

GROOVING SYSTEM

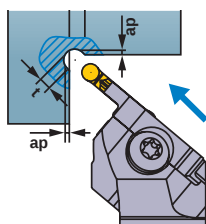
RECOMMENDED CUTTING CONDITIONS [For External Recessing]

	Work Material	Hardness	Grade	Cutting Speed (m/min)				
				50	100	150	200	250
P	Mild Steel	≤180HB	VP20RT		80	180		
			VP10RT		90	190		
	Carbon Steel Alloy Steel	180—280HB	VP20RT	60	140			
			VP10RT	70	150			
			MY5015		90	210		
	Carbon Steel Alloy Steel	280—350HB	NX2525	55	135			
			VP20RT	50	110			
			VP10RT	60	120			
			MY5015		80	160		
			NX2525	45	105			
M	Stainless Steel	≤350HB	VP20RT	50	110			
			VP10RT	60	120			
K	Gray Cast Iron	≤350MPa	VP20RT	60	140			
			VP10RT	70	150			
			MY5015		90	210		
	Ductile Cast Iron	≤800MPa	VP20RT	50	110			
			VP10RT	60	120			
			MY5015		80	160		
S	Titanium Alloy	—	VP20RT	30	60			
			VP10RT	40	70			
	Heat Resistant Alloy	—	VP20RT	30	60			
			VP10RT	40	70			

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.

(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

DISTANCE FROM THE WORKPIECE TO THE RECESS DEPTH

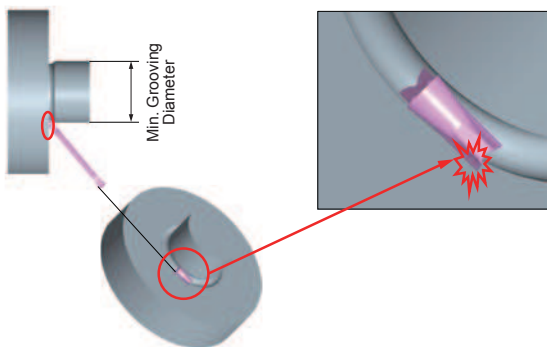


Grooving Width W (mm)	Recessing Depth t (mm)	Distance workpiece to the recess depth ap (mm)
2.00	1.50	0.646
2.50	1.75	0.720
3.00	2.00	0.793
3.18	2.09	0.819
4.00	2.50	0.939
4.75	2.88	1.049
5.00	3.00	1.086
6.00	3.50	1.232
6.35	3.68	1.283

BM BREAKER

Minimum grooving diameter

Ensure the tool is suitable for the diameter being machined. Refer to the Min. Grooving Diameter D1 as shown in the table on the first page to avoid a collision with the workpiece as shown below.



Recommended feed rate and depth of cut

