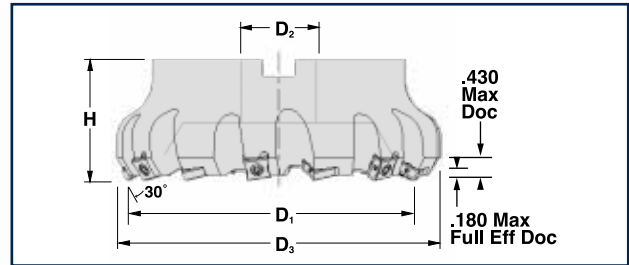
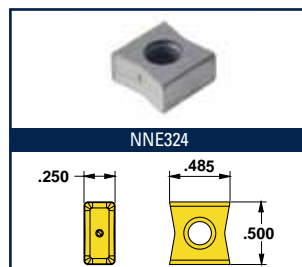


Diameters 2.50" to 12.00"    Cutting Edge Length .180"    Insert Corner .032" x 45°



D <sub>1</sub> Effective Diameter	New Cutter Number	Old Cutter Number	Number of Inserts	H Height	D <sub>2</sub> Bore Diameter	Bolt Circle	D <sub>3</sub> Overall Diameter
2.500	VM6V-02R25	6M6V-02R25	6	2.375	1.000	-	2.970
3.000	VM6V-03R01	6M6V-03R01	8	2.375	1.000	-	3.470
4.000	VM6V-04R01	6M6V-04R01	10	2.375	1.500	-	4.470
5.000	VM6V-05R01	6M6V-05R01	12	2.375	1.500	-	5.470
6.000	VM6V-06R01	6M6V-06R01	14	2.375	1.500	-	6.470
8.000	VM6V-08R01	6M6V-08R01	18	2.375	2.500	4.00	8.470
10.000	VM6V-10R01	6M6V-10R01	22	2.375	2.500	4.00	10.470
12.000	VM6V-12R01	6M6V-12R01	26	2.375	2.500	4.00, 7.00	12.470

### INSERTS (30°)



Insert Number	Corner	Grades				
		IN	2015	2030	2040	6515
NNE324-110	(2x) .031" x 45°	■	■	■	■	■

Will also accept NNE324-100, NNE432-102 but surface finish will be affected.

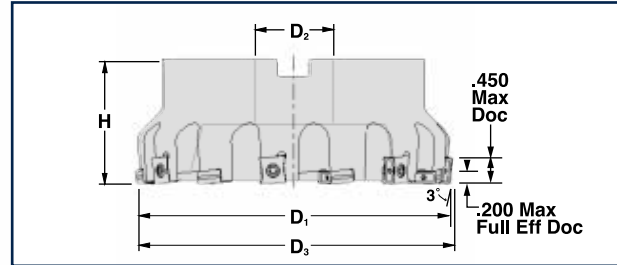
### HARDWARE

Insert Screw		Driver
Part No.	Torque	Part No.
SM40-120-20 (SE02-81)	25-30 in. lbs.	DS-T15T (Tx-15)

# 3° FACE MILL SERIES VL6V

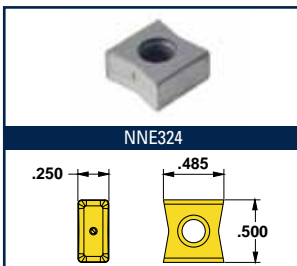


Diameters 2.50" to 12.00"  
 Cutting Edge Length .200"  
 Insert Corner .031"R



D <sub>1</sub> Effective Diameter	New Cutter Number	New Cutter Number	Number of Inserts	H Height	D <sub>2</sub> Bore Diameter	Bolt Circle	D <sub>3</sub> Overall Diameter
2.500	VL6V-02R25	6L6V-02R25	6	2.375	1.000	-	2.589
3.000	VL6V-03R01	6L6V-03R01	8	2.375	1.000	-	3.089
4.000	VL6V-04R01	6L6V-04R01	10	2.375	1.500	-	4.089
5.000	VL6V-05R01	6L6V-05R01	12	2.375	1.500	-	5.089
6.000	VL6V-06R01	6L6V-06R01	14	2.375	1.500	-	6.089
8.000	VL6V-08R01	6L6V-08R01	18	2.375	2.500	4.00	8.089
10.000	VL6V-10R01	6L6V-10R01	22	2.375	2.500	4.00	10.089
12.000	VL6V-12R01	6L6V-12R01	26	2.375	2.500	4.00, 7.00	12.089

## INSERTS (3°)



Insert Number	Corner	Grades				
		IN	2005	2015	2030	2040
NNE324R107	.031R	■	■	■	■	■

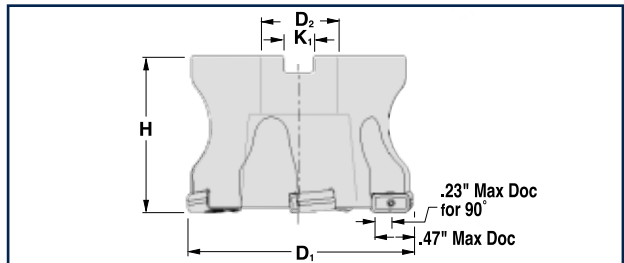
Will also accept NNE324-100, NNE432-102 but surface finish will be affected.

## HARDWARE

Insert Screw		Driver
Part No.	Torque	Part No.
SM40-120-20 (SE02-81)	25-30 in. lbs.	DS-T15T (Tx-15)

A comprehensive selection of standard metric tools of this cutter series is available. Contact your sales agent for more information. The metric tools utilize the same inserts.

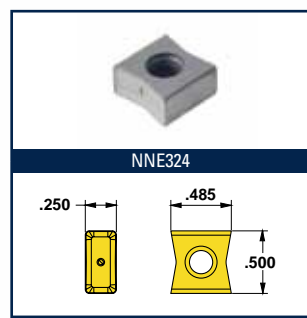
Diameters 2.00" to 6.00"  
 Cutting Edge Length .47"  
 Insert Corner .031", .063", .125"R  
 .23" or less for 90° shoulder



D <sub>1</sub> Nominal Diameter	New Cutter Number	K <sub>1</sub> Keyway	Number of Inserts	H Height	D <sub>2</sub> Bore Diameter	Retention Bolt
<b>Right-Hand Rotation</b>						
2.00	VHU-20015D1R01	.32	4	1.570	.750	SD06-46
2.50	VHU-25015D1R01	.32	5	1.570	.750	SD06-46
3.00	VHU-30020D3R01	.38	5	2.000	1.000	SD08-47
4.00	VHU-4001958R01	.63	7	1.970	1.500	-
5.00	VHU-5001958R01	.63	9	1.970	1.500	-
6.00	VHU-6001958R01	.63	11	1.970	1.500	-
<b>Left-Hand Rotation</b>						
2.00	VHU-20015D1L01	.32	4	1.570	.750	SD06-46
2.50	VHU-25015D1L01	.32	5	1.570	.750	SD06-46
3.00	VHU-30020D3L01	.38	5	2.000	1.000	SD08-47
4.00	VHU-4001958L01	.63	7	1.970	1.500	-
5.00	VHU-5001958L01	.63	9	1.970	1.500	-
6.00	VHU-6001958L01	.63	11	1.970	1.500	-

\*Can be used with **INNOFIT** system. **Note:** RH plungers can use remaining insert edges from a RH 0° lead 6K6V, 6K5V or 4W2A cutter. If using long edge V-Max use a RH insert in a LH tool and a LH insert in a RH tool.

### INSERTS (Plunge)



Insert Number	Corner	Grades					
		IN	1530	2005	2015	2030	2040
NNE324-100	.031R	■	■	■	■	■	■
NNE324-102	.063R			■	■	■	■
NNE324-125	.125R				■		

### HARDWARE

Insert Screw		Driver	
Part No.	Torque	Part No.	
SM40-120-20 (SE02-81)	25-30 in. lbs.	DS-T15T (Tx-15)	

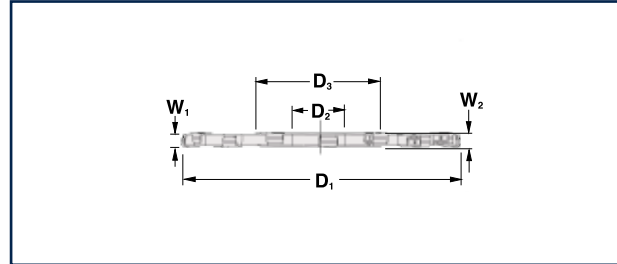
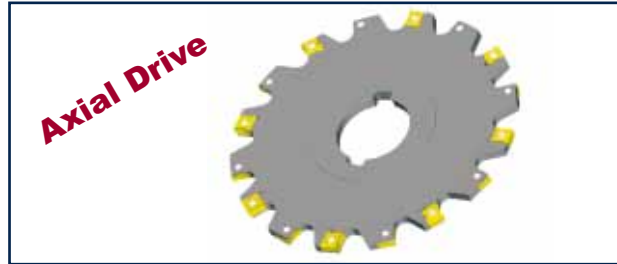
# MEDIUM DENSITY FACE MOUNT SLOTTERS SERIES 3VL5



Diameters  
4.000" to 8.000"

Width of Cut  
.375" and .500"

Insert Corner  
.031"R

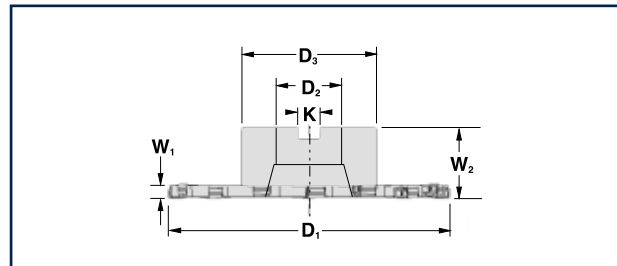


$W_1$ Cutter Width	$D_1$ Nominal Diameter	New Cutter Number	Old Cutter Number	$D_2$ Bore Diameter	$W_2$ Hub Width	$D_3$ Hub Diameter	K Keyway	Number of Effective Inserts
.375	4.000	<b>3VL5-04037AG-01</b>	36L5V-04037AG-01	1.250	.375	2.25	.32	5
.500	4.000	<b>3VL5-04037AG-01</b>	36L5V-04037AG-01	1.250	.500	2.25	.32	5
.375	5.000	<b>3VL5-05037AH-01</b>	36L5V-05037AH-01	1.500	.375	2.75	.38	6
.500	5.000	<b>3VL5-05050AH-01</b>	36L5V-05050AH-01	1.500	.500	2.75	.38	6
.375	6.000	<b>3VL5-06037AH-02</b>	36L5V-06037AH-02	1.500	.375	2.75	.38	7
.500	6.000	<b>3VL5-06050AH-02</b>	36L5V-06050AH-02	1.500	.500	2.75	.38	7
.375	8.000	<b>3VL5-08037AK-01</b>	36L5V-08037AK-01	2.000	.375	3.50	.50	8
.500	8.000	<b>3VL5-08050AK-01</b>	36L5V-08050AK-01	2.000	.500	3.50	.50	8

Diameters  
4.000" to 8.000"

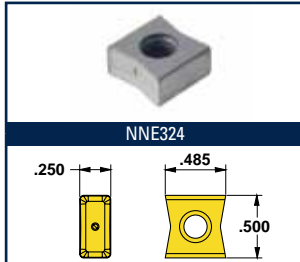
Width of Cut  
.375" and .500"

Insert Corner  
.031"R



$W_1$ Cutter Width	$D_1$ Nominal Diameter	New Cutter Number	Old Cutter Number	$D_2$ Bore Diameter	$W_2$ Hub Width	$D_3$ Hub Diameter	K Keyway	Number of Effective Inserts
.375	4.000	<b>3VL5-04037D3R01</b>	36L5V-04037D3R01	1.000	1.50	2.00	.38	5
.500	4.000	<b>3VL5-04050D3R01</b>	36L5V-04050D3R01	1.000	1.50	2.00	.38	5
.375	5.000	<b>3VL5-05037D3R01</b>	36L5V-05037D3R01	1.000	1.50	2.75	.38	6
.500	5.000	<b>3VL5-05050D3R01</b>	36L5V-05050D3R01	1.000	1.50	2.75	.38	6
.375	6.000	<b>3VL5-0603758R02</b>	36L5V-0603758R02	1.500	2.00	3.80	.63	7
.500	6.000	<b>3VL5-0605058R02</b>	36L5V-0605058R02	1.500	2.00	3.80	.63	7
.375	8.000	<b>3VL5-0803758R01</b>	36L5V-0803758R01	1.500	2.00	3.80	.63	8
.500	8.000	<b>3VL5-0805058R01</b>	36L5V-0805058R01	1.500	2.00	3.80	.63	8

## INSERTS (Slotting)



NNE324

Insert Number	Corner	Grades			
		IN	2015	2030	2040
NNE324-108	.031R	■	■	■	

## HARDWARE

Insert Screw		Driver
Part No.	Torque	Part No.
SM40-120-00 (SE02-75)	25-30 in. lbs.	DS-T15T (Tx-15)

**PRODUCT-UPDATE**

**NNE324-108 Insert (shown above) utilizes a wiper flat to extend tool life and provide exceptional side wall finish when slotting.**

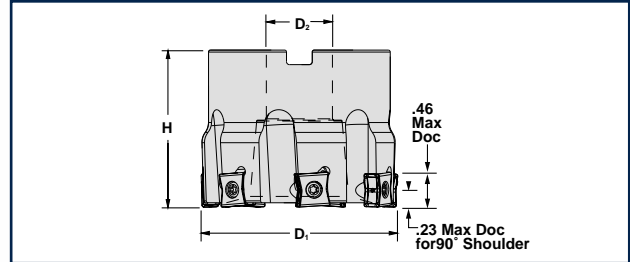
# 0° COARSE-DENSITY FACE MILL SERIES VK6V



Diameters  
2.00" to 12.00"

Cutting Edge Length  
.46"  
.23" (4RH/4LH)

Insert Corner  
.031", .063", .125"R and  
.031" x 45° chamfer

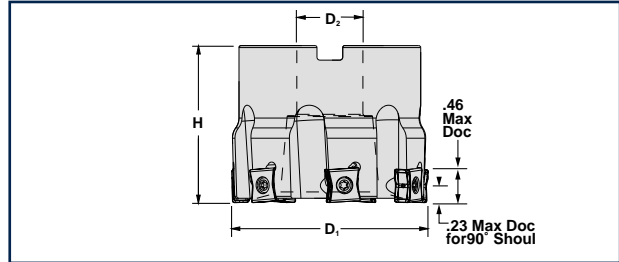


D <sub>1</sub> Effective Diameter	New Cutter Number	Old Cutter Number	Number of Inserts	H Height	D <sub>2</sub> Bore Diameter	Bolt Circle	Keyway
<b>Coarse Density - Right-Hand Rotation</b>							
2.000	VK6V-02R02	6K6V-02R02	3	1.570	0.750	-	.32
3.000	VK6V-03R02	6K6V-03R02	5	2.375	1.000	-	.38
4.000	VK6V-04R02	6K6V-04R02	6	2.375	1.500	-	.63
6.000	VK6V-06R02	6K6V-06R02	8	2.375	1.500	-	.63
8.000	VK6V-08R02	6K6V-08R02	10	2.375	2.500	4.00	1.00
10.000	VK6V-10R02	6K6V-10R02	12	2.375	2.500	4.00, 7.00	1.00
12.000	VK6V-12R02	6K6V-12R02	14	2.375	2.500	4.00, 7.00	1.00
<b>Coarse Density - Left-Hand Rotation</b>							
2.000	VK6V-02L02	6K6V-02L02	3	1.570	0.750	-	.32
3.000	VK6V-03L02	6K6V-03L02	5	2.375	1.000	-	.38
4.000	VK6V-04L02	6K6V-04L02	6	2.375	1.500	-	.63
6.000	VK6V-06L02	6K6V-06L02	8	2.375	1.500	-	.63
8.000	VK6V-08L02	6K6V-08L02	10	2.375	2.500	4.00	1.00
10.000	VK6V-10L02	6K6V-10L02	12	2.375	2.500	4.00, 7.00	1.00
12.000	VK6V-12L02	6K6V-12L02	14	2.375	2.500	4.00, 7.00	1.00

Diameters  
2.00" to 12.00"

Cutting Edge Length  
.46"  
.25" (4RH/4LH)

Insert Corner  
.031", .063", .125"R and  
.031" x 45° chamfer

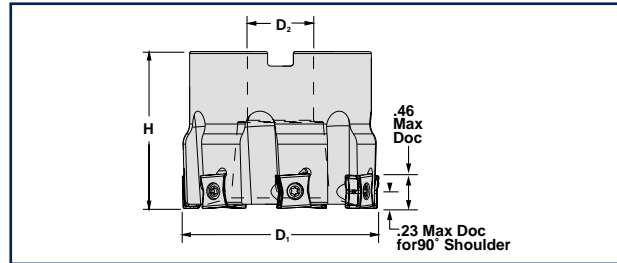


D <sub>1</sub> Effective Diameter	New Cutter Number	Old Cutter Number	Number of Inserts	H Height	D <sub>2</sub> Bore Diameter	Bolt Circle	Keyway
<b>Medium Density - Right-Hand Rotation</b>							
2.000	VK6V-02R01	6K6V-02R01	5	1.570	0.750	-	.32
2.500	VK6V-02R25	6K6V-02R25	6	1.570	1.000	-	.38
3.000	VK6V-03R01	6K6V-03R01	8	2.375	1.000	-	.38
4.000	VK6V-04R01	6K6V-04R01	9	2.375	1.500	-	.63
5.000	VK6V-05R01	6K6V-05R01	10	2.375	1.500	-	.63
6.000	VK6V-06R01	6K6V-06R01	13	2.375	1.500	-	.63
8.000	VK6V-08R01	6K6V-08R01	16	2.375	2.500	4.00	1.00
10.000	VK6V-10R01	6K6V-10R01	20	2.375	2.500	4.00, 7.00	1.00
12.000	VK6V-12R01	6K6V-12R01	24	2.375	2.500	4.00, 7.00	1.00
<b>Medium Density - Left-Hand Rotation</b>							
2.000	VK6V-02L01	6K6V-02L01	5	1.570	0.750	-	.32
2.500	VK6V-02L25	6K6V-02L25	6	1.570	1.000	-	.38
3.000	VK6V-03L01	6K6V-03L01	8	2.375	1.000	-	.38
4.000	VK6V-04L01	6K6V-04L01	9	2.375	1.500	-	.63
5.000	VK6V-05L01	6K6V-05L01	10	2.375	1.500	-	.63
6.000	VK6V-06L01	6K6V-06L01	13	2.375	1.500	-	.63
8.000	VK6V-08L01	6K6V-08L01	16	2.375	2.500	4.00	1.00
10.000	VK6V-10L01	6K6V-10L01	20	2.375	2.500	4.00, 7.00	1.00
12.000	VK6V-12L01	6K6V-12L01	24	2.375	2.500	4.00, 7.00	1.00

# 0° HI-DENSITY FACE MILL SERIES VK5V



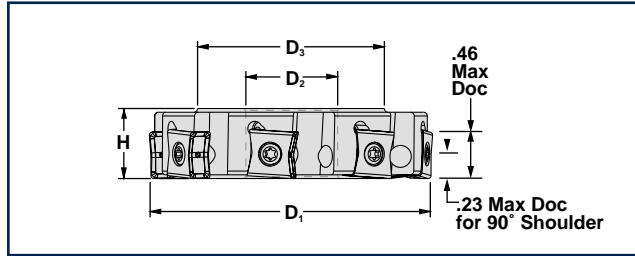
Diameters 2.00" to 12.00"	Cutting Edge Length .46" .23" (4RH/4LH)	Insert Corner .031", .063", .125R and .031" x 45° chamfer
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D <sub>1</sub> Effective Diameter	New Cutter Number	Old Cutter Number	Number of Inserts	H Height	D <sub>2</sub> Bore Diameter	Bolt Circle	Keyway
<b>High Density - Right-Hand Rotation</b>							
2.000	VK5V-02R01	6K5V-02R01	6	1.570	0.750	-	.32
2.500	VK5V-02R25	6K5V-02R25	8	1.570	1.000	-	.38
3.000	VK5V-03R01	6K5V-03R01	10	2.375	1.000	-	.38
4.000	VK5V-04R01	6K5V-04R01	13	2.375	1.500	-	.63
5.000	VK5V-05R01	6K5V-05R01	16	2.375	1.500	-	.63
6.000	VK5V-06R01	6K5V-06R01	21	2.375	1.500	-	.63
8.000	VK5V-08R01	6K5V-08R01	26	2.375	2.500	4.00	1.00
10.000	VK5V-10R01	6K5V-10R01	32	2.375	2.500	4.00, 7.00	1.00
12.000	VK5V-12R01	6K5V-12R01	38	2.375	2.500	4.00, 7.00	1.00
<b>High Density - Left-Hand Rotation</b>							
2.000	VK5V-02L01	6K5V-02L01	6	1.570	0.750	-	.32
2.500	VK5V-02L25	6K5V-02L25	8	1.570	1.000	-	.38
3.000	VK5V-03L01	6K5V-03L01	10	2.375	1.000	-	.38
4.000	VK5V-04L01	6K5V-04L01	13	2.375	1.500	-	.63
5.000	VK5V-05L01	6K5V-05L01	16	2.375	1.500	-	.63
6.000	VK5V-06L01	6K5V-06L01	21	2.375	1.500	-	.63
8.000	VK5V-08L01	6K5V-08L01	26	2.375	2.500	4.00	1.00
10.000	VK5V-10L01	6K5V-10L01	32	2.375	2.500	4.00, 7.00	1.00
12.000	VK5V-12L01	6K5V-12L01	38	2.375	2.500	4.00, 7.00	1.00

A comprehensive selection of standard metric tools of this cutter series is available. Contact your sales agent for more information. The metric tools utilize the same inserts.

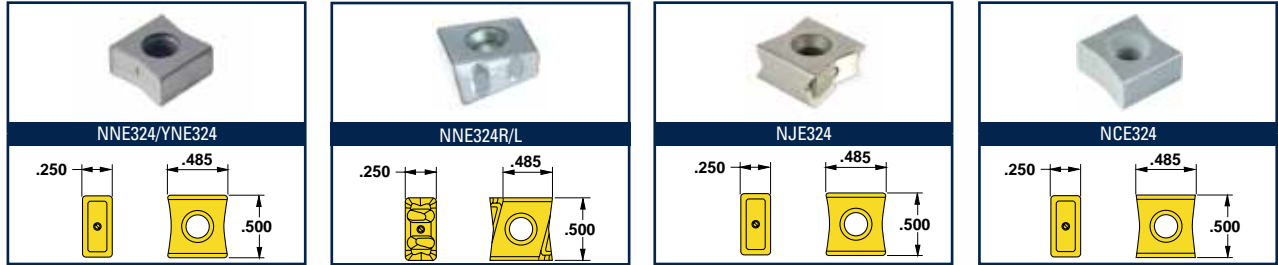
Diameters 3.00" to 10.00"  
 Cutting Edge Length .46"  
 .23" (4RH/4LH)  
 Insert Corner .031", .063", .125R and  
 .031" x 45° chamfer



D <sub>1</sub> Effective Diameter	New Cutter Number	Old Cutter Number	Number of Inserts	H Height	D <sub>2</sub> Bore Diameter	D <sub>3</sub> Mounting Diameter
<b>Right-Hand Rotation</b>						
3.000	5V6K-03075AFR01	56K6V-03075AFR01	8	0.750	1.000	2.00
4.000	5V6K-04075AHR01	56K6V-04075AHR01	9	0.750	1.500	2.75
5.000	5V6K-05075AHR01	56K6V-05075AHR01	10	0.750	1.500	2.75
6.000	5V6K-06075AHR01	56K6V-06075AHR01	13	0.750	1.500	2.75
8.000	5V6K-08075AKR01	56K6V-08075AKR01	16	0.750	2.00	4.00
10.000	5V6K-10075AKR01	56K6V-10075AKR01	20	0.750	2.00	4.00
<b>Left-Hand Rotation</b>						
3.000	5V6K-03075AFL01	56K6V-03075AFL01	8	0.750	1.000	2.00
4.000	5V6K-04075AHL01	56K6V-04075AHL01	9	0.750	1.500	2.75
5.000	5V6K-05075AHL01	56K6V-05075AHL01	10	0.750	1.500	2.75
6.000	5V6K-06075AHL01	56K6V-06075AHL01	13	0.750	1.500	2.75
8.000	5V6K-08075AKL01	56K6V-08075AKL01	16	0.750	2.00	4.00
10.000	5V6K-10075AKL01	56K6V-10075AKL01	20	0.750	2.00	4.00

Product Note: Full and half pitch axial Keyway on stock tools

INSERTS (0° Lead)



Insert Number	Application	Corner	Cut Edge Configuration	Grades											
				IN	2005	2010	2030	2015	2040	1530	6515	15K	70N		
NNE324-100	Multi-Purpose	.031R	4RH/4LH	■		■	■	■	■	■	■				
NNE324-102	Multi-Purpose	.063R	4RH/4LH				■	■	■				■		
NNE324-104	Multi-Purpose	.031 x 45°	4RH/4LH			■		■							
NNE324-125	Multi-Purpose	.125R	4RH/4LH				■								
YNE324-100	Wiper	.031R	2RH/2LH				■	■	■				■		
NNE324R109	Multi-Purpose	.031R	4RH	■	■	■	■	■	■				■		
NNE324L109	Multi-Purpose	.031R	4LH	■	■	■	■	■	■				■		
NJE324-100-P	Aluminum	.031R	4RH/4LH (Polished)												■
NCE324-100	Iron	.031R	4RH/4LH (SiNit)												■

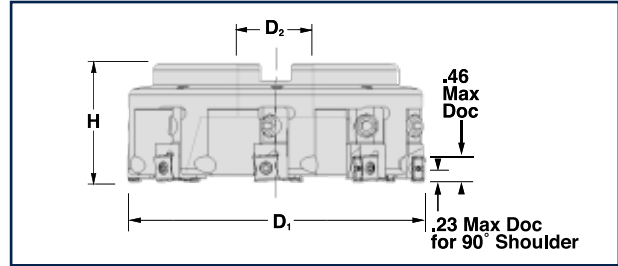



# MULTIPLE GEOMETRY CARTRIDGE FACE MILL SERIES 4W2A

Diameters  
4.00" to 12.00"

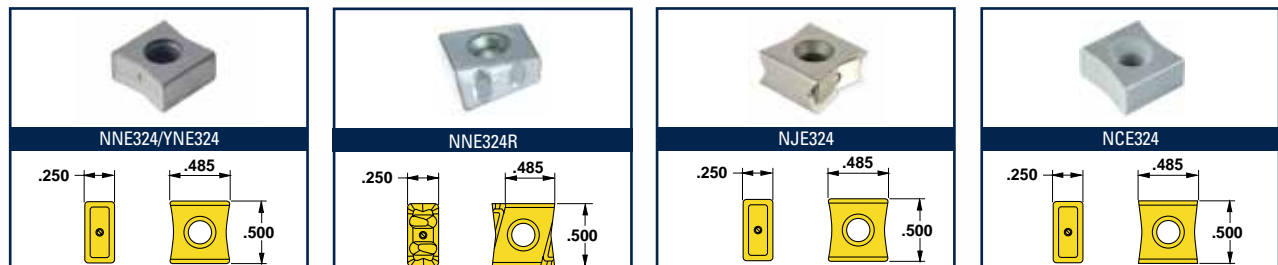
Cutting Edge Length  
.46"  
.23" (4RH/4LH)


Insert Corner  
.031", .063", .125R and  
.031" x 45° chamfer



Insert Style	D <sub>1</sub> Nom. Dia.	New Cutter Number	Assembly Components		Number of Inserts	H Height	D <sub>2</sub> Bore Dia.	Bolt Circle	Weight with Cartridges	Stock
			Cartridge Number	Body Number						
	4.00	<b>4W2A-04A07</b>	52K-11R02	4W2A-04R01	6	2.460	1.500	—	4.11 lbs.	2
	6.00	<b>4W2A-06A07</b>	52K-11R02	4W2A-06R01	8	2.460	1.500	—	10.13 lbs.	2
	8.00	<b>4W2A-08A07</b>	52K-11R02	4W2A-08R01	10	2.460	2.500	4.00	17.11 lbs.	2
	10.00	<b>4W2A-10A07</b>	52K-11R02	4W2A-10R01	12	2.460	2.500	4.00	28.7 lbs.	2
	12.00	<b>4W2A-12A07</b>	52K-11R02	4W2A-12R01	14	2.460	2.500	4.00, 7.00	39.15 lbs.	2

## INSERT/HARDWARE CONFIGURATIONS



Cartridge Style	Insert Number	Application	Corner	Cut Edge Configuration	Grades									
					IN	2005	2010	2030	2015	2040	1530	6515	15K	70N
	<b>NNE324-100</b>	Multi-Purpose	.031R	4RH/4LH	■		■	■	■	■	■			
	<b>NNE324-102</b>	Multi-Purpose	.063R	4RH/4LH				■	■	■				
	<b>NNE324-104</b>	Multi-Purpose	.031 x 45°	4RH/4LH			■		■					
	<b>NNE324-125</b>	Multi-Purpose	.125R	4RH/4LH				■						
	<b>YNE324-100</b>	Wiper	.031R	2RH/2LH				■	■	■				
	<b>NNE324R109</b>	Multi-Purpose	.031R	4RH		■	■	■	■	■				
	<b>NJE324-100-P</b>	Aluminum	.031R	4RH/4LH (Polished)										■
	<b>NCE324-100</b>	Iron	.031R	4RH/4LH (SiNit)										■

**Product Note:** See standard Ingersoll catalog for other cartridge and insert combinations available that fit same cutter body.