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Face Grooving Dia. ØD

Face grooving diameter (ØD) is the suitable value for the initial grooving on the unprocessed workpiece (Ref. Fig.1).
Then, you can widen it up to the center towards the inside (excluding the models listed in the right table) and towards the outside according to machine limits.

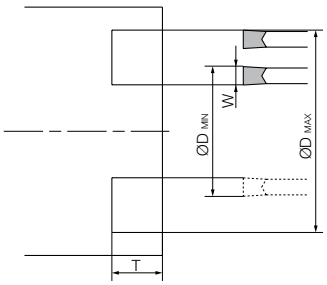
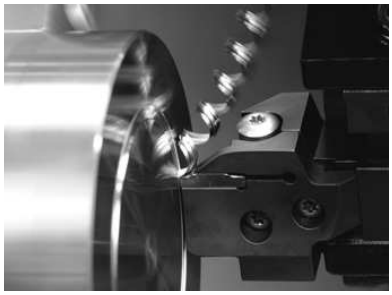
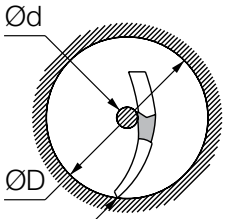


Fig.1



Limit of Turning toward Center

Turning towards the Center causes the toolholder to interfere with the groove wall depending on the initial cut's diameter.



Remaining Boss Dia. Ød

Part Number	ØD (mm)			
	25	26	27	28 and over
	Ød (mm)			
KGDFR/L 2020X25-3AS	4	2	0	(No remaining Boss) 0
2525X25-3AS				
KGDFR/L 2020X25-4AS	6	3	0	
2525X25-4AS				
KGDFR/L 2020X25-5AS	7	4	1	
2525X25-5AS				
KGDFR/L 2020X25-6AS	9	4	1	
2525X25-6AS				

e.g.)
If a groove of external diameter Ø25mm is created using KGDFR2020X25-3AS and turning is made toward the inside, a Ø4mm portion will be left in middle due to interference of toolholder.

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