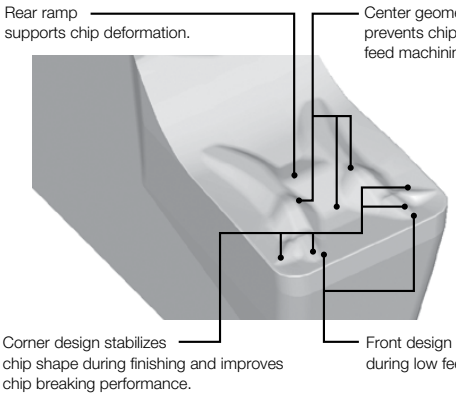
для заказа - kyocera@kyocera-tools.ru

KGDI NEW Internal Grooving

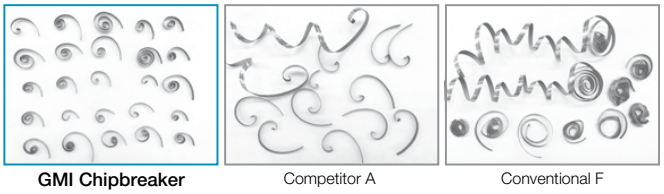
Stable Machining with Excellent Chip Control and Smooth Chip Evacuation

1 Excellent Chip Control with GMI Chipbreaker for Internal Grooving

Evenly breaks chips in various cutting conditions with newly designed chipbreaker geometry.
Good chip control even in finishing applications with small depths of cut.



Chip Control Comparison (Internal Evaluation)

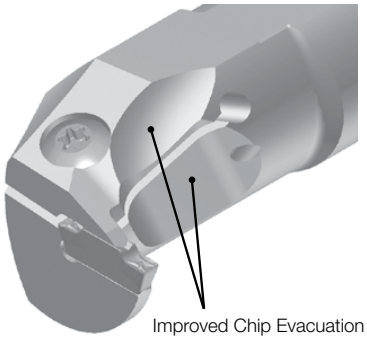


Smooth chip control with stable chip shape compared with Competitor A and Conventional F.
Prevents frequent machine stops caused by tangled chips.

Cutting Conditions: Vc = 330 sfm, f = 0.003 ipr Toolholder: KGDIR3225B-3
Insert: GDM3015N-040GMI Workpiece: 5120 Steel

2 Smooth Chip Evacuation by Creating Chip Pocket

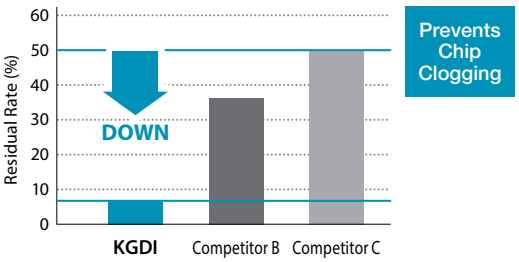
Smooth chip evacuation when grooving and finishing.

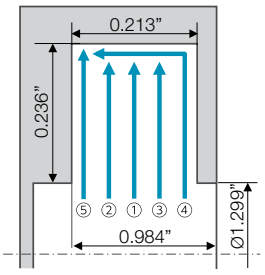


Improved Chip Evacuation with Innovative Chip Pockets

Cutting Conditions:
Vc = 100 m/min
①: D.O.C. = 0.118", ②③: D.O.C. = 0.039", ④⑤: D.O.C. = 0.008"
f = 0.003 ipr
Toolholder: KGDIR3225B-3
Insert: GDM3015N-040GMI
Workpiece: 4131 Steel

Residual Chips (Internal Evaluation)



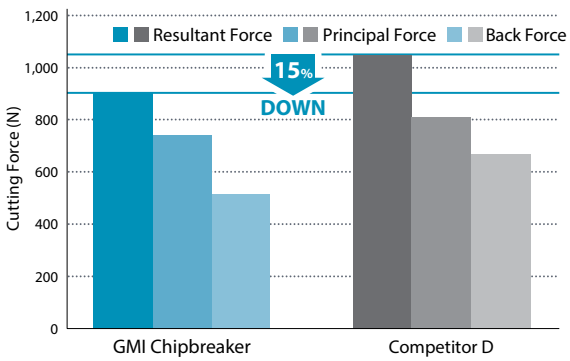


Chips remaining in machined bore were greatly reduced compared with Competitor B and C.

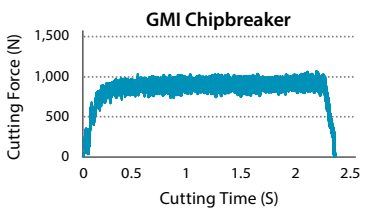
3 Low Cutting Forces and Stable Machining

GMI chipbreaker prevents chip clogging and reduces cutting forces.

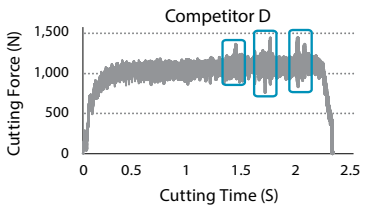
Cutting Force Comparison (Internal Evaluation)



Cutting Conditions: Vc = 490 sfm, f = 0.004 ipr Toolholder: KGDIR3225B-3
Insert: GDM3015N-040GMI Workpiece: 4131 Steel



Stable machining with few changes in cutting force.



Instantaneous increase of cutting force due to clogged chips.

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