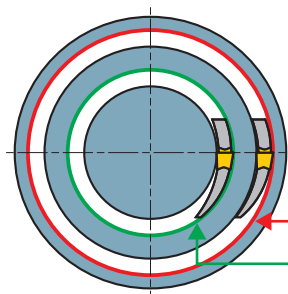


GROOVING SYSTEM

TOOL SELECTION

Notes when selecting the tool body

Modular blade (1)

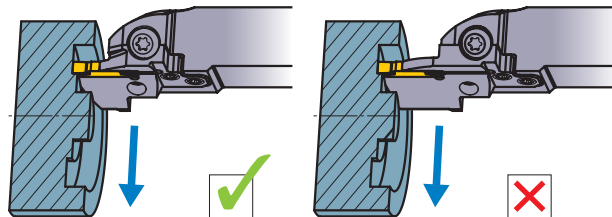


- Select a modular blade for face grooving, so that the cutting diameter at the first pass is within the range of D1 minimum and D1 maximum that are described in the table of dimensions.

$\phi D1$ (Max.)

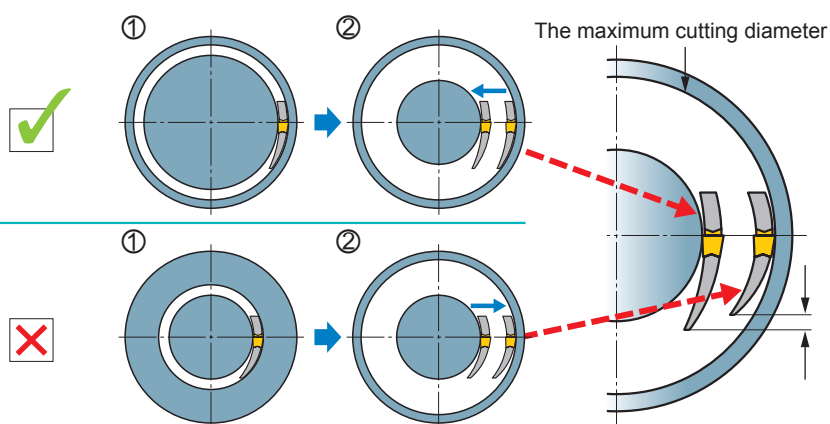
$\phi D1$ (Min.)

Modular blade (2)



- Select the shortest possible blade suitable for the application.

Modular blade (3)

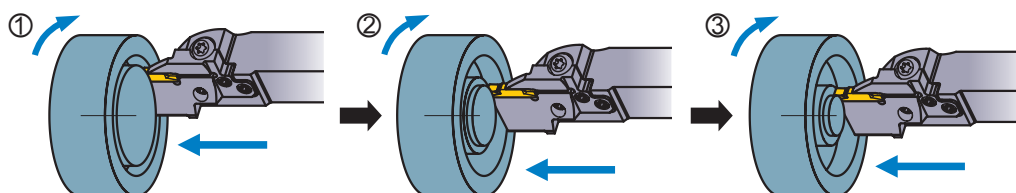


- Select the largest size blade within the maximum cutting diameter of the workpiece.
- Machine from the outer diameter towards the centre.

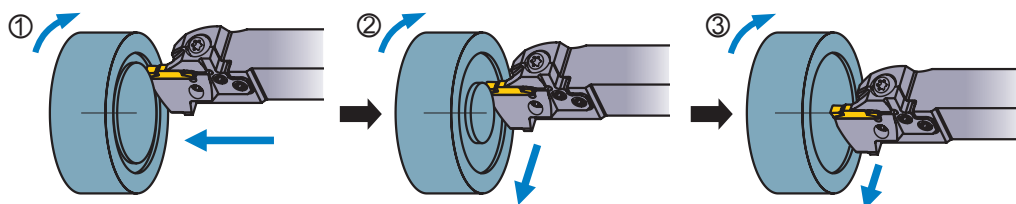
- Increased machining stability and rigidity is possible if a modular blade with the largest possible back metal is used.

- At first machine the maximum cutting diameter, there is no restriction in the cutting diameter on the remaining process.

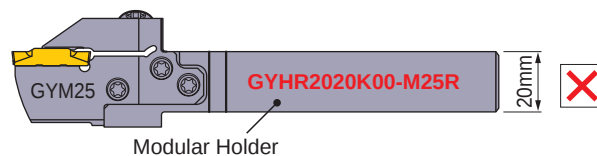
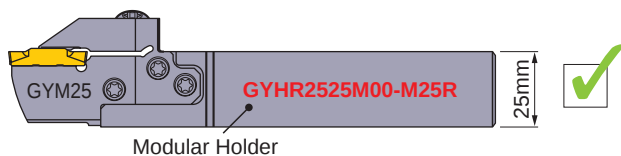
- When plunging in several passes.



- When combining plunging and infeed machining.



Modular holder



- To ensure sufficient clamping rigidity, select a modular holder with the largest possible shank size.