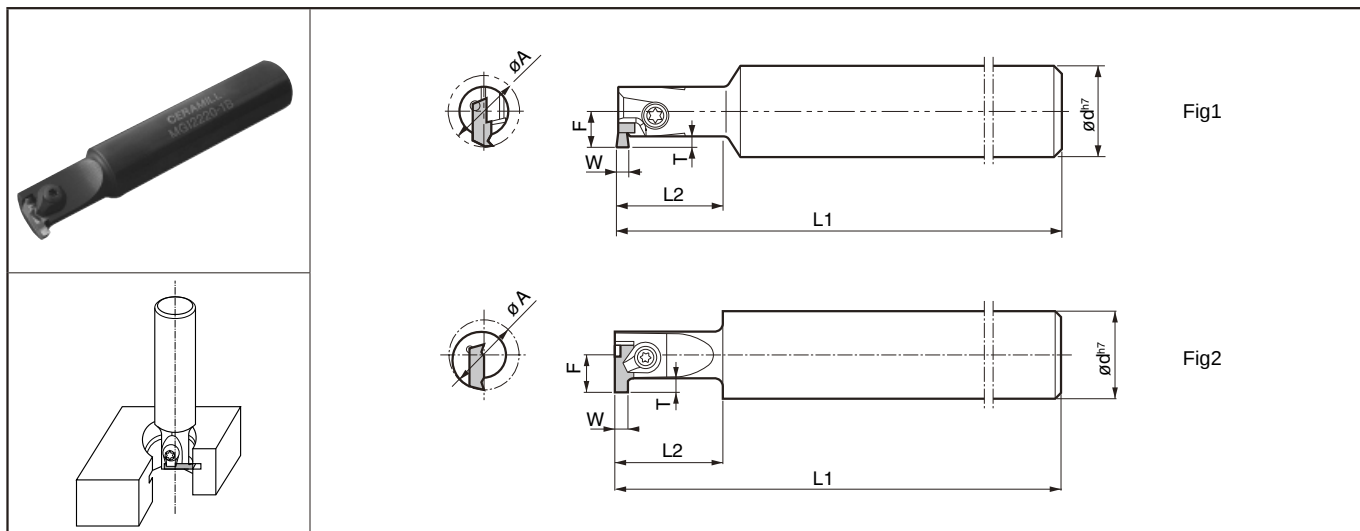


MGI Grooving Endmill



MGI



Toolholder Dimensions

Description		Std.	Min. Bore Dia.	Dimension (mm)				Edge Width	Drawing	Spare Parts			Applicable Inserts  M133			
				ØA	Ød	L1	L2			F	T	W		Clamp Set		Clamp Screw
								 5F						 6F		 FT
MGI	1420-1SS	● 14	20	100	20	6.8	2.2	1.0~3.0	Fig.1	-	SB-4065TR	FT-15	GVR100SS~GVR300SS			
	1620-1S	● 16			25	7.8	2.2	1.0~3.4		-	SB-4085TR	FT-15	GVR100S~GVR340S			
	2020-1A	● 20			110	30	9.8	2.2	1.0~3.4	Fig.2	CPS-5F	-	FT-15	GVR100A~GVR340A		
	2220-1B	● 22					11	2.8	1.45~4.0					GVR100AR~150AR		
	3225-1C	● 32	25	120	35	16	5.5 (4.5)	2.8~4.25	CPS-6F					-	LW-3	GVR145B~GVR400B
	4025-1C	● 40			40	20	GVR100BR~150BR									

• Dimension T: shows available grooving depth.

• GVR280C, GVR300C is available to the groove depth up to 4.5mm.

• GVR430C~500C can be installed to MGI3225-1C and 4025-1C, but not recommended for steel machining because of toolholder's rigidity.

Recommended Cutting Conditions

Workpiece Material	fz (mm/t)	Recommended Insert Grade (Cutting Speed Vc: m/min)							
		Cermet				CVD Coated Carbide	PVD Coated Carbide		Carbide
		TN60	TN90	TC40	TC60	CR9025	PR630	PR930	KW10
Stainless Steel	0.03~0.12		☆ 100~180	☆ 100~180	★ 80~150		☆ 60~130	★ 60~130	
Carbon Steel	0.05~0.15		★ 120~200	☆ 120~200	☆ 100~180		☆ 80~150	☆ 80~150	
Alloy Steel	0.05~0.15		★ 120~200	☆ 120~200	☆ 100~180		☆ 80~150	☆ 80~150	
Mold Steel	0.03~0.12		★ 100~180	☆ 100~180	☆ 80~150		☆ 60~130	☆ 60~130	
Cast Iron	0.05~0.2		★ 100~150	☆ 100~150					★ 80~150
Non-ferrous Metals	0.05~0.2								★ 100~300

• Use down-cut machining.

★ : 1st Recommendation ☆ : 2nd Recommendation

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Milling