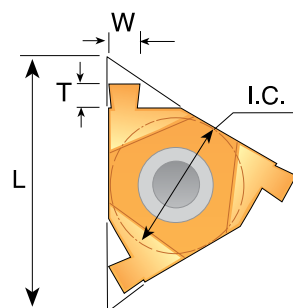


Grooving Inserts

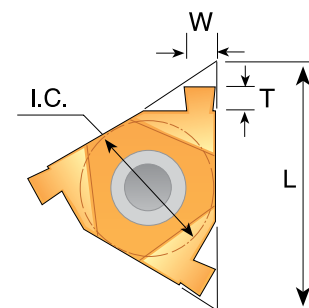
Carbide – Internal & External



CARBIDE GRADE BXC: P30-P50
K25-K40



External Right Hand
or Internal Left Hand



Internal Right Hand
or External Left Hand

- PVD TiN coated grade for low cutting speed
- Works well with a wide range of steel and stainless steel

NOTE: Shim must be changed to AE 16-0 or AI 16-0

Change shim from threading to grooving and use the same threading toolholder

Internal IR/EL

Description	I.C. (Inch)	W ±0.001" (Inch)	T (Inch)	L (mm)	Code
16 IR/EL 0.039	3/8	0.039	0.055	16	570685
16 IR/EL 0.047	3/8	0.047	0.063	16	570686
16 IR/EL 0.055	3/8	0.055	0.071	16	570687
16 IR/EL 0.067	3/8	0.067	0.079	16	570688
16 IR/EL 0.077	3/8	0.077	0.079	16	570689
16 IR/EL 0.089	3/8	0.089	0.089	16	570690
SHIM -- AI 16-0	-	-	-	-	570691

External ER/IL

Description	I.C. (Inch)	W ±0.001" (Inch)	T (Inch)	L (mm)	Code
16 ER/IL 0.039	3/8	0.039	0.055	16	570675
16 ER/IL 0.047	3/8	0.047	0.063	16	570676
16 ER/IL 0.055	3/8	0.055	0.071	16	570677
16 ER/IL 0.067	3/8	0.067	0.079	16	570678
16 ER/IL 0.077	3/8	0.077	0.079	16	570679
16 ER/IL 0.089	3/8	0.089	0.089	16	570680
SHIM -- AE 16-0	-	-	-	-	570681

Recommended Cutting Speeds

ISO	Materials	Cutting Speed m/min (ft/min)
P	Low and medium carbon steels	20-100 (66-330)
	High carbon steels	30-80 (100-265)
	Alloy steels, treated steels	40-90 (132-300)
M	Stainless steels	30-80 (100-265)
	Cast steels	30-90 (100-300)
K	Cast Iron	30-90 (100-300)
N	Non-ferrous and Aluminum	20-200 (66-660)