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Guide for Grooving with Cermet Insert (Steel)

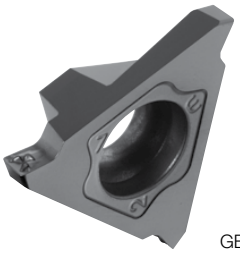
1. Set the feed under 0.0047" ipr (0.0020"~0.0039" ipr normally).
2. Coolant is recommended.
3. Set the cutting speed Vc = 490~720 sfm.
4. Set the toolholder overhang as short as possible.

How to Improve Surface Finish (when surface roughness below 3µm Rz is required)

1. Increase the cutting speed (Vc = 720 sfm MAX.)
2. Program retention time at the groove bottom.
3. Apply a light hone to the cutting edge.

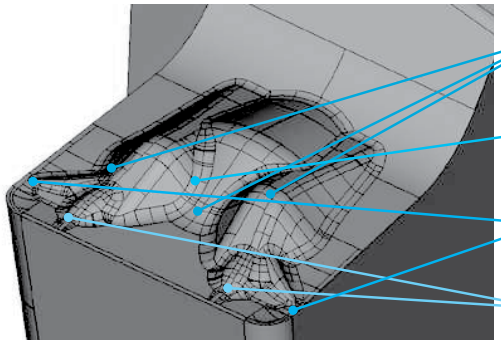
Chip Control of Grooving Insert with Molded Chipbreaker

1. Good chip control to cover wide application range stable chip control at high cutting speed, covering wide range of feed rate
2. Improved chip control and excellent surface finish
   Superior chip control performance and MEGACOAT PR1215 realizes the excellent surface quality
3. Chip control improvement at automated production line.
   (prevent frequent machine stop)



GBA type GM chipbreaker

Multi Bump Design



Center bump and dent squeeze chips for better control.

Helps modifying chip shape.

Stable chip control during shouldering and chamfering.

Front Bump: Stabilize chip control at low feed rates.

Smooth chip control due to optimized bump design of the chipbreaker

Alternative Toolholder Reference Table for Grooving Toolholder

Conventional Toolholder						Alternative Toolholder			
Part Number		Overall length (mm)	Spare Parts: Clamp Screw	Spare Parts: Wrench	Spare Parts: Wrench	Part Number	Overall length (mm)	Notes	Reference Page
KTGF	1010K-16F	125	SB-4070TRW	FT-8	-	KTGF	1010JX-16F	120		G12
	1212M-16F	150					1212JX-16F	120		
	1616M-16F	150					1616JX-16F	120		
KGM	0810K-1.5-125	125	SE-40120TR	-	LTW-15S		-	-	No replacement	G36
	1010K-1.5-125	125				KGM	1010JX-1.5	120		
	1212M-1.5-150	150					1212JX-1.5	120		
KGM	0810K-2-125	125	SE-40120TR	-	LTW-15S		-	-	No replacement	
	1010K-2-125	125				KGM	1010JX-2	120		
	1212M-2-150	150					1212JX-2	120		
	1616M-2-150	150	SE-50125TR	-	LTW-20		1616JX-2	120		
KGM	1010K-2.5-125	125	SE-40120TR	-	LTW-15S	KGM	1010JX-2.5	120		
	1212M-2.5-150	150					1212JX-2.5	120		
	1616M-2.5-150	150	SE-50125TR	-	LTW-20		1616JX-2.5	120		
KGM	1616M-3-150	150	SE-50125TR	-	LTW-20	KGM	1616JX-3	120		

Note) The corresponding replacements may be different from the conventional parts in insert clamping system or insert size.
Make sure their specifications referring to the catalog or other documents.

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