



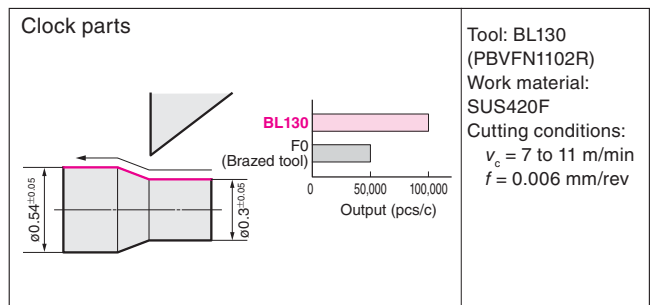
■ Features

- Expanded selection of high rigidity tools for gang tool NC lathes!
- Possible to use multiple inserts for different purposes on a single holder
- Compatible with turrets
- Blank inserts available
- Non-coated surface allows inserts to be ground freely
- Wear-resistance comparable to coated surfaces
- The cutting performance of a non-coated edge BL130
- Most popular brazed tools, fine-grained carbide F1 is used for indexable inserts

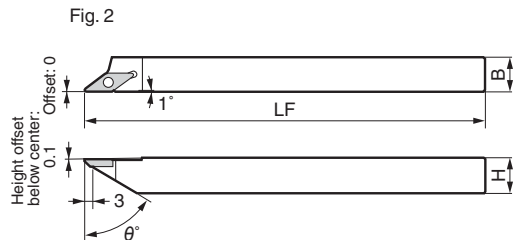
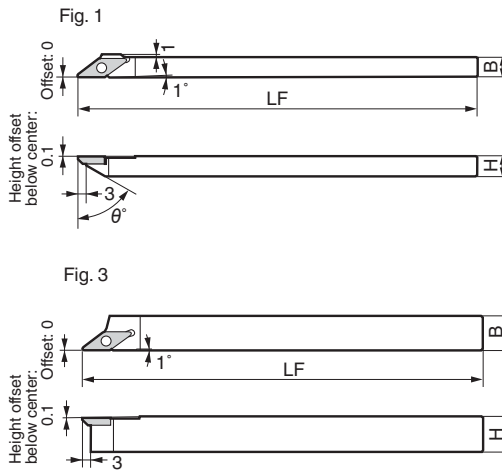
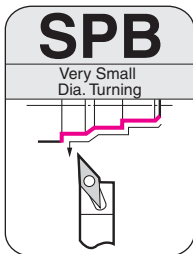
■ Applicable Grades

Application Work material	Stainless steel			Brass, aluminum
	General steel, SK material	Austenite	Martensite Ferrite	
BL130	○	○	◎	○
F1	○	◎	○	○

■ Cutting Applications

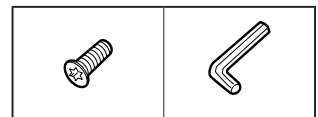


For Machining Very Small Parts



■ Parts

This figure shows right handed tools.



■ Holders

Toolpost	Cat. No.	Dimensions (mm)							Fig	Screw	N·m	Wrench
		Stock		Height	Width	Length	Relief angle					
		R	L	H	B	LF	θ°					
Turret type	SPB R/L0707-70	●	—	7	7	140	70	1	BFTX02505N	1.1	LT08-06	
	SPB R/L0808-60	●	—	8	8	140	60	2	BFTX02506N	1.5		
	SPB R/L0808-70	—	●	8	8	140	70	2	BFTX02505N	1.1		
	SPB R/L0909-70	—	●	9.5	9.5	140	70	2	BFTX02505N	1.1		
	SPB R/L1010-60	●	—	10	10	140	60	2	BFTX02506N	1.5		
	SPB R/L1212-60	●	—	12	12	140	60	2	BFTX02506N	1.5		
Gang-type	SPB R0808	●	—	8	8	140	—	3	BFTX02506N	1.5		
	SPB R1010	●	—	10	10	140	—	3	BFTX02506N	1.5		
	SPB R1212	●	—	12	12	140	—	3	BFTX02506N	1.5		

■ Inserts

● Blank inserts

Cat. No.	Dimensions (mm)	Application	Fig	BL 130	F1
	Length (L)				
PBVX 1102R-NB	17.2	A wide range of applications	1	●	●
PBVX 1102L-NB					
PBVX 1102R-SB	(20.14)	Sharp products	2	●	●
PBVX 1102L-SB					
PBVX 1102R-BB	17.2	Special products	3	●	●
PBVX 1102L-BB					

● Inserts for grooving

Cat. No.	Dimensions (mm)		BL 130	F1
	Groove depth CDX	Edge width CW		
PBVG 1102R-030	0.5	0.3	●	
PBVG 1102L-030				
PBVG 1102R-050	1.0	0.5	●	
PBVG 1102L-050				
PBVG 1102R-100	2.0	1.0	●	
PBVG 1102L-100				

● Inserts for front turning

Cat. No.	Dimensions (mm)	Wiper edge	Fig	BL 130	F1
	Effective length				
PBVFW 1102R	1.0	Yes	1	●	
PBVFW 1102L					
PBVFN 1102R	1.0	No	2	●	
PBVFN 1102L					

● Inserts for cut-off

Cat. No.	Dimensions (mm)		Fig	BL 130	F1
	Max. cut-off dia.	Edge width CW			
PBVC 1102R-50	ø5.0	1.0	1	●	
PBVC 1102L-50			2		

● Inserts for back-turning

Cat. No.	Dimensions (mm)	Wiper edge	Fig	BL 130	F1
	Effective length				
PBVBW 1102R	1.0	Yes (2°)	1	●	
PBVBW 1102L					
PBVBN 1102R	1.0	No (5°)	2	●	
PBVBN 1102L					

● Inserts for threading

Cat. No.	Dimensions (mm)		Fig	BL 130	F1
	Pitch				
PBVTF 1102R	0.2-0.5		1	●	
PBVTF 1102L					
PBVTB 1102R	0.2-0.5		2	●	
PBVTB 1102L					

■ Recommended Cutting Conditions

Work material	P Carbon steel	P Free-cutting steel	M Stainless steel	N Non-ferrous metal
Cutting speed Vc (m/min)	5-80	5-80	5-50	5-100
Feed rate f (mm/rev)	0.003-0.05			
Coolant	Oil-base			