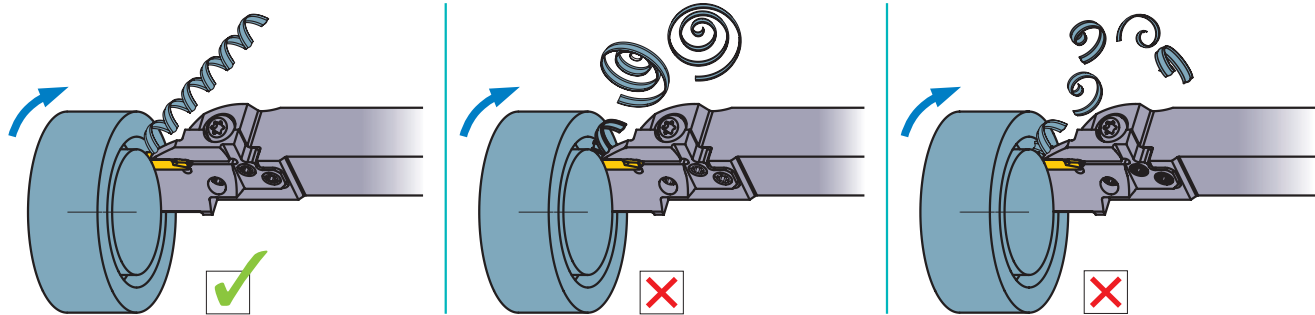


GROOVING SYSTEM

MACHINING RECOMMENDATIONS

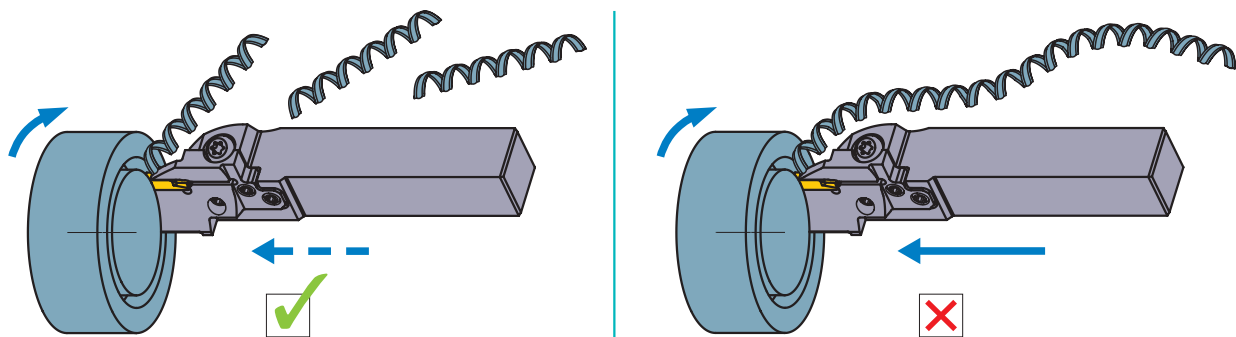
● Notes when face grooving (2)

Notes on the first pass (1)



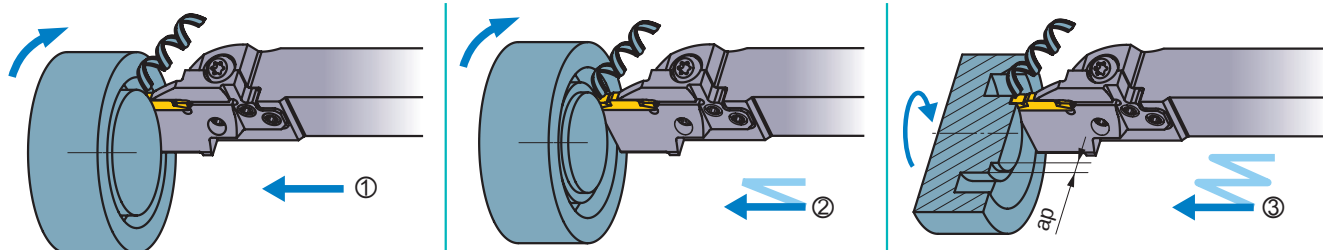
- During the first face grooving pass it is difficult to disperse broken chips and can lead to problems such as a chipped insert. Maintain longer chips that disperse easily by decreasing the feed per rotation.

Notes on the first pass (2)



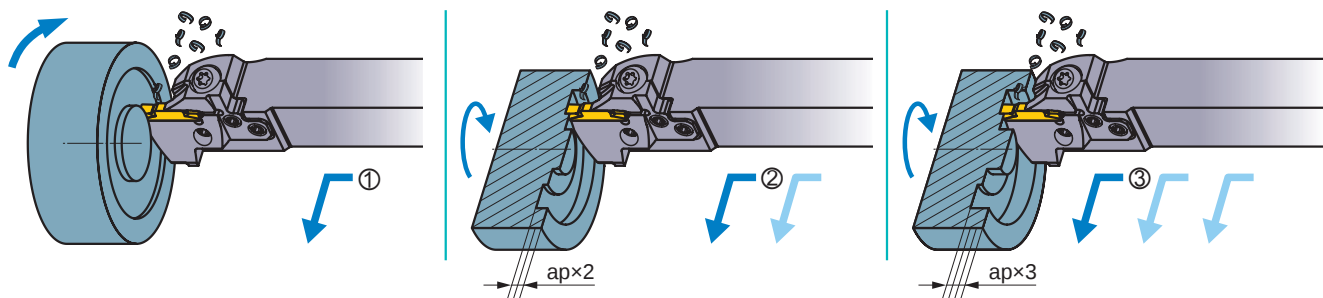
- When chips become too long, use peck feed to break them into a suitable length.

Notes when wide face grooving by plunging in several passes.



- When machining a face groove in several passes, machine from the outer diameter towards the centre so that space for discharging chips is created to prevent insert damage caused by chip jamming.
- Plunging width of cut is recommended to be set at 60 - 80% of the insert width. This enhances the effect of the chipbreaker by enlarging the width of the groove to improve chip dispersal.

Notes when wide face grooving by combination of plunging and traverse machining (1)



- When face groove machining by using plunge feed and traverse machining, always machine from the outer diameter towards the centre to disperse chips outward to avoid chip jamming problems.
- Set the depth of cut within 40% of the insert width.