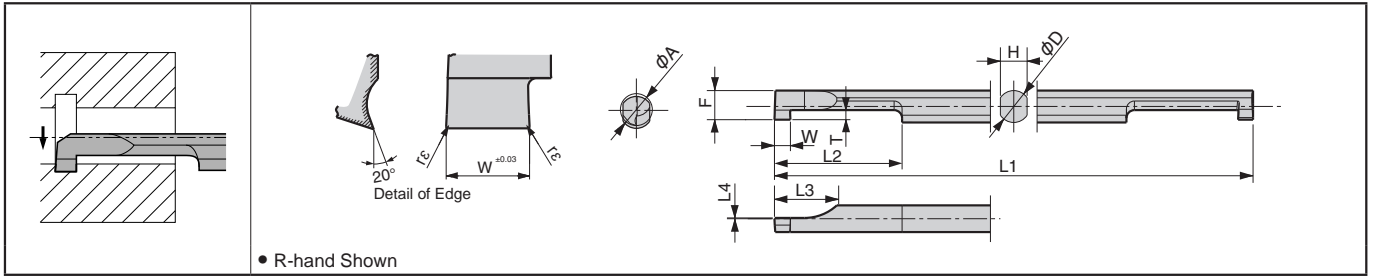


2-Edge Tip-Bar for Micro Internal Grooving HPG / PSG-S

HPG (Small Dia. Internal Grooving)



Tip-Bars Dimensions

Description	Min. Bore Dia. ϕA	Dimension (mm)										PVD Coated Carbide		Carbide		
		W±0.03	rε	ϕD	H	L1	L2	L3	L4	F	T	PR930		KW10		
												R	L	R	L	
HPG ^{R/L} 0404-10	4	1	0.05	4	3.35	60	15	8		3.65	1	●	●	●		
		2										●	●	●		
0505-10	5	1		5	4.3	70	20	10	0	4.55	1.5	●	●	●		
		2										●	●	●		
0606-10	6	1		6	5.2					5.5		2	●	●	●	
		2											●	●	●	
0707-10	7	1		7	6.2	80	25			6.45			●	●	●	
		2											●	●	●	

• Dimension T shows available grooving depth.

Description Table for Tip-Bars and Applicable Sleeves

Tip-Bar Description	Applicable Sleeves
HPG ^{R/L} 0404-...	PSH 04-....
0505-...	05-....
0606-...	06-....
0707-...	07-....

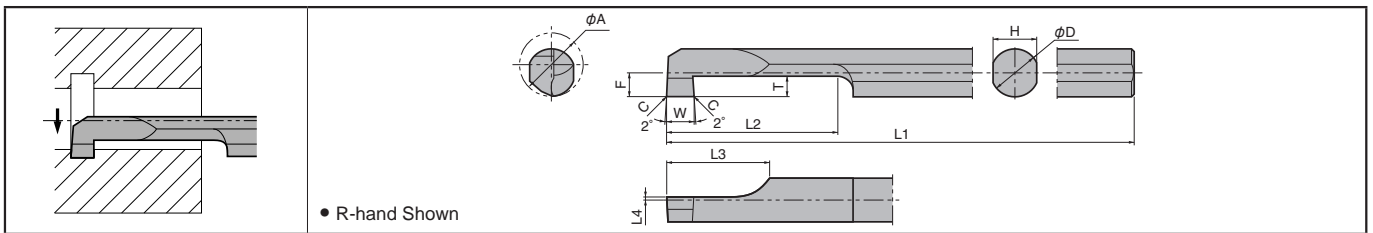
Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade (Vc: m/min)		HPG ^{R/L} 04 HPG ^{R/L} 05	HPG ^{R/L} 06 HPG ^{R/L} 07	Remarks
	PVD Coated Carbide	Carbide			
	PR930	KW10	Feed Rate (mm/rev)		
Carbon steel / Alloy steel (C45 / 34CrMo4 etc)	★ 30~100	-	~0.03	~0.05	Coolant
Stainless Steel (SUS304 etc)	★ 30~80	-	~0.02	~0.03	
Non-ferrous Metals (Aluminum / Brass)	-	★ ~300	~0.05	~0.08	

★:1st Recommendation ☆:2nd Recommendation

PSG-S (Tip-Bars)

This insert will be switched to HPG Type (2-Edge).



Tip-Bars Dimensions

Description	Min. Bore Dia. ϕA	Dimension (mm)										Cermet	PVD Coated Carbide	Carbide	Ref. page for Applicable Sleeves
		W±0.03	C	ϕD	H	L1	L2	L3	L4	F	T	TC60M	PR930	KW10	
												TC60M	PR930	KW10	
PSG ^{R/L} 0510-60S	5	1.0	0.05	3.8	3.6	60	15	8	0.1	1.86	1.5	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	F80
		2.0	0.1									<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
0610-70S	6	1.0	0.05	4.8	4.4	70	20	10	0.3	2.86	2.0	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		2.0	0.1									<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
0710-70S	7	1.0	0.05	5.8	5.2	70	20	10	0.3	2.86	2.0	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		2.0	0.1									<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
0810-80S	8	1.0	0.05	6.8	6.2	80	25	10	0.3	3.38	2.0	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
		2.0	0.1									<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	

• Dimension T shows available grooving depth.

• Dimension L4 indicates the cutting edge is above the Tool's Center Position.

Recommended Cutting Conditions **G89**