

For Successful Machining with KGDF

Points to be checked for face grooving

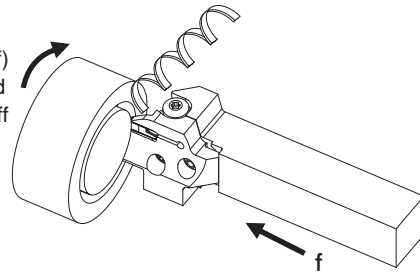
1) Toolholder Selection

Check the range of applicable "face grooving diameter" as well as the groove width and depth.

2) Machining conditions

(Feed rate: f)

When machining on steel, set the feed rate (f) so that chips are created in a helical form in cut-off (see Fig. 1).



3) How to widen the groove (Cut-off and Longitudinal turning)

Start machining from the outside and then proceed to the inside. Chip control will be better in this way.

Cut-off (Grooving + Side grooving)	Longitudinal turning

4) Guide for longitudinal turning

A. When the cutting amount (a_p) is over 0.5 mm

- ① Perform Cut-off.
- ② Return the cutting by 0.1 mm.
- ③ Perform longitudinal turning.

(See Fig.1)

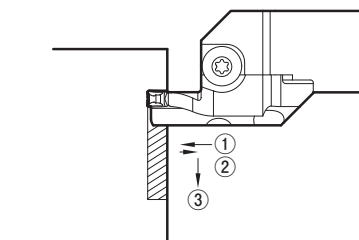
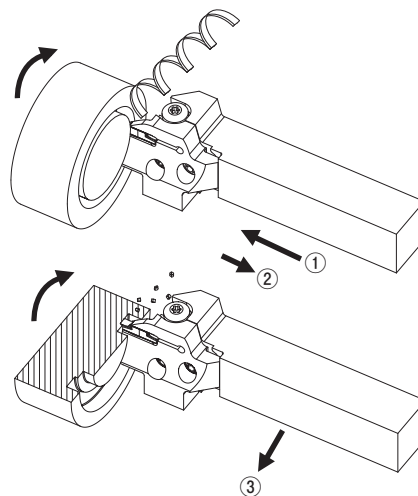


Fig.1

● When widening the face groove width (See Fig.2)

Apply the "Step Turning".
Then perform finishing.

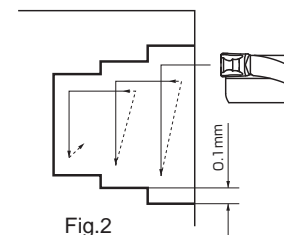


Fig.2

B. When the cutting amount (a_p) is under 0.5 mm

- ① Perform Cut-off.
- ② Perform longitudinal turning.

Machining without interruption is possible. (See Fig.3)

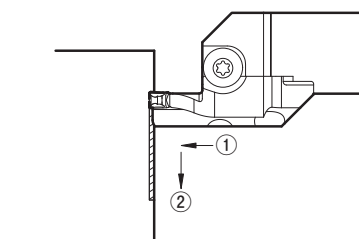
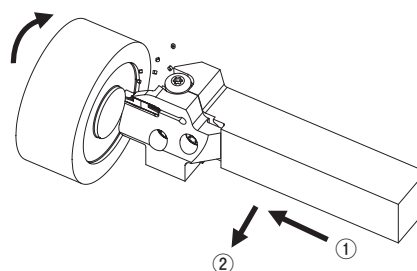


Fig.3

