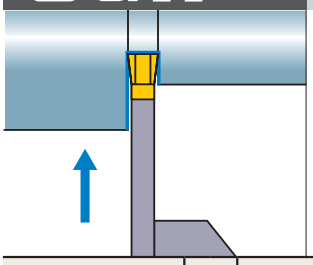
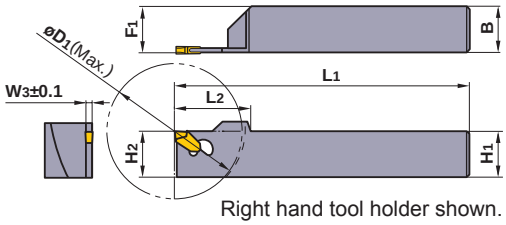
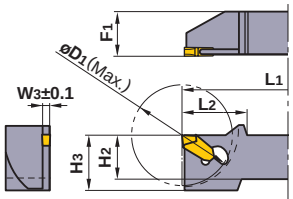
UGH External cutting off, Grooving





Right hand tool holder shown.

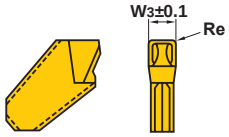
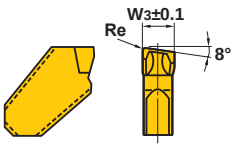


UGHR/L1616

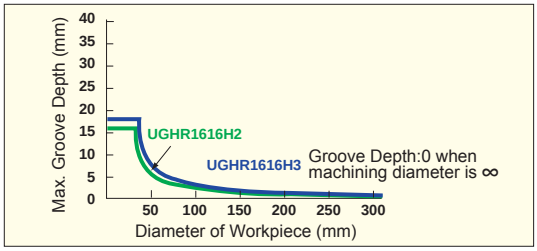
Order Number	Stock R	Stock L	Insert Number		Cutting Width W3 (mm)	Max. Cut off Diameter D1 (mm)	Max. Groove Depth (mm)	Dimensions (mm) B	H2	L1	L2	H1	F1	H3	Wrench
UGHR/L1616H2	●	●	KGT	2○	2.2	32	—	16	16	100	24	16	16.3	20	UGS1
1616H3	●	●		3○	3.1	36	—	16	16	100	24	16	16.4	20	UGS1
2020K2A	●	●		2○	2.2	32	—	20	20	125	24	20	20.3	—	UGS1
2020K2	●	●		2○	2.2	42	8	20	20	125	25	20	20.3	—	UGS1
2020K3A	●	●		3○	3.1	36	—	20	20	125	24	20	20.4	—	UGS1
2020K3	●	●		3○	3.1	58	21	20	20	125	32	20	20.4	—	UGS1
2525M3	●	●		3○	3.1	76	29	25	25	150	42	25	25.4	—	UGS1
2525M4	●	●		4○	4.1	76	29	25	25	150	42	25	25.5	—	UGS1

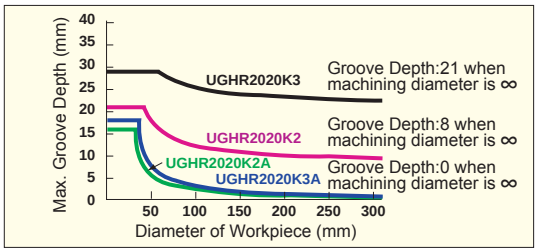
GROOVING

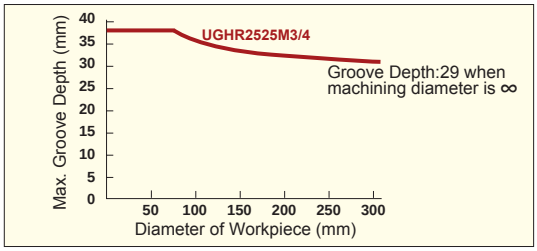
INSERTS

Order Number	Stock Coated UE6020	Coated US735	Cermet NX2525		Carbide UTi20T		Dimensions (mm) W3	Re	Geometry
KGT2N	●		●		★		2.2	0.2	
3N	●	●	●		★		3.1	0.2	
4N	●	●	●		★		4.1	0.2	
5N	●	●	●		★		5.1	0.2	
KGT2R	●	●	●		★		2.2	0.2	
2L	●	●	●		★		2.2	0.2	
3R	●	●	●		★		3.1	0.2	
3L	●	●	●		★		3.1	0.2	
4R	●	●	●		★		4.1	0.2	
4L	●	●	●		★		4.1	0.2	
5R	●	●	●		★		5.1	0.2	
5L	●	●	●		★		5.1	0.2	Left hand tool holder shown.

(Note) Above insert is not compatible with other manufacturer´s holders.







RECOMMENDED CUTTING CONDITIONS

Work Material		Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev) Groove Width 2.2mm	Groove Width 3.1mm	Groove Width 4.1mm	Groove Width 5.1mm
P	Mild Steel	≤180HB	UE6020 • NX2525 UTi20T	120 (100—140)	0.08 (0.06—0.1)	0.1 (0.08—0.12)	0.12 (0.1—0.14)	0.12 (0.1—0.14)
P	Carbon Steel Alloy Steel	180—280HB	UE6020 • NX2525 UTi20T	100 (80—120)	0.05 (0.04—0.06)	0.08 (0.06—0.1)	0.1 (0.08—0.12)	0.1 (0.08—0.12)
P	Carbon Steel Alloy Steel	280—350HB	UTi20T	80 (60—100)	0.05 (0.04—0.06)	0.08 (0.06—0.1)	0.1 (0.08—0.12)	0.1 (0.08—0.12)
M	Stainless Steel	≤200HB	US735	80 (60—100)	0.05 (0.04—0.06)	0.08 (0.06—0.1)	0.1 (0.08—0.12)	0.1 (0.08—0.12)

(Note) Please the set cutting edge height 0.1—0.2mm higher than centre.

SPARE PARTS ➤ M001
TECHNICAL DATA ➤ N001