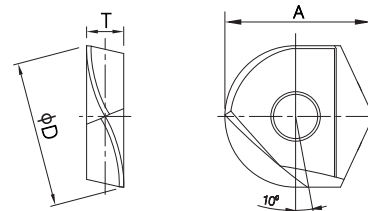
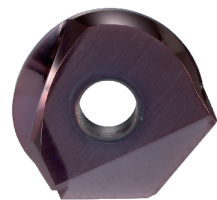




VSB Finishing Ball Nose Insert



Unit : mm

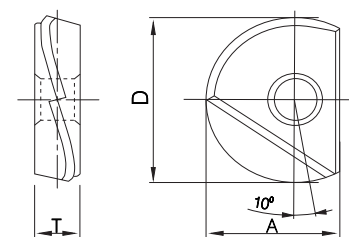
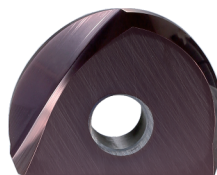
Type No.	D	R	A	T
VSB160-BS-R 9105-B	16	8	16.6	4.2
VSB200-BS-R 9105-B	20	10	20.2	5.2
VSB250-BS-R 9105-B	25	12.5	24.3	6.2
VSB300-BS-R 9105-B	30	15	29.2	7.2

Cutting Parameter

VSB Finishing Ball Nose Insert

Workpiece	Pre-Hardened Steels (<45HRC)				Hardened Steels (45-55HRC)				Hardened Steels (55-65HRC)			
Type No.	n min ⁻¹	Vf mm/min	ap mm	ae mm	n min ⁻¹	Vf mm/min	ap mm	ae mm	n min ⁻¹	Vf mm/min	ap mm	ae mm
VSB160-BS-R 9105-B	6000-10000	6000-10000	0.05-0.1	0.2	5500-6000	2500-3000	0.05-0.1	0.2	5500-6000	2500-3000	0.05-0.1	0.2
VSB200-BS-R 9105-B	6000-10000	6000-10000	0.05-0.12	0.25	5500-6000	3000-3600	0.05-0.12	0.25	5500-6000	3000-3600	0.05-0.12	0.25
VSB250-BS-R 9105-B	6000-8000	6000-8000	0.05-0.12	0.25	5000-5500	3000-4500	0.05-0.12	0.25	5000-5500	3000-4500	0.05-0.12	0.25
VSB300-BS-R 9105-B	5000-8000	5000-8000	0.05-0.2	0.3	4500-5000	3000-6000	0.05-0.2	0.3	4500-5000	3000-6000	0.05-0.2	0.3

MSB Finishing Ball Nose Insert



Unit : mm

Type No.	D	R	A	T
MSB120-S-R 9105-B	12	6	10	3
MSB160-S-R 9105-B	16	8	12	4
MSB200-S-R 9105-B	20	10	15	5
MSB250-S-R 9105-B	25	12.5	18.5	6
MSB300-S-R 9105-B	30	15	22.5	7

MSB Finishing Ball Nose Insert

Workpiece	Pre-Hardened Steels (<45HRC)				Hardened Steels (45-55HRC)				Hardened Steels (55-65HRC)			
	Type No.	n min ⁻¹	Vf mm/min	ap mm	ae mm	n min ⁻¹	Vf mm/min	ap mm	ae mm	n min ⁻¹	Vf mm/min	ap mm
MSB120-S-R 9105-B	8000-10000	2500-5000	0.05-0.1	0.2	6000-6500	2500-3000	0.05-0.1	0.2	6000-6500	2500-3000	0.05-0.1	0.2
MSB160-S-R 9105-B	6000-10000	6000-10000	0.05-0.1	0.2	5500-6000	2500-3000	0.05-0.1	0.2	5500-6000	2500-3000	0.05-0.1	0.2
MSB200-S-R 9105-B	6000-10000	6000-10000	0.05-0.12	0.25	5500-6000	3000-3600	0.05-0.12	0.25	5500-6000	3000-3600	0.05-0.12	0.25
MSB250-S-R 9105-B	6000-8000	6000-8000	0.05-0.12	0.25	5000-5500	3000-4500	0.05-0.12	0.25	5000-5500	3000-4500	0.05-0.12	0.25
MSB300-S-R 9105-B	5000-8000	5000-8000	0.05-0.2	0.3	4500-5000	3000-6000	0.05-0.2	0.3	4500-5000	3000-6000	0.05-0.2	0.3

