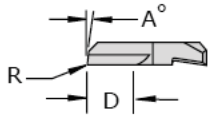
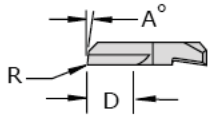
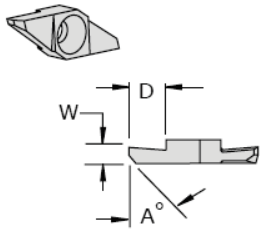
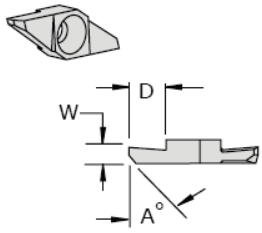
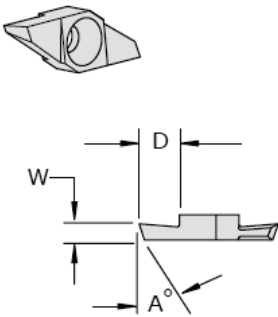
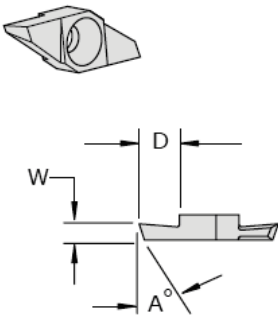
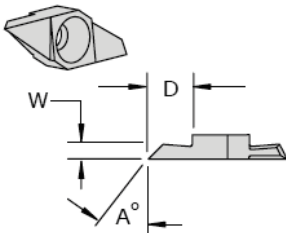
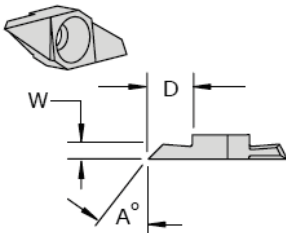
	Front Turn (Series 6)						
	Depth		Radius		A°	R.H. INSERT UNCOATED*	L.H. INSERT UNCOATED*
	Inch	MM	Inch	MM			
	.200	5.00	0	0	1°	VFTR-6M010	VFTL-6M010
	.200	5.00	0	0	4°	VFTR-6M040	VFTL-6M040
	.200	5.00	.002	.05	15°	VFTR-6M152	VFTL-6M152
	.200	5.00	.007	.18	15°	VFTR-6M157	VFTL-6M157
	.200	5.00	0	0	1°	VFTRB-6M010**	VFTLB-6M010**
	.200	5.00	0	0	4°	VFTRB-6M040**	VFTLB-6M040**
	.200	5.00	.002	.05	15°	VFTRB-6M152**	VFTLB-6M152**
	.200	5.00	.007	.18	15°	VFTRB-6M157**	VFTLB-6M157**

**With chip control

	Back Turn (Series 6)						
	Depth		Radius		A°	R.H. INSERT UNCOATED*	L.H. INSERT UNCOATED*
	Inch	MM	Inch	MM			
	.031	0.78	.050	1.27	45°	VBTR-6M452	VBTL-6M452
	.047	1.19	.085	2.16	45°	VBTR-6M453	VBTL-6M453
	.062	1.57	.130	3.30	45°	VBTR-6M454	VBTL-6M454
	.078	1.98	.200	5.00	45°	VBTR-6M455	VBTL-6M455
	.093	2.36	.200	5.00	45°	VBTR-6M456	VBTL-6M456

	Cut-Off (Series 6)						
	Width		Depth		A°	R.H. INSERT UNCOATED*	L.H. INSERT UNCOATED*
	Inch	MM	Inch	MM			
	.020	0.50	.050	1.30	25°	VCOR-6M2520	VCOL-6M2520
	.025	0.63	.065	1.65	25°	VCOR-6M2525	VCOL-6M2525
	.031	0.78	.090	2.30	25°	VCOR-6M2531	VCOL-6M2531
	.040	1.00	.100	2.60	20°	VCOR-6M2040	VCOL-6M2040
	.047	1.20	.130	3.30	20°	VCOR-6M2047	VCOL-6M2047
	.062	1.57	.160	4.06	15°	VCOR-6M1562	VCOL-6M1562
	.078	1.98	.200	5.00	15°	VCOR-6M1578	VCOL-6M1578
	.093	2.36	.200	5.00	15°	VCOR-6M1593	VCOL-6M1593

	Opp. Hand Cut-Off for Pickoff Spindle (Series 6)						
	Width		Depth		A°	R.H. INSERT UNCOATED*	L.H. INSERT UNCOATED*
	Inch	MM	Inch	MM			
	.031	0.78	.090	2.30	25°	VCORL-6M2531	VCOLR-6M2531
	.040	1.00	.100	2.60	20°	VCORL-6M2040	VCOLR-6M2040
	.047	1.20	.130	3.30	20°	VCORL-6M2047	VCOLR-6M2047
	.062	1.57	.160	4.06	15°	VCORL-6M1562	VCOLR-6M1562
	.078	1.98	.200	5.00	15°	VCORL-6M1578	VCOLR-6M1578
	.093	2.36	.200	5.00	15°	VCORL-6M1593	VCOLR-6M1593

Right hand with
Left hand cut-off shown

*For coated inserts add the appropriate suffix shown to the insert part number: -TIN, -TICN or -ALTIN