для заказа - kyocera@kyocera-tools.ru

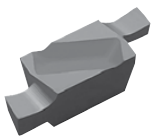
Applicable Inserts

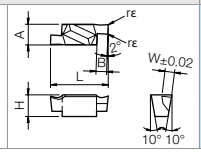
(mm)

Part Number		A	L	H
GVF□	100-…AA	4.3	12	4.5
	200-…AA	4.3	12	4.5
	300-…AA	4.3	12	4.5

P	Carbon Steel / Alloy Steel	●	○	
M	Stainless Steel	●	○	
K	Cast Iron			◕
N	Non-ferrous Metals			◕
S	Titanium Alloy			◕
H	Hard materials (≤40HRC)	●	○	
	Hard materials (≥40HRC)			

Classification of Usage
◕ : Light Interruption / 1st Choice
◴ : Light Interruption / 2nd Choice
● : Continuous / 1st Choice
○ : Continuous / 2nd Choice

Insert (Right-handed Insert Shown)	Part Number	Previous Part Number	Dimensions (mm) W	B	rε	MEGA COAT PR1225	PVD PR930	Carbide KW10	Applicable Toolholders	Ref. Page for Toolholder
	GVF□ 100-005AA	GVF□ 100AA	1.00	2.2	0.05	○	○	Ⓛ	GFVS□…-08AA GFVT□…-08AA	➡ G108
	200-005AA	200AA	2.00	2.2		○	○	○		
	300-005AA	300AA	3.00	2.2		○	○	○		

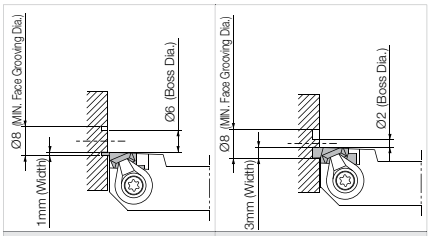


- Dimension B: shows available grooving depth.
- GVF□…005AA inserts are not compatible with GVF□…–OOOA (Ref. to Page ➡ **G116**) inserts because their Side Relief Angle is 10°.

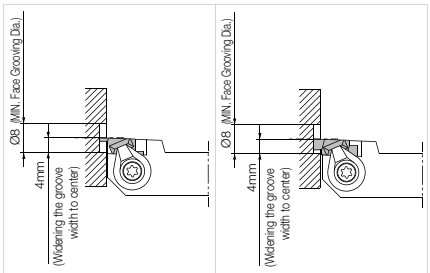
Face Grooving Diameter of GFVS-AA (also GFVT-AA)

Part Number		Face Grooving Dia. ØD MIN	MAX	Applicable Inserts
GFVS□	2020K-08AA	ø8	∞	GVF□100-005AA ~ GVF□300-005AA
	2525M-08AA			
GFVT□	2020K-08AA	(0)	(∞)	
	2525M-08AA			

- It is available to infinity ∞ in case of machining the first groove bigger than MIN.
- When machining towards the outer diameter then there is no MAX. limit to the further groove machining.
- Refer to the machining of the initial groove with MIN.(Ø8)
  If the initial groove is made smaller than this, the toolholder interferes with the workpiece.
- When widening the groove width to inner diameter.
  For machining up to the center of the workpiece regardless of insert width.



Installing GVFL100-005AA | Installing GVFL300-005AA



Installing GVFL100-005AA | Installing GVFL300-005AA

Recommended Cutting Conditions (GFVS-AA / GFVT-AA)

Workpiece Material	Recommended Insert Grade (Vc sfm) MEGACOAT PR1225	PVD PR930	Carbide KW10	Grooving Feed Rate (ipr)	Traversing D.O.C.	Traversing Feed Rate (ipr)	Notes
Carbon Steel / Alloy Steel	★ 160~330	☆ 160~330	-	0.0004~0.0020	Max 0.0197	0.0004~0.0020	Wet
Stainless Steel	★ 160~260	☆ 160~260	-	0.0004~0.0012	Max 0.0118	0.0004~0.0008	
Non-ferrous Metals	-	-	★ ~660	0.0004~0.0031	Max 0.0197	0.0004~0.0031	

* D.O.C. has to be set for less than corner-R (rε) when turning of edge width 0.039" (GVF□100-005AA).

★ : 1st Recommendation ☆ : 2nd Recommendation

Inserts are sold in 10 piece boxes.