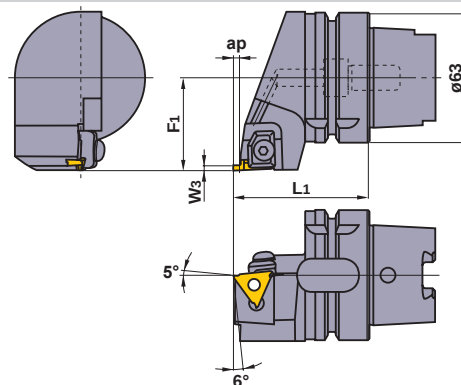
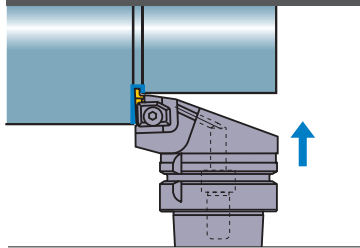


# HSK-T SYSTEM

**MG**
**Grooving**


Right hand tool holder shown.

| Order Number               | Stock |   | Insert Number                 | Groove Width<br>W <sub>3</sub> | Max.<br>Groove<br>Depth<br>ap | Dimensions<br>(mm) |    | Mass<br>(kg) |  |  |  |  |
|----------------------------|-------|---|-------------------------------|--------------------------------|-------------------------------|--------------------|----|--------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
|                            | R     | L |                               |                                |                               | L1                 | F1 |              |                                                                                     |                                                                                     |                                                                                     |                                                                                     |
| <b>H63TH-MGHR/L-DX4315</b> | ★     | ★ | MGTR/L<br>43125<br> <br>43470 | 1.25                           | 1.2                           |                    |    |              |                                                                                     |                                                                                     |                                                                                     |                                                                                     |
|                            |       |   |                               | 1.45                           | 1.5                           |                    |    |              |                                                                                     |                                                                                     |                                                                                     |                                                                                     |
|                            |       |   |                               | 1.5 ≤ W <sub>3</sub> ≤ 2.3     | 3                             | 65                 | 45 | 1.2          | MTK1R/L                                                                             | HBH06020                                                                            | MES3                                                                                | HKY40R                                                                              |
|                            |       |   |                               | 2.3 < W <sub>3</sub> ≤ 3.3     | 4.5                           |                    |    |              |                                                                                     |                                                                                     |                                                                                     |                                                                                     |
| <b>-DX4323</b>             | ★     | ★ |                               | 3.3 < W <sub>3</sub> ≤ 4.7     | 4.5                           |                    |    |              |                                                                                     |                                                                                     |                                                                                     |                                                                                     |
| <b>-DX4333</b>             | ★     | ★ |                               |                                |                               |                    |    |              |                                                                                     |                                                                                     |                                                                                     |                                                                                     |

★ Clamp Torque (N • m) : HBH06020=7.0

**RECOMMENDED CUTTING CONDITIONS**

|          | Work Material               | Hardness                 | Grade         | Cutting Speed<br>(m/min) | Feed<br>(mm/rev) |
|----------|-----------------------------|--------------------------|---------------|--------------------------|------------------|
| <b>P</b> | Carbon Steel<br>Alloy Steel | 180—350HB                | <b>VP20MF</b> | 120 (100—140)            | 0.10 (0.03—0.18) |
|          |                             |                          | <b>NX2525</b> | 130 (100—160)            | 0.12 (0.03—0.2)  |
| <b>M</b> | Stainless Steel             | ≤200HB                   | <b>VP20MF</b> | 120 (100—140)            | 0.10 (0.03—0.18) |
| <b>K</b> | Cast Iron                   | Tensile Strength ≤350MPa | <b>VP20MF</b> | 120 (100—140)            | 0.10 (0.03—0.18) |

● : Inventory maintained. ★ : Inventory maintained in Japan.