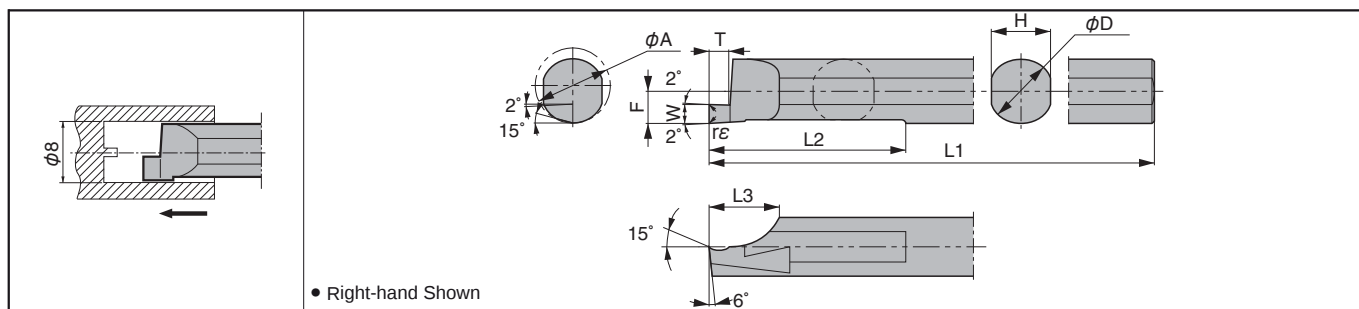


PSFG-S (Tip Bar)

This insert will be switched to **HPFG** (2-Edge See Page **G53**).



● Tip-Bar Dimensions

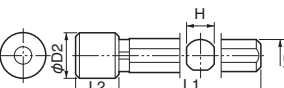
Classification of usage	P	Carbon Steel / Alloy Steel				●		
	M	Stainless Steel				●		
● : Continuous / 1st Choice	K	Cast Iron					●	
○ : Continuous / 2nd Choice	N	Non-ferrous Metals					●	
	S	Titanium Alloy					●	
	H	Hard materials (under 40HRC)				●		
		Hard materials (over 40HRC)						

Description		Min. Cutting Dia.	Dimension (mm)									Cermet		PVD Coated Carbide		Carbide		PCD	
			W ^{±0.03}	rε	H	L1	L2	F	T	F	T	TC60	PR630	PR915	PR930	KW10	KPD001	KPD010	
PSFG ^{R/L}	0810-20S	8	1.0	0.05	6.8	6.2	80	25.5	7	3.4	2.0	●	●	●	●	●	●		
	0820-20S	8	2.0									●	●	●	●	●	●		
	0830-20S	8	3.0									●	●	●	●	●	●		

• Dimension T shows available grooving depth.

● Applicable Sleeve

This sleeve is for 1-Edge Tip-Bar. For 2-Edge Tip-Bar, use **G53**.

Shape	Description	(Previous Description)	Std.	Dimension (mm)							Spare Parts		Applicable Tip-Ba
											Screw	Wrench	
				ØD1	ØD2	Ød1	Ød2	H	L1	L2			
 (Tip-Bar installation side)	PH 0712-60	PH -0712	●	12	19	6.8	8	11	60	20	HS4X4	LW-2	PSFG ⁵ / ₁₆ ○○ -20S
	PH 0716-80	PH -0716	●	16	22	6.8	Rp ¹ / ₄ (PS ¹ / ₄)	15	80	20	HS4X4	LW-2	PSFG ⁵ / ₁₆ ○○ -20S

• Besides the above Sleeves, Collet Chucks are also available in the market.

◆ Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade (Cutting Speed: m/min)				PSFG0810	PSFG0820	PSFG0830	Remarks
	Cermet	PVD Coated Carbide		Carbide				
	TC60	PR630	PR930	KW10				
Carbon Steel / Alloy Steel	☆ 60~120	☆ 30~100	★ 30~100		~0.02	~0.04	~0.05	Coolant
Stainless Steel	☆ 50~100	☆ 30~80	★ 30~80		~0.01	~0.02	~0.03	
Non-ferrous Metals				★ ~300	~0.04	~0.06	~0.08	

★ : 1st Recommendation ☆ : 2nd Recommendation

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

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Tip-Bars are sold in 1 piece boxes.