



WINSFEED

MULTITURN

VBMX INSERT & HOLDER

VBMX INSERT AND HOLDERS WITH RIGID CLAMPING

- Powerful clamping minimizes insert rotation •*
- Excellent surface finish •*
- Precise machining dimensions •*
- Stable tool life and excellent machining performance •*
- Suitable for finishing •*



Product Overview

New VBMX insert with increased rigidity holders for improved anti-rotating during operation.

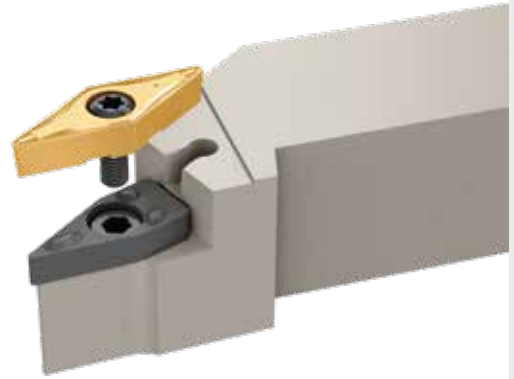
The **MultiTurn** insert's narrow corner angles mean the V-type insert is capable of various profiling operations. However, the clearance angle between the pressed type insert and the pocket causes the insert to rotate during machining, resulting in dimensional displacement.

To reduce dimensional displacement, Ingersoll has released an all new VBMX V-type positive insert and dedicated holders that reduce dimensional displacement caused by the pressed type insert's rotation.

The new VBMX insert and dedicated holders provide stable tool life, excellent machining performance, and precise machining dimensions based on a rigid clamping design. The insert's bottom face includes a groove that firmly seats it on a specially shaped shim, while the back end of the insert contacts to a specially designed pocket.

As the VBMX insert shares the same outline design as the ISO-V type insert, it is also compatible with ISO holders.

Please note that to obtain precise machining dimensions, the dedicated holder must be used.



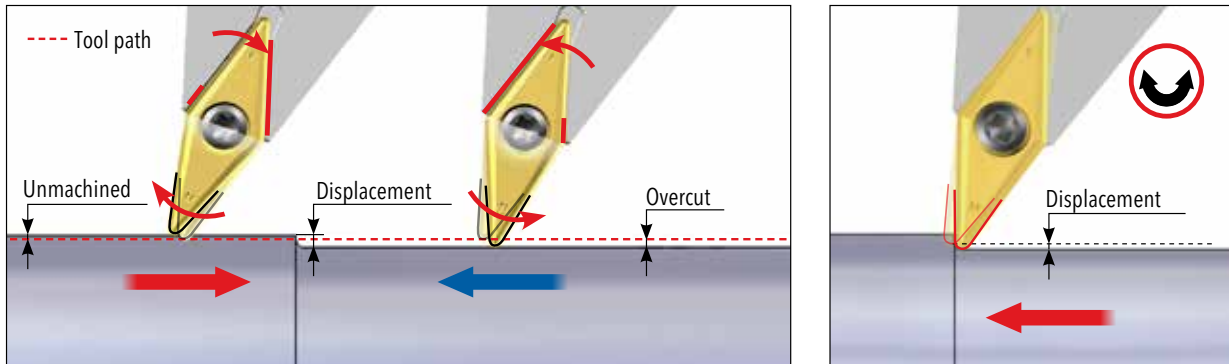
Advantages

- Unique and powerful clamping design that minimizes insert rotation
- Excellent surface finish and precise machining dimensions, suitable for finishing
- Stable tool life and excellent machining performance
- Compatible with standard ISO holders



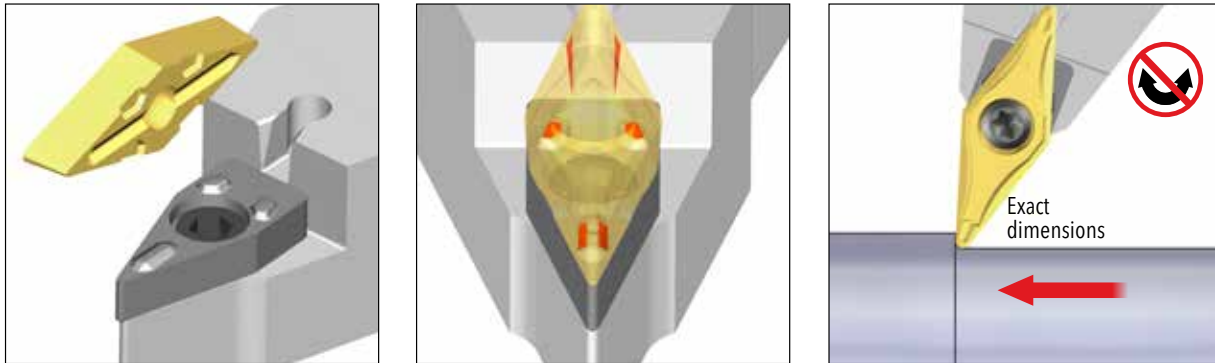
Technical Features

Displacement along the machining direction of conventional ISO inserts

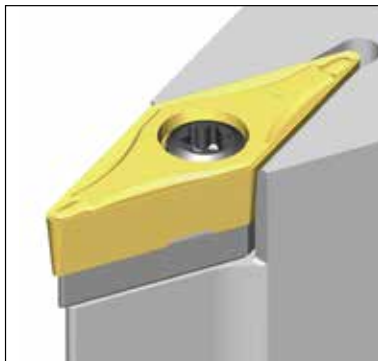


Unique and powerful clamping design

- Insert's bottom face groove seats to a special shim and the back end fits into a specially designed pocket


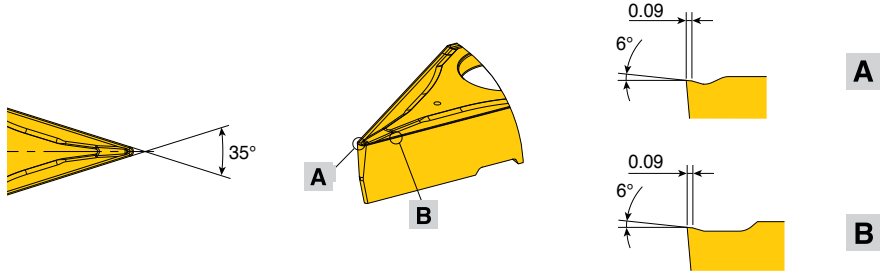


Compatible with standard ISO holders

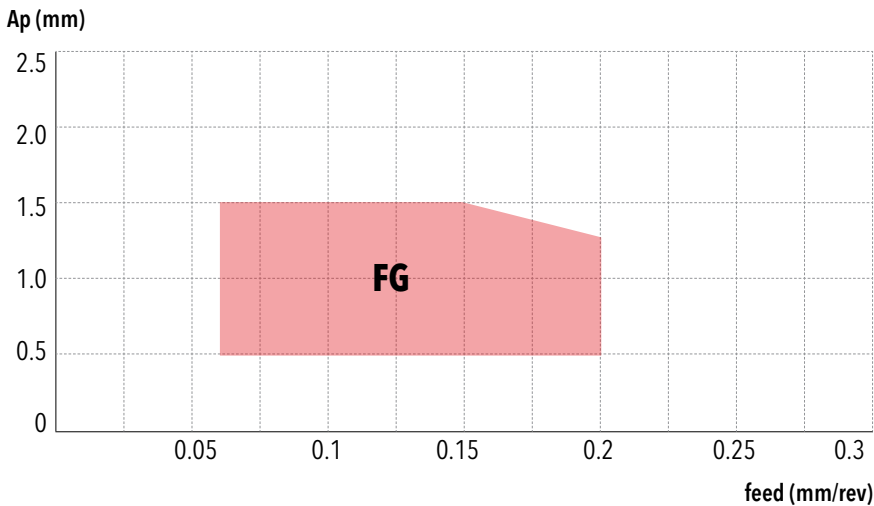


VBMX FG insert geometry

- Same cutting edge as VBMT FG

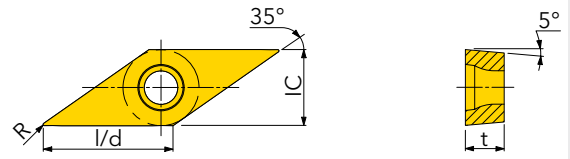
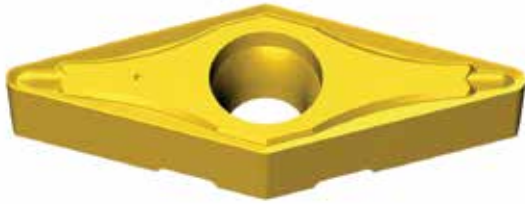
Chip breaker	Geometry
 <p style="text-align: center;">FG</p>	

VBMX FG Application Range



Insert: VBMX 160404 FG TT8115B
 Holder: LVJBR 2020 K16
 Cutting speed (V): 200 m/min
 Workpiece: SCM 440 (HB230-260)

POSITIVE 35° INSERT WITH 5° RAKE ANGLE



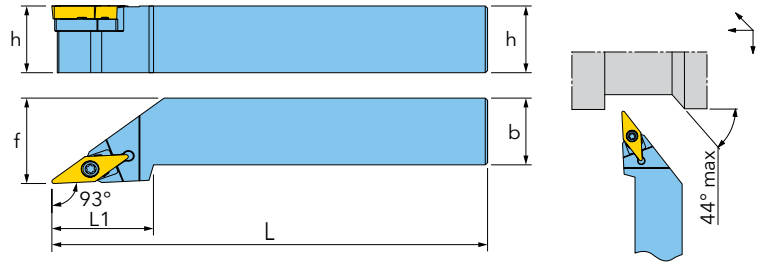
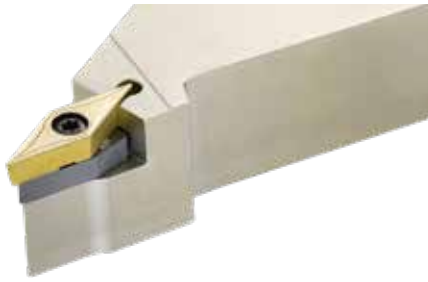
Designation	f (min/max)	ap (min/max)	Z	l	d	t	R	IC	Qualität	CT3000	TT8115B	TT5080	TT3020
VBMX 160402 FG	0,10 (0,05/0,20)	0,8 (0,3/1,5)	2	16,6	16,6	4,76	0,2	9,52					
VBMX 160404 FG	0,12 (0,07/0,20)	1,0 (0,5/2,0)	2	16,6	16,6	4,76	0,4	9,52					
VBMX 160408 FG	0,15 (0,10/0,25)	1,0 (0,7/2,0)	2	16,6	16,6	4,76	0,8	9,52					

For holder LVJBR/L & LVJBR-SH

● = P ● = M ● = K ● = N ● = S ○ = H

MULTITURN LVJBR/L

HOLDER WITH SCREW CLAMPING FOR VBMX INSERTS

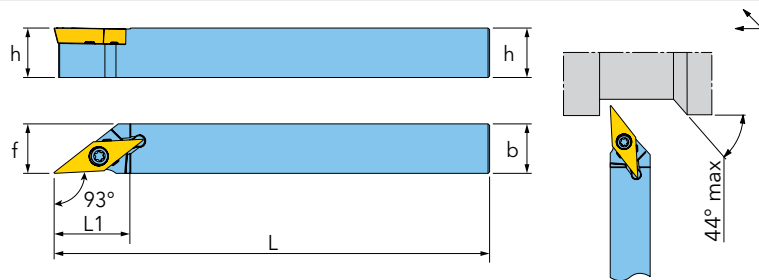
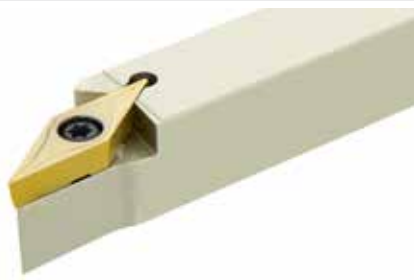


Designation	L1	L2	f	κ	h	b	kg		1	2	3	4	5
LVJBL 2020 K16	125	35	25	93	20	20	0,390	VBMX_1604_	SO 35124I	SSVX 32	TS 5035062S	L-W 3.5	T15
LVJBL 2525 M16	150	35	32	93	25	25	0,700	VBMX_1604_	SO 35124I	SSVX 32	TS 5035062S	L-W 3.5	T15
LVJBR 2020 K16	125	35	25	93	20	20	0,390	VBMX_1604_	SO 35124I	SSVX 32	TS 5035062S	L-W 3.5	T15
LVJBR 2525 M16	150	35	32	93	25	25	0,700	VBMX_1604_	SO 35124I	SSVX 32	TS 5035062S	L-W 3.5	T15

1 = insert screw 2 = shim 3 = clamp screw 4 = wrench 5 = wrench

MULTITURN LVJBR/L-SH

HOLDER WITH SCREW CLAMPING FOR VBMX INSERTS



Designation	L	L1	f	κ	h	b	kg		1	2
LVJBR 1616 K16-SH	125	24,5	16	93	16	16	0,245	VBMX_1604_	SO 35080I	T15

1 = clamp screw 2 = wrench