

Chatter Resistant Boring Bars

DIMPLE BAR

Expanded Inserts

Highly rigid and lightweight head prevents vibration for better surface finishes.

■ FV breaker for finish is added.

Achieving the excellent chip control performance at the region of finish turning as small depth of cut and small feed.

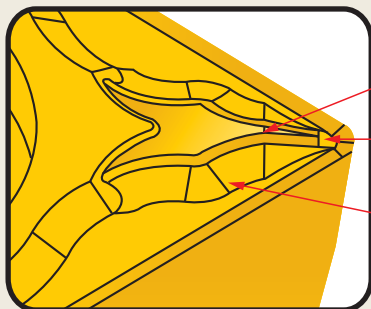


Feature of FV breaker

New-concept moulded chip breakers for Dimple Bars. Stable chip control and sharp cutting for finishing area.

● **FV breaker for finishing**

By the peninsula convex and the wall of two steps, it is achieved to the excellent chip control at the finish cutting such as the depth of cut not over 1mm.



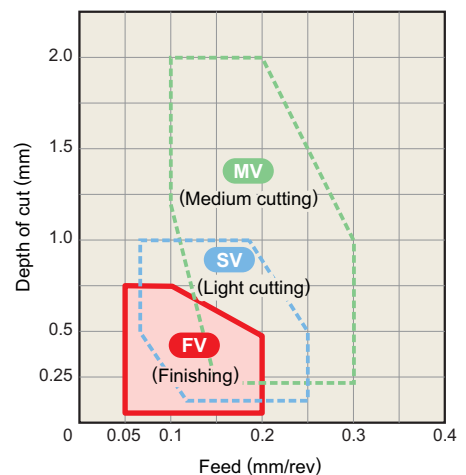
Second breaker wall

Peninsular land

First breaker wall

The rake angle ensures sharp cutting to prevent vibrations and gives an excellent surface finish.

Recommended Use of the Chip Breakers



DIMPLE BAR

Inserts

| Geometry | Class | Order Number | Dimensions (mm) | | | | Stock Grade | | | | | | | |
|--|-------|-------------------|-----------------|------|-----|----------------|-------------|--------|--------|--------|--------|---------------|-------|---|
| | | | D1 | S1 | Re | α° | Coated | | | Cermet | | Coated Cermet | | |
| | | | | | | | UE6110 | UE6020 | VP15TF | NX2525 | NX3035 | AP25N | VP45N | |
| For FSCLC/P FSCLC/P.E | M | CCMT060202-FV | 6.35 | 2.38 | 0.2 | 7 | | ● | NEW | ● | ● | ● | ● | ● |
| | | 060204-FV | 6.35 | 2.38 | 0.4 | 7 | | ● | NEW | ● | ● | ● | ● | ● |
| | | NEW CPMH080202-FV | 7.94 | 2.38 | 0.2 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 080204-FV | 7.94 | 2.38 | 0.4 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 090302-FV | 9.525 | 3.18 | 0.2 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 090304-FV | 9.525 | 3.18 | 0.4 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 090308-FV | 9.525 | 3.18 | 0.8 | 11 | | ● | ● | ● | ● | | | |
| For FSDUC FSDQC FSDUC-E FSDQC-E | M | DCMT070202-FV | 6.35 | 2.38 | 0.2 | 7 | □ | ● | NEW | ● | ● | ● | ● | |
| | | 070204-FV | 6.35 | 2.38 | 0.4 | 7 | □ | ● | NEW | ● | ● | ● | ● | |
| | | NEW 070208-FV | 6.35 | 2.38 | 0.8 | 7 | | ● | ● | ● | ● | | | |
| | | NEW 11T302-FV | 9.525 | 3.97 | 0.2 | 7 | | ● | ● | ● | ● | | | |
| | | NEW 11T304-FV | 9.525 | 3.97 | 0.4 | 7 | □ | ● | NEW | ● | ● | ● | ● | |
| For FSTUP FSTUP.E | M | NEW TPMH080202-FV | 4.76 | 2.38 | 0.2 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 080204-FV | 4.76 | 2.38 | 0.4 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 090202-FV | 5.56 | 2.38 | 0.2 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 090204-FV | 5.56 | 2.38 | 0.4 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 110302-FV | 6.35 | 3.18 | 0.2 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 110304-FV | 6.35 | 3.18 | 0.4 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 110308-FV | 6.35 | 3.18 | 0.8 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 160302-FV | 9.525 | 3.18 | 0.2 | 11 | | ● | ● | ● | ● | | | |
| | | NEW 160304-FV | 9.525 | 3.18 | 0.4 | 11 | | ● | ● | ● | ● | | | |
| For FSVUB/C FSVPB/C FSVJB/C | M | NEW VBMT110304-FV | 6.35 | 3.18 | 0.4 | 5 | | ● | ● | ● | ● | | | |
| | | NEW 110308-FV | 6.35 | 3.18 | 0.8 | 5 | | ● | ● | ● | ● | | | |
| | | NEW 160404-FV | 9.525 | 4.76 | 0.4 | 5 | | ● | ● | ● | ● | | | |
| | | NEW 160408-FV | 9.525 | 4.76 | 0.8 | 5 | | ● | ● | ● | ● | | | |
| | | NEW VCMT080202-FV | 4.76 | 2.38 | 0.2 | 7 | | ● | ● | ● | ● | | | |
| | | NEW 080204-FV | 4.76 | 2.38 | 0.4 | 7 | | ● | ● | ● | ● | | | |

● : Inventory maintained. □ : Non stock, produced to order only.

For Your Safety

- Don't handle inserts and chips without gloves. ● Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ● Please use safety covers and wear safety glasses. ● When using compounded cutting oils, please take fire precautions. ● When attaching inserts or spare parts, please use only the correct wrench or spanner. ● When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

MITSUBISHI MATERIALS CORPORATION

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(Tools specifications subject to change without notice.)