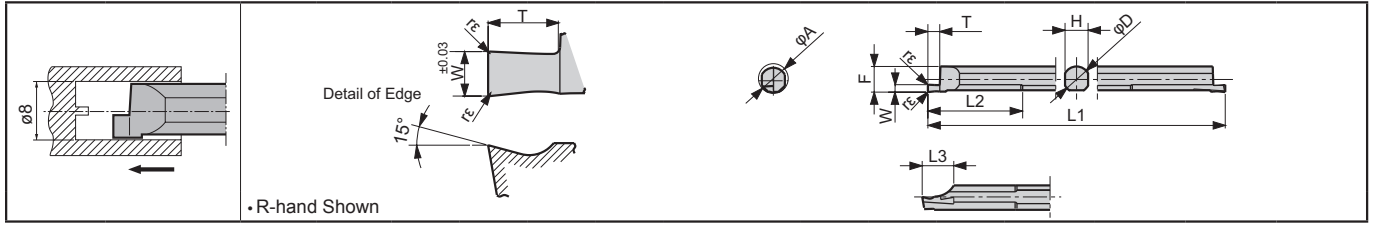


# Tip-Bar for Micro Internal Grooving HPFG / PSFG-S

## HPFG Face Grooving (Small Dia.)



• R-hand Shown

### Tip-Bars Dimensions

Description	Face Grooving Dia. øA		Dimension (mm)									Insert Grade			
			W <sup>±0.03</sup>	rε	øD	H	L1	L2	L3	F	T	PVD Coated Carbide		Carbide	
	PR930											KW10			
	MIN.	MAX.										R	L	R	L
<b>HPFG<sup>R/L</sup> 0807-10</b>	8 (0)	∞ (∞)	1	0.05	7	6.2	80	25	8.5	6.9	2	●	●	●	
<b>0807-20</b>			●									●	●		
<b>0807-30</b>			●									●	●		

• Dimension T shows available grooving depth.

• Face grooving diameter øD MIN. (0) means that you can make the initial groove within MIN – MAX and then widen it to the center.

Applicable Sleeves **F76**

### Recommended Cutting Conditions

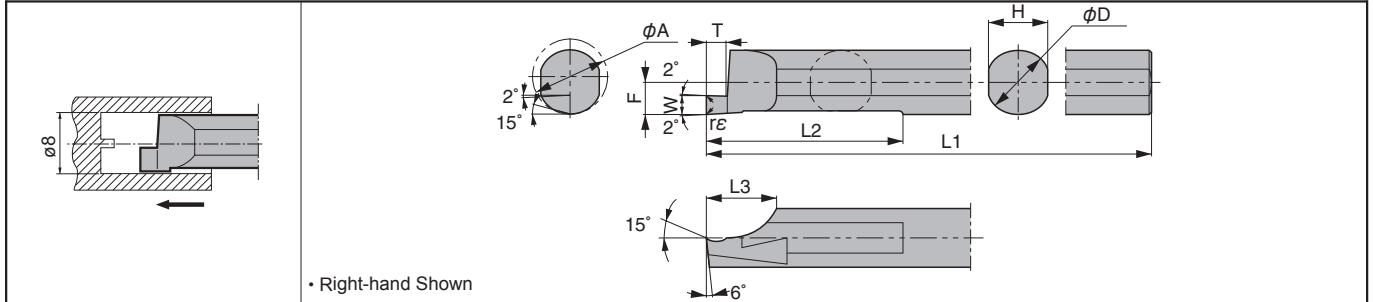
Workpiece Material	Recommended Insert Grade (Vc: m/min)		HPFG <sup>R/L</sup> 0807-10	HPFG <sup>R/L</sup> 0807-20	HPFG <sup>R/L</sup> 0807-30	Remarks
	PVD Coated Carbide	Carbide				
	PR930	KW10				
Carbon steel / Alloy steel (C45 / 34CrMo4 etc.)	★ 30-100	—	~0.02	~0.04	~0.05	Coolant
Stainless Steel (SUS304 etc.)	★ 30-80	—	~0.01	~0.02	~0.03	
Non-ferrous Metals (Aluminum / Brass etc.)	—	★ ~300	~0.04	~0.06	~0.08	

★ : 1st Recommendation ☆ : 2nd Recommendation



## PSFG-S (Tip-Bars)

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



• Right-hand Shown

Workpiece Material	Face Grooving Dia. øA		Dimension (mm)									TC60M	PVD Coated Carbide	Carbide	Ref. Page for Toolholder
			W <sup>±0.03</sup>	rε	øD	H	L1	L2	L3	F	T				
	MIN.	MAX.													
<b>PSFG<sup>R/L</sup> 0810-20S</b>	8 (0)	∞ (∞)	1.0	0.05	6.8	6.2	80	25.5	7	3.4	2.0	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<b>F80</b>
<b>0820-20S</b>			2.0									<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
<b>0830-20S</b>			3.0									<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	

• Dimension T shows available grooving depth.

• Face grooving diameter øD MIN. (0) means that you can make the initial groove within MIN – MAX and then widen it to the center.

### Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade (Vc: m/min)				PSFG0810	PSFG0820	PSFG0830	Remarks
	Cermet	PVD Coated Carbide	Carbide					
			TC60	PR630				
Carbon steel / Alloy steel (S45C / SCM etc.)	☆ 60-120	☆ 30-100	★ 30-100		~0.02	~0.04	~0.05	Coolant
Stainless Steel (SUS304 etc.)	☆ 50-100	☆ 30-80	★ 30-80		~0.01	~0.02	~0.03	
Non-ferrous Metals (Aluminum / Brass etc.)			★ ~300		~0.04	~0.06	~0.08	

★ : 1st Recommendation ☆ : 2nd Recommendation

- : Std. Item
- : Check Availability

Tip-Bar is sold in 1 piece boxes.