



SVHB(C)(RL) EXT



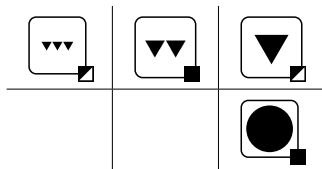
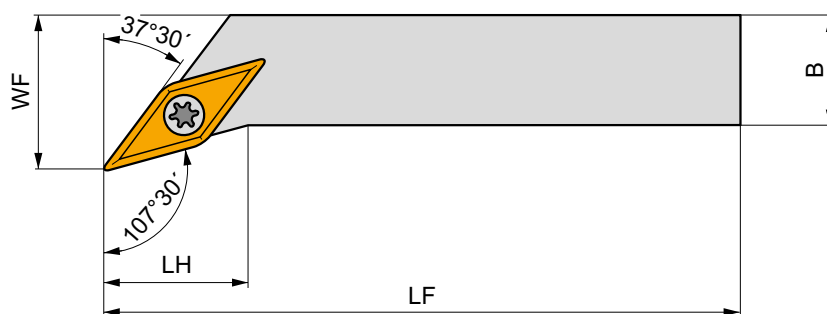
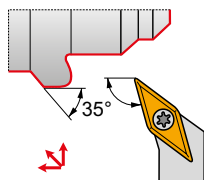
PRAMET

S



Ext. Screw Lock Tool Holder with 107.5° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool holder for screw type positive VB.. 11 or 16 and VC.. 11 or 16 inserts. Suited for external face and longitudinal turning with shoulder, taper, face and longitudinal copy turning up to 35° and chamfer turning. Available with shank size 16x16 up to 25x25 mm. Body treated for longer tool life.



Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SVHBR 1616 H 11	16	16	16	20	100	14	0	0	0.21	GI194 S01
	SVHCR 2020 K 16-M-A	20	20	20	25	125	20	0	0	0.40	GI017 SV10
	SVHCR 2525 M 16-M-A	25	25	25	32	150	20	0	0	0.68	GI017 SV10
L	SVHBL 1616 H 11	16	16	16	20	100	14	0	0	0.19	GI194 S01
	SVHCL 2020 K 16-M-A	20	20	20	25	125	20	0	0	0.40	GI017 SV10
	SVHCL 2525 M 16-M-A	25	25	25	32	150	20	0	0	0.07	GI017 SV10

GI017		VB.. 1604..								VC.. 1604..	
GI194		VB.. 1103..								VC.. 1103..	

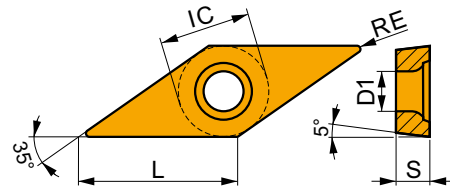
S01	US 2506-T07P	0.9	M 2.5	6.3	—	—	FLAG T07P	—			
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5			



VBMT

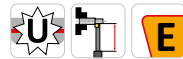
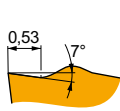


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1102	6.350	2.80	11.10	2.38
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



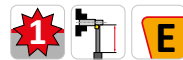
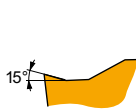
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)



FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

VBMT 160404E-FF2	T7325	0.4	145	0.12	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.4	150	0.12	0.8	—	—	—	125	0.12	0.8	—	—	—	—	—	—	—	—
	T9315	0.4	215	0.12	0.8	—	—	—	200	0.12	0.8	—	—	—	—	—	—	—	—
	T9325	0.4	190	0.12	0.8	—	—	—	180	0.12	0.8	—	—	—	—	—	—	—	—
	T9335	0.4	160	0.12	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—



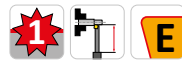
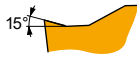
FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

VBMT 110302E-FM	T7325	0.2	160	0.10	0.8	120	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.2	145	0.10	0.8	85	0.09	0.8	135	0.10	0.8	435	0.12	0.8	—	—	—	—	—
	T8430	0.2	170	0.10	0.8	90	0.09	0.8	135	0.10	0.8	465	0.12	0.8	—	—	—	—	—
	T9325	0.2	210	0.10	0.8	125	0.09	0.8	195	0.10	0.8	—	—	—	—	—	—	—	—
	T9335	0.2	175	0.10	0.8	105	0.17	0.8	—	—	—	—	—	—	—	—	—	—	—
VBMT 110304E-FM	T7325	0.4	140	0.19	0.8	105	0.17	0.8	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.4	135	0.19	0.8	105	0.17	0.8	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	145	0.12	0.8	85	0.11	0.8	135	0.12	0.8	435	0.14	0.8	—	—	—	—	—
	T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	465	0.14	0.8	—	—	—	—	—
	T9315	0.4	235	0.12	0.8	—	—	—	220	0.12	0.8	—	—	—	—	—	—	—	—
VBMT 110308E-FM	T9325	0.4	175	0.19	0.8	105	0.17	0.8	165	0.19	0.8	—	—	—	—	—	—	—	—
	T7325	0.8	170	0.17	0.8	130	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.8	175	0.17	0.8	95	0.15	0.8	140	0.17	0.8	480	0.20	0.8	—	—	—	—	—
	T9315	0.8	240	0.17	0.8	—	—	—	225	0.17	0.8	—	—	—	—	—	—	—	—
	T9325	0.8	215	0.17	0.8	125	0.15	0.8	200	0.17	0.8	—	—	—	—	—	—	—	—
VBMT 160402E-FM	T7325	0.2	150	0.10	1.2	115	0.09	1.2	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.2	165	0.10	1.2	90	0.09	1.2	135	0.10	1.2	450	0.12	1.2	—	—	—	—	—
	T9315	0.2	230	0.10	1.2	—	—	—	215	0.10	1.2	—	—	—	—	—	—	—	—
	T9325	0.2	205	0.10	1.2	120	0.09	1.2	190	0.10	1.2	—	—	—	—	—	—	—	—
	T5315	0.4	225	0.12	1.2	—	—	—	210	0.12	1.2	—	—	—	—	—	—	—	—
VBMT 160404E-FM	T7325	0.4	130	0.19	1.2	100	0.17	1.2	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.4	130	0.19	1.2	100	0.17	1.2	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	140	0.12	1.2	80	0.11	1.2	130	0.12	1.2	420	0.14	1.2	—	—	—	—	—
	T8430	0.4	165	0.12	1.2	90	0.11	1.2	135	0.12	1.2	450	0.14	1.2	—	—	—	—	—
	T9315	0.4	225	0.12	1.2	—	—	—	210	0.12	1.2	—	—	—	—	—	—	—	—
	T9325	0.4	165	0.19	1.2	95	0.17	1.2	155	0.19	1.2	—	—	—	—	—	—	—	—
	T7325	0.8	170	0.17	0.8	130	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.8	175	0.17	0.8	95	0.15	0.8	140	0.17	0.8	480	0.20	0.8	—	—	—	—	—



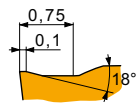
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



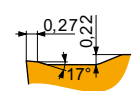
FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

VBMT 160408E-FM	T5315	0.8	235	0.17	1.2	—	—	—	220	0.17	1.2	—	—	—	—	—	—	—	—
	T7325	0.8	165	0.17	1.2	125	0.15	1.2	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.8	160	0.17	1.2	120	0.15	1.2	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.8	150	0.17	1.2	90	0.15	1.2	140	0.17	1.2	450	0.20	1.2	—	—	—	—	—
	T8430	0.8	170	0.17	1.2	90	0.15	1.2	135	0.17	1.2	465	0.20	1.2	—	—	—	—	—
	T9310	0.8	255	0.17	1.2	—	—	—	240	0.17	1.2	—	—	—	—	—	—	—	—
	T9315	0.8	230	0.17	1.2	—	—	—	215	0.17	1.2	—	—	—	—	—	—	—	—
	T9325	0.8	205	0.17	1.2	120	0.15	1.2	190	0.17	1.2	—	—	—	—	—	—	—	—
VBMT 160412E-FM	T7325	1.2	160	0.22	1.2	120	0.22	1.2	—	—	—	—	—	—	—	—	—	—	—
	T8430	1.2	155	0.22	1.2	85	0.22	1.2	130	0.22	1.2	435	0.26	1.2	—	—	—	—	—
	T9315	1.2	215	0.22	1.2	—	—	—	200	0.22	1.2	—	—	—	—	—	—	—	—
	T9325	1.2	195	0.22	1.2	115	0.22	1.2	185	0.22	1.2	—	—	—	—	—	—	—	—



FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

VBMT 160404E-FM2	T6310	0.4	120	0.12	1.2	85	0.11	1.2	95	0.12	1.2	—	—	—	—	—	—	—	—
	T7325	0.4	140	0.12	1.2	105	0.11	1.2	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.4	145	0.12	1.2	80	0.11	1.2	120	0.12	1.2	—	—	—	—	—	—	—	—
	T9315	0.4	200	0.12	1.2	—	—	—	190	0.12	1.2	—	—	—	—	—	—	—	—
	T9325	0.4	185	0.12	1.2	110	0.11	1.2	175	0.12	1.2	—	—	—	—	—	—	—	—
	T9335	0.4	155	0.12	1.2	90	0.11	1.2	—	—	—	—	—	—	—	—	—	—	—
VBMT 160408E-FM2	T6310	0.8	125	0.20	1.2	90	0.18	1.2	100	0.20	1.2	—	—	—	—	—	—	—	—
	T7325	0.8	145	0.20	1.2	110	0.18	1.2	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.8	140	0.20	1.2	75	0.18	1.2	115	0.20	1.2	—	—	—	—	—	—	—	—
	T9315	0.8	195	0.20	1.2	—	—	—	185	0.20	1.2	—	—	—	—	—	—	—	—
	T9325	0.8	175	0.20	1.2	105	0.18	1.2	165	0.20	1.2	—	—	—	—	—	—	—	—
	T9335	0.8	150	0.20	1.2	90	0.18	1.2	—	—	—	—	—	—	—	—	—	—	—
VBMT 160412E-FM2	T8430	1.2	145	0.22	1.2	80	0.20	1.2	120	0.22	1.2	—	—	—	—	—	—	—	—
	T9315	1.2	195	0.22	1.2	—	—	—	185	0.22	1.2	—	—	—	—	—	—	—	—
	T9325	1.2	175	0.22	1.2	105	0.20	1.2	165	0.22	1.2	—	—	—	—	—	—	—	—

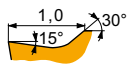


RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

VBMT 160404E-RM	T5305	0.4	270	0.12	1.2	—	—	—	255	0.12	1.2	—	—	—	—	50	0.12	0.3		
	T5315	0.4	235	0.12	1.2	—	—	—	220	0.12	1.2	—	—	—	—	45	0.12	0.3		
	T7335	0.4	140	0.18	1.2	105	0.16	1.2	—	—	—	—	45	0.16	1.0	—	—	—		
	T8430	0.4	170	0.12	1.2	90	0.11	1.2	135	0.12	1.2	—	—	—	35	0.11	1.0	25	0.12	0.3
	T9315	0.4	235	0.12	1.2	—	—	—	220	0.12	1.2	—	—	—	—	45	0.12	0.3		
	T9325	0.4	170	0.20	1.2	100	0.18	1.2	160	0.20	1.2	—	—	—	35	0.18	1.0	—	—	—
VBMT 160408E-RM	T5305	0.8	285	0.17	1.2	—	—	—	270	0.17	1.2	—	—	—	—	55	0.11	0.7		
	T5315	0.8	250	0.17	1.2	—	—	—	235	0.17	1.2	—	—	—	—	50	0.11	0.7		
	T7335	0.8	155	0.20	1.2	120	0.18	1.2	—	—	—	—	50	0.18	1.0	—	—	—		
	T8430	0.8	175	0.17	1.2	95	0.15	1.2	140	0.17	1.2	—	—	—	35	0.12	1.0	30	0.11	0.7
	T9315	0.8	240	0.17	1.2	—	—	—	225	0.17	1.2	—	—	—	—	45	0.12	0.7		
	T9325	0.8	200	0.20	1.2	120	0.18	1.2	190	0.20	1.2	—	—	—	45	0.18	1.0	—	—	—
VBMT 160412E-RM	T7335	1.2	150	0.27	1.2	115	0.24	1.2	—	—	—	—	—	—	45	0.19	1.0	—	—	—
	T8430	1.2	155	0.27	1.2	85	0.24	1.2	130	0.27	1.2	—	—	—	30	0.19	1.0	25	0.14	0.9
	T9315	1.2	210	0.27	1.2	—	—	—	195	0.27	1.2	—	—	—	—	40	0.14	0.9		
	T9325	1.2	185	0.27	1.2	110	0.24	1.2	175	0.27	1.2	—	—	—	40	0.19	1.0	—	—	—



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

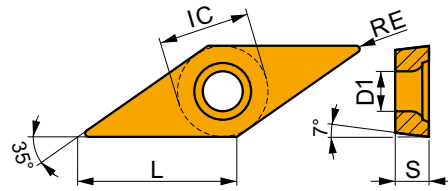
Product		RE (mm)	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
			UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.																	
VBM 110202E-UR	TT310	0.2	195	0.10	0.8	115	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—
VBM 110204E-UR	T8430	0.4	145	0.12	0.8	80	0.11	0.8	120	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	150	0.19	0.8	90	0.17	0.8	140	0.19	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.2	140	0.10	1.2	75	0.09	1.2	115	0.10	1.2	—	—	—	—	—	—	—	—	—
VBM 160404E-UR	T5315	0.4	195	0.12	1.2	—	—	—	185	0.12	1.2	—	—	—	—	—	—	—	—	—
	T7325	0.4	115	0.19	1.2	85	0.17	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.4	140	0.12	1.2	75	0.11	1.2	115	0.12	1.2	—	—	—	—	—	—	—	—	—
	T9310	0.4	215	0.12	1.2	—	—	—	200	0.12	1.2	—	—	—	—	—	—	—	—	—
	T9315	0.4	190	0.12	1.2	—	—	—	180	0.12	1.2	—	—	—	—	—	—	—	—	—
	T9325	0.4	145	0.18	1.2	85	0.16	1.2	135	0.18	1.2	—	—	—	—	—	—	—	—	—
	TT310	0.4	185	0.12	1.2	110	0.11	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T5315	0.8	205	0.17	1.2	—	—	—	190	0.17	1.2	—	—	—	—	—	—	—	—	—
VBM 160408E-UR	T7325	0.8	140	0.17	1.2	105	0.15	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.8	145	0.17	1.2	80	0.15	1.2	120	0.17	1.2	—	—	—	—	—	—	—	—	—
	T9310	0.8	220	0.17	1.2	—	—	—	205	0.17	1.2	—	—	—	—	—	—	—	—	—
	T9315	0.8	200	0.17	1.2	—	—	—	190	0.17	1.2	—	—	—	—	—	—	—	—	—
	T9325	0.8	180	0.17	1.2	105	0.15	1.2	170	0.17	1.2	—	—	—	—	—	—	—	—	—
	TT310	0.8	200	0.17	1.2	120	0.15	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	1.2	135	0.22	1.2	75	0.20	1.2	110	0.22	1.2	—	—	—	—	—	—	—	—	—
VBM 160412E-UR	T9310	1.2	205	0.22	1.2	—	—	—	190	0.22	1.2	—	—	—	—	—	—	—	—	—
	T9315	1.2	185	0.22	1.2	—	—	—	175	0.22	1.2	—	—	—	—	—	—	—	—	—
	T9325	1.2	170	0.22	1.2	100	0.20	1.2	160	0.22	1.2	—	—	—	—	—	—	—	—	—
	T9325	1.2	170	0.22	1.2	100	0.20	1.2	160	0.22	1.2	—	—	—	—	—	—	—	—	—



VCGT

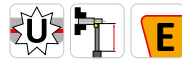
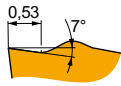


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0702	3.970	2.20	6.90	2.38
1102-SF3	6.350	2.80	11.10	2.58
1103-SF3	6.350	2.80	11.10	3.43
1303	7.940	3.40	13.80	3.18
1303-SF3	7.940	3.40	13.80	3.43
1604-SF3	9.525	4.40	16.60	5.01



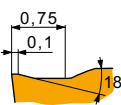
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)



FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

VCGT 070202E-FF2	T8315	0.2	150	0.05	0.8	—	—	—	140	0.05	0.8	—	—	—	—	—	—	—	—
	T8430	0.2	190	0.05	0.8	—	—	—	155	0.05	0.8	—	—	—	—	—	—	—	—
VCGT 070204E-FF2	T8315	0.4	125	0.12	0.8	—	—	—	115	0.12	0.8	—	—	—	—	—	—	—	—
	T8430	0.4	145	0.12	0.8	—	—	—	120	0.12	0.8	—	—	—	—	—	—	—	—
VCGT 130302E-FF2	T5315	0.2	250	0.05	1.0	—	—	—	235	0.05	1.0	—	—	—	—	—	—	—	—
	T8430	0.2	185	0.05	1.0	—	—	—	150	0.05	1.0	—	—	—	—	—	—	—	—
	T9315	0.2	265	0.05	1.0	—	—	—	250	0.05	1.0	—	—	—	—	—	—	—	—
	T9325	0.2	240	0.05	1.0	—	—	—	225	0.05	1.0	—	—	—	—	—	—	—	—
	TT010	0.2	240	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—
VCGT 130304E-FF2	T5315	0.4	195	0.12	1.0	—	—	—	185	0.12	1.0	—	—	—	—	—	—	—	—
	T7325	0.4	135	0.12	1.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.4	140	0.12	1.0	—	—	—	115	0.12	1.0	—	—	—	—	—	—	—	—
	T9315	0.4	195	0.12	1.0	—	—	—	185	0.12	1.0	—	—	—	—	—	—	—	—
	T9325	0.4	175	0.12	1.0	—	—	—	165	0.12	1.0	—	—	—	—	—	—	—	—
VCGT 130308E-FF2	TT010	0.4	245	0.06	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9315	0.8	200	0.17	1.0	—	—	—	190	0.17	1.0	—	—	—	—	—	—	—	—
	T9325	0.8	180	0.17	1.0	—	—	—	170	0.17	1.0	—	—	—	—	—	—	—	—
	TT010	0.8	245	0.10	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—



FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

VCGT 130308E-FM2	T8430	0.8	145	0.17	1.0	80	0.15	1.0	120	0.17	1.0	—	—	—	—	—	—	—	—
	T9325	0.8	180	0.17	1.0	105	0.15	1.0	170	0.17	1.0	—	—	—	—	—	—	—	—



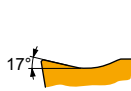
NF2 geometry with positive design for fine-finish to semi-rough machining, and continuous cuts.

VCGT 130302E-NF2	H07	0.2	—	—	—	60	0.09	1.0	95	0.10	1.0	310	0.12	1.0	30	0.07	0.8	—	—
	T6310	0.2	125	0.07	1.0	90	0.06	1.0	100	0.07	1.0	375	0.08	1.0	35	0.06	0.8	—	—
	T7325	0.2	150	0.07	1.0	115	0.06	1.0	—	—	—	—	—	—	45	0.06	0.8	—	—
	T7335	0.2	150	0.07	1.0	115	0.06	1.0	—	—	—	—	—	—	45	0.06	0.8	—	—
	T9315	0.2	200	0.10	1.0	—	—	—	190	0.10	1.0	—	—	—	—	—	—	—	—
	T9325	0.2	210	0.07	1.0	125	0.06	1.0	195	0.07	1.0	—	—	—	45	0.06	0.8	—	—
	T9335	0.2	155	0.10	1.0	90	0.09	1.0	—	—	—	—	—	—	30	0.07	0.8	—	—
	TT010	0.2	240	0.05	0.5	140	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—



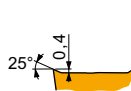
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



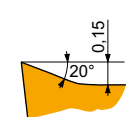
NF2 geometry with positive design for fine-finish to semi-rough machining, and continuous cuts.

VCGT 130304E-NF2	H07	0.4	—	—	—	🚧	60	0.11	1.0	🚧	95	0.12	1.0	🚧	310	0.14	1.0	🚧	30	0.11	0.8	—	—	—	
	T5315	0.4	🚧	195	0.12	1.0	—	—	—	🚧	185	0.12	1.0	—	—	—	—	—	—	—	—	—	—		
	T6310	0.4	🚧	115	0.12	1.0	🚧	80	0.11	1.0	🚧	90	0.12	1.0	🚧	345	0.14	1.0	🚧	30	0.11	0.8	—	—	—
	T7325	0.4	🚧	135	0.12	1.0	🚧	105	0.11	1.0	—	—	—	—	—	—	—	—	—	40	0.08	0.8	—	—	—
	T7335	0.4	🚧	135	0.12	1.0	🚧	105	0.11	1.0	—	—	—	—	—	—	—	—	—	40	0.08	0.8	—	—	—
	T9315	0.4	🚧	210	0.10	1.0	—	—	—	🚧	195	0.10	1.0	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.4	🚧	175	0.12	1.0	🚧	105	0.11	1.0	🚧	165	0.12	1.0	—	—	—	—	—	35	0.08	0.8	—	—	—
	T9335	0.4	🚧	150	0.12	1.0	🚧	90	0.11	1.0	—	—	—	—	—	—	—	—	—	30	0.11	0.8	—	—	—
	TT010	0.4	🚧	245	0.06	0.5	🚧	145	0.06	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
VCGT 130308E-NF2	T5315	0.8	🚧	205	0.17	1.0	—	—	—	🚧	190	0.17	1.0	—	—	—	—	—	—	—	—	—	—	—	—
	T6310	0.8	🚧	125	0.17	1.0	🚧	90	0.15	1.0	🚧	100	0.17	1.0	🚧	375	0.20	1.0	🚧	35	0.12	0.8	—	—	—
	T7325	0.8	🚧	145	0.17	1.0	🚧	110	0.15	1.0	—	—	—	—	—	—	—	—	—	45	0.12	0.8	—	—	—
	T7335	0.8	🚧	140	0.17	1.0	🚧	105	0.15	1.0	—	—	—	—	—	—	—	—	—	45	0.12	0.8	—	—	—
	T9315	0.8	🚧	200	0.17	1.0	—	—	—	🚧	190	0.17	1.0	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.8	🚧	180	0.17	1.0	🚧	105	0.15	1.0	🚧	170	0.17	1.0	—	—	—	—	—	40	0.12	0.8	—	—	—
	T9335	0.8	🚧	155	0.18	1.0	🚧	90	0.16	1.0	—	—	—	—	—	—	—	—	—	30	0.16	0.8	—	—	—
	TT010	0.8	🚧	245	0.10	0.8	🚧	145	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



SF2 geometry with highly positive design for fine to finish machining, and continuous cuts.

VCGT 130301E-SF2	H07	0.1	—	—	—	—	80	0.05	1.0	—	—	—	—	405	0.06	1.0	—	40	0.04	0.8	—	—	—	—
	T6310	0.1	—	140	0.05	1.0	—	100	0.05	1.0	—	—	—	420	0.06	1.0	—	40	0.04	0.8	—	—	—	—
VCGT 130302E-SF2	H07	0.2	—	—	—	—	80	0.05	1.0	—	—	—	—	405	0.06	1.0	—	40	0.04	0.8	—	—	—	—
	HF7	0.2	—	—	—	—	90	0.05	1.0	—	—	—	—	450	0.06	1.0	—	—	—	—	—	—	—	—
VCGT 130304E-SF2	T6310	0.2	—	140	0.05	1.0	—	100	0.05	1.0	—	—	—	420	0.06	1.0	—	40	0.04	0.8	—	—	—	—
	H07	0.4	—	—	—	—	65	0.09	1.0	—	—	—	—	335	0.12	1.0	—	30	0.07	0.8	—	—	—	—
	HF7	0.4	—	—	—	—	75	0.09	1.0	—	—	—	—	375	0.12	1.0	—	—	—	—	—	—	—	—
VCGT 130308E-SF2	T6310	0.4	—	125	0.10	1.0	—	90	0.09	1.0	—	—	—	375	0.12	1.0	—	35	0.07	0.8	—	—	—	—
	HF7	0.8	—	—	—	—	85	0.09	1.0	—	—	—	—	435	0.12	1.0	—	—	—	—	—	—	—	—
	T6310	0.8	—	145	0.10	1.0	—	100	0.09	1.0	—	—	—	435	0.12	1.0	—	40	0.08	0.8	—	—	—	—

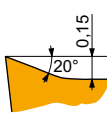


SF3 geometry with highly positive design for fine to finish machining, and continuous cuts.

VCGT 070202E-SF3	H07	0.2		—	—	—	▣	80	0.05	0.8	▣	130	0.05	0.8	▣	415	0.06	0.8	▣	40	0.04	0.6		—	—	—
	T6310	0.2	▣	145	0.05	0.8	▣	100	0.05	0.8	▣	115	0.05	0.8	▣	435	0.06	0.8	▣	40	0.04	0.6	▣	25	0.05	0.2
VCGT 070204E-SF3	T6310	0.4	▣	125	0.10	0.8	▣	90	0.09	0.8	▣	100	0.10	0.8	▣	375	0.12	0.8	▣	35	0.07	0.6	▣	25	0.07	0.3
VCGT 110202E-SF3	T6310	0.2	▣	145	0.05	0.8	▣	100	0.05	0.8	▣	115	0.05	0.8	▣	435	0.06	0.8	▣	40	0.04	0.6	▣	25	0.05	0.2
	T8315	0.2	▣	150	0.05	0.8	▣	90	0.05	0.8	▣	140	0.05	0.8	▣	450	0.06	0.8	▣	35	0.04	0.6	▣	30	0.05	0.2
VCGT 110204E-SF3	H07	0.4		—	—	—	▣	65	0.09	0.8	▣	105	0.10	0.8	▣	335	0.12	0.8	▣	30	0.07	0.6		—	—	—
	T6310	0.4	▣	125	0.10	0.8	▣	90	0.09	0.8	▣	100	0.10	0.8	▣	375	0.12	0.8	▣	35	0.07	0.6	▣	25	0.07	0.3
	T8315	0.4	▣	135	0.10	0.8	▣	80	0.09	0.8	▣	125	0.10	0.8	▣	405	0.12	0.8	▣	30	0.07	0.6	▣	25	0.07	0.3
VCGT 110301E-SF3	T6310	0.1	▣	140	0.05	0.5	▣	100	0.05	0.5	▣	110	0.05	0.5	▣	420	0.06	0.5	▣	40	0.04	0.4	▣	25	0.05	0.1
VCGT 110302E-SF3	T6310	0.2	▣	145	0.05	0.8	▣	100	0.05	0.8	▣	115	0.05	0.8	▣	435	0.06	0.8	▣	40	0.04	0.6	▣	25	0.05	0.2
VCGT 110304E-SF3	T6310	0.4	▣	125	0.10	0.8	▣	90	0.09	0.8	▣	100	0.10	0.8	▣	375	0.12	0.8	▣	35	0.07	0.6	▣	25	0.07	0.3
VCGT 130302E-SF3	H07	0.2		—	—	—	▣	80	0.05	0.8	▣	130	0.05	0.8	▣	415	0.06	0.8	▣	40	0.04	0.6		—	—	—
	T6310	0.2	▣	145	0.05	0.8	▣	100	0.05	0.8	▣	115	0.05	0.8	▣	435	0.06	0.8	▣	40	0.04	0.6	▣	25	0.05	0.2
	T8315	0.2	▣	150	0.05	0.8	▣	90	0.05	0.8	▣	140	0.05	0.8	▣	450	0.06	0.8	▣	35	0.04	0.6	▣	30	0.05	0.2
VCGT 130304E-SF3	H07	0.4		—	—	—	▣	65	0.09	1.0	▣	105	0.10	1.0	▣	335	0.12	1.0	▣	30	0.07	0.8		—	—	—
	T6310	0.4	▣	125	0.10	1.0	▣	90	0.09	1.0	▣	100	0.10	1.0	▣	375	0.12	1.0	▣	35	0.07	0.8	▣	25	0.07	0.3
	T8315	0.4	▣	130	0.10	1.0	▣	75	0.09	1.0	▣	120	0.10	1.0	▣	390	0.12	1.0	▣	30	0.07	0.8	▣	25	0.07	0.3
VCGT 130308E-SF3	H07	0.8		—	—	—	▣	75	0.09	1.0	▣	120	0.10	1.0	▣	390	0.12	1.0	▣	35	0.08	0.8		—	—	—
	T6310	0.8	▣	145	0.10	1.0	▣	100	0.09	1.0	▣	115	0.10	1.0	▣	435	0.12	1.0	▣	40	0.08	0.8	▣	25	0.08	0.7
	T8315	0.8	▣	155	0.10	1.0	▣	90	0.09	1.0	▣	145	0.10	1.0	▣	465	0.12	1.0	▣	35	0.08	0.8	▣	30	0.08	0.7



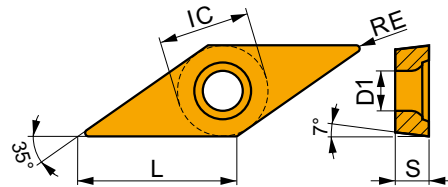
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
		0.15 20°																		
			SF3 geometry with highly positive design for fine to finish machining, and continuous cuts.																	
VCGT 160402E-SF3	T6310	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.05	0.2
VCGT 160404E-SF3	H07	0.4	—	—	—	65	0.09	1.0	105	0.10	1.0	335	0.12	1.0	30	0.07	0.8	—	—	—
	T6310	0.4	125	0.10	1.0	90	0.09	1.0	100	0.10	1.0	375	0.12	1.0	35	0.07	0.8	25	0.07	0.3
	T8315	0.4	130	0.10	1.0	75	0.09	1.0	120	0.10	1.0	390	0.12	1.0	30	0.07	0.8	25	0.07	0.3
VCGT 160408E-SF3	H07	0.8	—	—	—	75	0.09	1.2	120	0.10	1.2	390	0.12	1.2	35	0.08	1.0	—	—	—
	T6310	0.8	145	0.10	1.2	100	0.09	1.2	115	0.10	1.2	435	0.12	1.2	40	0.08	1.0	25	0.08	0.7
	T8315	0.8	155	0.10	1.2	90	0.09	1.2	145	0.10	1.2	465	0.12	1.2	35	0.08	1.0	30	0.08	0.7
VCGT 160412E-SF3	H07	1.2	—	—	—	60	0.18	1.2	95	0.20	1.2	310	0.24	1.2	30	0.14	1.0	—	—	—
	T6310	1.2	125	0.20	1.2	90	0.18	1.2	100	0.20	1.2	375	0.24	1.2	35	0.14	1.0	25	0.10	0.9

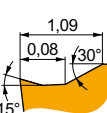
VCMT



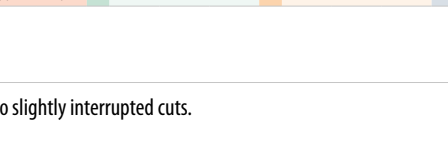
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



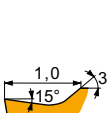
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
		1.09 0.08 30° 15°																		
			FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.																	
VCMT 160404E-FM	T7325	0.4	125	0.19	1.2	95	0.17	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.4	150	0.12	1.2	80	0.11	1.2	125	0.12	1.2	420	0.14	1.2	—	—	—	—	—	—
	T9315	0.4	210	0.12	1.2	—	—	—	195	0.12	1.2	—	—	—	—	—	—	—	—	—
	T9325	0.4	155	0.19	1.2	90	0.17	1.2	145	0.19	1.2	—	—	—	—	—	—	—	—	—
VCMT 160408E-FM	T7325	0.8	155	0.17	1.2	120	0.15	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.8	155	0.17	1.2	85	0.15	1.2	130	0.17	1.2	435	0.20	1.2	—	—	—	—	—	—
	T9315	0.8	220	0.17	1.2	—	—	—	205	0.17	1.2	—	—	—	—	—	—	—	—	—
	T9325	0.8	195	0.17	1.2	115	0.15	1.2	185	0.17	1.2	—	—	—	—	—	—	—	—	—

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



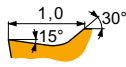
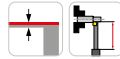
UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
		1.0 30° 15°																		
			UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.																	
VCMT 110304E-UR	T7325	0.4	110	0.19	0.8	85	0.17	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.4	135	0.12	0.8	75	0.11	0.8	110	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	190	0.12	0.8	—	—	—	180	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	140	0.19	0.8	80	0.17	0.8	130	0.19	0.8	—	—	—	—	—	—	—	—	—
VCMT 110308E-UR	T7325	0.8	140	0.17	0.8	105	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.8	140	0.17	0.8	75	0.15	0.8	115	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.8	195	0.17	0.8	—	—	—	185	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	175	0.17	0.8	105	0.15	0.8	165	0.17	0.8	—	—	—	—	—	—	—	—	—



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

VCMT 160404E-UR	T7325	0.4	✓	110	0.19	1.2	✓	85	0.17	1.2	—	—	—	—	—	—	—	—	—	—
	T8430	0.4	■	130	0.12	1.2	✓	70	0.11	1.2	✓	105	0.12	1.2	—	—	—	—	—	—
	T9315	0.4	■	180	0.12	1.2	—	—	—	—	✓	170	0.12	1.2	—	—	—	—	—	—
	T9325	0.4	■	135	0.19	1.2	✓	80	0.17	1.2	✓	125	0.19	1.2	—	—	—	—	—	—
VCMT 160408E-UR	T7325	0.8	✓	135	0.17	1.2	✓	105	0.15	1.2	—	—	—	—	—	—	—	—	—	—
	T8430	0.8	■	135	0.17	1.2	✓	75	0.15	1.2	✓	110	0.17	1.2	—	—	—	—	—	—
	T9315	0.8	■	190	0.17	1.2	—	—	—	—	✓	180	0.17	1.2	—	—	—	—	—	—
	T9325	0.8	■	170	0.17	1.2	✓	100	0.15	1.2	✓	160	0.17	1.2	—	—	—	—	—	—