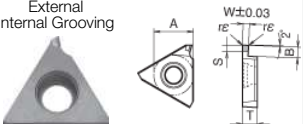


External Grooving Inserts

1 - Edge

Grooving Inserts (1-edge)

Edge Prep.																
Symbol	Cutting Edge Spec.	Example		K	Gray Cast Iron (with Scale)											
E	Rounded Cutting Edge (Hone)	E003	R0.003" Honed		Nodular Cast Iron (without Scale)											
T	Chamfered Cutting Edge	T00315	0.003" X 15° Chamfered Cutting Edge		Nodular Cast Iron (with Scale)											
S	Chamfered and Honed Cutting Edge	S00525	0.005" X 25° Chamfered and Honed Cutting Edge		Hard Materials (Roughing)											
				H	Hard Materials (Finishing)										○	●
					Hard Materials (Chip Control)											
				Powdered Steel												
				Dimensions										No. of Edges	CBN	
				Unit	W _{±0.0012} (in)	W _{±0.03} (mm)	B	rε	A	T	Ød	S				
Insert				Edge Prep (in)										KBN510	KBN525	Toolholder Page
				E003	mm	0.049	1.25	2.0	0.2	12.7	4.76	5.5	1.9	1	○	
<div>External Internal Grooving</div> 					0.059	1.50	3.5	0.2	12.7	4.76	5.5	1.9		○	○	
					0.079	2.00	3.5	0.2	12.7	4.76	5.5	1.9		●	○	
					0.098	2.50	4.0	0.2	12.7	4.76	5.5	1.9		●	○	
					0.118	3.00	4.0	0.2	12.7	4.76	5.5	1.9		○	○	