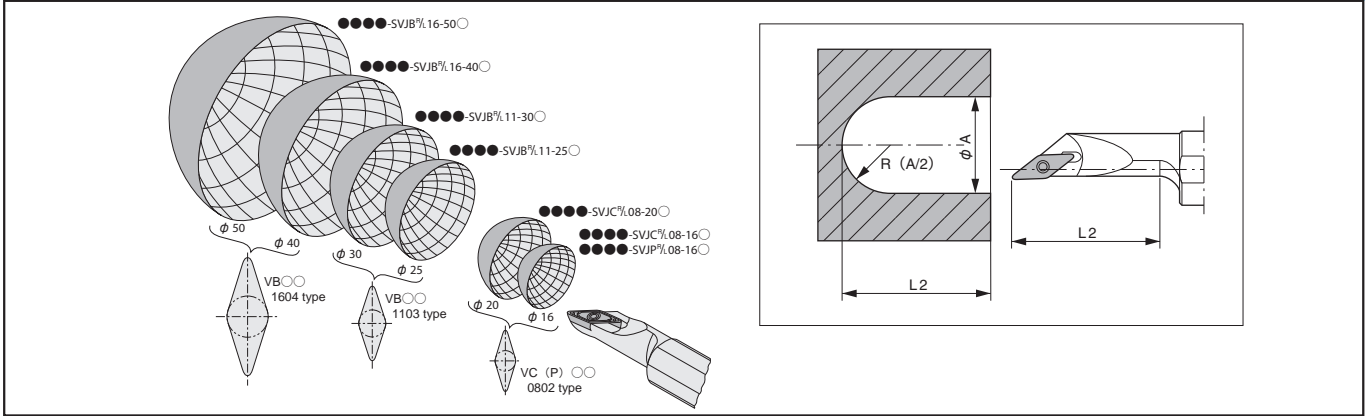


Application of ○...SVJB (C) - ○, S...SVJP-○

[Toolholder Refer Page for details **F50** (Dynamic Bar), **F54**]

1. Application Range



2. Machining method

Case with No Existing Hole	Finishing
<p>(Note) f shall be under 0.05mm/rev for internal facing.</p>	<p>Spherical Machining</p>
<h3>Case with Drilled Hole</h3> <p>(Note) f shall be under 0.05mm/rev for internal facing.</p>	<h3>Internal Facing</h3> <p>Machining Process ① Finish the internal face first. ② Next, finish the internal diameter.</p>

3. Caution

When machining past the center of the workpiece, insert may break.

Fix the insert edge at the center of the workpiece.
 Adjust the machining program to radius minus the value of Corner-R (r).

For internal profiling, a_p should be less than the value of Corner-R (r).
 [Burs may occur, if a_p is bigger than Corner-R (r).]

Poor finish

