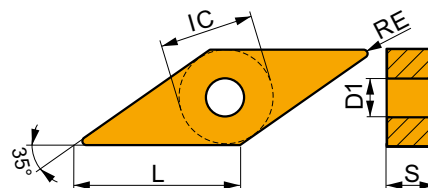




## VNGA CER



|      | IC    | D1   | L     | S    |
|------|-------|------|-------|------|
|      | [mm]  | [mm] | [mm]  | [mm] |
| 1604 | 9.525 | 3.81 | 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] |



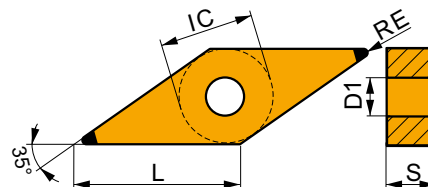
For machining with high speeds and continuous cuts.

|                    |       |     |   |   |   |   |   |   |     |      |     |   |   |   |   |   |   |   |   |
|--------------------|-------|-----|---|---|---|---|---|---|-----|------|-----|---|---|---|---|---|---|---|---|
| VNGA 160404 T01020 | TC100 | 0.4 | — | — | — | — | — | — | 425 | 0.10 | 1.0 | — | — | — | — | — | — | — | — |
| VNGA 160408 T01020 | TC100 | 0.8 | — | — | — | — | — | — | 395 | 0.20 | 1.0 | — | — | — | — | — | — | — | — |

## VNGA CBN



|      | IC    | D1   | L     | S    |
|------|-------|------|-------|------|
|      | [mm]  | [mm] | [mm]  | [mm] |
| 1604 | 9.525 | 3.81 | 16.00 | 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] |



For finish machining and continuous cuts.

|                    |       |     |   |   |   |   |   |   |     |      |     |   |   |   |    |      |     |    |      |     |
|--------------------|-------|-----|---|---|---|---|---|---|-----|------|-----|---|---|---|----|------|-----|----|------|-----|
| VNGA 160404S01020B | TB310 | 0.4 | — | — | — | — | — | — | 360 | 0.10 | 0.4 | — | — | — | 95 | 0.07 | 0.3 | 75 | 0.15 | 1.0 |
| VNGA 160408S01020B | TB310 | 0.8 | — | — | — | — | — | — | 370 | 0.15 | 0.6 | — | — | — | 95 | 0.11 | 0.5 | 75 | 0.15 | 1.0 |