

External Grooving Inserts

1 - Edge

Grooving Inserts (1-edge)

Edge Prep.				Material		CBN		Toolholder								
Symbol	Cutting Edge Spec.	Example														
E	Rounded Cutting Edge (Hone)	R0.003" Honed		Gray Cast Iron (with Scale)												
T	Chamfered Cutting Edge	0.003" X 15° Chamfered Cutting Edge		Nodular Cast Iron (without Scale)												
S	Chamfered and Honed Cutting Edge	0.005" X 25° Chamfered and Honed Cutting Edge		Nodular Cast Iron (with Scale)												
				Hard Materials (Roughing)												
				Hard Materials (Finishing)												
				Hard Materials (Chip Control)												
				Powdered Steel												
Insert			Edge Prep (in)	Dimensions				No. of Edges	CBN	Toolholder Page						
Handed Insert shows Right-hand			Unit	W ^{±0.0012} (in)	W ^{±0.03} (mm)	B	rε	A	T	∅d	S					
ANSI Part Number																
ANSI Old Part Number																
			E003	mm	0.049	1.25	2.0	0.2	12.7	4.76	5.5	1.9	1	○	Ⓞ	G11 G62
					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		●	○	
					0.118	3.00	4.0	0.2	12.7	4.76	5.5	1.9		●	Ⓞ	

Deep Grooving Inserts (1-edge)

Edge Prep.				Material		CBN		Toolholder							
Symbol	Cutting Edge Spec.	Example													
E	Rounded Cutting Edge (Hone)	R0.003" Honed		Gray Cast Iron (with Scale)											
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				Hard Materials (Roughing)											
				Hard Materials (Finishing)											
				Hard Materials (Chip Control)											
				Powdered Steel											
Insert			Edge Prep (in)	Dimensions				No. of Edges	MEGA CBN	Toolholder Page					
External Grooving			Unit	W ^{±0.0008} (in)	W ^{±0.03} (mm)	rε	L	H	M	S					
ANSI Part Number															
ANSI Old Part Number															
			E003	mm	0.079	2.0	0.2	20	4.3	1.8	2.9	1	○	○	G19 G25
			E0008		0.079	2.0	0.2	20	4.3	1.8	2.9		○	○	
			E003		0.118	3.0	0.4	20	4.3	2.3	2.9	1	●	○	G20 G25
			E0008		0.118	3.0	0.4	20	4.3	2.3	2.9		○	○	
			E003		0.158	4.0	0.4	20	4.3	3.3	2.9	1	●	○	G20 G25
			E0008		0.158	4.0	0.4	20	4.3	3.3	2.9		○	○	
			E003		0.197	5.0	0.4	20	4.3	4.2	2.9	1	○	○	G20 G25
			E0008		0.197	5.0	0.4	20	4.3	4.2	2.9		○	○	
			E003		0.236	6.0	0.4	20	4.3	5.2	2.9	1	○	○	G20 G25
			E0008		0.236	6.0	0.4	20	4.3	5.2	2.9		○	○	

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S	Chamfered and Honed Cutting Edge	0.005" X 25° Chamfered and Honed Cutting Edge		Nodular Cast Iron (with Scale)											
				Hard Materials (Roughing)											
				Hard Materials (Finishing)											
				Hard Materials (Chip Control)											
				Powdered Steel											
Insert			Edge Prep (in)	Dimensions				No. of Edges	CBN	Toolholder Page					
External Grooving			Unit	W ^{±0.0020} (in)	W ^{±0.05} (mm)	rε	L	H	M	S					
ANSI Part Number															
ANSI Old Part Number															
			E003	mm	0.079	2	0.2	20	4.3	1.8	2.9	1	○	○	G36,G37
					0.118	3	0.4	20	4.3	2.3	2.9		○	○	
					0.158	4	0.4	20	4.3	3.3	2.9	1	○	○	G36 G37 G38
					0.197	5	0.4	20	4.3	4.2	2.9		○	○	
					0.236	6	0.4	20	4.3	5.2	2.9	1	○	○	G36,G37
													○	○	