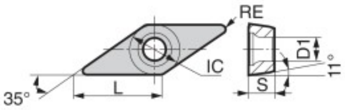
イゲタロイ

# 35°菱形ポジティブインサート

## VP
**35°菱形**
**11°ポジティブ**
**穴つき**



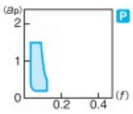
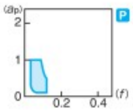
材種選択ガイド ☞A2、A3
チップブレーカ選択ガイド ☞B10～
被削材別インサート材種選択ガイド ☞A10～

● ：連続切削 第一推奨
○ ：連続切削 第二推奨
◕ ：一般切削 第一推奨
◌ ：一般切削 第二推奨
✖ ：断続切削 第一推奨
⌘ ：断続切削 第二推奨

### VP■■0802●●

| 寸法 (mm) | 切刃長L | 8.3 | 厚さS | 2.38 |
|---|---|---|---|---|
| | 内接円IC | 4.76 | 穴径D1 | 2.4 |

| 推奨用途 | AC8015P | AC8020P | AC8025P | AC8035P | AC810P | AC820P | AC830P | AC6020M | AC6030M | AC6040M | AC610M | AC630M | AC4010K | AC4015K | AC420K | AC405K | AC415K | AC503U | AC5005S | AC5015S | AC5025S | AC510U | AC520U | AC1030U | AC530U | ACZ150 | T1500Z | T2500Z | T3000Z | T1000A | T1500A | ST10P | ST20E | A30 | G10E | EH510 | EH520 | H1 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| P 鋼 | ● | ◌ | ◕ | ✖ | ○ | ◌ | ⌘ | | ◌ | | | ◌ | | | | | | | | | ⌘ | | ⌘ | ◕ | | | ◕ | ✖ | ⌘ | ● | ◕ | | | | | | | |
| M ステンレス鋼 | | | | ⌘ | | | ⌘ | ● | ◕ | ✖ | ○ | ◌ | | | | | | | | | ⌘ | | ⌘ | ◕ | ⌘ | | | | | | | | | | | | | |
| K 鋳鉄 | | | ⌘ | | | ⌘ | | | | | | | ● | ◕ | ✖ | ○ | ◌ | | | ⌘ | | ⌘ | | ◕ | | | | | | ● | | | | | | | | |
| N 非鉄金属 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | ◕ |
| S 難削材 | | | | | | | | | | | | | | | | | | | ● | ◕ | ✖ | ◌ | ⌘ | ⌘ | | | | | | | | | | | | | | |
| H 高硬度材 | | | | | | | | | | | | | | | | | ● | | | | | | | | | | | | | | | | | | | | | |

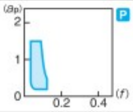
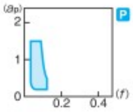
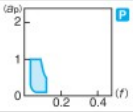
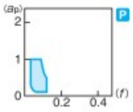
| | 形状 | 適用領域 | 型　番 | コーナー半径 RE | コーティング | | | | | | | | | | | | | | | | | | | | | | | | | | コーテッドサーメット | | | サーメット | | 超硬合金 | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | AC8015P | AC8020P | AC8025P | AC8035P | AC810P | AC820P | AC830P | AC6020M | AC6030M | AC6040M | AC610M | AC630M | AC4010K | AC4015K | AC420K | AC405K | AC415K | AC503U | AC5005S | AC5015S | AC5025S | AC510U | AC520U | AC1030U | AC530U | ACZ150 | T1500Z | T2500Z | T3000Z | T1000A | T1500A | ST10P | ST20E | A30 | G10E | EH510 | EH520 | H1 |
| 仕上切削 | **FX**<br> <br>15° |  | VPET 0802008R-FX | 0.08 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 0802008L-FX | 0.08 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 0802015R-FX | 0.15 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 0802015L-FX | 0.15 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 0802018R-FX | 0.18 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 0802018L-FX | 0.18 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | **FY**<br> <br>15° |  | VPET 0802008R-FY | 0.08 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 0802008L-FY | 0.08 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 0802015R-FY | 0.15 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 0802015L-FY | 0.15 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 0802018R-FY | 0.18 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 0802018L-FY | 0.18 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |

### VP■■1103●●

| 寸法 (mm) | 切刃長L | 11.1 | 厚さS | 3.18 |
|---|---|---|---|---|
| | 内接円IC | 6.35 | 穴径D1 | 2.8 |

適用外径ホルダ ☞D15、D29

| 推奨用途 | AC8015P | AC8020P | AC8025P | AC8035P | AC810P | AC820P | AC830P | AC6020M | AC6030M | AC6040M | AC610M | AC630M | AC4010K | AC4015K | AC420K | AC405K | AC415K | AC503U | AC5005S | AC5015S | AC5025S | AC510U | AC520U | AC1030U | AC530U | ACZ150 | T1500Z | T2500Z | T3000Z | T1000A | T1500A | ST10P | ST20E | A30 | G10E | EH510 | EH520 | H1 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| P 鋼 | ● | ◌ | ◕ | ✖ | ○ | ◌ | ⌘ | | ◌ | | | ◌ | | | | | | | | | ⌘ | | ⌘ | ◕ | | | ◕ | ✖ | ⌘ | ● | ◕ | | | | | | | |
| M ステンレス鋼 | | | | ⌘ | | | ⌘ | ● | ◕ | ✖ | ○ | ◌ | | | | | | | | | ⌘ | | ⌘ | ◕ | ⌘ | | | | | | | | | | | | | |
| K 鋳鉄 | | | ⌘ | | | ⌘ | | | | | | | ● | ◕ | ✖ | ○ | ◌ | | | ⌘ | | ⌘ | | ◕ | | | | | | ● | | | | | | | | |
| N 非鉄金属 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | ◕ |
| S 難削材 | | | | | | | | | | | | | | | | | | | ● | ◕ | ✖ | ◌ | ⌘ | ⌘ | | | | | | | | | | | | | | |
| H 高硬度材 | | | | | | | | | | | | | | | | | ● | | | | | | | | | | | | | | | | | | | | | |

| | 形状 | 適用領域 | 型　番 | コーナー半径 RE | コーティング | | | | | | | | | | | | | | | | | | | | | | | | | | コーテッドサーメット | | | サーメット | | 超硬合金 | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | AC8015P | AC8020P | AC8025P | AC8035P | AC810P | AC820P | AC830P | AC6020M | AC6030M | AC6040M | AC610M | AC630M | AC4010K | AC4015K | AC420K | AC405K | AC415K | AC503U | AC5005S | AC5015S | AC5025S | AC510U | AC520U | AC1030U | AC530U | ACZ150 | T1500Z | T2500Z | T3000Z | T1000A | T1500A | ST10P | ST20E | A30 | G10E | EH510 | EH520 | H1 |
| 仕上切削 | **FX**<br> <br>15° |  | VPGT 110301R-FX | 0.1 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | 110301L-FX | 0.1 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | 110302R-FX | 0.2 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | 110302L-FX | 0.2 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | **FX**<br> <br>15° |  | VPET 1103003R-FX | 0.03 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 1103003L-FX | 0.03 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 110301R-FX | 0.1 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 110301L-FX | 0.1 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 110302R-FX | 0.2 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 110302L-FX | 0.2 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | **FY**<br> <br>15° |  | VPGT 110301R-FY | 0.1 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | 110301L-FY | 0.1 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | 110302R-FY | 0.2 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | 110302L-FY | 0.2 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | **FY**<br> <br>15° |  | VPET 1103003R-FY | 0.03 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 1103003L-FY | 0.03 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 110301R-FY | 0.1 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 110301L-FY | 0.1 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 110302R-FY | 0.2 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |
| | | | 110302L-FY | 0.2 | | | | | | | | | | | | | | | | | | | | | | | | ● | | ● | | | | | | | | | | | | |

インサート
B
ネガティブ
ポジティブ
C
D
R
S
T
V
W
セラミックス
ソリッドCBN