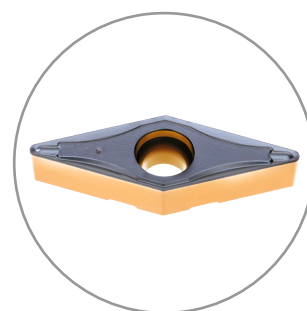


MULTITURN

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.

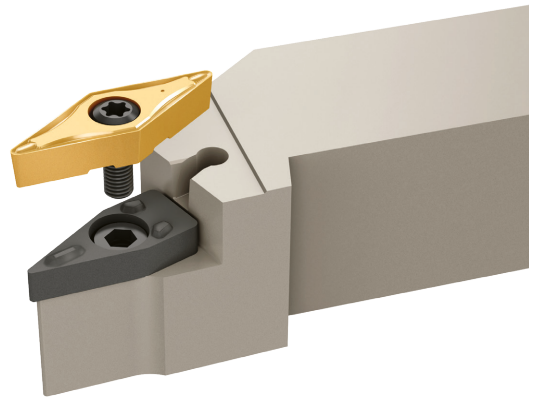
The **MultiTurn** insert's narrow corner angles mean the V-type insert is capable of various profiling operations. However, the clearance angle between the pressed type insert and the pocket causes the insert to rotate during machining, resulting in dimensional displacement.

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.

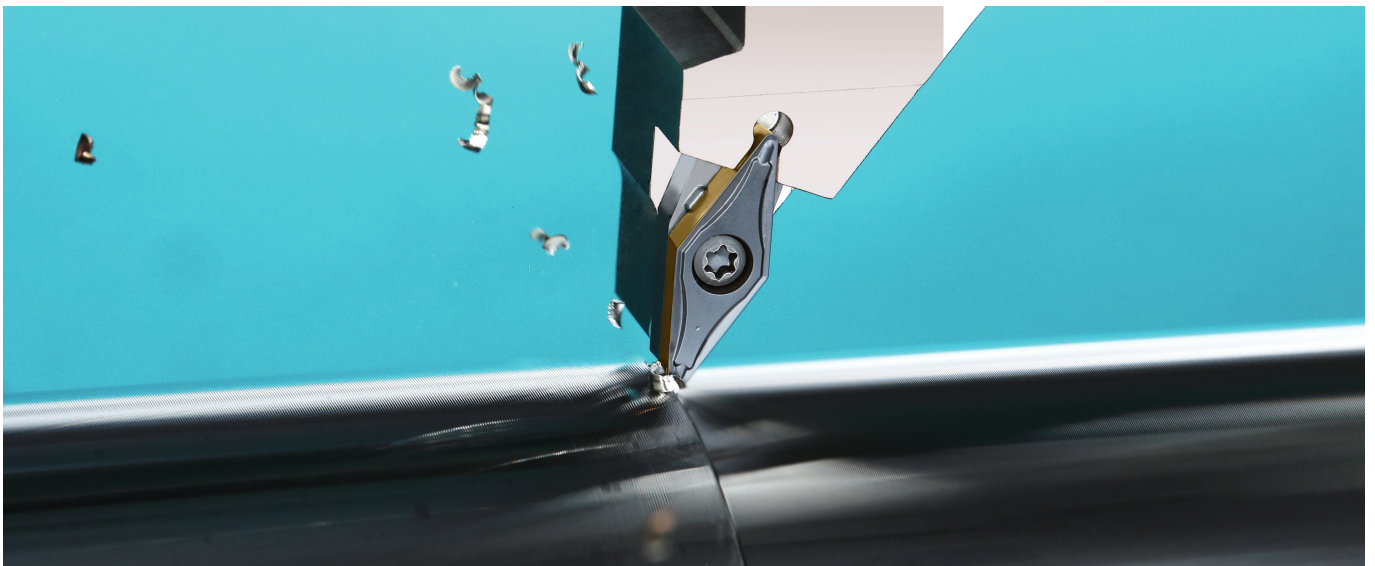
As the **VBMX** insert shares the same outline design as the ISO-V type insert, it is also compatible with ISO holders.

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



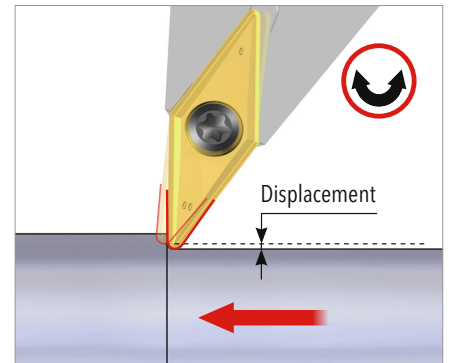
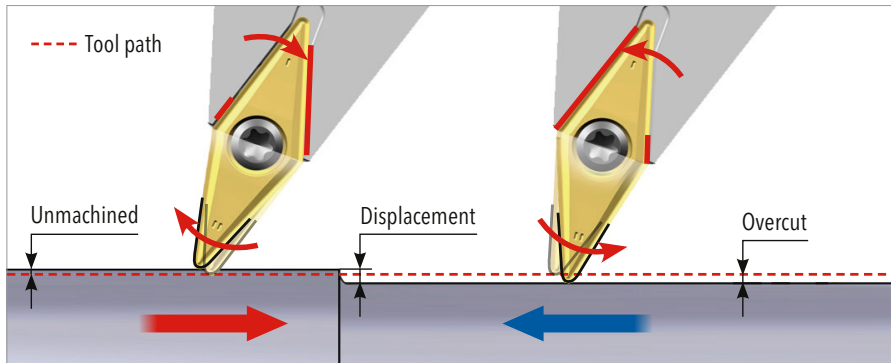
ADVANTAGES

- 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



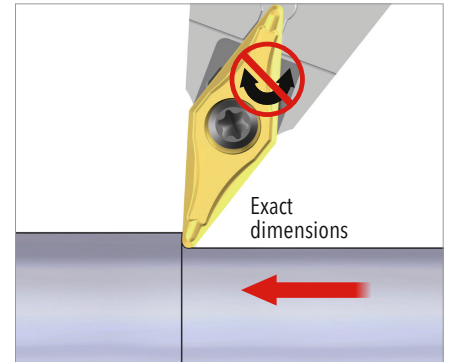
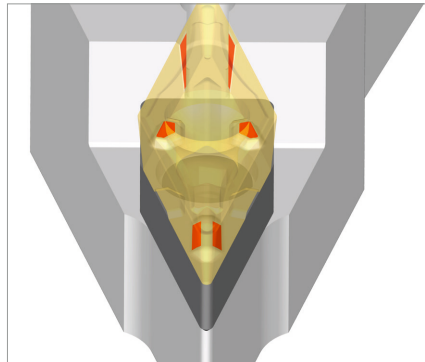
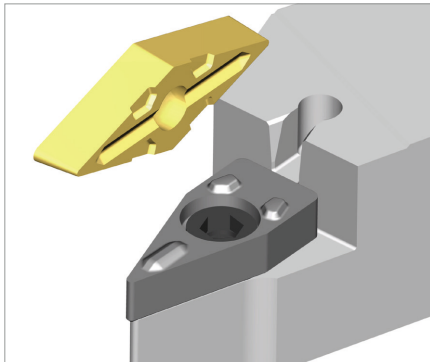
TECHNICAL FEATURES

Displacement along the machining direction of conventional ISO inserts

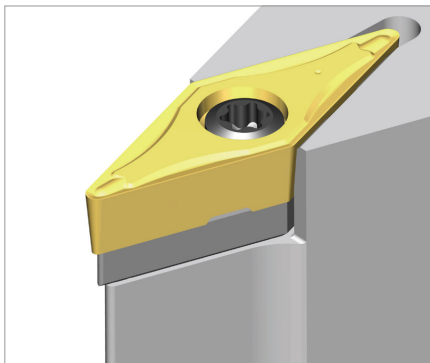


Unique and powerful clamping design

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

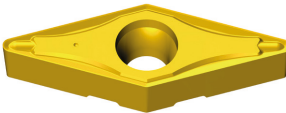
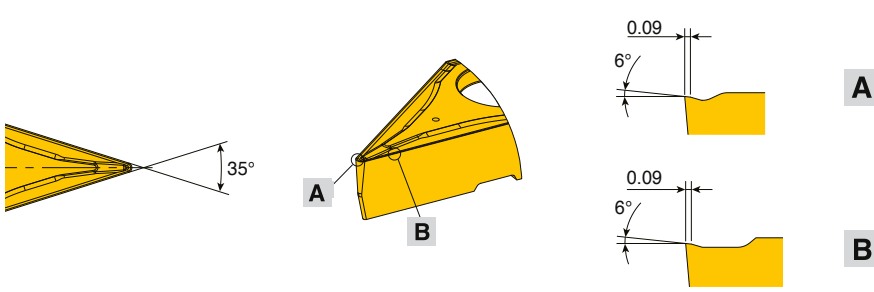


Compatible with standard ISO holders

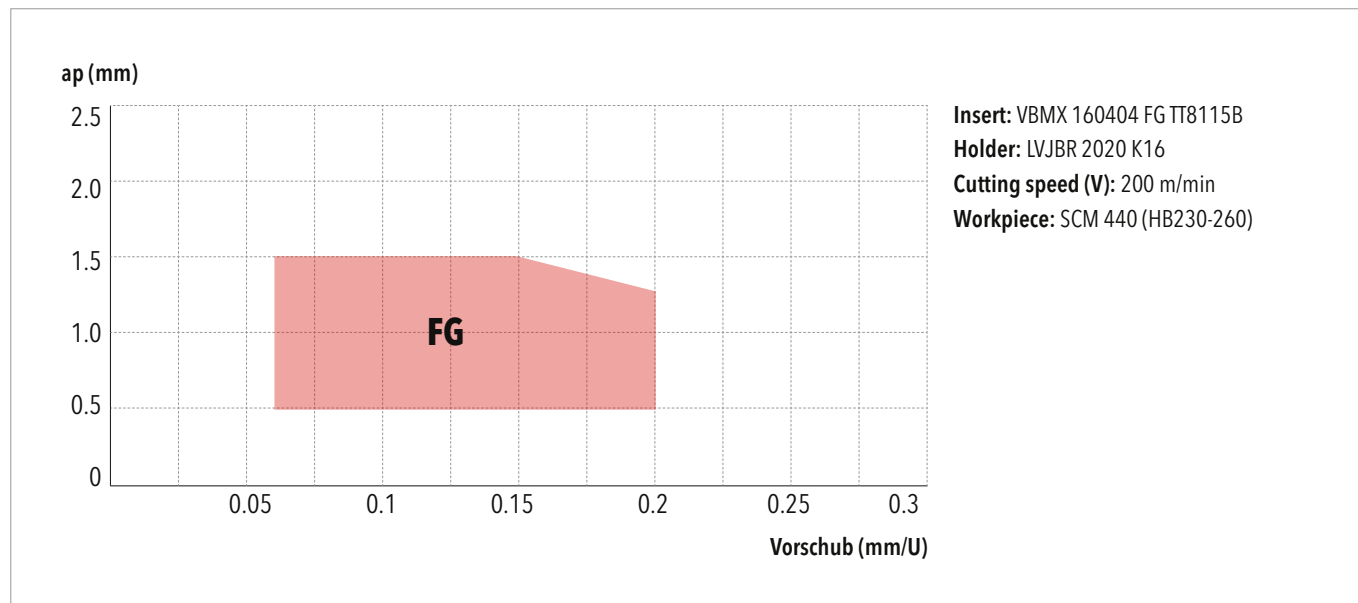


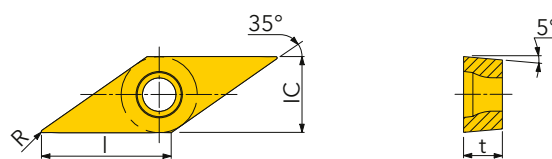
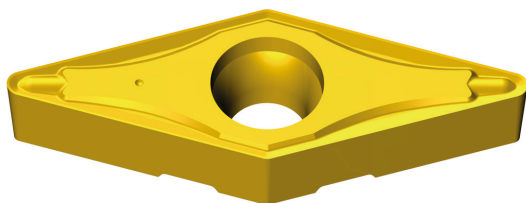
VBMX FG INSERT GEOMETRY

- Same cutting edge as VBMT FG

Chip breaker	Geometry
 FG	

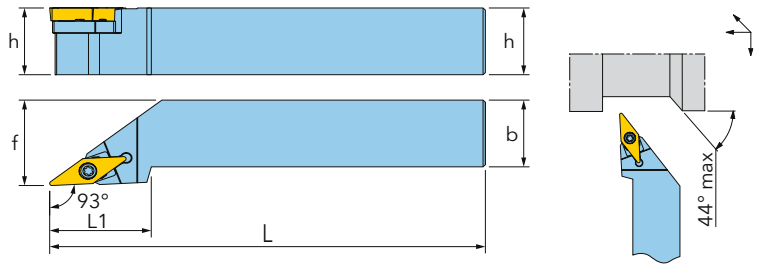
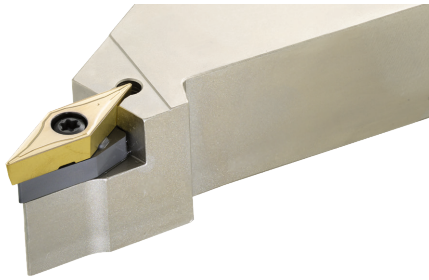
VBMX FG APPLICATION RANGE



POSITIVE 35° INSERT WITH 5° RAKE ANGLE


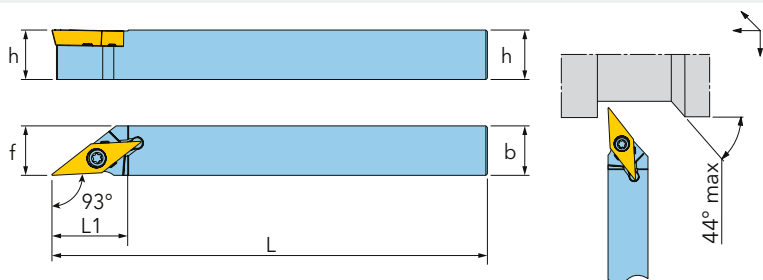
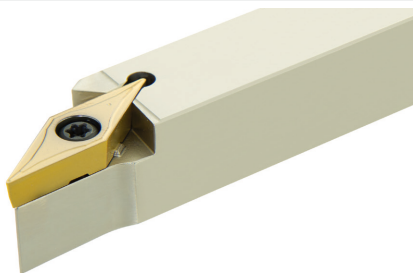
Designation	f (min/max)	ap (min/max)	Z	l	d	t	R	IC	Qualität	CT3000	TT8115B	TT5080	TT3020
VBMX 160402 FG	0,10 (0,05/0,20)	0,8 (0,3/1,5)	2	16,6	16,6	4,76	0,2	9,52					
VBMX 160404 FG	0,12 (0,07/0,20)	1,0 (0,5/2,0)	2	16,6	16,6	4,76	0,4	9,52					
VBMX 160408 FG	0,15 (0,10/0,25)	1,0 (0,7/2,0)	2	16,6	16,6	4,76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

= P = M = K = N = S = H

**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	LW 3.5	T15
LVJBL 2525 M16	150	35	32	93	25	25	0,700	VBMX_1604_	SO 35124I	SSVX 32	TS 5035062S	LW 3.5	T15
LVJBR 2020 K16	125	35	25	93	20	20	0,390	VBMX_1604_	SO 35124I	SSVX 32	TS 5035062S	LW 3.5	T15
LVJBR 2525 M16	150	35	32	93	25	25	0,700	VBMX_1604_	SO 35124I	SSVX 32	TS 5035062S	LW 3.5	T15

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

**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

Ingersoll Cutting Tools

Marketing- & Technologie-Standorte

Germany / Allemagne

Ingersoll Werkzeuge GmbH

Kalteiche-Ring 21-25

35708 Haiger, Germany

Telefon: +49 (0) 27 73-7 42-0

E-Mail: info@ingersoll-imc.de

Internet: www.ingersoll-imc.de

France

Ingersoll France

22, rue Albert Einstein

F-77420 CHAMPS-sur-MARNE

Téléphone: +33 (0) 1 64 68 45 36

E-Mail: info@ingersoll-imc.fr

Internet: www.ingersoll-imc.fr

