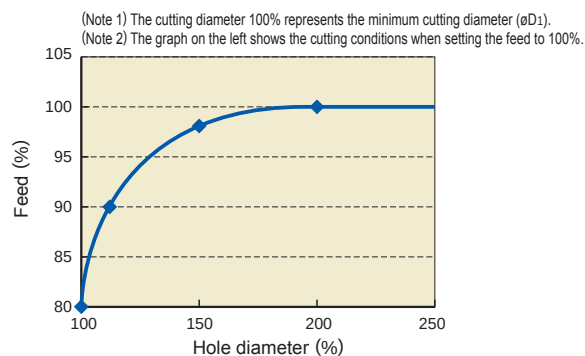
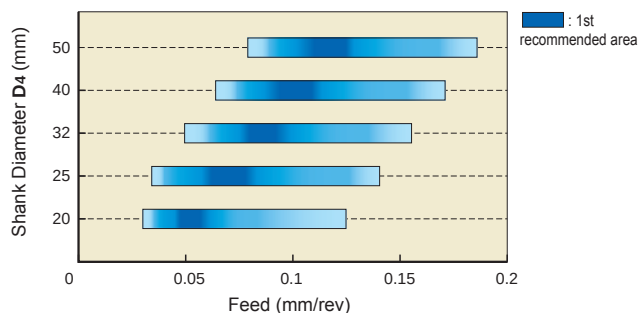


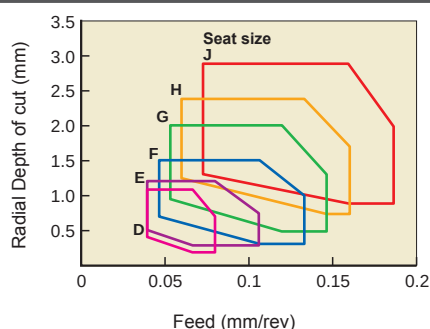
GROOVING SYSTEM

RECOMMENDED CUTTING CONDITIONS [For Internal Grooving]

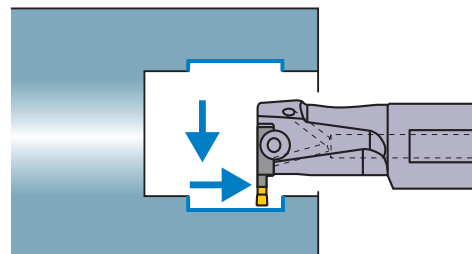
GROOVING



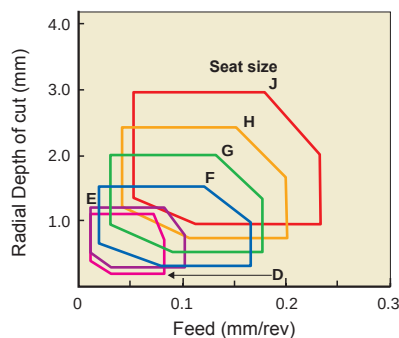
TRAVERSE MACHINING (MF BREAKER)



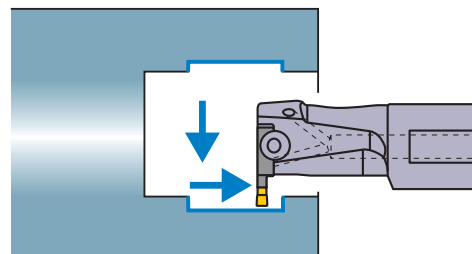
● When traverse machining a blind hole, it is recommended to carry out back turning considering chip disposal.



TRAVERSE MACHINING (MM/MS BREAKER)



● When traverse machining a blind hole, it is recommended to carry out back turning considering chip disposal.



(Note) The above cutting conditions are for when using the tool overhang (L) 1.6-2.0 times larger than the shank diameter ($\phi D4$). (L/D=1.6-2.0)
 When using L/D larger than 2.0, reduce the cutting conditions.

Seat Size (mm)			
D	2.00	G	4.00
	2.24		4.24
E	2.39	H	4.75
	2.50		5.00
	2.74		5.24
F	3.00	J	6.00
	3.18		6.31
	3.24		6.35

