

Guide for Machining

Grooving Insert with Molded Chipbreaker

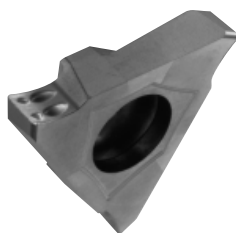
Guide for Grooving by Cermet Insert (Steel)

1. Set the f under 0.12mm/rev (0.05~0.10mm/rev normally).
2. Coolant is recommended.
3. Set the cutting speed $V_c=150\text{--}220\text{m/min}$.
4. Set the toolholder overhang as short as possible.

How to Improve Surface Finish (when surface roughness below $3\text{ }\mu\text{m Rz}$ is required)

1. Increase the cutting speed ($V_c=220\text{m/min}$.MAX)
2. Program dwell-motion at the groove bottom.
3. Apply a light hone to the cutting edge by hand lapper.

Chip Control of Grooving Insert with Molded Chipbreaker

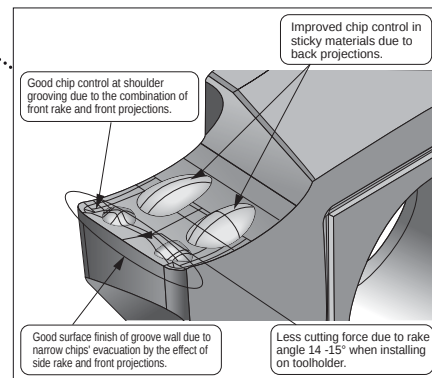


GBA-MY

3-Edge Molded Chipbreaker

•Advantages of MY Chipbreaker

1. Molded chipbreaker curls chips spirally and evacuates chips easily.
2. High precision molded Insert with economical 3 cutting edges.
3. Can be used in automated production.



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Grooving