 06 02 08-MR								★		☆								
		09	CCMT 09 T3 08-MR								☆	★	☆								
			CCMT 09 T3 12-MR									★									
		06	CCMT 06 02 04-UR					☆						☆							
		09	CCMT 09 T3 04-UR			☆	☆	☆						☆							
			CCMT 09 T3 08-UR			☆	☆	☆						☆							
Aluminium		06	CCGX 06 02 02-AL												★	☆					
			CCGX 06 02 04-AL												★	☆					
		09	CCGX 09 T3 04-AL												★	☆					
			CCGX 09 T3 08-AL												★	☆					
				P15	P05	P15	P35	P25	P10	M15	M15	M25	M35	M35	N10	N15	S15	S15	S15	S10	S15

★= First choice

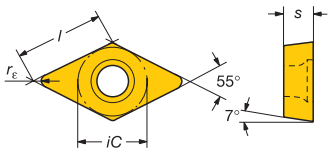
For dimensions, see code key on page H2.

B3 B25 C3 F1 G2

Positive basic-shape inserts

General turning

Rhombic 55°



For ISO application areas, see bottom of the page.

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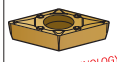
Finishing		07	DCMX 07 02 04-WF	☆		★			☆	☆	★								★			
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			DCMT 11 T3 08-PF			★		☆	☆													
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	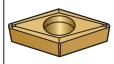	07	DCMT 07 02 02-UF						☆													
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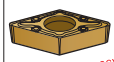
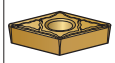
Medium		11	DCMX 11 T3 04-WM	☆	☆	★		☆		☆	★								★			
			DCMX 11 T3 08-WM	☆	☆	★		☆		☆	★								★			
		07	DCMT 07 02 04-PM	☆		☆	☆	★	☆													
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		11	DCMT 11 T3 04-PM	☆	☆	☆	☆	★	☆													
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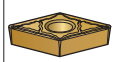
			DCMT 11 T3 12-PM	☆		☆	☆	★	☆													
		07	DCMT 07 02 04-MM							☆	☆	★	☆					☆	☆	★		
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		11	DCMT 11 T3 04-MM							☆	☆	★	☆					☆	☆	★		
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	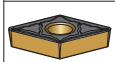	07	DCMT 07 02 04-KM																		★	
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		11	DCMT 11 T3 04-KM																		★	
			DCMT 11 T3 08-KM																		★	
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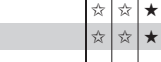


★= First choice

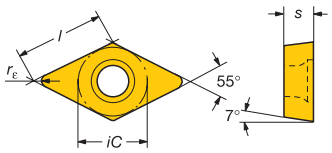
For dimensions, see code key on page H2.

B4 B25 C4 F1 G2

Positive basic-shape inserts

General turning

Rhombic 55°



For ISO application areas, see bottom of the page.

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			Ordering code																			
Medium		07	DCGT 07 02 01-UM							☆									★		☆	
			DCGT 07 02 02-UM							☆									★		☆	
			DCGT 07 02 04-UM						☆	☆			☆						★		☆	
			DCGT 07 02 08-UM						☆	☆			☆						★		☆	
		11	DCGT 11 T3 01-UM						☆	☆			☆						☆	★	☆	
			DCGT 11 T3 02-UM						☆	☆			☆						☆	★	☆	
			DCGT 11 T3 04-UM						☆	☆			☆					☆	☆	★	☆	☆
			DCGT 11 T3 08-UM						☆	☆			☆					☆	☆	★	☆	☆
		11	DCMW 11 T3 04																		☆	
		07	DCET 07 02 00-UM[1]							☆									★			
			DCET 07 02 01-UM[1]							☆									★			
		11	DCET 11 T3 01-UM[1]							☆									★			
			DCET 11 T3 02-UM[1]							☆									★			
			DCET 11 T3 04-UM[1]							☆									★			
		07	DCMT 07 02 04-UM	☆				☆		☆				☆					☆			
			DCMT 07 02 08-UM					☆		☆									☆			
		11	DCMT 11 T3 04-UM	☆				☆	☆	☆		☆		☆					☆			
			DCMT 11 T3 08-UM	☆				☆		☆		☆		☆					☆			
Roughing		11	DCMT 11 T3 08-PR		☆	☆	☆	★														
			DCMT 11 T3 12-PR		☆	☆	☆	★														
		11	DCMT 11 T3 08-MR								☆	★	☆									
			DCMT 11 T3 12-MR								☆	★	☆									
		11	DCMT 11 T3 08-KR																		☆	
		11	DCMT 11 T3 04-UR			☆		☆														
			DCMT 11 T3 08-UR			☆	☆	☆														
			DCMT 11 T3 12-UR			☆	☆	☆														
Aluminium		07	DCGX 07 02 02-AL													★	☆					
			DCGX 07 02 04-AL												☆	★	☆					
		11	DCGX 11 T3 02-AL													★	☆					
			DCGX 11 T3 04-AL												☆	★	☆					
			DCGX 11 T3 08-AL												☆	★	☆					
				P15	P05	P15	P35	P25	P10	M15	M15	M25	M35	M35	N15	N10	N15	S15	S15	S15	S15	S05

[1] Super sharp cutting edge.

★= First choice

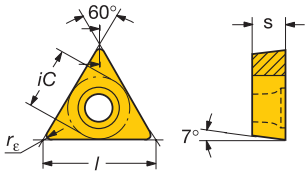
For dimensions, see code key on page H2.

B4 B25 C4 F1 G2

Positive basic-shape inserts

General turning

Triangular



For ISO application areas, see bottom of the page.

		△	Ordering code	P								M						N		S					
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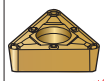
Finishing		09	TCMX 09 02 04-WF	☆			★				☆	☆	★							★			
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			TCMX 11 03 08-WF	☆			★				☆	☆	★							★			
		06	TCMT 06 T1 02-PF							★	☆												
			TCMT 06 T1 04-PF				★				☆												
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			TCMT 09 02 04-PF				★			☆	☆												
		11	TCMT 11 03 02-PF							★	☆												
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			TCMT 11 03 04-MF									☆	★	☆						★			
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		06	TCMT 06 T1 02-KF																				★
			TCMT 06 T1 04-KF																				★
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[1]R = Right hand, L = Left hand
★= First choice

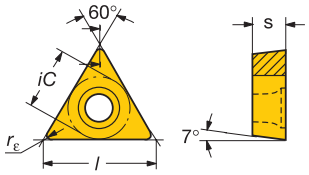
For dimensions, see code key on page H2.

B5 B27 C6 F1 G2

Positive basic-shape inserts

General turning

Triangular



For ISO application areas, see bottom of the page.

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Finishing		06	TCMT 06 T1 02-UF													☆							
			TCMT 06 T1 04-UF							☆						☆							
		09	TCMT 09 02 04-UF								☆												
		11	TCMT 11 02 02-UF						☆	☆	☆	☆				☆				☆			☆
			TCMT 11 02 04-UF				☆		☆	☆	☆	☆				☆				☆			☆
			TCMT 11 02 08-UF				☆		☆	☆	☆					☆							
Medium		11	TCMX 11 03 04-WM				★					★								★			
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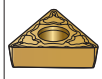
		09	TCMT 09 02 04-PM	☆			☆		☆	★	☆												
			TCMT 09 02 08-PM	☆			☆		☆	★	☆												
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			TCMT 11 03 08-PM	☆			☆		☆	★	☆												
			TCMT 11 03 12-PM							★													
		09	TCMT 09 02 04-MM									☆	☆	★	☆					★			
			TCMT 09 02 08-MM									☆	☆	★	☆					★			
		11	TCMT 11 03 04-MM									☆	☆	★	☆				☆	☆	★		
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	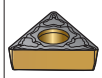		TCMT 09 02 08-KM																				★
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		11	TCGT 11 02 01-UM								☆	☆			☆					★			☆
			TCGT 11 02 02-UM								☆	☆			☆					★			☆
			TCGT 11 02 04-UM								☆	☆			☆					★			☆
			TCGT 11 02 08-UM								☆	☆			☆					★			☆
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		11	TCMW 11 02 04								☆							☆					☆
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		09	TCMT 09 02 04-UM	☆				☆		☆		☆				☆				☆			
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★= First choice

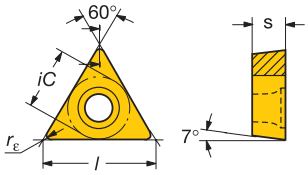
For dimensions, see code key on page H2.

B5 B27 C6 F1 G2

Positive basic-shape inserts

General turning

Triangular



For ISO application areas, see bottom of the page.

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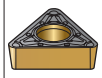
Roughing		11	TCMT 11 03 08-PR				☆		☆	★													
			TCMT 11 03 12-PR							★													
		11	TCMT 11 03 08-MR											★	☆								
		11	TCMT 11 03 08-KR																				★
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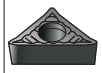
			TCMT 11 02 08-UR	☆			☆		☆	☆				☆		☆							☆
Aluminium		06	TCGX 06 T1 04-AL															★					
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			TCGX 11 02 04-AL														★	☆					
			TCGX 11 02 08-AL															★					
			TCGX 11 03 02-AL															★					
			TCGX 11 03 04-AL															★					
			TCGX 11 03 08-AL															★					
				P15	P35	P05	P15	P25	P35	P25	P10	M15	M15	M25	M35	M35	N10	N15	S15	S15	S15	S10	S15

★= First choice

For dimensions, see code key on page H2.

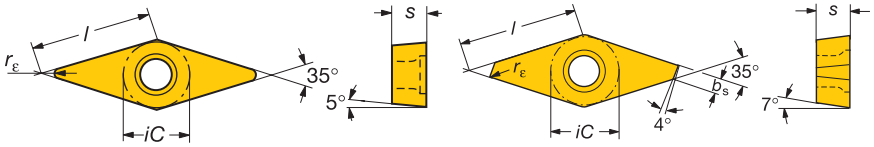
B5 B25 C6 F1 G2

Positive basic-shape inserts

General turning

Rhombic 35°

VCEX



For ISO application areas, see bottom of the page.

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Finishing		11	VBMT 11 03 02-PF	☆					★	☆														
			VBMT 11 03 04-PF	☆		★			☆	☆														
			VBMT 11 03 08-PF			★			☆	☆														
			VBMT 11 03 12-PF			★																		
		16	VBMT 16 04 02-PF							★														
			VBMT 16 04 04-PF			★			☆	☆														
			VBMT 16 04 08-PF			★			☆	☆														
			VBMT 16 04 12-PF			★																		
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			VBMT 11 03 08-MF									☆	★	☆							★				
		16	VBMT 16 04 02-MF									★									★				
			VBMT 16 04 04-MF									☆	★	☆							★				
			VBMT 16 04 08-MF									☆	★	☆							★				
			VBMT 16 04 12-MF										★												
		11	VBMT 11 03 02-KF																				★		
			VBMT 11 03 04-KF																				★		
		16	VBMT 16 04 02-KF																				★		
			VBMT 16 04 04-KF																				★		
			VBMT 16 04 08-KF																				★		
		11	VCEX 11 03 00R/L-F[1) 2)]							★	★											★			
			VCEX 11 03 01R/L-F[1) 2)]							★	★											★			
		11	VBMT 11 02 02-UF	☆				☆	☆	☆		☆				☆					☆		☆		
			VBMT 11 02 04-UF	☆				☆	☆	☆		☆				☆					☆		☆		
			VBMT 11 02 08-UF	☆				☆	☆	☆						☆							☆		
Medium		16	VBMT 16 04 04-PM	☆	☆	☆		☆	★	☆															
			VBMT 16 04 08-PM	☆	☆	☆		☆	★	☆															
			VBMT 16 04 12-PM	☆		☆		☆	★	☆															
		16	VBMT 16 04 04-MM									☆	☆	★	☆					☆	☆	★			
			VBMT 16 04 08-MM									☆	☆	★	☆					☆	☆	★			
			VBMT 16 04 12-MM									☆	☆	★	☆						★				
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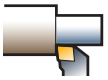
			VBMT 16 04 08-KM																				★		
			VBMT 16 04 12-KM																				★		
		11	VCET 11 03 01-UM[1)]									☆									★				
			VCET 11 03 02-UM[1)]									☆									★				
		11	VCGT 11 03 01-UM									☆									★		☆		
			VCGT 11 03 02-UM									☆									★		☆		
			VCGT 11 03 04-UM									☆									★		☆		
		16	VBGT 16 04 01-UM									☆									★		☆		
			VBGT 16 04 02-UM									☆									★		☆		
			VBGT 16 04 04-UM									☆			☆						☆	★	☆	☆	
			VBGT 16 04 08-UM									☆			☆						☆	★	☆	☆	
				P15	P05	P15	P25	P35	P25	P10	M35	M15	M15	M25	M35	M35	N15	N10	N15	S15	S15	S15	S15	S05	

[1)] Super sharp cutting edge.

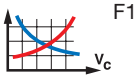
[2)] R = Right hand, L = Left hand

★= First choice

For dimensions, see code key on page H2.


B6

B28



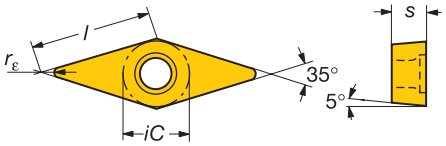
F1

G2

Positive basic-shape inserts

General turning

Rhombic 35°



For ISO application areas, see bottom of the page.

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Medium		16	VBMW 16 04 04																				☆	
		16	VBMT 16 04 04-UM	☆					☆	☆		☆		☆							☆		☆	
			VBMT 16 04 08-UM	☆			☆		☆	☆		☆		☆							☆		☆	
Roughing		16	VBMT 16 04 08-PR		☆	☆		☆	★															
			VBMT 16 04 12-PR		☆	☆		☆	★															
		16	VBMT 16 04 08-MR										☆	★	☆					☆		★		
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			VBMT 16 04 12-KR																				★	
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			VBMT 16 04 08-UR			☆		☆	☆							☆							☆	
			VBMT 16 04 12-UR			☆			☆														☆	
Aluminium		11	VCGX 11 02 02-AL															★	☆					
			VCGX 11 02 04-AL															★	☆					
			VCGX 11 03 02-AL																★					
			VCGX 11 03 04-AL														☆		★					
		16	VCGX 16 04 04-AL														☆	★	☆					
			VCGX 16 04 08-AL														☆	★	☆					
			VCGX 16 04 12-AL														☆	★	☆					
				P15	P05	P15	P25	P35	P25	P10	M35	M15	M15	M25	M35	M35	N15	N10	N15	S15	S15	S15	S15	S05

★= First choice

For dimensions, see code key on page H2.

B6 B28 F1 G2