для заказа - kyocera@kyocera-tools.ru

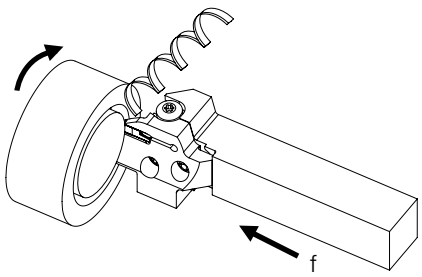
Face Grooving Guide

1) Toolholder Selection

Check the range of applicable "face grooving diameter" as well as the groove width and depth.

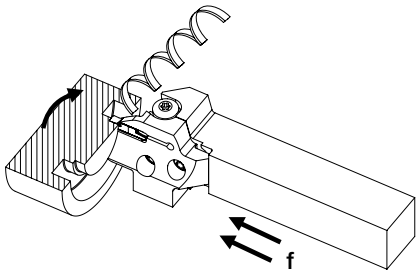
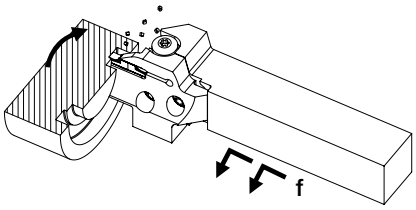
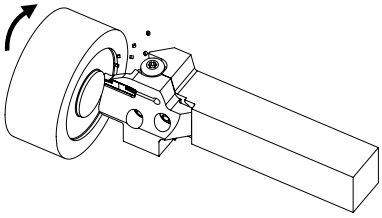
2) Cutting conditions (Feed rate : f)

When machining on steel, set the feed rate (f) so that chips are created in a helical form in cut-off.



3) How to widen the groove (Plunge machining and Turning)

Start machining from the outside and then proceed to the inside.
Chip control will be better in this way.

Plunge milling (Grooving + Side grooving)	Traversing
	 

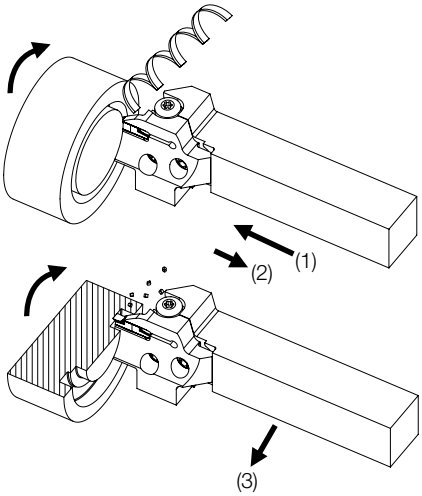
4) Guide for turning

A. When the cutting amount (D.O.C.) is over 0.020"

(1) Perform plunging.

(2) Return the cutting by 0.004".

(3) Perform turning. (Ref. to Fig.1)



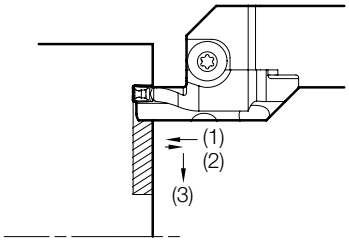


Fig.1

● **When widening the face groove width (Ref. to Fig.2)**

Apply the “Step Turning”.
Then perform finishing.

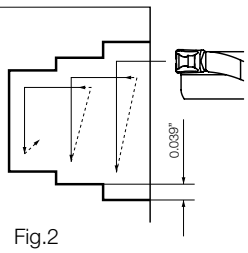


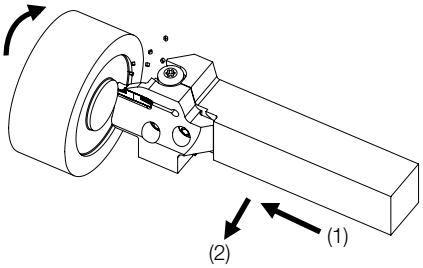
Fig.2

B. When the cutting amount (D.O.C.) is under 0.020"

(1) Perform plunging.

(2) Perform turning.

Machining without interruption is possible.
(Ref. to Fig.3)



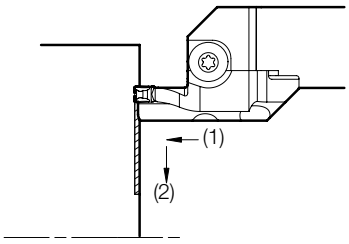


Fig.3

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