





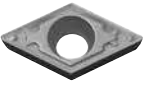
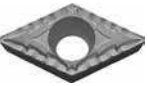


# API RING GROOVER

## Cartridge Set Spare Parts & Applicable Inserts

Ring Specification	Cartridge Set Part Number	Spare Parts		③ Applicable Inserts Choose Inserts		
		Clamp Screw 	Wrench 			
BX-150	BX150-SET	SCR-02	T15	DCMT3252		
BX-150-R	BX150-R-SET			DCMT3253		
BX-151	BX151-SET			DCMT3252		
BX-151-R	BX151-R-SET			DCMT3253		
BX-152	BX152-SET			DCMT3252		
BX-152-R	BX152-R-SET			DCMT3253		
BX-153	BX153-SET			DCMT3252		
BX-153-R	BX153-R-SET			DCMT3253		
BX-154	BX154-SET			DCMT3252		
BX-154-R	BX154-R-SET			DCMT3253		
BX-155	BX155-SET			DCMT3252		
BX-155-R	BX155-R-SET			VCMT333		
BX-156	BX156-SET			VCMT332		
BX-156-R	BX156-R-SET			VCMT333		
BX-169	BX169-SET			VCMT332		
R-16	R16-SET			SCR-01	T7	VCMT222
R-18	R18-SET					VCMT222
R-20	R20-SET					VCMT222
R-23	R23-SET	SCR-02	T15	DCMT3252		
R-23-R	R23-R-SET			VCMT333		
R-24	R24-SET			DCMT3252		
R-24-R	R24-R-SET			VCMT333		

Ring Specification	Cartridge Set Part Number	Spare Parts		③ Applicable Inserts Choose Inserts			
		Clamp Screw 	Wrench 				
R-26	R26-SET	SCR-02	T15	DCMT3252			
R-27	R27-SET						
R-31	R31-SET						
R-31-R	R31-R-SET						
R-35	R35-SET						
R-35-R	R35-R-SET						
R-37	R37-SET						
R-39	R39-SET						
R-39-R	R39-R-SET						
R-41	R41-SET						
R-44	R44-SET						
R-44-R	R44-R-SET						
R-45	R45-SET						
R-46	R46-SET						
R-46-R	R46-R-SET						
1-13/16	1-13/16-SET				SCR-01	T7	VCMT222
2-1/16-10K	2-1/16-10K-SET						
2-9/16-15K	2-9/16-15K-SET						
3-1/16-10K	3-1/16-10K-SET						
4-1/16-10K	4-1/16-10K-SET						
5-1/8-10K	5-1/8-10K-SET						

## Applicable Inserts (Inch Size)

Insert	ANSI Part Number	ISO Part Number	Dimensions (in)		Angle (°)	Insert Grades							
			I.C. (A)	T		Ød	rε	α	CVD Coated Carbide			MEGACOAT Coated Carbide	
			CA525	CA5525	CA6525	PR1225	PR1425	PR660					
	DCMT 3252HQ	DCMT 11T308HQ	3/8	5/32	0.173	1/32	7°	●	●	●		●	●
	DCMT 3253CQ	DCMT 11T312CQ	3/8	5/32	0.173	3/64	7°		●	●			●
	VCMT 222HQ	VCMT 110308HQ	1/4	1/8	0.110	1/32	7°				●		
	VCMT 332HQ	VCMT 160408HQ	3/8	3/16	0.173	1/32	7°	●	●	●			●
	333HQ	160412HQ	3/8	3/16	0.173	3/64	7°				●		

## Sample CNC Program for the API Ring Groover

<p>Sample is shown without cutter comp.                  N10 (Incremental Program)                  N20 G00 X (As required) Y (As required) Z.100 M03 S (As required)                  N30 G01 Z0.0 F100                  N40 G91 Y (Offset) Z-.100 F (As required)                  N50 G03 J (Offset) Z-.100 F (As required)                  N60 G03 J (Offset) Z-.100                  Continue to Depth                  Last Pass                  N90 G03 J (Offset) Z0.00</p>	<p>Use 0.03 Depth in Z for Inconel and                  0.04 Depth in Z for Steel</p>
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