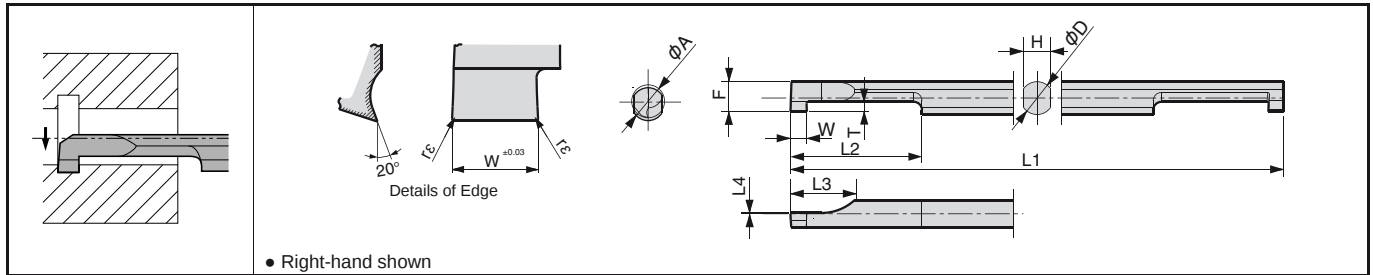


2-Edge Tip-Bar for Micro Internal Grooving HPG type

HPG (Micro Internal Grooving)



Tip-Bar Dimensions

Description	Min. Cutting Dia.	Dimension (mm)										Insert Grade			
												PVD Coated Carbide		Carbide	
	øA	W ^{±0.03}	rε	øD	H	L1	L2	L3	L4	F	T	PR930		KW10	
												R	L	R	L
HPG ^{R/L} 0404-10 0404-20 0505-10 0505-20 0606-10 0606-20 0707-10 0707-20	4	1	0.05 ^{+0 -0.02}	4	3.35	60	15	8	0	3.65	1	●	●	●	
		2										●	●	●	
	5	1		5	4.3	70	20	10		4.55	1.5	●	●	●	
		2										●	●	●	
	6	1		6	5.2	80	25	5.5		2	●	●	●		
		2									●	●	●		
	7	1		7	6.2	80	25	6.45		2	●	●	●		
		2									●	●	●		

• Dimension T: shows available grooving depth.

Description Table for Tip-Bars and Applicable Sleeves

Tip-Bar	Applicable Sleeve ➡ G31
HPG^{R/L} 0404-...	PSH 04-...
0505-...	05-...
0606-...	06-...
0707-...	07-...

Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade (Cutting Speed: m/min)		HPG ^{R/L} 04 HPG ^{R/L} 05	HPG ^{R/L} 06 HPG ^{R/L} 07	Remarks
	PVD Coated Carbide	Carbide			
	PR930	KW10			
Carbon Steel / Alloy Steel	★ 30 ~ 100	-	~0.03	~0.05	Coolant
Stainless Steel	★ 30 ~ 80	-	~0.02	~0.03	
Non-ferrous Metals	-	★ ~300	~0.05	~0.08	

★: 1st Recommendation ☆: 2nd Recommendation

G

Grooving

Tip-Bars are sold
in 1 piece boxes.

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)

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