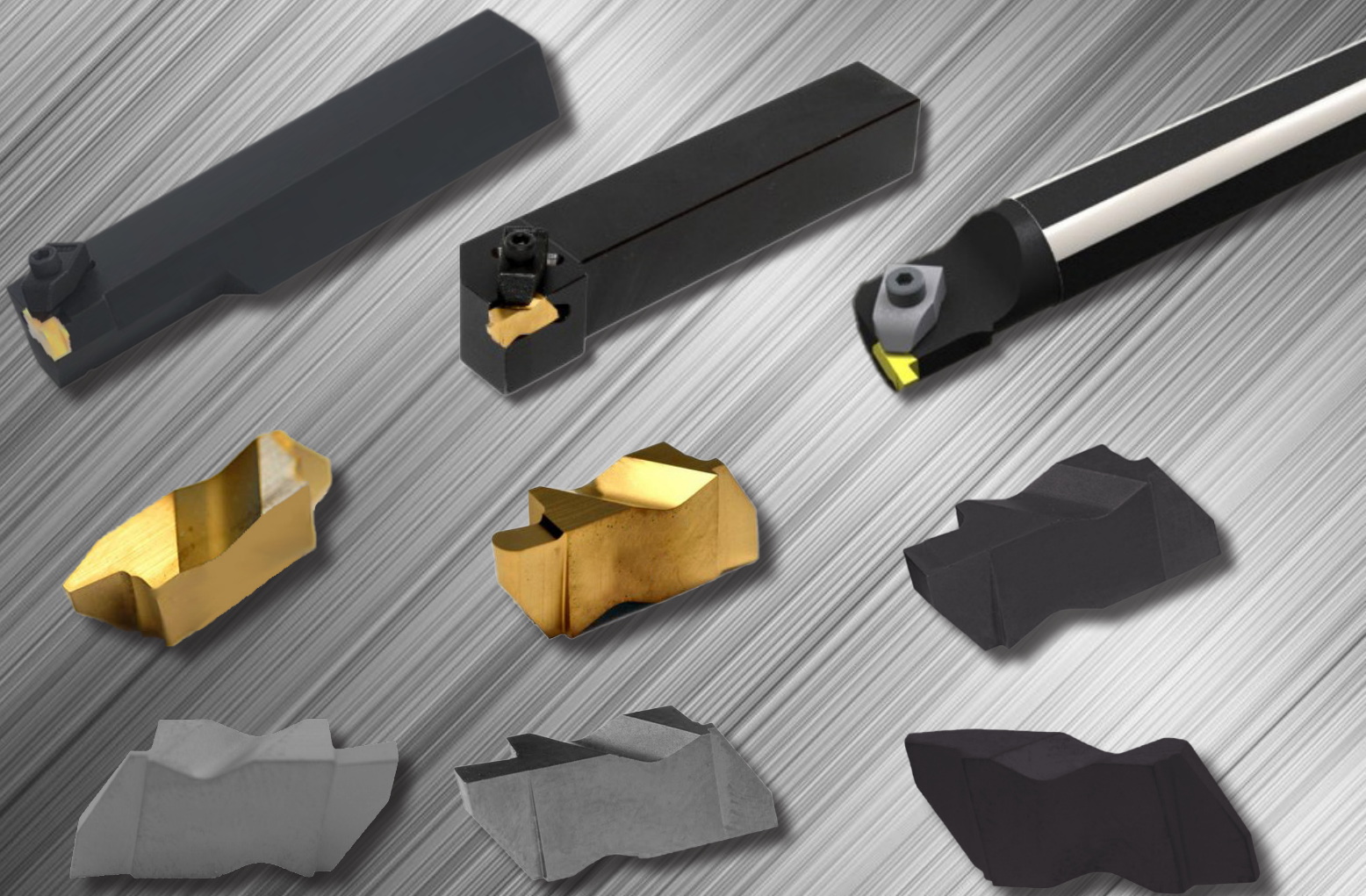


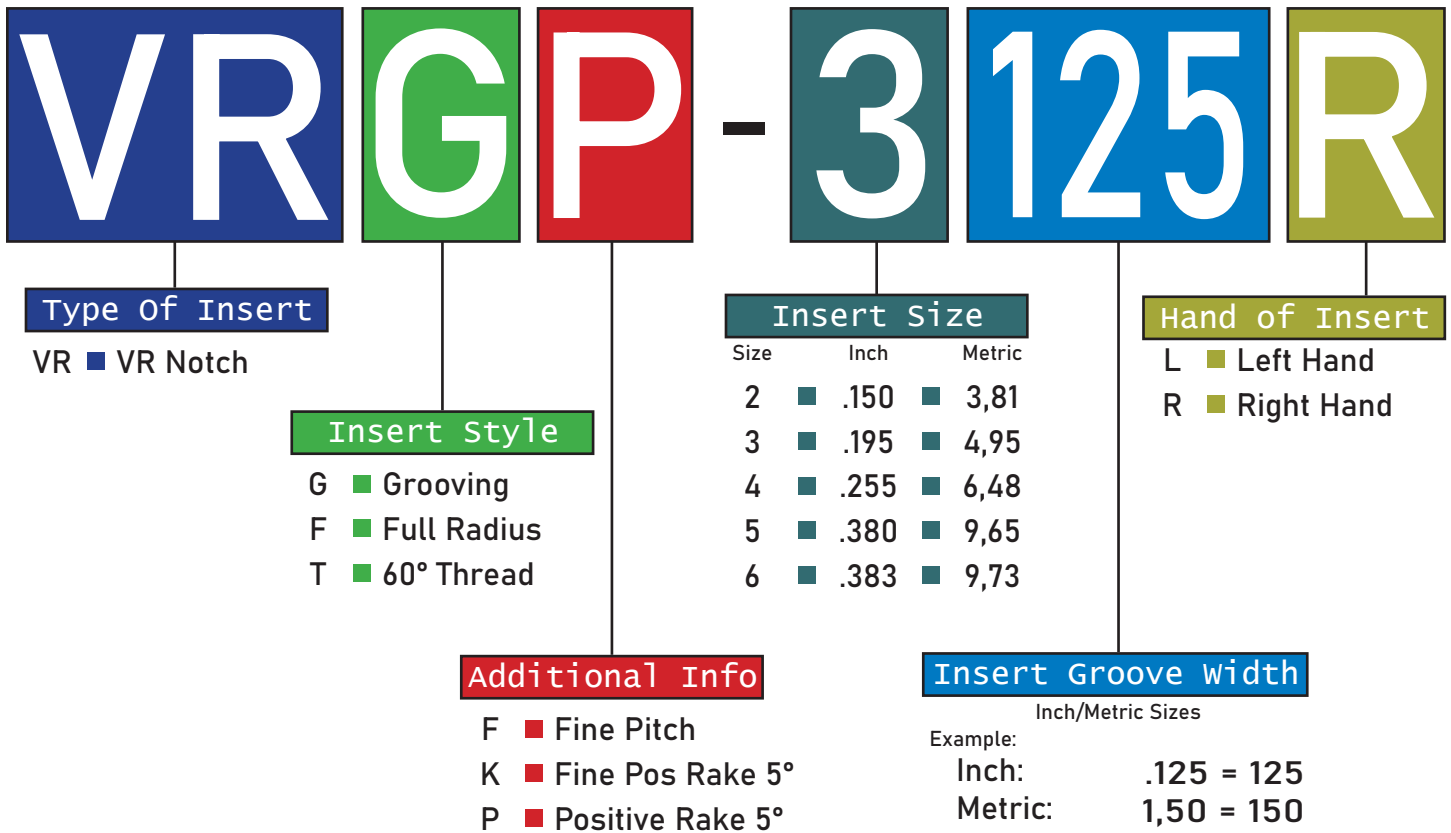
# **VR/Wesson**

## **STOCKED VR/NOTCH INSERTS**



Phone: 239-573-5132  
Fax: 239-573-5137  
EMail: [sales@vrwesson.com](mailto:sales@vrwesson.com)  
[www.vrwesson.com](http://www.vrwesson.com)

**Made In The USA**  
**ISO 9001:2015 Certified**



## VR/Notch Cross Reference Chart

| STYLE                       | VR/WESSION | TOOL-FLO | KENNAMETAL | SANDVIK* |
|-----------------------------|------------|----------|------------|----------|
| GROOVING                    | VRG        | FLG      | NG         | TLG      |
| GROOVING - POSITIVE         | VRGP       | FLGP     | NGP        | TLGP     |
| GROOVING - FNR              | VRR        | FLR      | NR         | TLR      |
| GROOVING - FNR POS.         | VRRP       | FLRP     | NRP        | TLP      |
| 60° V                       | VRT        | FLT      | NT         | TLT      |
| 60° V - FINE PITCH          | VRTF       | FLTF     | NTF        | TLTF     |
| 60° V - FINE PITCH POSITIVE | VRTK       | FLTK     | NTK        | TLTK     |
| 60° V - POSITIVE            | VRTP       | FLTP     | NTP        | TLTP     |

\* Sandvik inserts require toolholder clamp and clamp screw replacement.  
Call for more information.



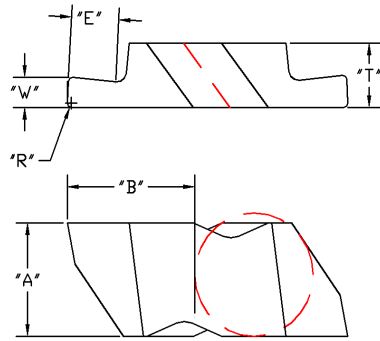
*Carbide Grades*

|              |                                                                                                                                                                                                                                                                                                                                                                                                                                       |
|--------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>VR52</b>  | A hard, low binder content, unalloyed WC/Co fine-grained grade. VR52 has exceptional edge wear resistance combined with very high strength for machining titanium, cast irons, austenitic stainless steels, non-ferrous metals, nonmetals, and most high-temperature alloys. Superior thermal deformation and depth of cut notch resistance. The micron size of the WC is well controlled creating consistent performance every time. |
| <b>VR772</b> | A PVD TiN coating over a general purpose alloyed substrate. Use to cut steel at medium to high speeds. Grade VR772 will greatly improve productivity, and allow higher speed capabilities in comparison to uncoated carbide. Available in threading and grooving geometries where upgrades from uncoated carbides are common. Most cutting edges are lightly honed. Positive rake VR Notch inserts are sharp.                         |
| <b>VR527</b> | A PVD TiAlN coating over a general purpose unalloyed substrate. The VR527 grade is ideal for finishing to general machining of most workpiece materials at higher speeds. Excellent for machining most steels, stainless steels, cast irons, non-ferrous materials and super alloys under standard conditions. It also performs well machining hardened steels and short chipping materials.                                          |

*VR/Notch Cross Reference Chart*

| VR/WESSION | TOOL FLO | KENNAMETAL  |
|------------|----------|-------------|
| VR52       | C3       | K313        |
| VR772      | GP50     | KC810/KC850 |
| VR527      | AC3      | KC5010      |

## GROOVING VRG



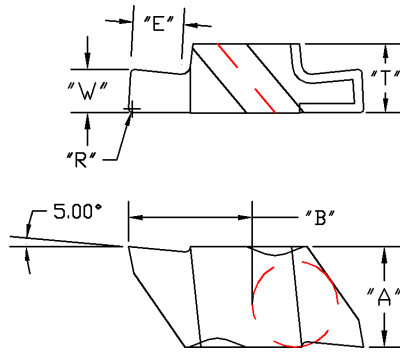
| DESCRIPTION | W     | R         | E     | T     | A     | B      | Gage Dia | VR52 UNCOATED | VR772 TIN COATED | VR527 TIALN COATED |
|-------------|-------|-----------|-------|-------|-------|--------|----------|---------------|------------------|--------------------|
|             |       |           |       |       |       |        |          | Part Number   | Part Number      | Part Number        |
| VRG-2031R   | 0.031 | .002/.005 | 0.050 | 0.150 | 0.219 | 0.2700 | 0.1875   | 68271         | 68270            | 68272              |
| VRG-2031L   | 0.031 | .002/.005 | 0.050 | 0.150 | 0.219 | 0.2700 | 0.1875   | 68275         | 68274            | 68276              |
| VRG-2047R   | 0.047 | .002/.005 | 0.050 | 0.150 | 0.219 | 0.2700 | 0.1875   | 68287         | 68286            | 68288              |
| VRG-2047L   | 0.047 | .002/.005 | 0.050 | 0.150 | 0.219 | 0.2700 | 0.1875   | 68291         | 68290            | 68292              |
| VRG-2062R   | 0.062 | .005/.010 | 0.110 | 0.150 | 0.219 | 0.2700 | 0.1875   | 68303         | 68302            | 68304              |
| VRG-2062L   | 0.062 | .005/.010 | 0.110 | 0.150 | 0.219 | 0.2700 | 0.1875   | 68307         | 68306            | 68309              |
| VRG-2094R   | 0.094 | .005/.010 | 0.110 | 0.150 | 0.219 | 0.2700 | 0.1875   | 68308         | 68310            | 68311              |
| VRG-2094L   | 0.094 | .005/.010 | 0.110 | 0.150 | 0.219 | 0.2700 | 0.1875   | 68313         | 68312            | 68329              |
| VRG-2125R   | 0.125 | .005/.010 | 0.110 | 0.150 | 0.219 | 0.2700 | 0.1875   | 68315         | 68314            | 68319              |
| VRG-2125L   | 0.125 | .005/.010 | 0.110 | 0.150 | 0.219 | 0.2700 | 0.1875   | 68317         | 68316            | 68318              |
| VRG-3031R   | 0.031 | .002/.005 | 0.050 | 0.195 | 0.344 | 0.4050 | 0.3750   | 68324         | 68332            | 68323              |
| VRG-3031L   | 0.031 | .002/.005 | 0.050 | 0.195 | 0.344 | 0.4050 | 0.3750   | 68327         | 68624            | 68325              |
| VRG-3047R   | 0.047 | .005/.010 | 0.075 | 0.195 | 0.344 | 0.4050 | 0.3750   | 63010         | 68326            | 68328              |
| VRG-3047L   | 0.047 | .005/.010 | 0.075 | 0.195 | 0.344 | 0.4050 | 0.3750   | 63012         | 68330            | 68331              |
| VRG-3062R   | 0.062 | .005/.010 | 0.120 | 0.195 | 0.344 | 0.4050 | 0.3750   | 63014         | 68334            | 68336              |
| VRG-3062L   | 0.062 | .005/.010 | 0.120 | 0.195 | 0.344 | 0.4050 | 0.3750   | 68339         | 68338            | 68340              |
| VRG-3094R   | 0.094 | .005/.010 | 0.180 | 0.195 | 0.344 | 0.4050 | 0.3750   | 63018         | 68366            | 68368              |
| VRG-3094L   | 0.094 | .005/.010 | 0.180 | 0.195 | 0.344 | 0.4050 | 0.3750   | 63020         | 68370            | 68372              |
| VRG-3125R   | 0.125 | .005/.010 | 0.180 | 0.195 | 0.344 | 0.4050 | 0.3750   | 63022         | 68406            | 68408              |
| VRG-3125L   | 0.125 | .005/.010 | 0.180 | 0.195 | 0.344 | 0.4050 | 0.3750   | 63024         | 68410            | 68412              |
| VRG-3189R   | 0.189 | .020/.025 | 0.180 | 0.195 | 0.344 | 0.4050 | 0.3750   | 68447         | 68446            | 68448              |
| VRG-3189L   | 0.189 | .020/.025 | 0.180 | 0.195 | 0.344 | 0.4050 | 0.3750   | 68451         | 68450            | 68452              |
| VRG-4125R   | 0.125 | .005/.010 | 0.250 | 0.250 | 0.453 | 0.6360 | 0.3750   | NS            | 68454            | 68456              |
| VRG-4125L   | 0.125 | .005/.010 | 0.250 | 0.250 | 0.453 | 0.6360 | 0.3750   | NS            | 68458            | 68460              |
| VRG-4189R   | 0.189 | .020/.025 | 0.250 | 0.250 | 0.453 | 0.6360 | 0.3750   | NS            | 68462            | 68464              |
| VRG-4189L   | 0.189 | .020/.025 | 0.250 | 0.250 | 0.453 | 0.6360 | 0.3750   | NS            | 68466            | 68468              |
| VRG-4250R   | 0.250 | .020/.025 | 0.250 | 0.250 | 0.453 | 0.6360 | 0.3750   | NS            | 68486            | 68488              |
| VRG-4250L   | 0.250 | .020/.025 | 0.250 | 0.250 | 0.453 | 0.6360 | 0.3750   | NS            | 68490            | 68492              |

\* NS - Non-Standard

# STOCKED VR/NOTCH



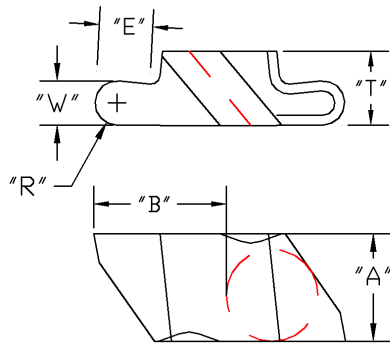
## GROOVING POSITIVE VRGP



|             | VR52 UNCOATED | VR772 TIN COATED | VR527 TIALN COATED |
|-------------|---------------|------------------|--------------------|
| DESCRIPTION | Part Number   | Part Number      | Part Number        |
| VRGP-2031R  | 68801         | 68800            | 68802              |
| VRGP-2031L  | 68805         | 68804            | 68806              |
| VRGP-2047R  | 68817         | 68816            | 68818              |
| VRGP-2047L  | 68821         | 68820            | 68822              |
| VRGP-2062R  | 68831         | 68832            | 68834              |
| VRGP-2062L  | 68837         | 68836            | 68838              |
| VRGP-2094R  | 68841         | 68840            | 68842              |
| VRGP-2094L  | 68845         | 68844            | 68846              |
| VRGP-2125R  | 68849         | 68848            | 68850              |
| VRGP-2125L  | 68853         | 68852            | 68854              |
| VRGP-3031R  | 68855         | 68856            | 68858              |
| VRGP-3031L  | 68859         | 68860            | 68862              |
| VRGP-3047R  | 68865         | 68864            | 68866              |
| VRGP-3047L  | 68869         | 68868            | 68870              |
| VRGP-3062R  | 68873         | 68872            | 68874              |
| VRGP-3062L  | 68877         | 68876            | 68878              |
| VRGP-3094R  | 68905         | 68904            | 68906              |
| VRGP-3094L  | 68909         | 68908            | 68910              |
| VRGP-3125R  | 68945         | 68944            | 68946              |
| VRGP-3125L  | 68949         | 68948            | 68950              |
| VRGP-3189R  | 68985         | 68984            | 68986              |
| VRGP-3189L  | 68989         | 68988            | 68990              |
| VRGP-4125R  | NS            | 68992            | 68994              |
| VRGP-4125L  | NS            | 68996            | 68998              |
| VRGP-4189R  | NS            | 69000            | 69002              |
| VRGP-4189L  | NS            | 69004            | 69006              |
| VRGP-4250R  | NS            | 69024            | 69026              |
| VRGP-4250L  | NS            | 69028            | 69030              |

\* NS - Non-Standard

GROOVING VRR  
w/ full nose radius



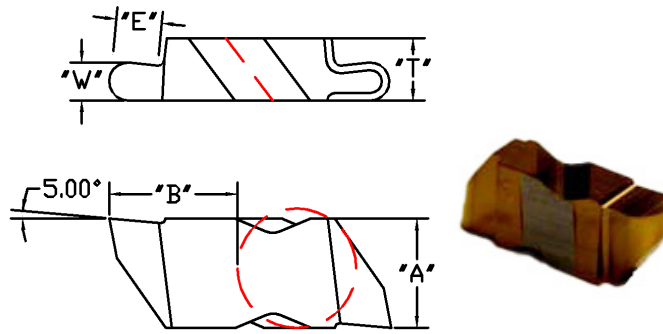
| VR52 UNCOATED | VR772 TIN COATED | VR527 TIALN COATED |
|---------------|------------------|--------------------|
| Part Number   | Part Number      | Part Number        |
| NS            | 69036            | 69037              |
| NS            | 69039            | 69038              |
| NS            | 66040            | 69050              |
| NS            | 66041            | 66137              |
| NS            | 69048            | 69049              |
| NS            | 69051            | 69052              |
| 68503         | 68500            | 68502              |
| 68507         | 68506            | 68508              |
| 68511         | 68509            | 68510              |
| 68513         | 68512            | 68514              |
| 68517         | 68516            | 68518              |
| 63016         | 68522            | 68524              |
| NS            | 68534            | 68536              |
| NS            | 68537            | 68538              |
| NS            | 69082            | 69081              |
| NS            | 69085            | 69086              |
| NS            | 69088            | 69087              |
| NS            | 69091            | 69092              |
| NS            | 68558            | 69093              |
| NS            | 69097            | 69098              |

\* NS - Non-Standard

## STOCKED VR/NOTCH



GROOVING VRRP  
w/ full nose radius  
and positive rake



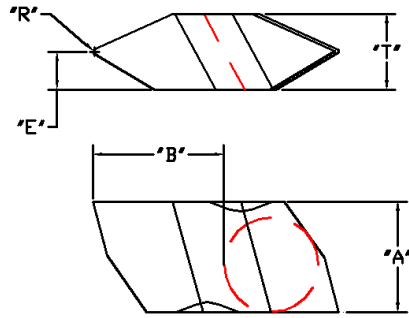
| VR52 UNCOATED | VR772 TIN COATED | VR527 TIALN COATED |
|---------------|------------------|--------------------|
| Part Number   | Part Number      | Part Number        |
| 66100         | 66004            | 66003              |
| 66102         | 66006            | 66005              |
| 66104         | 66008            | 66007              |
| 66106         | 66010            | 66009              |
| 66108         | 66012            | 66013              |
| 66110         | 66016            | 66015              |
| 66112         | 66024            | 66021              |
| 66114         | 66028            | 66023              |
| NS            | 66030            | 66027              |
| NS            | 66032            | 66029              |
| NS            | 66034            | 66031              |
| NS            | 66036            | 66033              |
| NS            | 66038            | 66035              |
| NS            | 66042            | 66037              |

| DESCRIPTION | W     | R     | E     | T     | A     | B      | Gage Dia | Part Number | Part Number | Part Number |
|-------------|-------|-------|-------|-------|-------|--------|----------|-------------|-------------|-------------|
| VRRP-3031R  | 0.062 | 0.031 | 0.125 | 0.195 | 0.344 | 0.4033 | 0.3750   | 66100       | 66004       | 66003       |
| VRRP-3031L  | 0.062 | 0.031 | 0.125 | 0.195 | 0.344 | 0.4033 | 0.3750   | 66102       | 66006       | 66005       |
| VRRP-3047R  | 0.094 | 0.047 | 0.180 | 0.195 | 0.344 | 0.4025 | 0.3750   | 66104       | 66008       | 66007       |
| VRRP-3047L  | 0.094 | 0.047 | 0.180 | 0.195 | 0.344 | 0.4025 | 0.3750   | 66106       | 66010       | 66009       |
| VRRP-3062R  | 0.125 | 0.062 | 0.180 | 0.195 | 0.344 | 0.4017 | 0.3750   | 66108       | 66012       | 66013       |
| VRRP-3062L  | 0.125 | 0.062 | 0.180 | 0.195 | 0.344 | 0.4017 | 0.3750   | 66110       | 66016       | 66015       |
| VRRP-3094R  | 0.189 | 0.094 | 0.180 | 0.195 | 0.344 | 0.4000 | 0.3750   | 66112       | 66024       | 66021       |
| VRRP-3094L  | 0.189 | 0.094 | 0.180 | 0.195 | 0.344 | 0.4000 | 0.3750   | 66114       | 66028       | 66023       |
| VRRP-4062R  | 0.125 | 0.062 | 0.250 | 0.255 | 0.453 | 0.6327 | 0.3750   | NS          | 66030       | 66027       |
| VRRP-4062L  | 0.125 | 0.062 | 0.250 | 0.255 | 0.453 | 0.6327 | 0.3750   | NS          | 66032       | 66029       |
| VRRP-4094R  | 0.189 | 0.094 | 0.250 | 0.255 | 0.453 | 0.6310 | 0.3750   | NS          | 66034       | 66031       |
| VRRP-4094L  | 0.189 | 0.094 | 0.250 | 0.255 | 0.453 | 0.6310 | 0.3750   | NS          | 66036       | 66033       |
| VRRP-4125R  | 0.250 | 0.125 | 0.250 | 0.255 | 0.453 | 0.6293 | 0.3750   | NS          | 66038       | 66035       |
| VRRP-4125L  | 0.250 | 0.125 | 0.250 | 0.255 | 0.453 | 0.6293 | 0.3750   | NS          | 66042       | 66037       |

\* NS - Non-Standard

## STOCKED VR/NOTCH

60° V-THREADING  
VRT

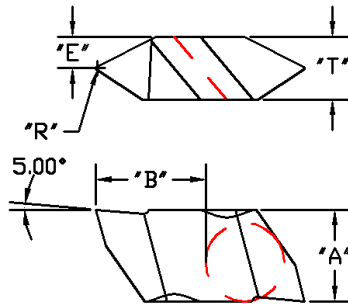


TPI

|               |                  |                    |
|---------------|------------------|--------------------|
| VR52 UNCOATED | VR772 TIN COATED | VR527 TIALN COATED |
| Part Number   | Part Number      | Part Number        |
| 68103         | 68102            | 68104              |
| 68107         | 68106            | 68108              |
| 68111         | 68110            | 68112              |
| 68115         | 68114            | 68116              |
| 68119         | 68118            | 68120              |
| 68123         | 68122            | 68124              |

| DESCRIPTION | Int. | Ext. | R         | E     | T     | A     | B      | Gage Dia | Part Number | Part Number | Part Number |
|-------------|------|------|-----------|-------|-------|-------|--------|----------|-------------|-------------|-------------|
| VRT-2R      | 7-20 | 8-36 | .003/.005 | 0.075 | 0.150 | 0.219 | 0.2661 | 0.1875   | 68103       | 68102       | 68104       |
| VRT-2L      | 7-20 | 8-36 | .003/.005 | 0.075 | 0.150 | 0.219 | 0.2661 | 0.1875   | 68107       | 68106       | 68108       |
| VRT-3R      | 5-12 | 6-20 | .005/.008 | 0.098 | 0.195 | 0.344 | 0.3999 | 0.3750   | 68111       | 68110       | 68112       |
| VRT-3L      | 5-12 | 6-20 | .005/.008 | 0.098 | 0.195 | 0.344 | 0.3999 | 0.3750   | 68115       | 68114       | 68116       |
| VRT-4R      | 4-12 | 4-20 | .005/.008 | 0.128 | 0.255 | 0.453 | 0.6298 | 0.3750   | 68119       | 68118       | 68120       |
| VRT-4L      | 4-12 | 4-20 | .005/.008 | 0.128 | 0.255 | 0.453 | 0.6298 | 0.3750   | 68123       | 68122       | 68124       |

60° V-THREADING  
POSITIVE RAKE  
VRTP



TPI

|               |                  |                    |
|---------------|------------------|--------------------|
| VR52 UNCOATED | VR772 TIN COATED | VR527 TIALN COATED |
| Part Number   | Part Number      | Part Number        |
| 68601         | 68600            | 68602              |
| 68605         | 68604            | 68606              |
| 68609         | 68608            | 68610              |
| 68611         | 68612            | 68614              |
| 68617         | 68616            | 68618              |
| 68621         | 68620            | 68622              |

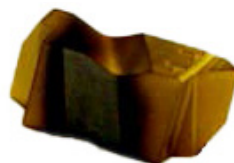
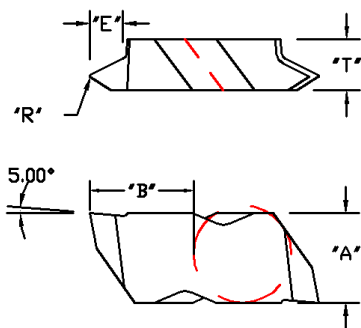
| DESCRIPTION | Int. | Ext. | R         | E     | T     | A     | B      | Gage Dia | Part Number | Part Number | Part Number |
|-------------|------|------|-----------|-------|-------|-------|--------|----------|-------------|-------------|-------------|
| VRTP-2R     | 7-20 | 8-36 | .003/.005 | 0.075 | 0.150 | 0.219 | 0.2661 | 0.1875   | 68601       | 68600       | 68602       |
| VRTP-2L     | 7-20 | 8-36 | .003/.005 | 0.075 | 0.150 | 0.219 | 0.2661 | 0.1875   | 68605       | 68604       | 68606       |
| VRTP-3R     | 5-12 | 6-20 | .005/.008 | 0.098 | 0.195 | 0.344 | 0.3999 | 0.3750   | 68609       | 68608       | 68610       |
| VRTP-3L     | 5-12 | 6-20 | .005/.008 | 0.098 | 0.195 | 0.344 | 0.3999 | 0.3750   | 68611       | 68612       | 68614       |
| VRTP-4R     | 4-12 | 4-20 | .005/.008 | 0.128 | 0.255 | 0.453 | 0.6298 | 0.3750   | 68617       | 68616       | 68618       |
| VRTP-4L     | 4-12 | 4-20 | .005/.008 | 0.128 | 0.255 | 0.453 | 0.6298 | 0.3750   | 68621       | 68620       | 68622       |



## STOCKED VR/NOTCH



60° V-THREADING  
VRTK  
POSITIVE RAKE  
FINE PITCH

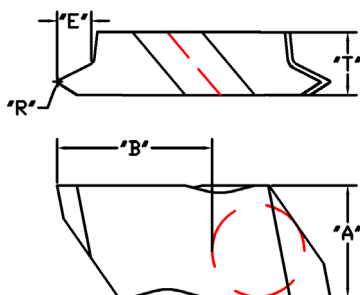


TPI

|               |                  |                    |
|---------------|------------------|--------------------|
| VR52 UNCOATED | VR772 TIN COATED | VR527 TIALN COATED |
| Part Number   | Part Number      | Part Number        |
| 68631         | 68630            | 68632              |
| 68633         | 68634            | 68636              |
| 68639         | 68638            | 68640              |
| 68643         | 68642            | 68644              |
| 68647         | 68646            | 68648              |
| 68651         | 68650            | 68652              |

| DESCRIPTION | Int.  | Ext.  | R         | E     | T     | A     | B      | Gage Dia | Part Number | Part Number | Part Number |
|-------------|-------|-------|-----------|-------|-------|-------|--------|----------|-------------|-------------|-------------|
| VRTK-2R     | 12-24 | 14-44 | .002/.004 | 0.110 | 0.150 | 0.219 | 0.2679 | 0.1875   | 68631       | 68630       | 68632       |
| VRTK-2L     | 12-24 | 14-44 | .002/.004 | 0.110 | 0.150 | 0.219 | 0.2679 | 0.1875   | 68633       | 68634       | 68636       |
| VRTK-3R     | 9-24  | 10-44 | .002/.004 | 0.141 | 0.195 | 0.344 | 0.4022 | 0.3750   | 68639       | 68638       | 68640       |
| VRTK-3L     | 9-24  | 10-44 | .002/.004 | 0.141 | 0.195 | 0.344 | 0.4022 | 0.3750   | 68643       | 68642       | 68644       |
| VRTK-4R     | 9-24  | 10-44 | .002/.004 | 0.201 | 0.255 | 0.453 | 0.6322 | 0.3750   | 68647       | 68646       | 68648       |
| VRTK-4L     | 9-24  | 10-44 | .002/.004 | 0.201 | 0.255 | 0.453 | 0.6322 | 0.3750   | 68651       | 68650       | 68652       |

60° V-THREADING  
VRTF  
FINE PITCH



TPI

|               |                  |                    |
|---------------|------------------|--------------------|
| VR52 UNCOATED | VR772 TIN COATED | VR527 TIALN COATED |
| Part Number   | Part Number      | Part Number        |
| 68127         | 68126            | 68128              |
| 68131         | 68130            | 68132              |
| 68135         | 68134            | 68136              |
| 68139         | 68138            | 68140              |
| 68143         | 68142            | 68144              |
| 68147         | 68146            | 68148              |

| DESCRIPTION | Int.  | Ext.  | R         | E     | T     | A     | B      | Gage Dia | Part Number | Part Number | Part Number |
|-------------|-------|-------|-----------|-------|-------|-------|--------|----------|-------------|-------------|-------------|
| VRTF-2R     | 12-24 | 14-44 | .002/.004 | 0.110 | 0.150 | 0.219 | 0.2679 | 0.1875   | 68127       | 68126       | 68128       |
| VRTF-2L     | 12-24 | 14-44 | .002/.004 | 0.110 | 0.150 | 0.219 | 0.2679 | 0.1875   | 68131       | 68130       | 68132       |
| VRTF-3R     | 9-24  | 10-44 | .002/.004 | 0.141 | 0.195 | 0.344 | 0.4022 | 0.3750   | 68135       | 68134       | 68136       |
| VRTF-3L     | 9-24  | 10-44 | .002/.004 | 0.141 | 0.195 | 0.344 | 0.4022 | 0.3750   | 68139       | 68138       | 68140       |
| VRTF-4R     | 9-24  | 10-44 | .002/.004 | 0.201 | 0.255 | 0.453 | 0.6322 | 0.3750   | 68143       | 68142       | 68144       |
| VRTF-4L     | 9-24  | 10-44 | .002/.004 | 0.201 | 0.255 | 0.453 | 0.6322 | 0.3750   | 68147       | 68146       | 68148       |



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