

THE NEW VALUE FRONTIER



**CERATIP**<sup>®</sup>

KYOCERA Cutting Tools

CP153-1-E

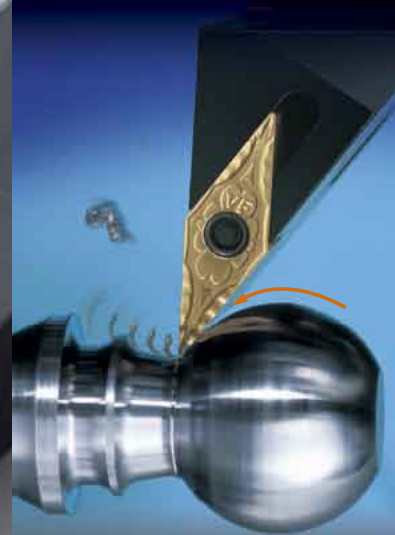
# VF Chipbreaker

**VF Chipbreaker**

**Good Chip Control for Variable D.O.C  
( Undercutting and Profiling )**



**V Pulley**






**Ball Stud**



**Undercutting**

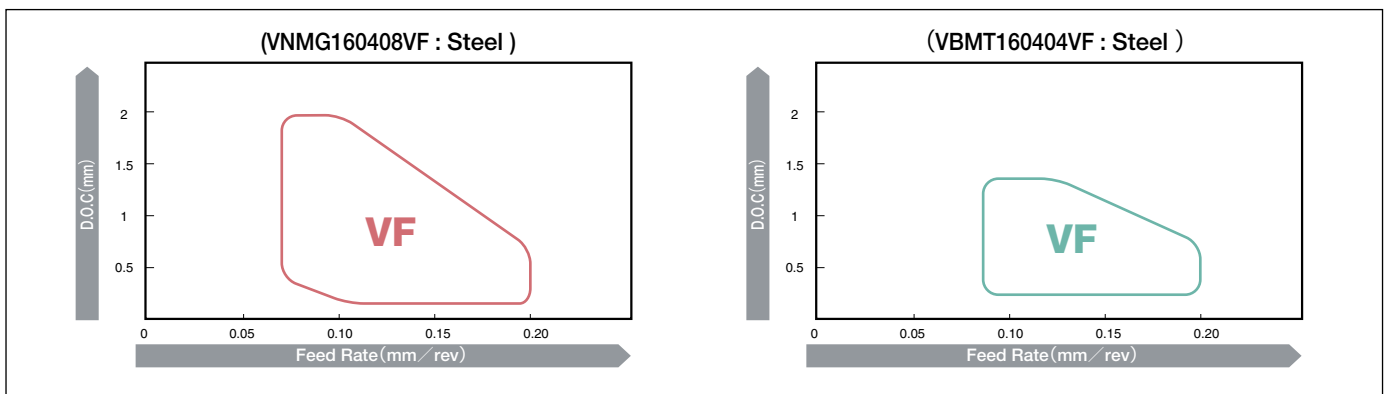
**New Positive Geometries Available**

## Stock Items

Shape	Description	Dimension (mm)					Insert Grade									
		I.C.	Thickness	Hole	Corner-R	Relief Angle	Cermet	PVD coated Cermet		CVD coated Carbide				PVD coated Carbide		
								PV7020	PV90	CA5505	CA5515	CA5525	CA5535	CA5025	PR930	PR1025
	VNMG 160404VF 160408VF 160412VF	9.525	4.76	3.81	0.4	-	●	●			●	●		●		
					0.8		●	●		●	●		●			
					1.2		●	●		●	●		●			
	VBMT 110302VF 110304VF 110308VF	6.35	3.18	2.8	0.2	5°	▲	▲	▲	▲	▲	▲		▲	▲	
					0.4		●	●	●	●	●	●		●	▲	
					0.8		●	●	●	●	●	●		●	▲	
	VBMT 160402VF 160404VF 160408VF 160412VF	9.525	4.76	4.4	0.2	5°	▲	▲	▲	▲	▲	▲		▲	▲	
					0.4		●	●	●	●	●	●		●	▲	
					0.8		●	●	●	●	●	●		●	▲	
	VCMT 080202VF 080204VF	4.76	2.38	2.3	0.2	7°	▲	▲	▲	▲	▲		▲	▲		
					0.4		●	●	●	●	●	●		●	▲	

● : Standard Stock ▲ : Scheduled to be Stocked in January 2007

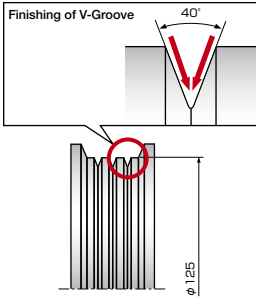
## Chip Control Range



## Case Studies



**S12C**

- V-Pulley
- V=700m/min
- d=0.2mm
- f=0.2mm/rev
- Wet
- VNMG160404VF (PV7020)



<b>VF Chipbreaker</b>	180pcs/edge
Competitor A	90pcs/edge

VF Chipbreaker insert showed stabler machining and better chip control than Competitor A while doubling its tool life.

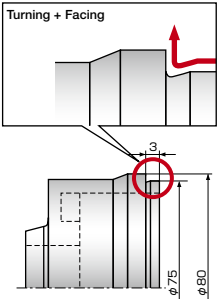

➔


Competitor A
VF

Evaluation from the user



**SCr420H**

- Housing
- V=220m/min
- d=0.2~1.2mm
- f=0.15mm/rev
- Wet
- VNMG160404VF (CA5025)



<b>VF Chipbreaker</b>	600pcs/edge
Competitor B	400pcs/edge

VF Chipbreaker insert (CA5025) improved the surface finish by improving chip control compared with Competitor B. It also improved the tool life 150%.


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Competitor B
VF

Evaluation from the user