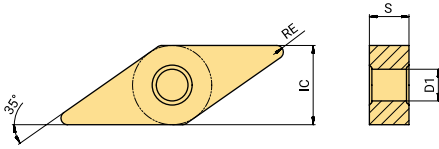


Negative 35° (V)

(mm)

Product code	IC	S	D1
VN_1604_	9.525	4.76	3.81



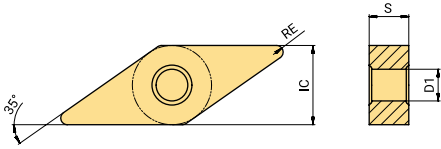
ISO Turning Inserts

Inserts	Product code	RE (mm)	Recommended parameters		Machining conditions														
					● Good Conditions ● General Conditions ✖ Bad Conditions														
					P						M				K		N		S
f (mm/rev)	ap (mm)	AT202	AT210A	AC052P	AC152P	AC252P	AC350P	AC100M	AC200M	AP200U	AP301M	AC100K	AC102K	AC202K	AW100K	AP010S	AP100S		
Finishing	VNGG 160401FP-UF	0.10	0.02-0.10	0.50-2.00															
	160402FP-UF	0.20	0.02-0.10	0.50-2.00															
	160404FP-UF	0.40	0.02-0.10	0.50-2.00															
	VNMG 160402E-PA1	0.20	0.04-0.25	0.20-1.50	●	●	●	○											
	160404E-PA1	0.40	0.04-0.28	0.20-1.50	●	●	●	●											
	160408E-PA1	0.80	0.05-0.35	0.20-1.50	●	●	●	●											
	160412E-PA1	1.20	0.05-0.42	0.20-1.50	●	●													
	VNMG 160404E-PB1	0.40	0.05-0.15	0.26-2.10	●	●	●	●	○										
	160408E-PB1	0.80	0.10-0.30	0.52-2.10	●	●	●	●	●										
	VNMG 160404E-SC1	0.40	0.10-0.25	0.20-0.80							●							●	
	160408E-SC1	0.80	0.15-0.30	0.20-0.80							●							●	
	VNMG 160404E-MB2	0.40	0.05-0.15	0.26-2.10						●	●	●	●					●	
160408E-MB2	0.80	0.10-0.30	0.52-2.10						●	●	●	●					●		
Semi-finishing	VNMG 160404E-SL3	0.40	0.10-0.20	0.60-2.50													●	●	
	160408E-SL3	0.80	0.12-0.25	0.80-2.50													●	●	
	VNMG 160404E-BS	0.40	0.07-0.16	0.30-2.00	●	●	●	●	○										
	160408E-BS	0.80	0.08-0.20	0.30-2.00	●	●	●	●	●										
	160412E-BS	1.20	0.09-0.22	0.30-2.00	●	○	○	●											
	VNMG 160404E-F2K	0.40	0.08-0.20	0.50-2.00	●	●													
	160408E-F2K	0.80	0.10-0.25	0.50-2.00	●	●													
	VNMG 160404E-PB3	0.40	0.06-0.18	0.30-3.10	●	●	●	●	○										
	160408E-PB3	0.80	0.12-0.36	0.60-3.10	●	●	●	●	●										
	160412E-PB3	1.20	0.18-0.54	0.90-3.10	●	●	○	●	○										
	VNMG 160404E-PC3	0.40	0.07-0.20	0.34-3.30	●	●		●											
	160408E-PC3	0.80	0.14-0.40	0.68-3.30	●	●		●	○										
	160412E-PC3	1.20	0.20-0.60	1.02-3.30	●	●		○											
	VNMG 160404E-SC3	0.40	0.08-0.22	0.40-3.30						●	●	●						●	●
	160408E-SC3	0.80	0.15-0.44	0.80-3.30						●	●	●						●	●
	160412E-SC3	1.20	0.23-0.66	1.20-3.30						●	●	●						●	●
	VNMG 160404E-MC3	0.40	0.08-0.22	0.32-3.30						●	●	●	●						
	160408E-MC3	0.80	0.15-0.44	0.64-3.30						●	●	●	●						






● : Standard stock ○ : Made-to-Order

Negative 35° (V)

(mm)



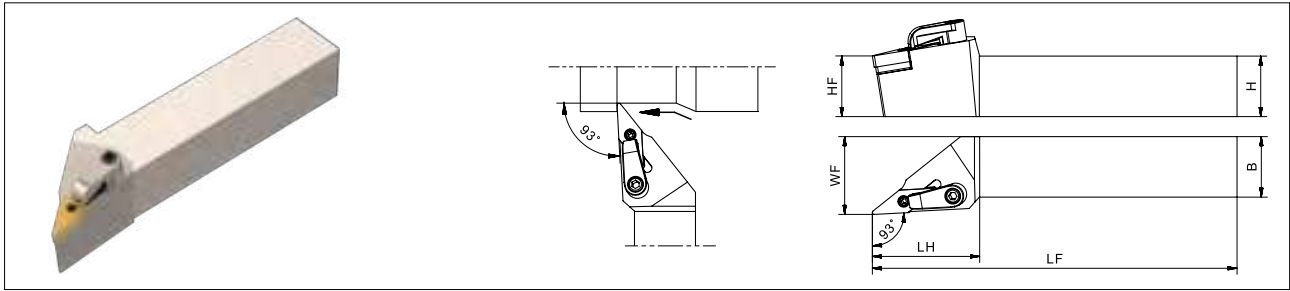
Product code	IC	S	D1
VN_12T3_	7.15	3.97	3.81
VN_1604_	9.525	4.76	3.81

Inserts	Product code	RE (mm)	Recommended parameters		Machining conditions														
					● Good Conditions ● General Conditions ✖ Bad Conditions														
					P						M				K		N		S
f (mm/rev)	ap (mm)	AT202	AT210A	AC052P	AC152P	AC252P	AC350P	AC100M	AC200M	AP200U	AP301M	AC100K	AC102K	AC202K	AW100K	AP010S	AP100S		
Medium	 VNMG 12T304E-PD3 12T308E-PD3 160404E-PD3 160408E-PD3 160412E-PD3	0.40	0.08-0.22	0.40-2.50				●	○										
		0.80	0.15-0.44	0.80-2.50				●	○										
		0.40	0.08-0.22	0.40-3.30	●	●		●	○										
		0.80	0.15-0.44	0.80-3.30	●	●	○	●	○	●									
		1.20	0.23-0.66	1.20-3.30	●	●	●	●	○										
	 VNMG 160404-M3T 160408-M3T	0.40	0.20-0.40	1.00-4.00	●	●													
		0.80	0.20-0.40	1.00-4.00	●	●													
		 VNMG 160408E-UC4 160412E-UC4	0.80	0.15-0.48	0.80-4.50			●	●	●	●		●	○		○	○		
	1.20		0.23-0.72	1.20-4.50			●	●	●										
	 VNMG 160404E-PC4 160408E-PC4 160412E-PC4	0.40	0.08-0.22	0.40-3.30	●	●		○							●	●			
0.80		0.15-0.44	0.80-3.30	●	●	○	○							●	●				
1.20		0.23-0.66	1.20-3.30	●	●	○	○							●	●				
 VNMG 160404E-KC4 160408E-KC4 160412E-KC4	0.40	0.09-0.24	0.48-3.30											●	●				
	0.80	0.18-0.48	0.96-3.30											●	●				
	1.20	0.26-0.72	1.44-3.30											●	●				
Roughing																			

● : Standard stock ○ : Made-to-Order

ISO Turning Inserts

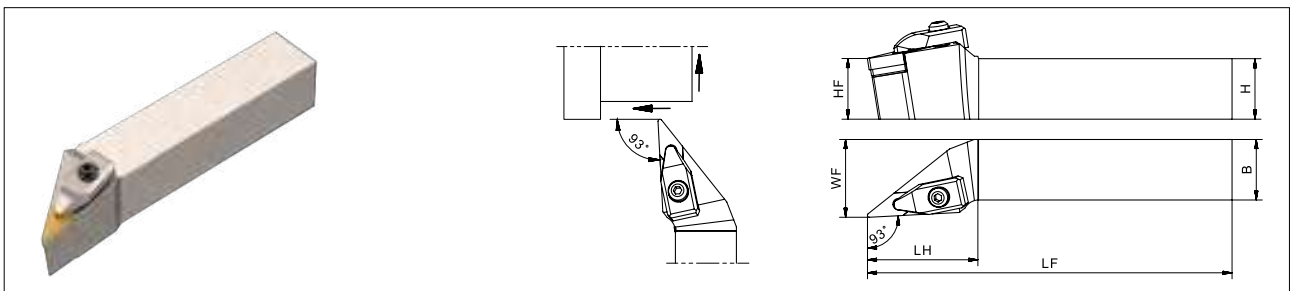
MVJN (External/Profile Turning)



Product code	Stock		Dimension							Insert corner radius (RE)	Spare parts					Insert
	R	L	H	HF	B	LF	LH	WF	Wrench		Clamp screw	Clamp	Lock pin	Shim		
MVJN^{R/L} 2020K-16	●	●	20	20	20	125	44	25	0.8	LT-H2/LT-H3	CD060255X	CLM240130	CS050140	S-MVN16032	VN*A 1604... VN*G 1604... VN*M 1604...	
2525M-16	●	●	25	25	25	150	44	32	0.8							

● : Standard stock ○ : Made-to-Order

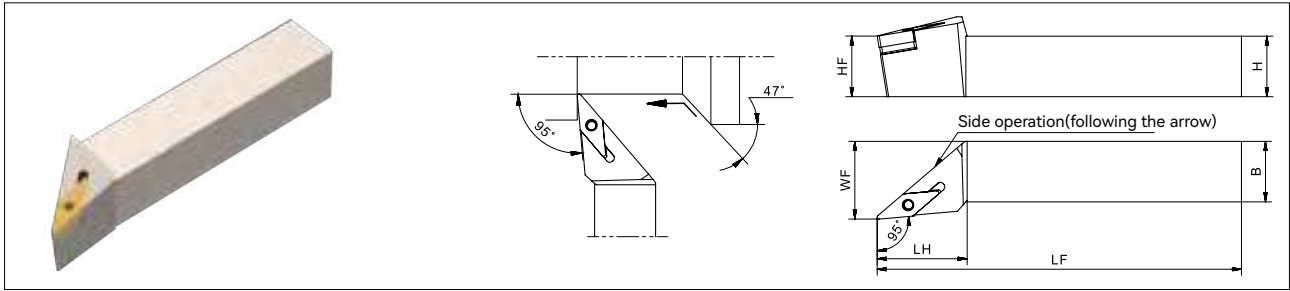
DVJN (External/Profile Turning)



Product code	Stock		Dimension							Insert corner radius (RE)	Spare parts						Insert
	R	L	H	HF	B	LF	LH	WF	Wrench		Clamp screw	Clamp	Spring	Shim screw	Shim		
DVJN^{R/L} 2020K-16	○	○	20	20	20	125	46	25	0.8	LT-H3	CH050215	CLD296090	YB0.20-2.50-12-5.5	SH050080X	S-DVN16033	VN*A 1604... VN*G 1604... VN*M 1604...	
2525M-16	○	○	25	25	25	150	32										

● : Standard stock ○ : Made-to-Order

PVLN (External/Profile Turning)

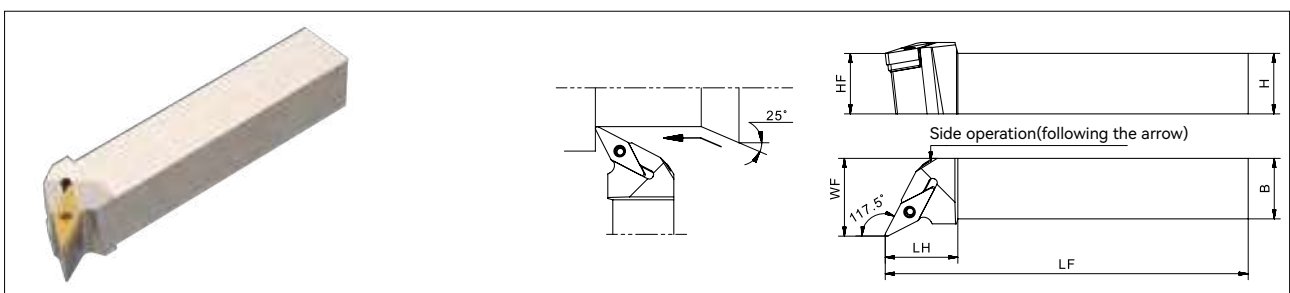


Product code	Stock		Dimension						Insert corner radius (RE)	Spare parts				Insert
	R	L	H	HF	B	LF	LH	WF		Wrench	Lever screw	Lever	Shim	
PVLN^{R/L} 2020K-16	○	○	20	20	20	125	37	25	0.8	LT-H3	AH060125	LC3	S-PVN16032	VN*A 1604... VN*G 1604... VN*M 1604...
2525M-16	●	●	25	25	25	150	32							

● : Standard stock ○ : Made-to-Order

Turning
Tools

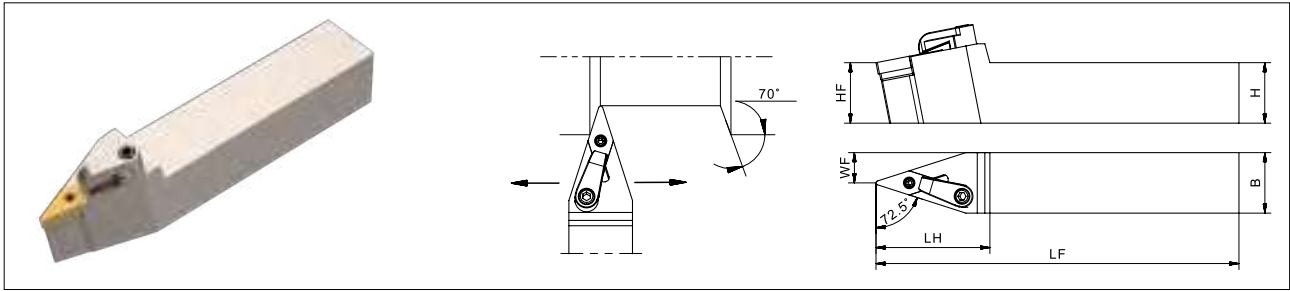
PVPN (External/Face/Profile/undercut Turning)



Product code	Stock		Dimension						Insert corner radius (RE)	Spare parts				Insert
	R	L	H	HF	B	LF	LH	WF		Wrench	Lever screw	Lever	Shim	
PVPN^{R/L} 2020K-16	○	○	20	20	20	125	30	25	0.8	LT-H3	AH060125	LC3	S-PVN16032	VN*A 1604... VN*G 1604... VN*M 1604...
2525M-16	●	○	25	25	25	150	32							

● : Standard stock ○ : Made-to-Order

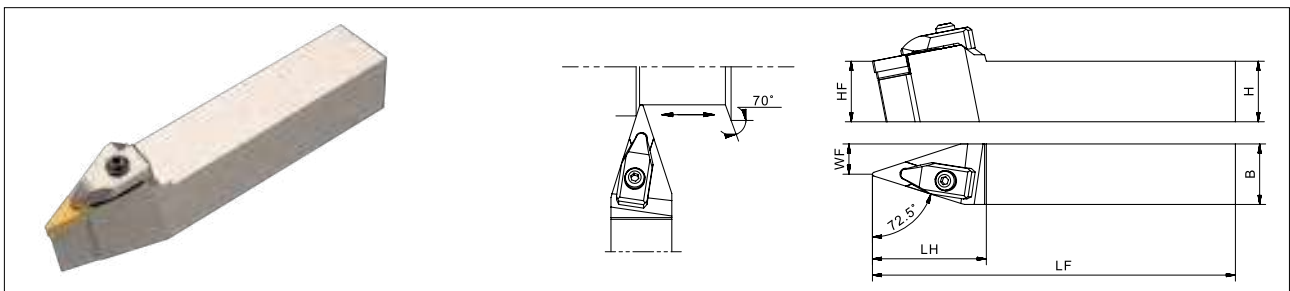
MVVN (External/Profile Turning)



Product code	Stock	Dimension						Insert corner radius (RE)	Spare parts					Insert	
		H	HF	B	LF	LH	WF		Wrench	Clamp screw	Clamp	Lock pin	Shim		
	N														
MVVNN	2020K-16	●	20	20	20	125	47	10	0.8	LT-H2/LT-H3	CD060255X	CLM240130	CS050140	S-MVN16032	VN*A 1604... VN*G 1604... VN*M 1604...
	2525M-16	●	25	25	25	150	47	12.5							

● : Standard stock ○ : Made-to-Order

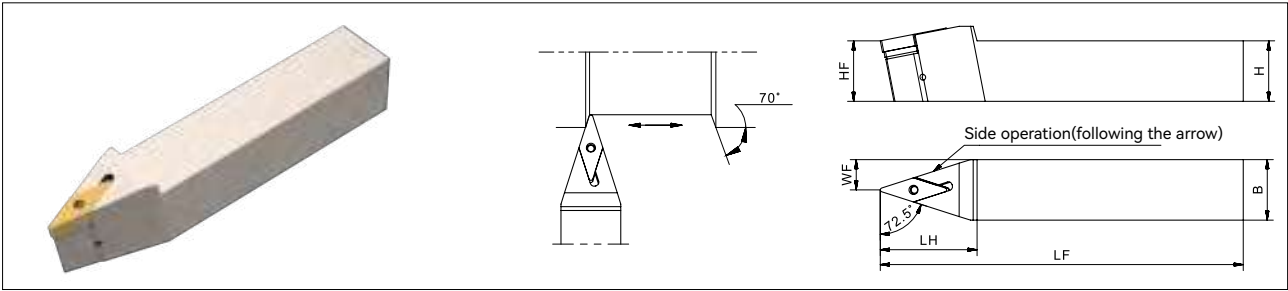
DVVN (External/Profile Turning)



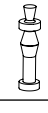



Product code	Stock	Dimension						Insert corner radius (RE)	Spare parts						Insert	
		H	HF	B	LF	LH	WF		Wrench	Clamp screw	Clamp	Spring	Shim screw	Shim		
	N															
DVVNN	2020K-16	○	20	20	20	125	47	10	0.8	LT-H3	CH050215	CLD296090	YB0.20-2.50-12-5.5	SH050080X	S-DVN16033	VN*A 1604... VN*G 1604... VN*M 1604...
	2525M-16	○	25	25	25	150	12.5									

● : Standard stock ○ : Made-to-Order

PVVN (External/Profile Turning)



Product code	Stock	Dimension							Insert corner radius (RE)	Spare parts				Insert
		H	HF	B	LF	LH	WF	Wrench		Lever screw	Lever	Shim		
		N												
PVVNN	2020K-16	○	20	20	20	125	35	10	0.8	LT-H3	AH060125	LC3	S-PVN16032	VN*A 1604... VN*G 1604... VN*M 1604...
	2525M-16	●	25	25	25	150	40	12.5						

● : Standard stock ○ : Made-to-Order