

Face Grooving Toolholders (Separate type)

KGDF

Toolholder Dimensions

Angle	Width (mm)	Max. depth of cut (mm)	Unit Description	Std.		Toolholder Description G28	Blade Description G73	Dimension (mm)								Width (mm)		Face Grooving Dia. øD(mm)	
				R	L			H1-h	H2	H3	B	L1	L2	F1	T	W	MIN.	MAX.	
0°	6	15	KGDF ^{R/L} 2020X25-6BS	●	●	KGD ^R 2020-C	KGDF ^{R/L} -25-6B-C	20	12	11.6	20	120	38	24.2	15	20	25	35	
				●	●		KGDF ^{R/L} -35-6B-C										35	50	
				●	●		KGDF ^{R/L} -50-6B-C										50	75	
				●	●		KGDF ^{R/L} -75-6B-C										75	115	
				●	●		KGDF ^{R/L} -115-6B-C										115	180	
				●	●		KGDF ^{R/L} -180-6B-C										180	235	
		20	KGDF ^{R/L} 2020X25-6CS	●	●		KGDF ^{R/L} -235-6B-C										235	∞	
				●	●		KGDF ^{R/L} -25-6C-C										25	35	
				●	●		KGDF ^{R/L} -35-6C-C										35	50	
				●	●		KGDF ^{R/L} -50-6C-C										50	75	
				●	●		KGDF ^{R/L} -75-6C-C										75	115	
				●	●		KGDF ^{R/L} -115-6C-C										115	180	
	25	KGDF ^{R/L} 2020X35-6CS	●	●	KGDF ^{R/L} -180-6C-C	180	235												
			●	●	KGDF ^{R/L} -235-6C-C	235	∞												
			●	●	KGDF ^{R/L} -25-6C-C	25	35												
			●	●	KGDF ^{R/L} -35-6C-C	35	50												
			●	●	KGDF ^{R/L} -50-6C-C	50	75												
			●	●	KGDF ^{R/L} -75-6C-C	75	115												
	6	15	KGDF ^{R/L} 2525X25-6BS	●	●	KGD ^R 2525-C	KGDF ^{R/L} -25-6B-C	25	7	11.6	25	145	38	29.2	15	20	25	35	
				●	●		KGDF ^{R/L} -35-6B-C										35	50	
				●	●		KGDF ^{R/L} -50-6B-C										50	75	
				●	●		KGDF ^{R/L} -75-6B-C										75	115	
				●	●		KGDF ^{R/L} -115-6B-C										115	180	
				●	●		KGDF ^{R/L} -180-6B-C										180	235	
20		KGDF ^{R/L} 2525X25-6CS	●	●	KGDF ^{R/L} -235-6B-C		235										∞		
			●	●	KGDF ^{R/L} -25-6C-C		25										35		
			●	●	KGDF ^{R/L} -35-6C-C		35										50		
			●	●	KGDF ^{R/L} -50-6C-C		50										75		
			●	●	KGDF ^{R/L} -75-6C-C		75										115		
			●	●	KGDF ^{R/L} -115-6C-C		115										180		
25	KGDF ^{R/L} 2525X35-6CS	●	●	KGDF ^{R/L} -180-6C-C	180	235													
		●	●	KGDF ^{R/L} -235-6C-C	235	∞													
		●	●	KGDF ^{R/L} -25-6C-C	25	35													
		●	●	KGDF ^{R/L} -35-6C-C	35	50													
		●	●	KGDF ^{R/L} -50-6C-C	50	75													
		●	●	KGDF ^{R/L} -75-6C-C	75	115													
32	KGDF ^{R/L} 2525X75-6DS	●	●	KGDF ^{R/L} -115-6D-C	115	180													
		●	●	KGDF ^{R/L} -180-6D-C	180	235													
		●	●	KGDF ^{R/L} -235-6D-C	235	∞													
		●	●	KGDF ^{R/L} -25-6D-C	25	35													
		●	●	KGDF ^{R/L} -35-6D-C	35	50													
		●	●	KGDF ^{R/L} -50-6D-C	50	75													

Spare Parts

Unit Description	Spare Parts		
	Clamp Bolt (for Insert Clamp)	Fixing bolt (for blade)	Wrench
KGDF ^{R/L}S			

* Note that the parts are included in the toolholder when purchasing the toolholder and blade separately.

Face Grooving Dia. øD

Face grooving diameter (øD) is the suitable value for the initial grooving on the unprocessed workpiece (see Fig.1). Then, you can widen it up to the center towards the inside (excluding the models listed in the right table), and towards the outside according to machine limits.

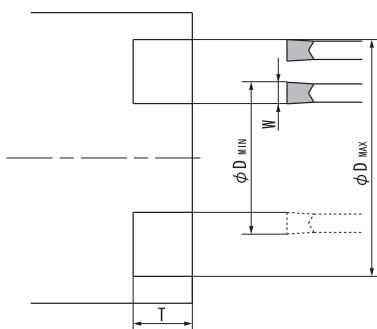


Fig.1

Minimum traversing diameter of small groove

Traversing towards the Center causes the toolholder to interfere with the groove wall depending on the initial cut's diameter.

Description	øD			
	25	26	27	28 Over
KGDF ^{R/L} 2020X25-3AS 2525X25-3AS	4	2	0	(No remaining Boss)
KGDF ^{R/L} 2020X25-4AS 2525X25-4AS	6	3	0	
KGDF ^{R/L} 2020X25-5AS 2525X25-5AS	7	4	1	
KGDF ^{R/L} 2020X25-6AS 2525X25-6AS	9	4	1	

Example)

If a groove of external diameter ø25 is created using KGDFR2020X25-3AS and traversing is made toward the inside, a ø4 portion will be left in middle due to interference of toolholder.

● : Std. Item □ : Check Availability