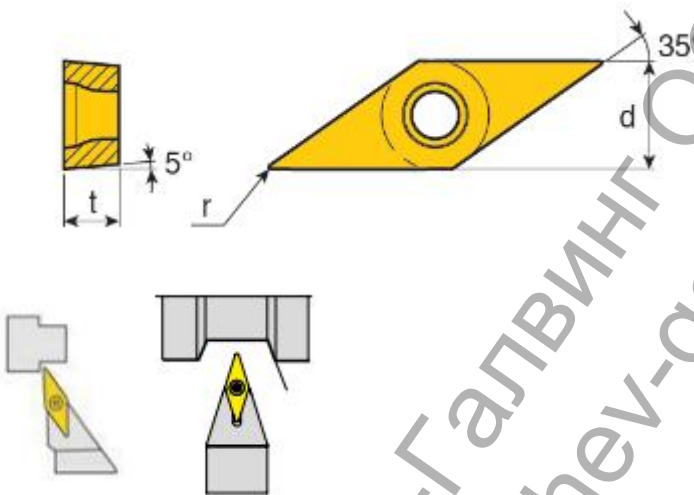
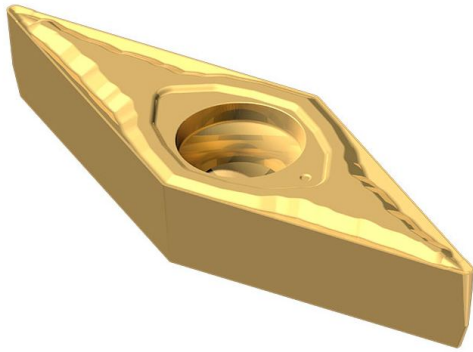


Пластина твърдосплавна за стругарски нож **VBMT**



VBMT

D-P - 35° V-Пластина - Геометрия За Груба Обработка

Код на артикула	VBMT
Тв. пластина Форма	VBMT* (35°)
Заден ъгъл на твърдосплавната пластина	5°
ISO-Обхват P	P

ISO-Обхват М	М
ISO-Обхват К	К

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www.tashev-galving.com

C

N

M

G

12

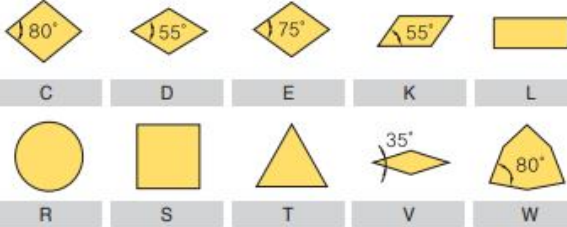
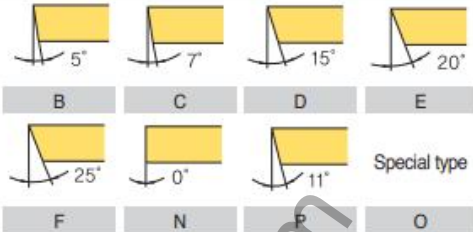
1**2****3****4****5**

Insert Shape

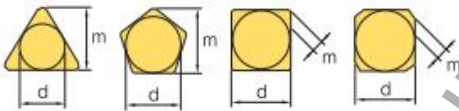
Relief Angle

Tolerance

Cross Section Type

Cutting Edge Length,
Diameter of Incribed Circle**1 Insert Shape****C N M G 12 04 08 - VM****2 Relief Angle****C N M G 12 04 08 - VM****3 Tolerance****C N M G 12 04 08 - VM**

d : Incribed circle
t : Thickness
m : Refer to figure



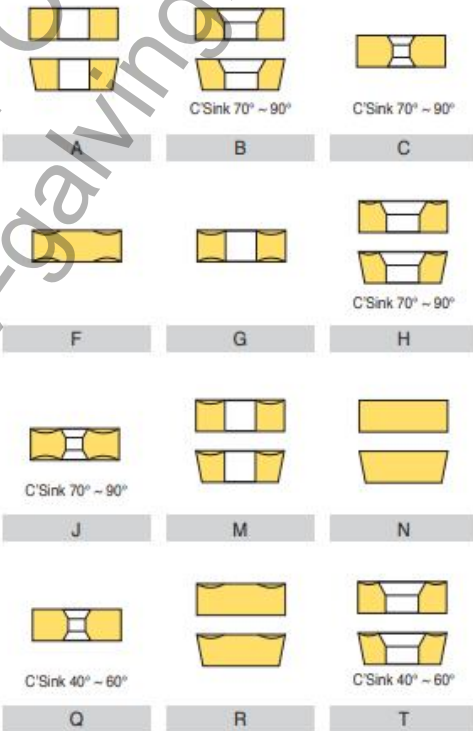
Class	d	m	t (mm)
A	±0.025	±0.005	±0.025
C	±0.025	±0.013	±0.025
H	±0.013	±0.013	±0.025
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
J*	±0.05 ~ ±0.15	±0.005	±0.025
K*	±0.05 ~ ±0.15	±0.013	±0.025
L*	±0.05 ~ ±0.15	±0.025	±0.025
M*	±0.05 ~ ±0.15	±0.08 ~ ±0.20	±0.13
N*	±0.05 ~ ±0.15	±0.08 ~ ±0.18	±0.025
U*	±0.08 ~ ±0.25	±0.13 ~ ±0.38	±0.13

*Sides are based on unground insert

Tolerance on C,E,H,M,O,P,R,S,T,W Insert Shape (Exceptional case)

d	Tolerance on d		Tolerance on m	
	J, K, L, M, N	U	M, N	U
6.35	±0.05	±0.08	±0.08	±0.13
9.525	±0.05	±0.08	±0.08	±0.13
12.7	±0.08	±0.13	±0.13	±0.20
15.875	±0.10	±0.18	±0.15	±0.27
19.05	±0.10	±0.18	±0.15	±0.27
25.4	±0.13	±0.25	±0.18	±0.38

Tolerance on D Insert Shape (Exceptional case)

4 Cross Section Type**C N M G 12 04 08 - VM**

04

08

VM

6

7

8

Height of Cutting Edge

Nose Radius (Nose R)

Chip Breaker for Turning

5 Cutting Edge Length, Diameter of Inscribed Circle
C N M G 12 04 08 - VM

Symbol								IC
C	d	S	T	R	v	W	Inch	
Metric								d(mm)
03	04	03	06	03	-	02	1.2(5)	3.97
04	05	04	08	04	08	S3	1.5(6)	4.76
05	06	05	09	05	09	03	1.8(7)	5.56
-	-	-	-	06	-	-	-	6.00
06	07	06	11	06	11	04	2	6.35
08	09	07	13	07	13	05	2.5	7.94
-	-	-	-	08	-	-	-	8.00
09	11	09	16	09	16	06	3	9.525
-	-	-	-	10	-	-	-	10.00
11	13	11	19	11	19	07	3.5	11.11
-	-	-	-	12	-	-	-	12.00
12	15	12	22	12	22	08	4	12.70
14	17	14	24	14	24	09	4.5	14.29
16	19	15	27	15	27	10	5	15.875
-	-	-	-	16	-	-	-	16.00
17	21	17	30	17	30	11	5.5	17.46
19	23	19	33	19	33	13	6	19.05
-	-	-	-	20	-	-	-	20.00
22	27	22	38	22	38	15	7	22.225
-	-	-	-	25	-	-	-	25.00
25	31	25	44	25	44	17	8	25.40
32	38	31	54	31	54	21	10	31.75
-	-	-	-	32	-	-	-	32.00

() Symbol for small size insert

6 Height of Cutting Edge
C N M G 12 04 08 - VM

Symbol		Height of Cutting Edge(t)	
Metric	Inch	mm	Inch
01	1/2	1.59	1/16
T0	1.125	1.79	9/128
T1	1.2	1.98	5/64
02	1.5(3)	2.38	3/32
T2	1.75	2.78	7/64
03	2	3.18	1/8
T3	2.5	3.97	5/32
04	3	4.76	3/16
05	3.5	5.56	7/32
06	4	6.35	1/4
07	5	7.94	5/16
09	6	9.52	3/8
11	7	11.11	7/16
12	8	12.70	1/2

() Symbol for small size insert

7 Nose Radius (Nose R)
C N M G 12 04 08 - VM

Symbol		Corner Radius	
Metric	Inch	Metric	Inch
01	0	0.1	0.004
02	0.5	0.2	0.008
04	1	0.4	1/64
08	2	0.8	1/32
12	3	1.2	3/64
16	4	1.6	1/16
20	5	2.0	5/64
24	6	2.4	3/32
28	7	2.8	7/64
32	8	3.2	1/8
00	-	Round insert(Inch)	
M0	-	Round insert(Metric)	

C25 AK AR