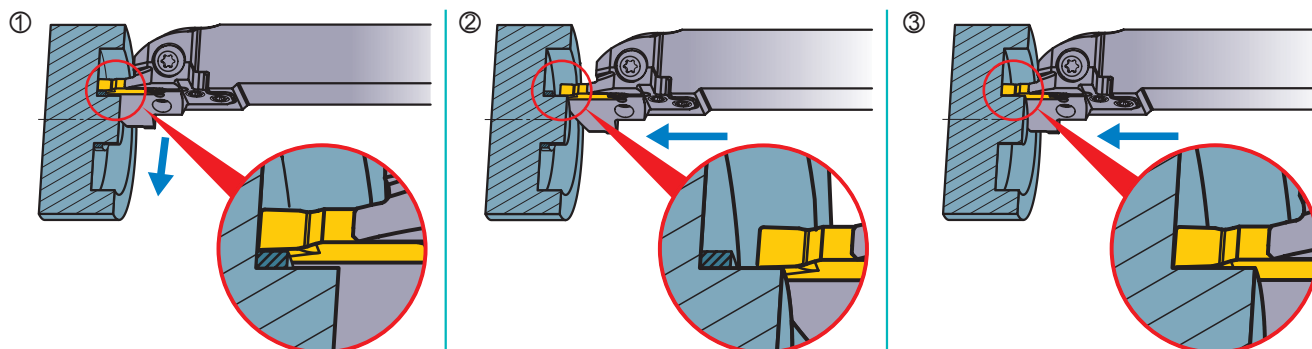
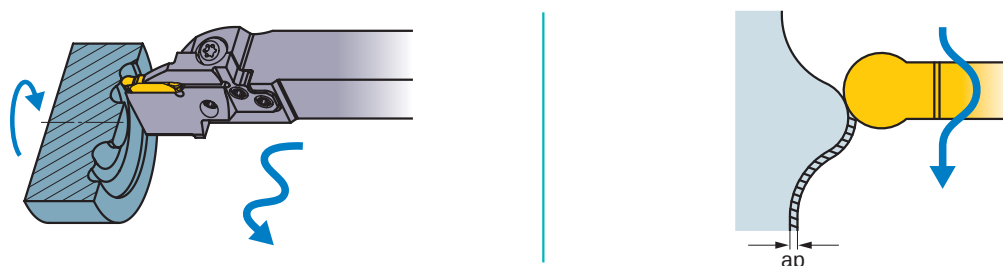


Notes when wide face grooving by combination of plunging and traverse machining (2)



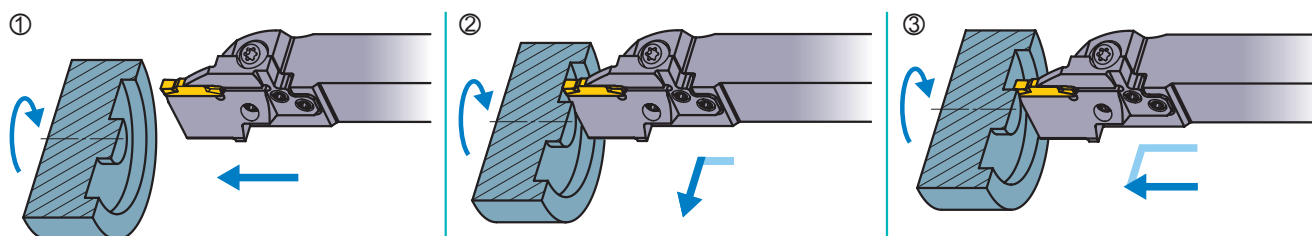
- When infeed machining at the bottom of a deep groove, chips may interfere on the cutting edge near the centre wall. In such cases, stop infeed machining just before the centre wall (at a point less than the insert width) then remove the remaining material by plunging.

Notes when copying (BM Breaker)



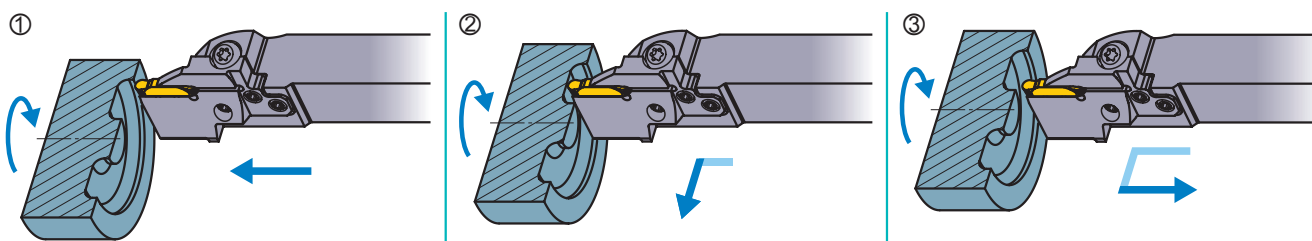
- With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (a_p) to 30% less than the insert width.

Finishing (1)

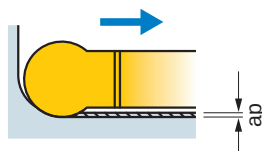


- When finish cutting, machine continuously from the outer wall to the bottom of the groove, then finally plunge cut the centre wall.

Finishing (2) (BM Breaker)



- Carry out finishing in one process. For the depth of cut (a_p) when back turning, refer to the table on the right.



Insert	a_p (mm)
GY2M0200D100N-BM	0.10
GY2M0250E125N-BM	
GY2M0300F150N-BM	
GY2M0318F159N-BM	0.15
GY2M0400G200N-BM	
GY2M0475H238N-BM	0.20
GY2M0500H250N-BM	
GY2M0600J150N-BM	0.25
GY2M0635J318N-BM	