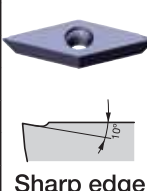
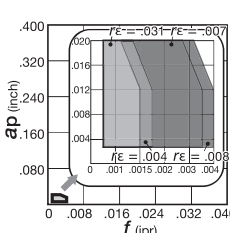
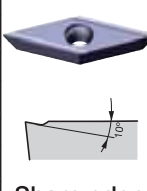
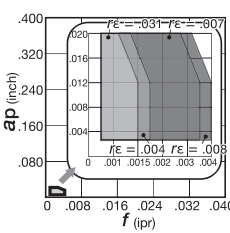
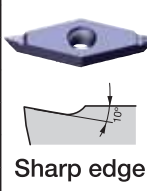
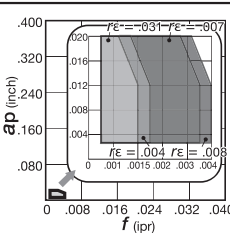


35° Rhombic, 11° Positive

| Application | Chipbreaker Appearance (Cross section) | $f - ap$ | Cat. No. | | Grades Coated SH730 | Dimensions (inch) | | | |
|--------------------------------------|---|---|-------------------|--------------------|----------------------------------|-------------------|---------------------|--------------------------------|---------------------------------|
| | | | Inch | Metric | | I.C.dia ød | Thick- ness s | Hole dia ød ₁ | Corner radius $r\epsilon$ |
| For external turning on small lathes |  <p>Sharp edge</p> |  | VPET53YMFR-JRP | VPET0802008MFR-JRP | ● | .187 | .094 | .091 | .003 |
| | | | VPET53YMFL-JRP | VPET0802008MFL-JRP | ● | | | | .004 |
| | | | VPET530MFR-JRP | VPET080201 MFR-JRP | ● | | | | .007 |
| | | | VPET530MFL-JRP | VPET080201 MFL-JRP | ● | | | | .008 |
| | | | VPET530.4MFR-JRP | VPET0802018MFR-JRP | ● | | | | .003 |
| | | | VPET530.4MFL-JRP | VPET0802018MFL-JRP | ● | | | | .004 |
| | | | VPET530.5MFR-JRP | VPET080202 MFR-JRP | ● | | | | .007 |
| | | | VPET530.5MFL-JRP | VPET080202 MFL-JRP | ● | | | | .008 |
| | | | VPET22YMFR-JRP | VPET1103008MFR-JRP | ● | .250 | .125 | .110 | .003 |
| | | | VPET22YMFL-JRP | VPET1103008MFL-JRP | ● | | | | .004 |
| | | | VPET220MFR-JRP | VPET110301 MFR-JRP | ● | | | | .007 |
| | | | VPET220MFL-JRP | VPET110301 MFL-JRP | ● | | | | .008 |
| | | | VPET220.4MFR-JRP | VPET1103018MFR-JRP | ● | | | | .003 |
| | | | VPET220.4MFL-JRP | VPET1103018MFL-JRP | ● | | | | .004 |
| | | | *VPET220.5MFR-JRP | VPET110302 MFR-JRP | ● | | | | .007 |
| | | | VPET220.5MFL-JRP | VPET110302 MFL-JRP | ● | | | | .008 |
| For external turning on small lathes |  <p>Sharp edge</p> |  | VPET53YMFR-JPP | VPET0802008MFR-JPP | ● | .187 | .094 | .091 | .003 |
| | | | VPET53YMFL-JPP | VPET0802008MFL-JPP | ● | | | | .004 |
| | | | VPET530MFR-JPP | VPET080201 MFR-JPP | ● | | | | .007 |
| | | | VPET530MFL-JPP | VPET080201 MFL-JPP | ● | | | | .008 |
| | | | VPET530.4MFR-JPP | VPET0802018MFR-JPP | ● | | | | .003 |
| | | | VPET530.4MFL-JPP | VPET0802018MFL-JPP | ● | | | | .004 |
| | | | VPET530.5MFR-JPP | VPET080202 MFR-JPP | ● | | | | .007 |
| | | | VPET530.5MFL-JPP | VPET080202 MFL-JPP | ● | | | | .008 |
| | | | VPET22YMFR-JPP | VPET1103008MFR-JPP | ● | .250 | .125 | .110 | .003 |
| | | | VPET22YMFL-JPP | VPET1103008MFL-JPP | ● | | | | .004 |
| | | | VPET220MFR-JPP | VPET110301 MFR-JPP | ● | | | | .007 |
| | | | VPET220MFL-JPP | VPET110301 MFL-JPP | ● | | | | .008 |
| | | | VPET220.4MFR-JPP | VPET1103018MFR-JPP | ● | | | | .003 |
| | | | VPET220.4MFL-JPP | VPET1103018MFL-JPP | ● | | | | .004 |
| | | | *VPET220.5MFR-JPP | VPET110302 MFR-JPP | ● | | | | .007 |
| | | | VPET220.5MFL-JPP | VPET110302 MFL-JPP | ● | | | | .008 |
| For external turning on small lathes |  <p>Sharp edge</p> |  | VPET53YMFN-JSP | VPET0802008MFN-JSP | ● | .187 | .094 | .091 | .003 |
| | | | VPET530MFN-JSP | VPET080201 MFN-JSP | ● | | | | .004 |
| | | | VPET530.4MFN-JSP | VPET0802018MFN-JSP | ● | | | | .007 |
| | | | VPET530.5MFN-JSP | VPET080202 MFN-JSP | ● | | | | .008 |
| | | | VPET22YMFN-JSP | VPET1103008MFN-JSP | ● | .250 | .125 | .110 | .003 |
| | | | VPET220MFN-JSP | VPET110301 MFN-JSP | ● | | | | .004 |
| | | | VPET220.4MFN-JSP | VPET1103018MFN-JSP | ● | | | | .007 |
| | | | *VPET220.5MFN-JSP | VPET110302 MFN-JSP | ● | | | | .008 |

Note: Chipbreaker Cross section is marked * next to the Cat. No.

● : Stocked items

Standard cutting conditions JPP / JRP / JSP types

| Work material | chip-breaker | Grade | Cutting speed V_c (sfm) | Depth of cut ap (inch) | Feed: f (ipr) | | | |
|-------------------------------------|-------------------|-------|------------------------------|-----------------------------|----------------------|----------------------|----------------------|----------------------|
| | | | | | $r\epsilon = .003''$ | $r\epsilon = .004''$ | $r\epsilon = .007''$ | $r\epsilon = .008''$ |
| Steels 1045, 4137 etc. | JPP JRP JSP | SH730 | 160 - 500 | .004 - .020 | .0004 - .0016 | .0004 - .002 | .0008 - .0036 | .0008 - .004 |
| Stainless steels 303, 304 etc. | | | 100 - 500 | | | | | |
| Titanium alloys (Ti-6AL-4v etc.) | | | 100 - 330 | | | | | |

● : Stocked items