

◆ Face Grooving Diameter of GFV

① e.g.) GFV^{R/L}...-201A

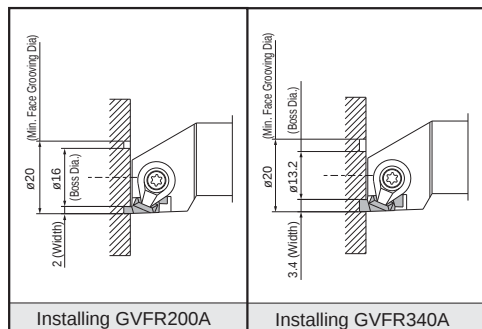
Description	Face Grooving Dia. ϕD		Applicable inserts
	MIN.	MAX.	
GFV^{R/L} 2020K-201A 2525M-201A	20 (12)	∞ (∞)	GVF ^{R/L} 200A~340A GVF ^{R/L} 100AR~150AR

• It is available to infinity ∞ in case of machining the first groove bigger than MIN.

• It is available to infinity ∞ when machining toward outer diameter.

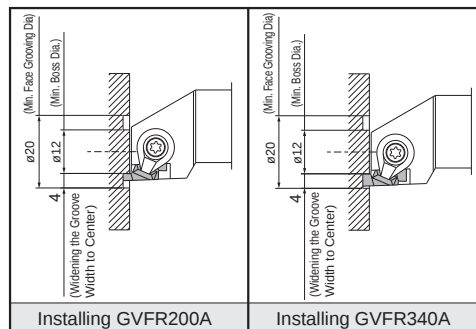
• When machining the initial groove on the face of MIN. $\phi 20$

If the initial groove is made smaller than this, the toolholder interferes with the workpiece.



• When widening the groove width to inner diameter.

Face groove diameter D MIN (12) is the limit; the toolholder interferes with the workpiece in case of smaller than $\phi 12$.



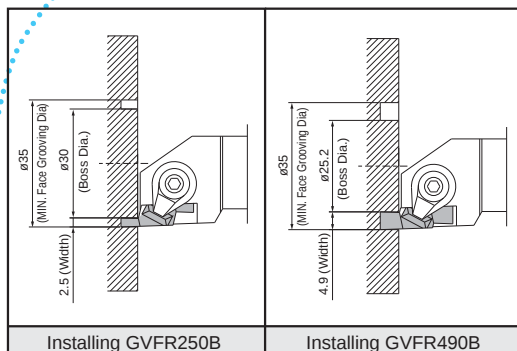
② e.g.) GFV^{R/L}...-351B / 352B (same as GFV^{R/L}...-○○○B type, GFV^{R/L}...-○○○C type)

Description	Face Grooving Dia. ϕD		Applicable Inserts
	MIN.	MAX.	
GFV^{R/L} 2020K-351B 2525M-351B 2020K-352B 2525M-352B	35 (25)	50 (∞)	GVF ^{R/L} 250B~350B GVF ^{R/L} 150BR GVF ^{R/L} 400B~490B GVF ^{R/L} 200BR

• It is possible to widen the groove to infinity ∞ when machining the initial groove within MIN-MAX. and then widening to outer diameter.

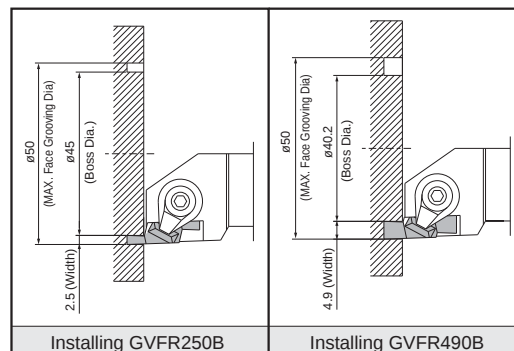
• When machining the initial groove on the face at MIN. $\phi 35$

If the initial groove is made smaller than this, the toolholder interferes with the workpiece.



• When machining the initial groove on the face at MAX. $\phi 50$.

If the first groove is bigger than this, the toolholder interferes with the workpiece.



• When widening the groove width to inner diameter.

Face Grooving Dia. ϕD MIN. ($\phi 25$ Boss Dia.) is the limitation regardless of insert width, even widening the groove width to the center from the initial groove at ϕD MIN. ($\phi 35$) or ϕD MAX. ($\phi 50$). The toolholder interferes with the workpiece when closer to the center.

