
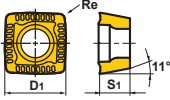

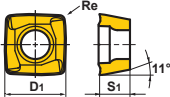


## Inserts

Shape	Drill Dia.	Insert Number	D <sub>1</sub>	S <sub>1</sub>	Re	Stock VP15TF	Geometry
<b>UM</b>  General purpose	ø17—ø19.5	<b>SOMX063005-UM</b>	6	3	0.5	●	
	ø20—ø22.5	<b>SOMX073505-UM</b>	7	3.5	0.5	●	
	ø23—ø27.5	<b>SOMX084005-UM</b>	8.3	4	0.5	●	
	ø28—ø33	<b>SOMX094506-UM</b>	9.7	4.5	0.6	●	
	NEW ø33.5—ø39	<b>SOMX115506-UM</b>	11.6	5.5	0.6	●	
	NEW ø40—ø46	<b>SOMX136008-UM</b>	13.8	6	0.8	●	
<b>US</b>  For stainless steel and inner edge	ø17—ø19.5	<b>SOMX063005-US</b>	6	3	0.5	●	
	ø20—ø22.5	<b>SOMX073505-US</b>	7	3.5	0.5	●	
	ø23—ø27.5	<b>SOMX084005-US</b>	8.3	4	0.5	●	
	ø28—ø33	<b>SOMX094506-US</b>	9.7	4.5	0.6	●	
	NEW ø33.5—ø39	<b>SOMX115506-US</b>	11.6	5.5	0.6	●	

VP15TF grade first recommendation in both pockets (Outer/Inner).

## Recommended Cutting Conditions

Work material	Hardness	Grade		ø17—ø19.5				ø20—ø23.5				
				Vc (m/min)	f (mm/rev)			Vc (m/min)	f (mm/rev)			
		Outer	Inner	l/d=2—6	l/d=2, 3	l/d=4, 5	l/d=6	l/d=2—6	l/d=2, 3	l/d=4, 5	l/d=6	
P	Mild Steel (C15, Ck15)	≤180HB	MC1020	VP15TF	200 (180—235)	0.05 (0.04—0.06)	0.05 (0.04—0.06)	0.04 (0.04—0.05)	200 (180—235)	0.06 (0.04—0.08)	0.06 (0.04—0.07)	0.04 (0.04—0.05)
	Carbon Steel, Alloy Steel (Ck45, 41CrMo4)	180—280HB	MC1020	VP15TF	140 (115—180)	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.05 (0.04—0.06)	140 (115—180)	0.10 (0.06—0.18)	0.09 (0.06—0.12)	0.07 (0.06—0.08)
	Carbon Steel, Alloy Steel (100Cr6)	280—350HB	MC1020	VP15TF	100 (75—140)	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.05 (0.04—0.06)	100 (75—140)	0.10 (0.06—0.18)	0.09 (0.06—0.12)	0.07 (0.06—0.08)
	Alloy Tool Steel (X210Cr12)	≤350HB	MC1020	VP15TF	135 (100—170)	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.05 (0.04—0.06)	135 (100—170)	0.10 (0.06—0.18)	0.09 (0.06—0.12)	0.07 (0.06—0.08)
M	Austenitic Stainless Steel (X5CrNi189, X5CrNiMo1810)	≤200HB	MC1020	VP15TF	140 (115—180)	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.04 (0.04—0.05)	140 (115—180)	0.08 (0.06—0.12)	0.07 (0.06—0.08)	0.06 (0.06—0.07)
	Austenitic Stainless Steel (X2CrNi1810, X5CrNiMo1813)	>200HB	MC1020	VP15TF	140 (115—180)	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.04 (0.04—0.05)	140 (115—180)	0.08 (0.06—0.12)	0.07 (0.06—0.08)	0.06 (0.06—0.07)
	Ferritic and Martensitic Stainless Steel (X10Cr13, X10CrAl18)	≤200HB	MC1020	VP15TF	140 (115—165)	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.04 (0.04—0.05)	140 (115—165)	0.09 (0.06—0.14)	0.07 (0.06—0.09)	0.06 (0.06—0.07)
	Ferritic and Martensitic Stainless Steel (X22CrNi17, X46Cr13)	>200HB	MC1020	VP15TF	140 (115—165)	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.04 (0.04—0.05)	140 (115—165)	0.09 (0.06—0.14)	0.07 (0.06—0.09)	0.06 (0.06—0.07)
K	Gray Cast Iron (GG25, GG30)	≤350MPa	MC5020	VP15TF	160 (130—195)	0.11 (0.08—0.14)	0.09 (0.08—0.10)	0.05 (0.04—0.06)	160 (130—195)	0.14 (0.10—0.18)	0.10 (0.10—0.12)	0.07 (0.06—0.08)
	Ductile Cast Iron (GG40)	≤450MPa	MC5020	VP15TF	100 (80—135)	0.11 (0.08—0.14)	0.09 (0.08—0.10)	0.05 (0.04—0.06)	100 (80—135)	0.13 (0.10—0.16)	0.10 (0.10—0.11)	0.07 (0.06—0.08)
	Ductile Cast Iron (GGG70)	≤800MPa	MC5020	VP15TF	100 (70—125)	0.11 (0.08—0.14)	0.09 (0.08—0.10)	0.05 (0.04—0.06)	100 (70—125)	0.13 (0.10—0.16)	0.10 (0.10—0.11)	0.07 (0.06—0.08)

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MXV2250X2F25	£192.44
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MXV2400X2F25	£192.44
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MXV2550X2F25	£192.44
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MXV2900X2F32	£220.87
MXV2950X2F32	£220.87
MXV3000X2F32	£220.87
MXV3100X2F32	£241.04
MXV3100X2F40	£241.04
MXV3200X2F40	£241.04
MXV3300X2F32	£241.04
MXV3300X2F40	£241.04
MXV3400X2F40	£244.75
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MXV2200X3F25	£205.53
MXV2250X3F25	£205.53
MXV2300X3F25	£205.53
MXV2350X3F25	£205.53
MXV2400X3F25	£205.53
MXV2450X3F25	£205.53
MXV2500X3F25	£205.53
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MXV2600X4F32	£267.66
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MXV3100X4F40	£290.73
MXV3200X4F32	£290.73
MXV3200X4F40	£290.73
MXV3300X4F32	£290.73
MXV3300X4F40	£290.73
MXV3400X4F40	£296.11
MXV3500X4F40	£296.11
MXV3600X4F40	£296.11
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MXV5100X4F40	£367.67
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MXV2400X6F25	£278.31
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MXV2600X6F32	£319.77
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