

# Summary of Face Grooving

## KGDF Face Grooving $\phi 25\sim$ (G68~G75)

Type	* KGDF
Min. Face Groove Dia.	$\phi 25$
Width (mm)	3.0~6.0
Grooving Depth (mm)	13~32
Ref. Page	<b>G70</b>

\* The separate type toolholders can be used with all applicable insert types if their hand is matching.

Grooving and Longitudinal turning

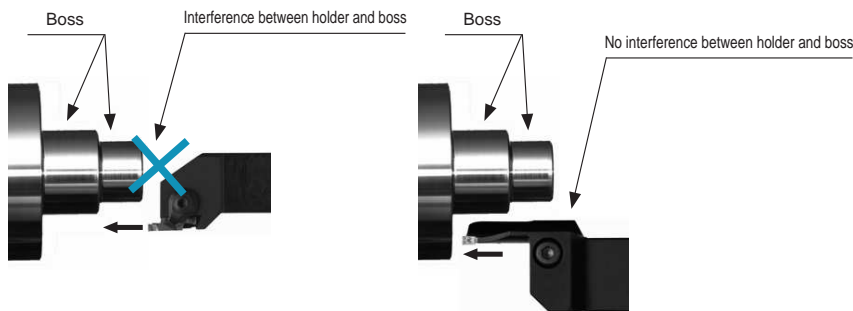
**GM**

Deep grooving and Longitudinal turning

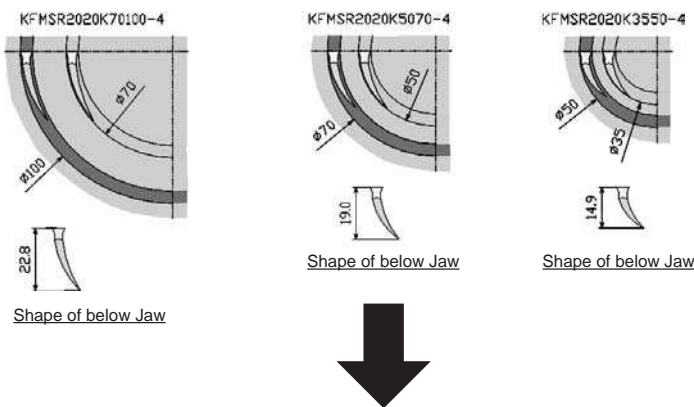
**DM**

## Caution for Face Grooving

1) When face grooving, the suitable holder depends on the length of the boss



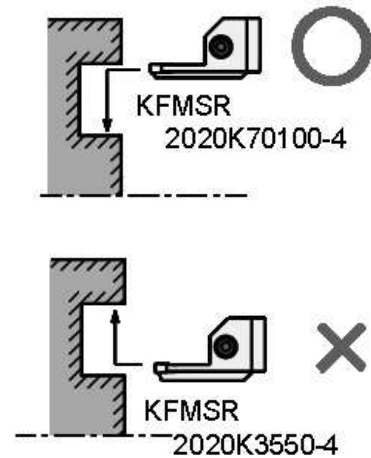
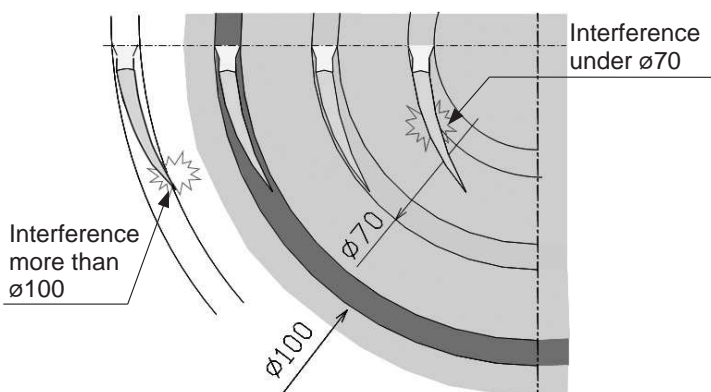
2) Selection of Face Grooving Toolholder



Wider grooving (longitudinal turning) should be performed from the outside inwards

3) Interference of Face Grooving Toolholder

e.g.) [KFMSR2525M70100-4](#)



- Example of usage for the face grooving toolholder. When face grooving, KFMSR2525M70100-4 should be between  $\phi 70\sim\phi 100$  for grooving the outer diameter. If the workpiece is machined at a diameter  $\geq \phi 100$  or  $\leq \phi 70$ , the jaw of holder interferes with the workpiece.