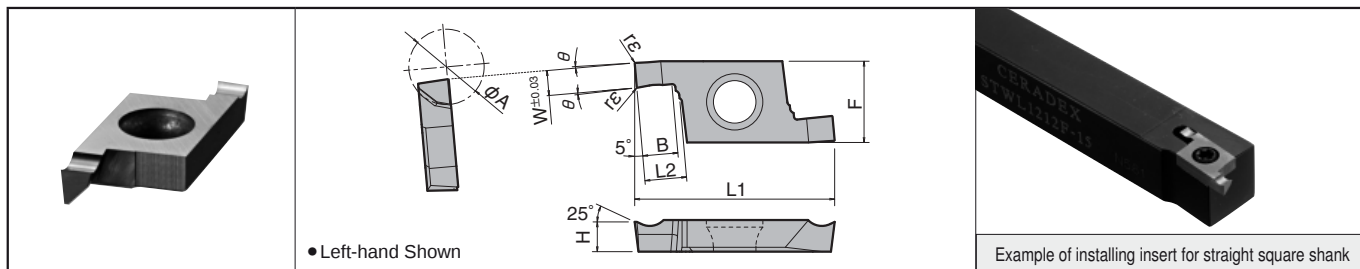


Micro Face Grooving (Twin Bar)

TWFG (Lay-down type)

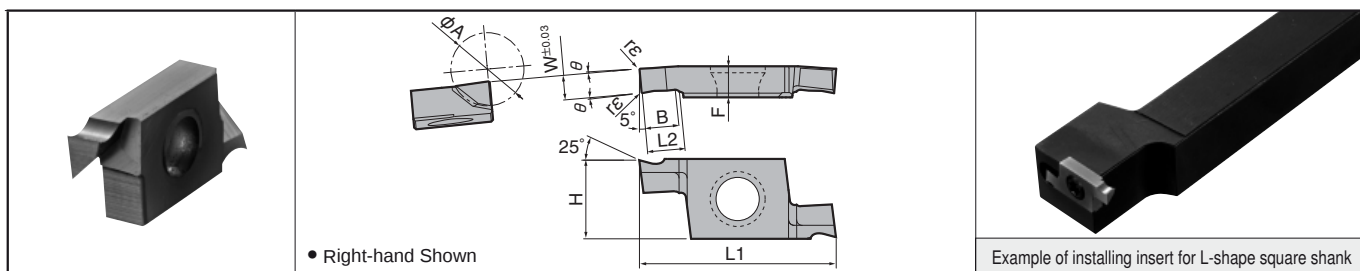


Insert Dimensions

Description	Min. Cutting Dia. øA	Dimension (mm)							Angle (°)	Insert Grade		Ref. Page for Toolholder
		W	rε	H	L1	L2	F	B		PVD Coated Carbide PR1025	Carbide KW10	
TWFG L 050 080 100 125 150 180 200	6	0.5	0.05	2.38	16	3	6.5	1.0	1.5°	L	L	G55
		0.8						1.5		L	L	
		1.0								L	L	
		1.25						2.2	2°	L	L	
		1.5								L	L	
		1.8								L	L	
		2.0						3.0		L	L	

* Dimension B: shows available grooving depth.

TWFGT (Up-right type)



Insert Dimensions

Description	Min. Cutting Dia. øA	Dimension (mm)							Angle (°)	Insert Grade		Ref. Page for Toolholder
		W	rε	H	L1	L2	F	B		PVD Coated Carbide PR1025	Carbide KW10	
TWFGT R 050 080 100 125 150 180 200	6	0.5	0.05	6.4	16	3	2.35	1.0	1.5°	R	R	G55
		0.8						1.5		R	R	
		1.0								R	R	
		1.25						2.2	2°	R	R	
		1.5								R	R	
		1.8								R	R	
		2.0						3.0		R	R	

* Dimension B: shows available grooving depth.

Recommended Cutting Conditions (TWFG / TWFGT)

Workpiece Material	Recommended Insert Grade (Cutting Speed: m/min)		TWFG L050 TWFG L080 TWFG L100 TWFG TR050 TWFG TR080 TWFG TR100	TWFG L125 TWFG L150 TWFG TR125 TWFG TR150	TWFG L180 TWFG L200 TWFG TR180 TWFG TR200	Remarks
	PVD Coated Carbide	Carbide				
	PR1025	KW10	f (mm/rev)			
Carbon Steel / Alloy Steel	★ 30~100		~0.02	~0.03	~0.04	Coolant
Stainless Steel	★ 30~80		~0.01	~0.02	~0.02	
Non-ferrous Metals		★ ~300	~0.03	~0.04	~0.06	

★ : 1st Recommendation ☆ : 2nd Recommendation

Twin Bars are sold in 5 piece boxes.

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

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