

# VIT

VERMONT INDEXABLE TOOLING



**WORLD CLASS  
INDEXABLE CUTTING TOOLS**

**INDEXABLE CATALOG**

**PROUDLY MADE IN THE USA**



**VERMONT INDEXABLE TOOLING**

IT'S NOT JUST WHAT WE DO, IT'S WHAT WE DO BEST

## **GUARANTEE**

Vermont Indexable Tooling guarantees precision and perfection for the best quality product and enthusiastic service. Continuous improvement of our product, system, and company assures customer satisfaction. We guarantee if the tool is not made to specification, the tool will be replaced at no additional charge.

## **POLICIES**

**Conditions of Sale:** VIT's tool warranty is limited to workmanship and materials. Tool / cutter is supplied complete less inserts. Should an order be cancelled for any reason, all incurred costs will be passed onto purchaser.

**Terms of Payment:** MasterCard, American Express and Visa are accepted. Terms 2% 10 days Net 30.

**Minimum Order:** \$50.00

**Delivery:** Stock tools typically ship next business day. Custom tool delivery is as quoted. All shipping is FOB Factory.

### **Returns:**

- Stock tools or inserts in unused condition, returns will be accepted within 30 days of purchase. Full credit minus shipping will be issued.
- If stock items are returned after 30 days in unused conditions 25% restocking will apply.
- If damaged, worn, or show any signs of wear/use no credit will be given.
- All returns must have a Factory issued RMA number.
- Custom tools are non-returnable.

## **SAFETY PRECAUTIONS:**

Cutting tools can break or shatter. Always wear the proper personal protective equipment when performing metal cutting operations. Cutting tools have sharp edges. Use caution while handling cutting tools to avoid injury.

126 JACKSON ST. • RED BUD IL 62278 • VERMONTINDEXABLE.COM

**TO ORDER: CALL: 800.639.1616 FAX: 618.282.6898 EMAIL: SALES@VERMONTINDEXABLE.COM**

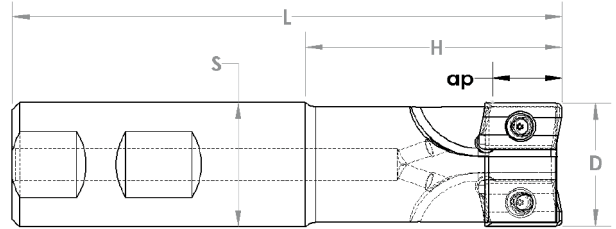


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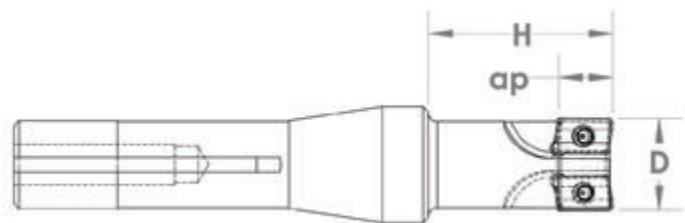
## SSEM SERIES—SQUARE SHOULDER END MILL

- Standard coolant thru Weldon shank bodies ONLY
- APET AND XPET inserts feature high positive geometry for aggressive material removal rates with lower horsepower consumption and strong edge prep for heavy chip loads
- Applications: Facing, milling, slotting, helical interpolation, roughing, pocketing, profiling
- 2 x D



### Weldon Shank - Coolant Style

Part #	EDP#	(D)	(ap)	# of Flutes	(S)	(L)	(H)	Insert
SSEM0500-0500-3501	V12000	.500"	.35"	1	.500"	2.91"	1.00"	APET or XPET 1003...
SSEM0625-0750-3502	V12001	.625"	.35"	2	.750"	3.28"	1.25"	APET or XPET 1003...
SSEM0750-0750-3502	V12002	.750"	.35"	2	.750"	3.53"	1.50"	APET or XPET 1003...
SSEM1000-1000-5502	V12003	1.000"	.55"	2	1.000"	4.28"	2.00"	APET or XPET 1604...
SSEM1250-1250-5503	V12004	1.250"	.55"	3	1.250"	4.78"	2.50"	APET or XPET 1604...
SSEM1500-1250-5503	V12005	1.500"	.55"	3	1.250"	5.28"	3.00"	APET or XPET 1604...
SSEM2000-1500-5504	V12006	2.000"	.55"	4	1.500"	6.69"	4.00"	APET or XPET 1604...

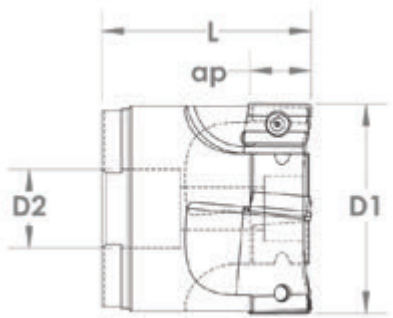


### R8 Shank

Part #	EDP#	(D)	(ap)	# of Flutes	(S)	(H)	Insert
SSEM0500-R8-3501	V12007	.500"	.35"	1	R8	1.00"	APET or XPET 1003...
SSEM0625-R8-3502	V12008	.625"	.35"	2	R8	1.25"	APET or XPET 1003...
SSEM0750-R8-3502	V12009	.750"	.35"	2	R8	1.50"	APET or XPET 1003...
SSEM1000-R8-5502	V12010	1.000"	.55"	2	R8	2.00"	APET or XPET 1604...

## SSFM SERIES—SQUARE SHOULDER FACE MILL

- APET AND XPET inserts feature high positive geometry for aggressive material removal rates with lower horsepower consumption and strong edge prep for heavy chip loads
- **Applications:** Facing, milling, slotting, helical interpolation, roughing, pocketing, profiling



### Shell Mill Mount

Part #	EDP#	(D)	(ap)	# of Flutes	(D2)	(L)	Insert
SSFM1500-0750SM-5503	V12011	1.500"	.55"	3	.750"	2.00	APET or XPET 1604...
SSFM2000-0750SM-5504	V12012	2.000"	.55"	4	.750"	2.00	APET or XPET 1604...
SSFM2500-0750SM-5505	V12013	2.500"	.55"	5	.750"	2.00	APET or XPET 1604...
SSFM3000-1000SM-5505	V12014	3.000"	.55"	5	1.000"	2.25	APET or XPET 1604...
SSFM4000-1000SM-5506	V12015	4.000"	.55"	6	1.000"	2.25	APET or XPET 1604...
SSFM5000-1500SM-5507	V12016	5.000"	.55"	7	1.500"	2.50	APET or XPET 1604...
SSFM6000-1500SM-5508	V12017	6.000"	.55"	8	1.500"	2.50	APET or XPET 1604...
SSFM8000-1500SM-5508	V12018	8.000"	.55"	8	1.500"	2.50	APET or XPET 1604...

### R8 Shank

Part #	EDP#	(D)	(ap)	# of Flutes	(S)	(H)	Insert
SSFM2000-R8-5504	V12069	2.000"	.55"	4	R8	2.00"	APET or XPET 1604...
SSFM3000-R8-5505	V12070	3.000"	.55"	5	R8	2.00"	APET or XPET 1604...

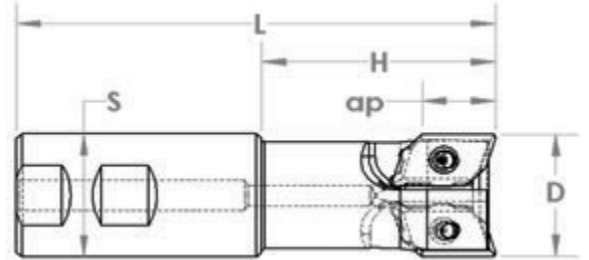
*Note: For tool R8 Shank tool description see bottom of page 4*

### Hardware for Square Shoulder End Mills or Face Mills

INSERT	SCREW
APET or XPET 1003...	F663
APET or XPET 1604...	F899

# SSRM SERIES- SQUARE SHOULDER ROUTER MILL

- Standard coolant thru bodies - **Weldon Shanks Only**
- **Applications:** milling, slotting, helical interpolation, facing
- Best Suited for high speed, high shear, **Aluminum Applications**
- **2 x D**



## Weldon Shank - Coolant Style

Part #	EDP#	(D)	(ap)	# of Flutes	(S)	(L)	(H)	Insert
SSRM1000-1000-6252	V12020	1.000"	.62"	2	1.000"	4.28"	2.00"	XEGT 00903...
SSRM1250-1250-6252	V12022	1.250"	.62"	2	1.250"	4.78"	2.50"	XEGT 00903...
SSRM1500-1250-6253	V12023	1.500"	.62"	3	1.250"	5.28"	3.00"	XEGT 00903...
SSRM1500-1250-7812	V12024	1.500"	.78"	2	1.250"	5.28"	3.00"	XEGT 01609...
SSRM40MM-1250-6253	V12025	40mm	.62"	3	1.250"	5.41"	3.13"	XEGT 00903...
SSRM40MM-1250-7812	V12026	40mm	.78"	2	1.250"	5.41"	3.13"	XEGT 01609...
SSRM2000-1500-7813	V12027	2.000"	.78"	3	1.500"	6.69"	4.00"	XEGT 01609...
SSRM60MM-1500-7813	V12028	60mm	.78"	3	1.500"	7.44"	4.75"	XEGT 01609...

## Shell Mill Mount

Part #	EDP#	(D)	(ap)	# of Flutes	(S)	(L)	Insert
SSRM40MM-0750SM-6253	V12029	40mm	.62"	3	.750	2.25"	XEGT 00903...
SSRM2000-0750SM-7813	V12030	2.000"	.78"	3	.750	2.25"	XEGT 01609...
SSRM60MM-0750SM-7813	V12031	60mm	.78"	3	.750	2.25"	XEGT 01609...
SSRM3000-1000SM-6255	V12032	3.000"	.62"	5	1.000	2.50"	XEGT 00903...
SSRM4000-1000SM-6256	V12033	4.000"	.62"	6	1.000	2.50"	XEGT 00903...
SSRM6000-1500SM-6257	V12034	6.000"	.62"	7	1.500	2.50"	XEGT 00903...

*Note: For tool R8 Shank tool description see bottom of page 4*

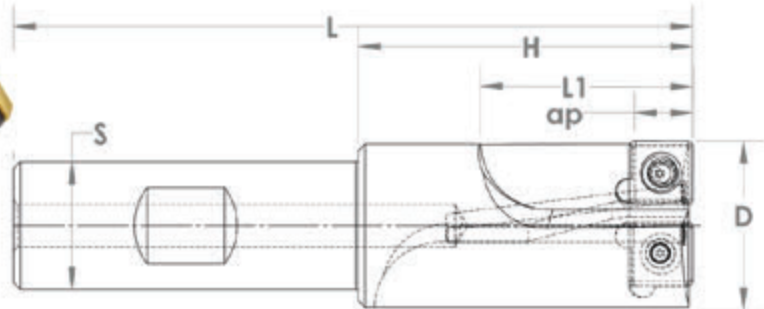
## Hardware for Router Mill

INSERT	SCREW
XEGT 00903...	F1109
XEGT 01609...	F704



## PM SERIES—PLUNGE MILL / DRILL MILL

- Applications: Drilling, Plunging, Milling, Slotting, Helical Interpolation, Shoulder Milling, Contours, Facing, Core Drilling, Boring
- Center cut end milling



### Weldon Shank - Coolant Style

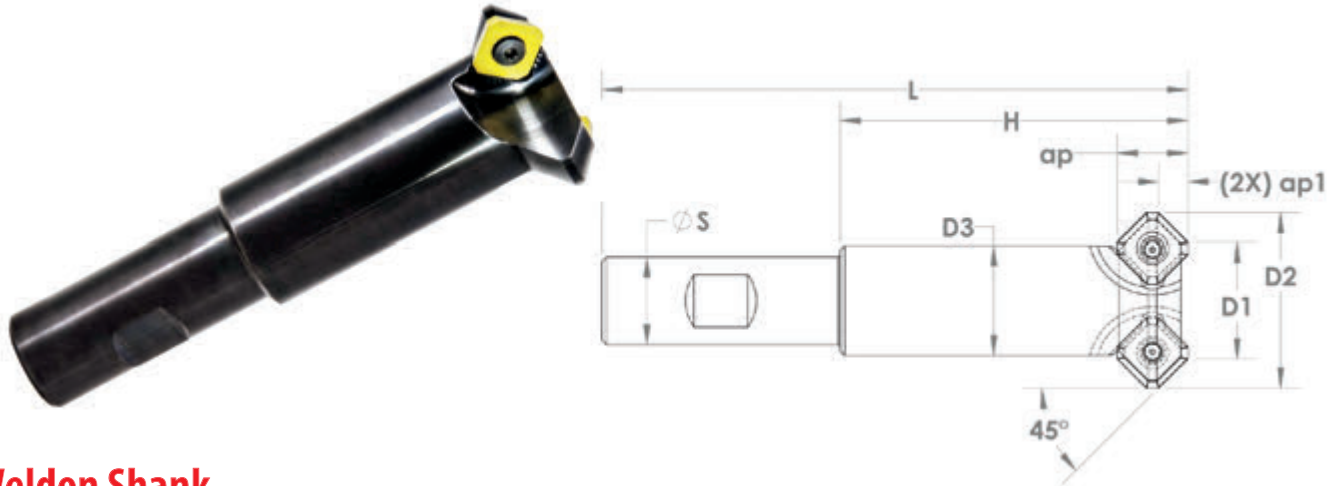
Part #	EDP#	(D)	(ap)	# of Flutes	(S)	(L)	(H)	(L1)	Insert
PM0480-0500-0001	V12035	.480"	.23"	1	.500"	3.03"	1.25"	.67"	SECW 21.21
PM0605-0625-0001	V12036	.605"	.29"	1	.625"	3.41"	1.50"	.74"	SECW 2.51.51
PM0750-0750-0002	V12037	.750"	.29"	2	.750"	4.22"	2.19"	1.05"	SECW 2.51.51
PM0875-0750-0002	V12038	.875"	.29"	2	.750"	4.41"	2.38"	1.05"	SECW 2.51.51
PM1000-1000-0002	V12039	1.000"	.34"	2	1.000"	4.66"	2.38"	1.36"	SD-322P
PM1125-1000-0002	V12040	1.125"	.34"	2	1.000"	4.78"	2.50"	1.36"	SD-322P
PM1250-1250-0002	V12042	1.250"	.47"	2	1.250"	5.03"	2.75"	1.69"	SD-422P
PM1500-1250-0002	V12044	1.500"	.59"	2	1.250"	6.03"	3.75"	1.73"	SD-532P
PM1625-1250-0002	V12046	1.625"	.59"	2	1.250"	6.28"	4.00"	1.73"	SD-532P
PM1750-1250-0002	V12047	1.750"	.59"	2	1.250"	6.53"	4.25"	1.73"	SD-532P
PM1875-1250-0002	V12048	1.875"	.59"	2	1.250"	6.78"	4.50"	1.73"	SD-532P
PM2000-1250-0002	V12049	2.000"	.59"	2	1.250"	6.78"	4.50"	1.73"	SD-532P

### Hardware for Plunge Mill/Drill Mill

INSERT	SCREW
SECW 21.21	F663
SECW 2.51.51	F708
SD-322P	F1099
SD-422P	F610
SD-532P	F1185

## ACM SERIES—ANGLE & CHAMFER MILL

- 45° Chamfering—Top and/or Bottom, Back and/or Front, Angle Roughing, Face Milling, Slotting, etc.
- Positive Shear design for lessening tool pressures in all cutting applications



### Weldon Shank

Part #	EDP#	(D1)	(D2)	(D3)	(ap)	(ap1)	(S)	(L)	(H)	Insert	Qty. of Inserts
ACM1500-0750-50002	V12050	1.000"	1.500"	.938"	.60"	.25	.750"	5.00"	2.97"	SXEX 42A	2
ACM2000-1000-60003	V12051	1.500"	2.000"	1.438"	.60"	.25	1.000"	6.00"	3.72"	SXEX 42A	3
ACM2500-1250-70003	V12052	2.000"	2.500"	1.938"	.60"	.25	1.250"	7.00"	4.72"	SXEX 42A	3

### Shell Mill Mount

Part #	EDP#	(D1)	(D2)	(D3)	(ap)	(ap1)	(L)	Pilot Dia.	Insert	Qty. of Inserts
ACM2500-0750-17504SM	V12053	2.000"	2.500"	1.900"	.60"	.25	1.75"	.750"	SXEX 42A	4
ACM3000-0750-20004SM	V12054	2.500"	3.000"	1.900"	.60"	.25	2.00"	.750"	SXEX 42A	4
ACM4000-1000-22505SM	V12055	3.500"	4.000"	2.400"	.60"	.25	2.25"	1.000"	SXEX 42A	5
ACM5000-1000-22505SM	V12056	4.500"	5.000"	2.400"	.60"	.25	2.25"	1.000"	SXEX 42A	5
ACM6000-1250-22506SM	V12057	5.500"	6.000"	2.900"	.60"	.25	2.25"	1.250"	SXEX 42A	6

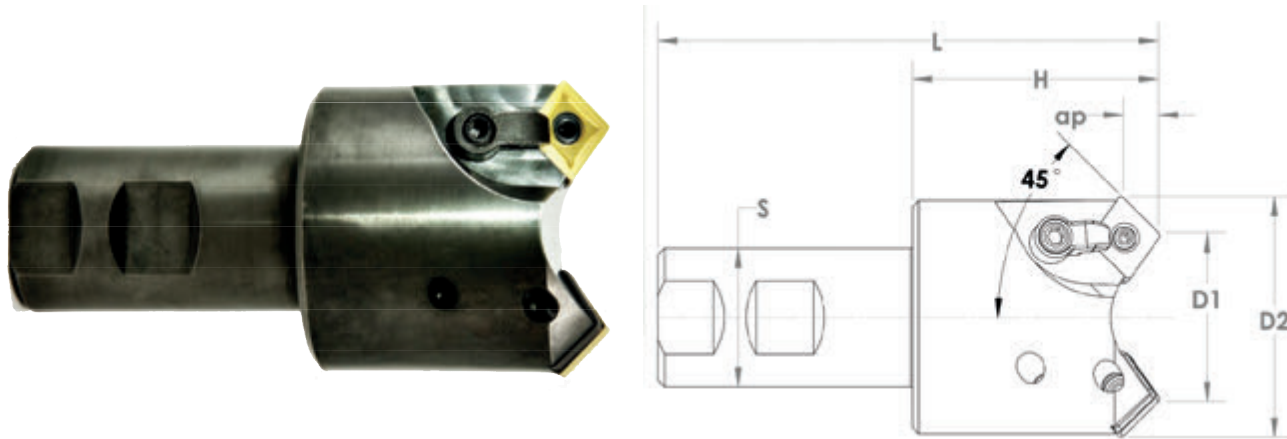
### Hardware for Angle & Chamfer Mill

INSERT	SCREW
SXEX 42A	F610



## WPM SERIES—WELD PREPARATION MILLS

- **Applications: 45° Milling, Chamfering, Roughing, Face Milling, etc**
- This tool designed to utilize 100 deg. corner of a CNMG 432 insert. Recapture unused corners & reduce costs



### Weldon Shank

Part #	EDP#	(D1)	(D2)	(ap)	(S)	(L)	(H)	Insert	Qty. of Inserts
WPM1500-1250-45002	V12058	1.50"	2.16"	.32"	1.250"	4.50"	2.22"	CNMG 432	2
WPM2000-1250-50003	V12059	2.00"	2.66"	.32"	1.250"	5.00"	2.72"	CNMG 432	3
WPM3000-1250-55004	V12060	3.00"	3.66"	.32"	1.250"	5.50"	3.22"	CNMG 432	4

### Shell Mill Mount

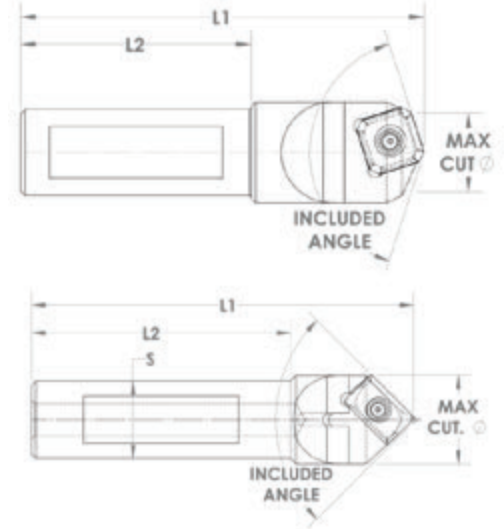
Part #	EDP#	(D1)	(D2)	(ap)	(L)	Pilot Dia.	Insert	Qty. of Inserts
WPM3000-1000-2500SM	V12061	3.00"	3.67"	.32"	2.50"	1.000"	CNMG 432	4
WPM4000-1250-2500SM	V12062	4.00"	4.67"	.32"	2.50"	1.250"	CNMG 432	4
WPM5000-1500-3000SM	V12063	5.00"	5.67"	.32"	3.00"	1.500"	CNMG 432	5
WPM6000-1500-3000SM	V12064	6.00"	6.67"	.32"	3.00"	1.500"	CNMG 432	5

### Hardware for Weld Preparation Mills

INSERT	LOCK PIN	SHIM	CLAMP	CLAMP SCREW
CNMG 432	F1137	M834	F737	F744

## SCT SERIES- SPOT / CENTERING TOOL

- Manual Mills or CNC Spotting, Centering, Slotting
- Manual Lathe or CNC Centering, Facing, Grooving, OD, ID Chamfer
- Unique design to produce a multitude of applications



### Straight Shank - Coolant Style

Part #	EDP#	Tool Description and Included Angle	(L1)	(L2)	Max Cut Dia.	(S)	Insert Description	Screws
SCT0490-0375-2250	V8122	82° - 1/4" IC Insert	2.25"	1.50"	Ø.49	.375"	XEGW 21.5X	F1109
SCT0520-0375-2250	V8120	90° - 1/4" IC insert	2.25"	1.50"	Ø.52	.375"	XEGW 21.5X	F1109
SCT0860-0750-3700	V8000	90° - 3/8" IC Insert	3.70"	2.50"	Ø.86	.750"	XEGW 32X	F575
SCT0860-0750-3700X	V8620	90° - V8000 w/ no flat	3.70"	2.50"	Ø.86	.750"	XEGW 32X	F575
SCT0560-0375-2250	V9150	100° - 1/4" IC insert	2.25"	1.50"	Ø.56	.375"	XEGW 21.5X	F1109
SCT1030-0750-3700	V8172	120° - 3/8" IC Insert	3.70"	2.50"	Ø1.03	.750"	XEGW 32X	F575
SCT0700-0750-3750	V1361	144° - 1/2" IC Insert	3.75"	2.00"	Ø.70	.750"	SXEX 42A	F610

### Hardware for SPOT & Centering Tools

INSERT	SCREW
XEGW 21.5X	F1109
XEGW 32	F575
SXEX 42A	F610

# FCB SERIES—FORWARD COUNTERBORE TOOL

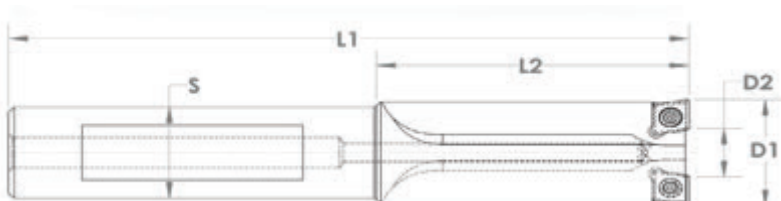
- Standard coolant thru bodies
- **Applications: Plunge Boring on mill or lathe, Counterbore, Spot Face**
- All tools provided complete less Insert (s)

## Straight Shank - Coolant Style

Part #	EDP#	Cap Screw	(D1)	(D2)	(L1)	(L2)	(S)	Insert	# OF FLUTES
FCB0432-0500-3200	V4764	M6	.432"	.118"	3.20	1.20	0.500	CPGT 1.51.21	1
FCB0438-0500-3250	V7900	1/4"	.438"	.266"	3.25	1.25	0.500	CPGT 1.51.21	1
FCB0531-0500-3500	V7901	5/16"	.531"	.328"	3.50	1.50	0.500	CPGT 1.51.21	1
FCB0552-0500-3375	V4765	M8	.552"	.240"	3.37	1.37	0.500	CPGT 1.51.21	1
FCB0561-0500-3375	V13574	M8	.561"	.249	3.37	1.37	0.500	CPGT 1.51.21	1
FCB0625-0750-4125	V7902	3/8"	.625"	.391"	4.12	1.62	0.750	CPGT 1.51.21	2
FCB0679-0750-4060	V7922	M10	.679"	.413"	4.06	1.56	0.750	CPGT 1.51.21	2
FCB0749-0750-4430	V4767	M12	.750"	.315"	4.43	1.93	0.750	CPMT 21.51	2
FCB0781-0750-4500	V3764	1/2"	.781"	.375"	4.50	2.00	0.750	CPMT 21.51	2
FCB0813-0750-4625	V7903	1/2"	.813"	.516"	4.62	2.12	0.750	CPMT 21.51	2
FCB0875-0750-4625	V11021	-	.875"	.516"	4.62	2.12	0.750	CPMT 21.51	2
FCB0987-0750-4800	V4768	M16	.987"	.276"	4.80	2.30	0.750	CPMT 32.51	2
FCB1000-0750-5000	V7904	5/8"	1.000"	.641"	5.00	2.50	0.750	CPMT 32.51	2
FCB1188-1000-5750	V7905	3/4"	1.188"	.766"	5.75	2.75	1.000	CPMT 32.51	2
FCB1250-1000-6000	V11022	-	1.250"	.625"	6.00	3.00	1.000	CPMT 32.51	2
FCB1375-1000-6000	V11023	-	1.375"	.750"	6.00	3.00	1.000	CPMT 32.51	2
FCB1463-1000-5880	V4770	M24	1.463"	.748"	5.88	2.88	1.000	CPMT 32.51	2
FCB1476-1000-5690	V7926	M24	1.476"	.964"	5.69	2.69	1.000	CPMT 32.51	2
FCB1500-1000-5500	V13257	-	1.500"		5.50	2.50	1.00	CPMT 32.51	2
FCB1532-1000-5500	V3767	1"	1.532"	.875"	5.50	2.50	1.000	CPMT 32.51	2
FCB1625-1000-5750	V7906	1"	1.625"	1.016"	5.75	2.75	1.000	CPMT 32.51	2
FCB1750-1000-6000	V11024	-	1.750"	.875"	6.00	3.00	1.000	CCMT 432	2

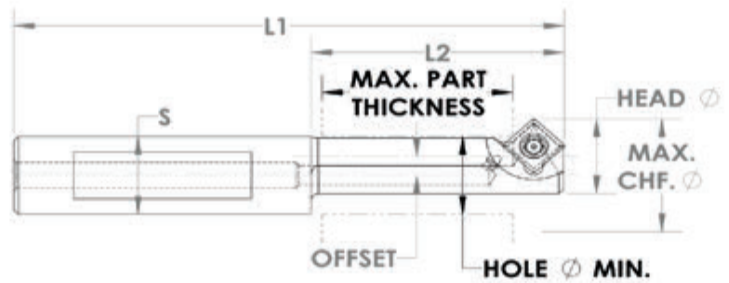
## Hardware for Forward Counterbore Tool

INSERT	SCREW
CPGT 1.51.21	F908
CPMT 21.51	F663
CPMT 32.51	F899
CCMT 432	F704



# BCT SERIES—45° FORWARD & BACK CHAMFER TOOL

- **Applications: 45° Forward or Back Chamfering on variety of hole sizes**
- **Plunging**—Tools are designed with an elliptical neck and is intended for offset entry similar to the offset neck style back spot facing tools
- **Circular Interpolating**—Tools can also be used for front & back chamfering by circular interpolating on thru holes larger than the Max Chamfer Dia.
- **Milling**—Tools can also be used for front & back chamfer milling on the side of a part
- For programming sequence please see page 20



## Straight Shank - Coolant Style PLUNGE Applications:

Part #	EDP#	Max. Chf. Dia.	Min. Thru Hole	Head Dia.	(S)	Offset	(L1)	(L2)	Max. Part Thickness	Insert
BCT0408-0744-0953-45	V12065	Ø.735	Ø.438	Ø.408	Ø.500	.168	3.12"	1.12"	.700"	SECW 21.21
BCT0658-1139-1670-45	V12066	Ø1.121	Ø.688	Ø.658	Ø.750	.241	4.42"	1.92"	1.244	SD-322
BCT1000-1499-2926-45	V12067	Ø1.481	Ø1.048	Ø1.000	Ø1.000	.250	6.18"	3.18"	2.500"	SD-322
BCT1408-1969-3967-45	V12068	Ø1.951	Ø1.438	Ø1.408	Ø1.500	.281	7.31"	4.31"	3.500"	SD-422

## CIRCULAR INTEPOLATION Applications:

Part #	EDP#	Max Chamfer Width	Min. Thru Hole	(S)	(L1)	(L2)	Max. Part Thickness	Insert
BCT0408-0744-0953-45	V12065	.148	Ø.774	Ø.500	3.12"	1.12"	.700"	SECW 21.21
BCT0658-1139-1670-45	V12066	.216	Ø1.169	Ø.750	4.42"	1.92"	1.244"	SD-322
BCT1000-1499-2926-45	V12067	.216	Ø1.529	Ø1.000	6.18"	3.18"	2.500"	SD-322
BCT1408-1969-3967-45	V12068	.256	Ø2.000	Ø1.500	7.31"	4.31"	3.500"	SD-422

## Hardware for Back Chamfer Tool

INSERT	SCREW
SECW 21.21	F1109
SD-322P	F1099
SD-422P	F610

# BCB SERIES—BACK COUNTERBORE

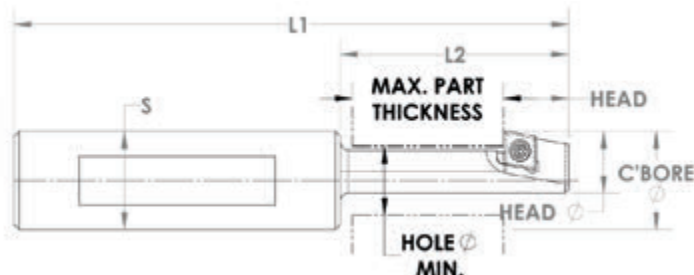
- **Applications:** Back Counterboring or Back Spot Facing, on back side of holes
- Coolant style upon request (up to 3 day turn around)
- For programming sequence please see page 20

## Back Counterbore Tool

Part #	EDP#	Cap Screw	Hole Dia. Min.	Tool Head Dia.	C' bore Dia.	Max Part Thickness	Offset	(L2)	(L1)	Insert	Head	(S)
BCB0250-0406-0609	V1940	1/4"	.266"	.250"	.406"	.548"	.094	.922	2.92	CDHB 1.20.61	.313"	.500
BCB0236-0432-0472	V4757	M6	.252"	.236"	.432"	.412"	.098	.785	2.78	CDHB 1.20.61	.313"	.500
BCB0250-0438-0609	V7820	1/4"	.266"	.250"	.438"	.548"	.094	.922	2.92	CDHB 1.20.61	.313"	.500
BCB0281-0500-0600	V10420	-	.313"	.281"	.500"	.531"	.110	.913	2.91	CDHB 1.20.61	.313"	.500
BCB0313-0531-0781	V7821	5/16"	.328"	.313"	.531"	.719"	.109	1.094	3.09	CDHB 1.20.61	.313"	.500
BCB0315-0561-0688	V7911	M8	.330"	.315"	.561"	.629"	.123	1.001	3.00	CDHB 1.20.61	.313"	.500
BCB0375-0625-0937	V7822	3/8"	.391"	.375"	.625"	.875"	.125	1.375	3.87	CPGT 1.51.21	.438"	.750
BCB0394-0679-0906	V7912	M10	.413"	.394"	.679"	.846"	.143	1.344	3.84	CPGT 1.51.21	.438"	.750
BCB0470-0750-1250	V10421	-	.500"	.470"	.750"	1.188"	.140	1.750	4.25	CPMT 21.51	.500"	.500
BCB0500-0781-1281	V1943	1/2"	.516"	.500"	.781"	1.219"	.141	1.719	4.22	CPMT 21.51	.438"	.750
BCB0500-0813-1281	V7823	1/2"	.516"	.500"	.813"	1.219"	.157	1.219	4.22	CPMT 21.51	.438"	.750
BCB0500-0875-1500	V11041	-	.516"	.500"	.875"	1.19"	.188	1.719	4.44	CPMT 21.51	.438"	.750
BCB0625-1000-1625	V7824	5/8"	.641"	.625"	1.000"	1.563"	.188	2.250	5.25	CPMT 32.51	.625"	1.000
BCB0750-1156-1937	V1945	3/4"	.766"	.750"	1.156"	1.875"	.203	2.562	5.56	CPMT 32.51	.625"	1.000
BCB0750-1188-1937	V7825	3/4"	.766"	.750"	1.188"	1.875"	.219	2.562	5.56	CPMT 32.51	.625"	1.000
BCB0720-1250-1729	V10422	-	.750"	.720"	1.250"	1.669"	.265	2.354	5.35	CPMT 32.51	.625"	1.000
BCB0720-1375-1500	V11130	-	.750"	.720"	1.375"	1.312"	.328	2.250	4.75	CPMT 32.51	.750"	.750
BCB0945-1476-2441	V7916	M24	.964"	.945"	1.476"	2.381"	.266	3.066	6.06	CPMT 32.51	.625"	1.250
BCB0945-1500-2538	V10423	-	.975"	.945"	1.500"	2.478"	.278	3.163	6.16	CPMT 32.51	.625"	1.250
BCB1000-1625-2625	V7826	1"	1.016"	1.000"	1.625"	2.563"	.313	3.250	6.25	CPMT 32.51	.625"	1.250
BCB0970-1750-2209	V10424	-	1.000"	.970"	1.750"	2.144"	.390	2.954	5.95	CCMT 432	.750"	1.250
BCB0970-1875-2188	V11730	-	1.000"	.970"	1.875"	2.188"	.453	3.188	6.18	CCMT 432	1.000"	1.000

## Hardware for Back Counterbore Tool

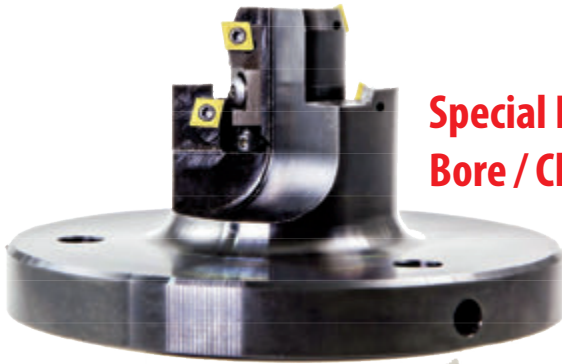
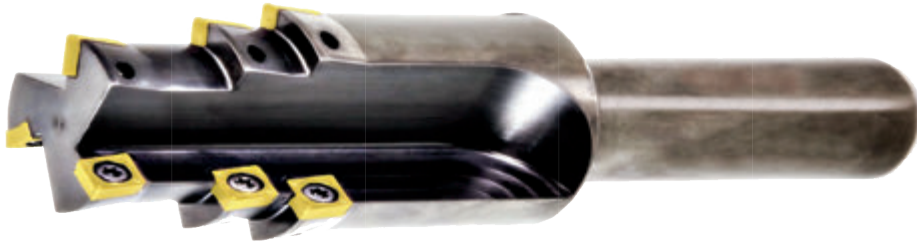
INSERT	SCREW
CDHB 1.20.61	F716
CPGT 1.51.21	F908
CPMT 21.51	F663
CPMT 32.51	F899
CCMT 432	F704



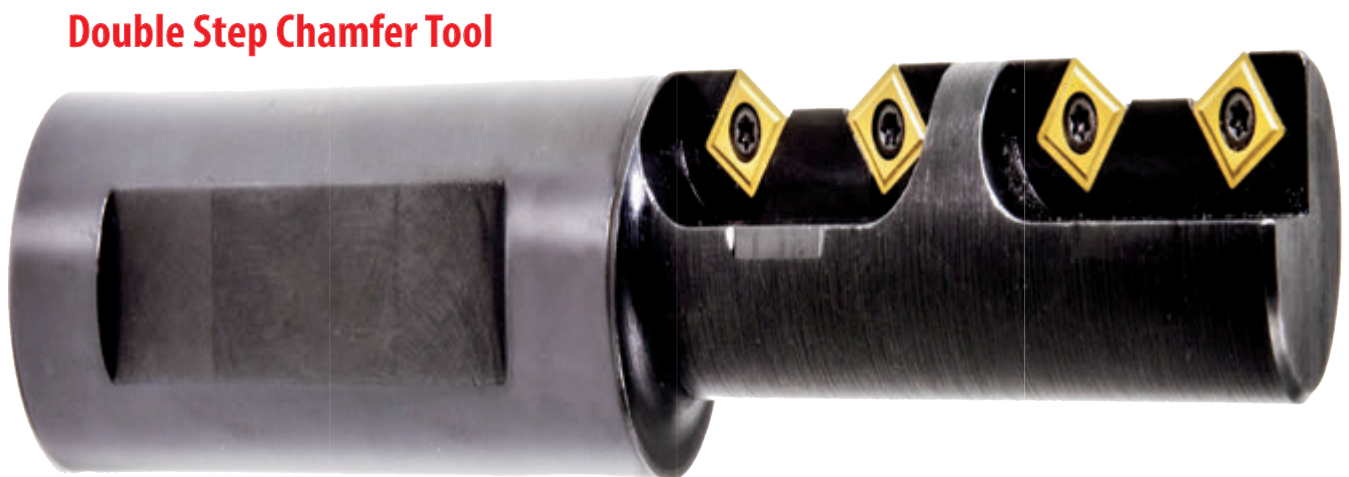


## CUSTOM TOOLS

### Special Drill / Rough-Finish Bore / ID Chamfer / Face Tool



### Special Flange Mount: Bore / Chamfer / Face Tool



### Double Step Chamfer Tool

Special tools are quoted upon request, please fax or email your information along with a part print (if available).



## CUSTOM TOOLS



**Special Adjustable Step  
Bore / Chamfer Tool**



**Special Shell Mill Mount Hollow  
Mill / OD Chamfer / Face Tool**

**Special tools are quoted upon request, please fax or email  
your information along with a part print (if available).**

## INSERTS & COATINGS

Part #	Nose Radius	IC	Thickness	VC2 EDP#	VC3 EDP#	VC4 EDP#
APET100308	.031	.250	.125	C1560	C1538	C1517
APET100316	.063	.250	.125	C1561	C1539	C1518
APET160408	.031	.375	.187	C1562	C1540	C1519
APET160416	.063	.375	.187	C1563	C1541	C1520
XPET100308	.031	.250	.125	C1564	C1542	C1513
XPET100316	.063	.250	.125	C1565	C1543	C1514
XPET160408	.031	.375	.187	C1566	C1544	C1515
XPET160416	.063	.375	.187	C1567	C1545	C1516
SECW 21.21	.015	.250	.078	C1568	C1546	C1521
SECW 2.51.51	.015	.313	.125	C1569	C1547	C1522
SD 322P	.031	.375	.125	C1570	C1548	C1523
SD 422P	.031	.500	.125	C1571	C1549	C1524
SD 532P	.031	.625	.187	C1572	C1550	C1525
XEGT009003008	.031	.375	.125	C1573	C1551	C1532
XEGT009003016	.063	.375	.125	C1574	C1552	C1533
XEGT009003120	.120	.375	.125	C1575	C1553	C1534
XEGT016005008	.031	16mm	.187	C1576	C1554	C1535
XEGT016005016	.063	16mm	.187	C1577	C1555	C1536
XEGT016005120	.120	16mm	.187	C1578	C1556	C1537
SXEX 42A	-	.500	.125	C1579	C1557	C1045
XEGW 32X	-	.375	.125	C1580	C1401	C1350
XEGW 21.5X	-	.250	.094	C1581	C1558	C1356

## INSERTS & COATINGS

Grade	Code	Coating	Color	Description
ZrN	VC2	Zirconium Nitride	Silver/ Gold	High lubricity, improved finish and resists sticking when used in Aluminum, higher oxidation temp. than TiN
V-Coat	VC3	PVD Multi layered coating	Silver	Excellent wear resistance, thermal shock stability and hot hardness, Multi purpose use in variety of material including high temp, hard-to-machine, gummy materials, such as 316L cold rolled stainless steel and Inconel 718
TiN	VC4	Titanium Nitride	Gold	A general purpose coating with a broad range of applicability (Steels, Cast Irons, Stainless Steels)

	Good	Better
Aluminum 6061-T6, 7075	V-Coat	ZrN
Brass / Bronze	V-Coat	ZrN
High Temp Alloys – alpha & beta alloys, Ni & Co based	TiN	V-Coat
Inconel, Hastolloy, Monel 400	V-Coat	ZrN
Iron (Cast, Wrought, Low Silicon, Nodular, Grey, Maileable)	V-Coat	ZrN
Plastic	V-Coat	ZrN
Steel - Alloy, 1018, A36, 8620, cast steel 4130, 4140, 8620, 4330, 4340	TiN	V-Coat
Steel - Die Mold, P20, A-2, D-2, M2, M42, Hardened (55-60Rc)	TiN	V-Coat
Steel - Stainless, 15-5Ph, 17-4Ph, 303, 304, 304L, 312, 316, 316L	TiN	V-Coat
Tritanium Alloy Ti-6Al4V	V-Coat	ZrN

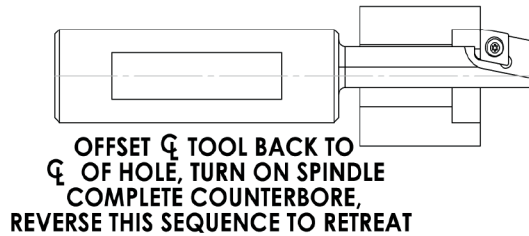
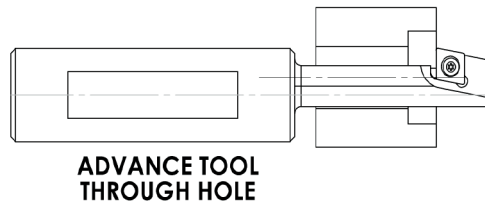
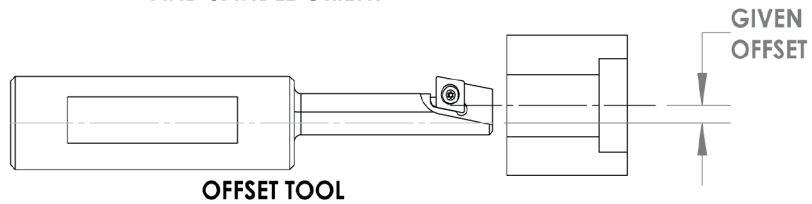
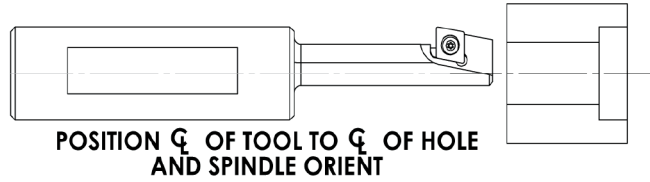
# HARDWARE

EDP #	Size	Wrench Size
<b>Insert Screws</b>		
F663	M2.5 x .45	T9
F899	M4 x .70	T15
F575	M4 x .70	T15
F610	M4 x .70	T10
F655	M4 x .70	T15
F716	M1.8 x .35	T5
F1109	M2.5 x .45	T9
F908	M2 x .4	T6
F704	M5 x .8	T20
F708	M3 x .5	T8
F1099	M3.5 x .6	T10
F1185	M5 x .8	T20
F575	M4 x .7	T15
<b>Lock Pin</b>		
F1137	1/4-28	3/32 HEX
<b>Shim</b>		
M834	1/2 IC x 3/16	
<b>Clamp</b>		
F737	1/4-28	
<b>Clamp Screw</b>		
F744	1/4-28	1/8 HEX

## **INDUSTRIES SERVED**

- **Agricultural**
- **Aerospace**
- **Aircraft**
- **Automotive**
- **Defense**
- **Energy Generation**
  - **Hydroelectric**
  - **Oil**
  - **Natural Gas**
  - **Nuclear**
  - **Steam**
  - **Wind**
- **Gears**
- **Government**
- **Heavy Equipment**
- **HVAC**
- **Hydraulic**
- **Medical**
- **Machine Builders (OEM)**
- **Manufacturing & Assembly**
- **Mining**
- **Motorsports**
- **Plumbing**
- **Pumps**
- **Train**
- **Valves**
- **Wheels & Brakes**
- **Workholding**

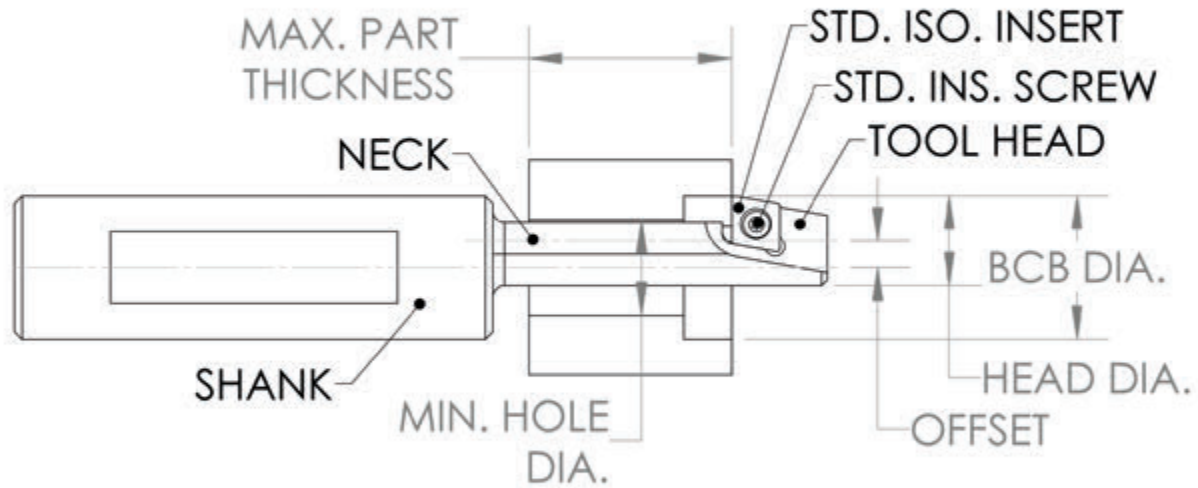
## BCB SERIES AND BCT SERIES PROGRAMMING SEQUENCE





# TECHNICAL INFORMATION

## BCB SERIES AND BCT SERIES TOOL DESCRIPTION



## **SERVICE & REPAIRS**

- **VIT tools that are damaged or out of tolerance can be returned for repair evaluation**
- **Some non-VIT tools can also be repaired by Vermont Indexable Tooling**
- **Contact VIT's sales or engineering department for specifics before sending non-VIT tools for repair**
- **Please call us at 1-800-639-1616**

# QUOTE FORM

DISTRIBUTOR:

CUSTOMER / END-USER:

<i>Dist. Contact:</i>	<i>Customer Contact:</i>
<i>Company:</i>	<i>Company:</i>
<i>Address:</i>	<i>Address:</i>
<i>Email:</i>	<i>Email:</i>
<i>Tel.#:</i>	<i>Tel.#:</i>
<i>Fax #:</i>	<i>Fax #:</i>

*SUBMITTED BY:*

*Date:*

Please provide a Product Part Print showing:

Areas to be Machined Identified	Part Material	Corner Radius Requirements
Finish or Rough Tolerances	Part Hardness	Part Name

**Machine Information:**

1. Type of Machine:
2. Spindle Size:
3. Other Info:

**SPOT FACING TOOLS**  
**Back / Forward / Chamfer**

C-BORE: BACK / FORWARD

BSF Dia.: \_\_\_\_\_

Hole Dia.: \_\_\_\_\_

Part Thick: \_\_\_\_\_

Tolerance: \_\_\_\_\_

Angle: \_\_\_\_\_

Material: \_\_\_\_\_

Machine: \_\_\_\_\_

**Type of Operation:**

Please describe what type of custom tooling or machining operation is needed.

**Miscellaneous Information:**

Machine Shank Capacity:
Special Shank Requirements:
Potential Interference Areas:
Through Coolant Required:
Lead Time:
Present Carbide Sources:
Size or Weight Restrictions:
Current Problems :

*You can also use Vermont Indexable Tooling's Online Quote Form at [www.vermontindexable.com](http://www.vermontindexable.com)*

# VIT

**VERMONT INDEXABLE TOOLING**

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**Fx: 618.282.6898**

**[sales@vermontindexable.com](mailto:sales@vermontindexable.com)**

**[vermontindexable.com](http://vermontindexable.com)**