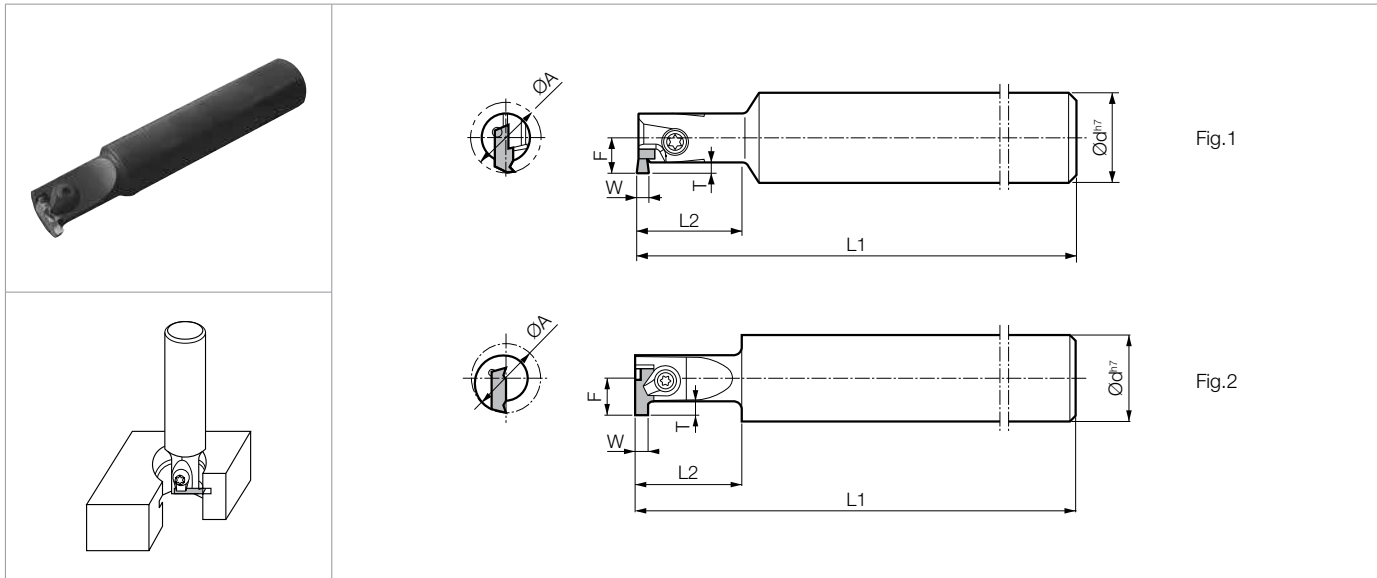


MGI GROOVING END MILL

MGI



Toolholder Dimensions

Part Number	Stock	Min. Bore Dia.	Dimensions (mm)						Edge Width	Drawing	Spare Parts			Applicable Inserts K13		
			ØA	Ød	L1	L2	F	T			W	Clamp Set			Clamp Screw	Wrench
												5F	6F		SB-4065TR	FT
MGI 1420-1SS	○	14	20	100	20	6.8	2.2	1.0~3.0	Fig.1	-	-	SB-4065TR	FT-15	GVR...-020SS		
1620-1S	○	16	20	110	25	7.8	2.2	1.0~3.4	Fig.1	-	-	SB-4085TR	FT-15	GVR...-020S		
2020-1A	○	20	20	110	30	9.8	2.2	1.0~3.4	Fig.2	CPS-5F	-	-	FT-15	GVR...-020A GVR...-...AR		
2220-1B	○	22	20	110	30	11.0	2.8	1.45~4.0	Fig.2	CPS-5F	-	-	FT-15	GVR...-020B GVR...-...BR		
3225-1C	○	32	25	120	35	16.0	5.5 (4.5)	2.8~4.0	Fig.2	-	CPS-6F	-	LW-3	GVR...-020C		
4025-1C	○	40	25	120	40	20.0										

- Dimension T shows available grooving depth.
- **GVR280-020C, GVR300-020C** inserts are available for groove depths up to 4.5mm.
- **GVR430-020C ~ GVR500-020C** inserts can be installed into **MGI3225-1C** and **MGI4025-1C** holders, but are not recommended for steel machining because of toolholder's rigidity.

Recommended Cutting Conditions

Workpiece Material	Feed Rate fz (µm)	Recommended Insert Grades (Cutting Speed Vc: sfm)					
		Cermet			MEGA COAT	PVD Coated Carbide	Carbide
		TN90	TC40N	TC60	PR1225	PR930	KW10
Carbon Steel	0.002~0.006	★ 390~660	☆ 390~660	☆ 330~590	★ 260~490	☆ 260~490	-
Alloy Steel	0.002~0.006	★ 390~660	☆ 390~660	☆ 330~590	★ 260~490	☆ 260~490	-
Mold Steel	0.001~0.005	★ 330~590	☆ 330~590	☆ 260~490	★ 200~430	☆ 200~430	-
Stainless Steel	0.001~0.005	☆ 330~590	☆ 330~590	★ 260~490	★ 200~430	☆ 200~430	-
Cast Iron	0.002~0.008	★ 330~490	☆ 330~490	-	-	-	★ 260~490
Non-ferrous Metals	0.002~0.008	-	-	-	-	-	★ 330~980

- Use down-cut machining.
- ★: 1st Recommendation ☆: 2nd Recommendation