

Holders

- External
HVJNR/L, HVQNR/L, HVVNN
- Boring Bars
A-SVQNR/L, A-SVUNR/L

Corner Radii

- .008, .016, .031 and .047"

Grades

- Cermet -
CT3000, PV3010
for high cutting speeds
- PVD coated carbide
TT5080, TT9080
for stainless and high-temp
- CVD coated carbide
TT8115, TT8125, TT8135, TT5100
for steel
TT9225, TT9235, TT5100
for stainless
TT7005, TT7015
for cast iron

**NEW
PRODUCT
ANNOUNCEMENT
• 2015 •**

VNMX Inserts and Holders

Ingersoll is pleased to announce another expansion to the Gold-Rhino™ product line, this time for 35 degree VNMX inserts and corresponding external holders and boring bars.

These negative, double-sided inserts provide the same benefit as other Gold-Rhino inserts...a 25-30% lower price for a smaller IC insert (compared to typical 3/8" IC, VNMG inserts). Normally, 35° inserts are used for lighter depths of cut which makes the smaller IC, VNMX Gold-Rhino inserts a logical choice - they achieve the same or better performance compared to larger, more expensive inserts.

All external holders for the VNMX inserts use a hook lever, H-Type holder, whereas all internal boring bars use a screw to hold the insert in place. All inserts are top & bottom ground and feature a wide seating surface to maximize contact in the pocket, thereby increasing stability of the tool.

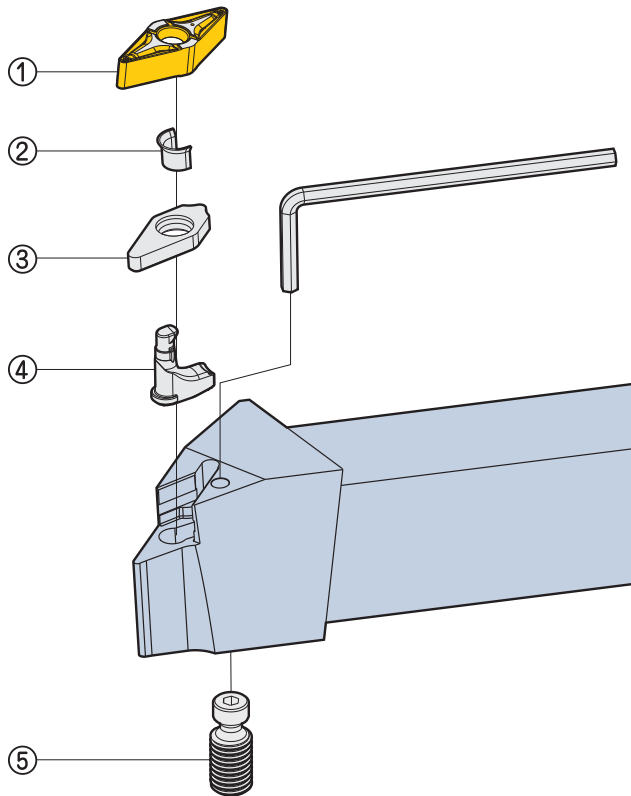
VNMX inserts are available in 6 different chipbreakers and 12 grades, with 86 unique inserts offered as standard items. Nose radii from .008" to .047".

FEATURES

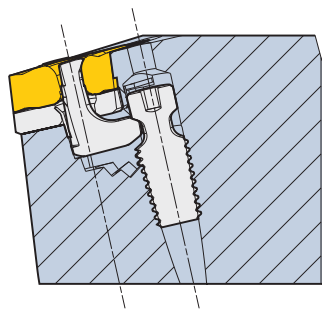
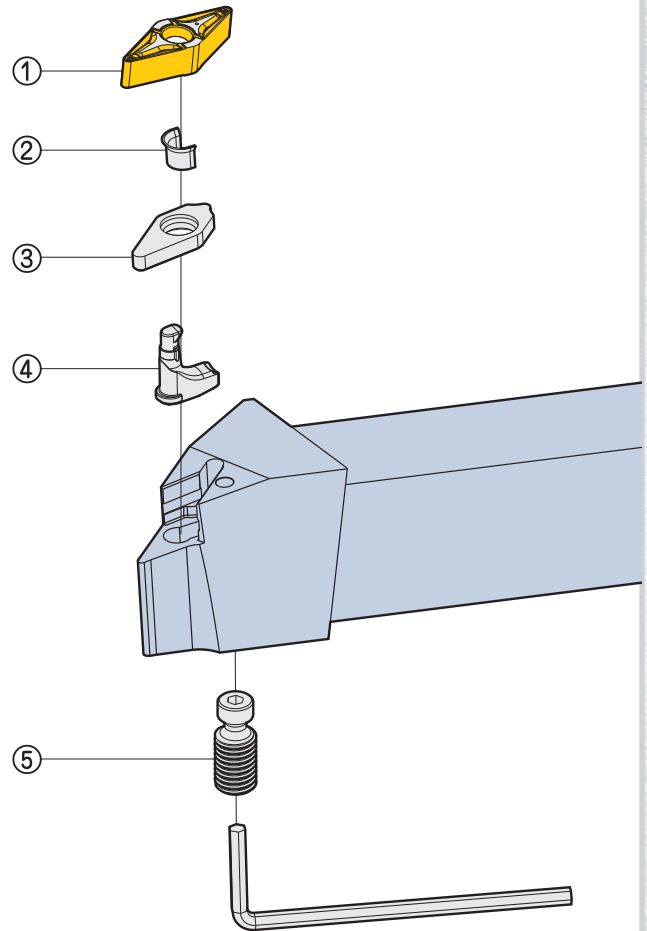
- Same thickness as VNMG33x inserts, but 25-30% lower price!
- Double-sided Inserts
- External holder and boring bar options
- Convenient and stable hook-lever clamping for external holders

Holder Clamping Method

Clamping from the top



Clamping from the bottom



- ① Insert
- ② Shim Pin
- ③ Shim
- ④ Hook Lever
- ⑤ Screw

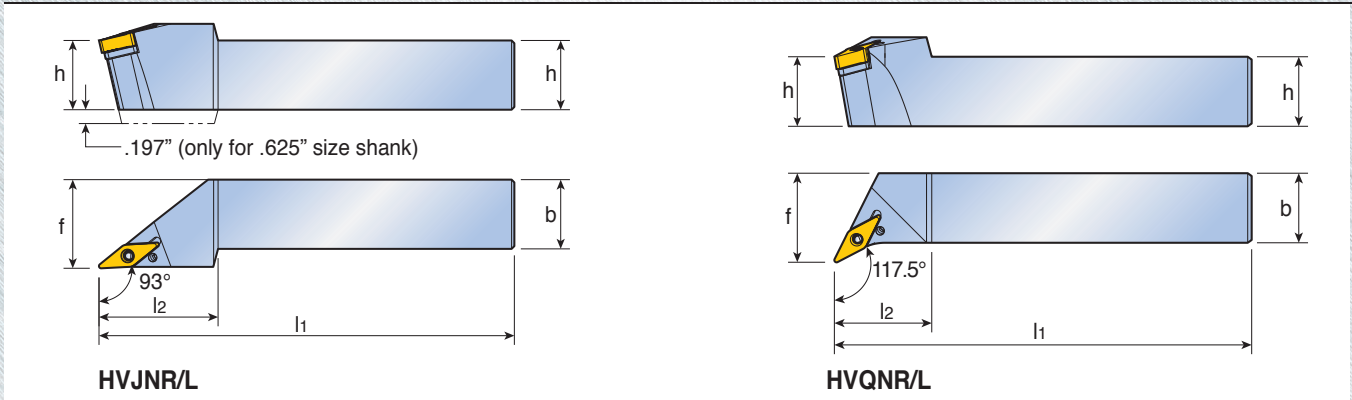
VNMX Negative 35° rhombic inserts

	Size	Dimension (in)		
		d	t	r
	VNMX2.530.5	.312	.187	.008
	VNMX2.531	.312	.187	.016
	VNMX2.532	.312	.187	.031
VNMX2.533	.312	.187	.047	

Insert	ANSI (ISO) Designation	Recommended machining conditions		Cermet		CVD Coated								PVD coated		
		feed (ipr)	ap (in)	PV3010	CT3000	TT7005	TT7015	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT5080	TT9080
	VNMX 2.531 (130404) FG	.003-.008	.020-.079		●			●	●					●	●	●
	2.532 (130408) FG	.004-.009	.020-.079		●			●	●					●	●	●
	VNMX 2.531 (130404) FM	.003-.012	.010-.059		●			●	●	●				●	●	●
	2.532 (130408) FM	.004-.014	.012-.059		●			●	●	●				●	●	●
	VNMX 2.530.5 (130402) FS	.002-.010	.008-.039	●	●			●	●							
	2.531 (130404) FS	.003-.012	.012-.039	●	●			●	●							
	2.532 (130408) FS	.004-.012	.020-.039	●	●			●	●							
	VNMX 2.531 (130404) MK	.007-.014	.028-.118									●	●		●	●
	2.532 (130408) MK	.008-.016	.039-.118									●	●		●	●
	VNMX 2.531 (130404) MT	.006-.014	.031-.118		●			●	●	●				●	●	●
	2.532 (130408) MT	.007-.014	.039-.118		●	●	●	●	●	●				●	●	●
	2.533 (130412) MT	.008-.016	.059-.118			●	●	●	●	●				●	●	●
	VNMX 2.531 (130404) PC	.006-.014	.016-.118					●	●	●				●	●	●
	2.532 (130408) PC	.007-.014	.020-.118					●	●	●				●	●	●
	2.533 (130412) PC	.008-.016	.039-.118					●	●	●				●	●	●

● : Standard item

HVJNR/L HVQNR/L Hook lever type holder

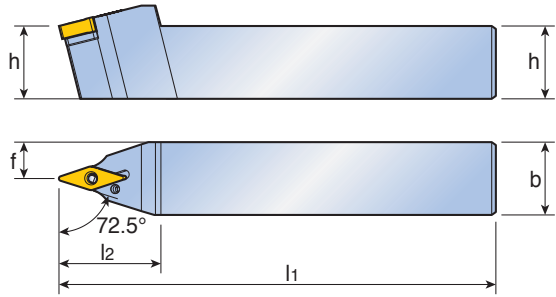


Approach angle	Designation	Dimension (in)					Insert
		h	b	l ₁	l ₂	f	
<p>93°</p>	HVJNR/L 10-253A	.625	.625	4.00	1.18	.750	VNMX 2.53x
	12-253B	.750	.750	4.50	1.38	1.000	
	16-253D	1.000	1.000	6.00	1.69	1.250	
	20-253D	1.250	1.250	6.00	1.97	1.500	
<p>117.5°</p>	HVQNR/L 12-253B	.750	.750	4.50	1.38	1.000	
	16-253D	1.000	1.000	6.00	1.38	1.250	

Spare parts

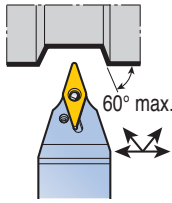
Designation	Lever	Screw	Shim	Shim pin	Wrench			
VNMX 2.53x	 LCL 08-NX	 LCS 4-DH	 LSV 2.51.8H	 LSP 3B	 L-W 2.5			

HVVNN Hook lever type holder



HVVNN

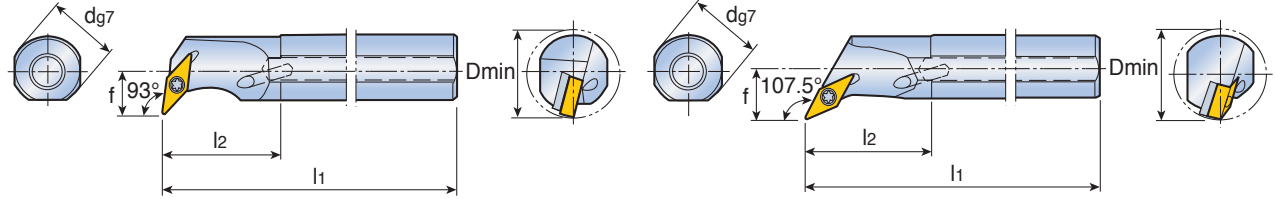
Approach angle	Designation	Dimension (in)					Insert
		h	b	l ₁	l ₂	f	
72.5°	HVVNN 12-253B	.750	.750	4.50	1.38	.375	VNMX 2.53x
	16-253D	1.000	1.000	6.00	1.38	.500	



Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
VNMX 2.53x	LCL 08-NX	LCS 4-DH	LSV 2.51.8H	LSP 3B	L-W 2.5			

A-SVUNR/L A-SVQNR/L Screw type holder



A-SVUNR/L

A-SVQNR/L

Approach angle	Designation	Dimension (in)					Insert
		dg7	l1	l2	f	Dmin	
95°	A16T SVUNR/L-2.53	1.00	12.0	1.58	.625	1.25	VNMX 2.53x
	A20U SVUNR/L-2.53	1.25	14.0	1.58	.750	1.50	
117.5°	A16T SVQNR/L-2.53	1.00	12.0	1.30	.750	1.30	
	A20U SVQNR/L-2.53	1.25	14.0	1.38	.875	1.65	

Spare parts

Designation	Screw	Shim	Shim screw	Wrench 1	Wrench 2			
VNMX 2.53x								
	TS 30120I/HG	SSVN 2.523	TS 5030062S	T 9(T-9/5)	L-W 3.5			