

TURNING NEGATIVE INSERTS - V SHAPE

TURNLINE

|                 |     |                 |             |              |              | CUTTING DATA |                      |                                              |   |   |   |   |   |   |  |  |  |
|-----------------|-----|-----------------|-------------|--------------|--------------|--------------|----------------------|----------------------------------------------|---|---|---|---|---|---|--|--|--|
|                 |     |                 | Description | Grade        | Tech. Code   |              | Depth<br>mm          | Feed<br>mm/rev                               | P | M | K | N | S | H |  |  |  |
| FINISHING       | TSF | VNMG 160404-TSF | T9215       |              | B0V10VNTSF09 |              | 0,20<br>1,00<br>1,50 | 0,08<br>0,15<br>0,40                         | ● | ● | ● |   |   |   |  |  |  |
|                 |     |                 | T9225       |              | B0V10VNTSF11 |              |                      |                                              | ● | ● | ● |   |   |   |  |  |  |
|                 |     | VNMG 160408-TSF | T9215       |              | B0V10VNTSF10 |              |                      |                                              | ● | ● | ● |   |   |   |  |  |  |
|                 |     |                 | T9225       |              | B0V10VNTSF12 |              |                      |                                              | ● | ● | ● |   |   |   |  |  |  |
|                 | SF  | VNMG 160404-SF  | T6120       |              | B0V11VNSF05  |              | 0,80<br>1,50<br>2,80 | 0,08<br>0,25<br>0,45                         |   | ● |   |   |   |   |  |  |  |
|                 |     |                 | T6130       |              | B0V11VNSF06  |              |                      |                                              |   | ● |   |   |   |   |  |  |  |
|                 |     |                 | AH630       |              | B0V11VNSF07  |              |                      |                                              | ● | ● |   |   | ● |   |  |  |  |
|                 |     | VNMG 160408-SF  | T6120       |              | B0V11VNSF08  |              |                      |                                              |   | ● |   |   |   |   |  |  |  |
|                 |     |                 | T6130       |              | B0V11VNSF09  |              |                      |                                              |   | ● |   |   |   |   |  |  |  |
|                 |     |                 | AH630       |              | B0V11VNSF10  |              |                      |                                              | ● | ● |   |   | ● |   |  |  |  |
|                 | HRF | VNMG 160404-HRF | AH8005      |              | B0V12VNHRF05 |              | 0,40<br>1,00<br>1,50 | 0,05<br>0,15<br>0,25                         |   |   |   |   | ● |   |  |  |  |
|                 |     |                 | AH8015      |              | B0V12VNHRF06 |              |                      |                                              |   |   |   |   | ● |   |  |  |  |
| VNMG 160408-HRF |     | AH8005          |             | B0V12VNHRF07 |              |              |                      |                                              |   |   |   | ● |   |   |  |  |  |
|                 |     | AH8015          |             | B0V12VNHRF08 |              |              |                      |                                              |   |   |   | ● |   |   |  |  |  |
| MEDIUM CUTTING  | TM  | VNMG 160404-TM  | T9215       |              | B0V13VNTM09  |              | 1,00<br>3,00<br>5,00 | 0,20<br>0,30<br>0,50<br>0,10<br>0,20<br>0,30 | ● | ● | ● |   |   |   |  |  |  |
|                 |     |                 | T9225       |              | B0V13VNTM12  |              |                      |                                              | ● | ● | ● |   |   |   |  |  |  |
|                 |     | VNMG 160408-TM  | T9215       |              | B0V13VNTM10  |              |                      |                                              | ● | ● | ● |   |   |   |  |  |  |
|                 |     |                 | T9225       |              | B0V13VNTM13  |              |                      |                                              | ● | ● | ● |   |   |   |  |  |  |
|                 | SM  | VNMG 160404-SM  | T6120       |              | B0V14VNSM05  |              | 0,50<br>2,00<br>4,00 |                                              |   | ● |   |   |   |   |  |  |  |
|                 |     |                 | T6130       |              | B0V14VNSM06  |              |                      |                                              |   | ● |   |   |   |   |  |  |  |
|                 |     |                 | AH630       |              | B0V14VNSM07  |              |                      |                                              | ● | ● |   |   | ● |   |  |  |  |
|                 |     | VNMG 160408-SM  | T6120       |              | B0V14VNSM08  |              |                      |                                              |   | ● |   |   |   |   |  |  |  |
|                 |     |                 | T6130       |              | B0V14VNSM09  |              |                      |                                              |   | ● |   |   |   |   |  |  |  |
|                 |     |                 | AH630       |              | B0V14VNSM10  |              |                      |                                              | ● | ● |   |   | ● |   |  |  |  |
|                 | HRM | VNMG 160404-HRM | AH8005      |              | B0V15VNHRM05 |              |                      |                                              |   |   |   |   | ● |   |  |  |  |
|                 |     |                 | AH8015      |              | B0V15VNHRM06 |              |                      |                                              |   |   |   |   | ● |   |  |  |  |
|                 |     | VNMG 160408-HRM | AH8005      |              | B0V15VNHRM07 |              |                      |                                              |   |   |   |   | ● |   |  |  |  |
|                 |     |                 | AH8015      |              | B0V15VNHRM08 |              |                      |                                              |   |   |   |   | ● |   |  |  |  |