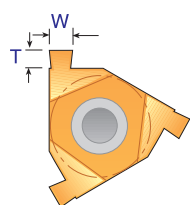


Grooving Inserts



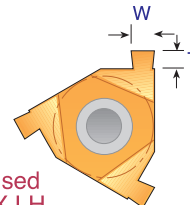
External & Internal

ER / IL

Same insert can be used for EX.RH and for IN.LH.

IR / EL

Same insert can be used for IN.RH. and for EX.LH.

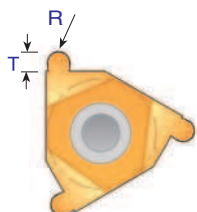


W ± 0.02	T	IC	Ordering Code		Ordering Code	
			ER/IL Inserts	Anvil	IR/EL Inserts	Anvil
1.00	1.4	3/8"	16 ER/IL 1.00	AE 16 - 0	16 IR/EL 1.00	AI 16 - 0
1.20	1.6	3/8"	16 ER/IL 1.20	AE 16 - 0	16 IR/EL 1.20	AI 16 - 0
1.40	1.8	3/8"	16 ER/IL 1.40	AE 16 - 0	16 IR/EL 1.40	AI 16 - 0
1.70	2.0	3/8"	16 ER/IL 1.70	AE 16 - 0	16 IR/EL 1.70	AI 16 - 0
1.95	2.0	3/8"	16 ER/IL 1.95	AE 16 - 0	16 IR/EL 1.95	AI 16 - 0
2.25	2.25	3/8"	16 ER/IL 2.25	AE 16 - 0	16 IR/EL 2.25	AI 16 - 0

Order example: 16 ER/IL 1.20 BXC

- * The inserts should be used with our standard threading toolholders (See pages 33-38)
- * Attention: The anvil must be changed to AE 16-0 or AI 16-0
- * Other available blank sizes: I.C. 5/8", 1/2", 1/4", 3/16" & 5/32"

Grooving Inserts for Snap Ring



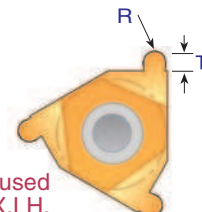
External & Internal Partial Profile Inserts

ER / IL

Same insert can be used for EX.RH and for IN.LH.

IR / EL

Same insert can be used for IN.RH and for EX.LH.



R ±0.04	T	IC	Ordering Code		Ordering Code	
			ER/IL Inserts	Anvil	IR/EL Inserts	Anvil
0.5	1.4	3/8	16 ER/IL R0.50	AE 16 - 0	16 IR/EL R0.50	AI 16 - 0
0.6	1.6	3/8	16 ER/IL R0.60	AE 16 - 0	16 IR/EL R0.60	AI 16 - 0
0.9	2.0	3/8	16 ER/IL R0.90	AE 16 - 0	16 IR/EL R0.90	AI 16 - 0
1.0	2.0	3/8	16 ER/IL R1.00	AE 16 - 0	16 IR/EL R1.00	AI 16 - 0
1.1	2.15	3/8	16 ER/IL R1.10	AE 16 - 0	16 IR/EL R1.10	AI 16 - 0
1.2	2.25	3/8	16 ER/IL R1.20	AE 16 - 0	16 IR/EL R1.20	AI 16 - 0

Order example: 16ER/IL R1.20 BXC

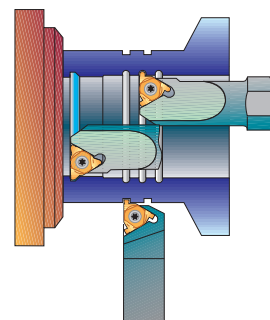
- * The inserts should be used with our standard threading toolholders (See pages 33-38)
- * Attention: The anvil must be changed to AE 16-0 or AI 16-0
- * Other available blank sizes: I.C. 5/8", 1/2", 1/4", 3/16" & 5/32"

Technical Section

Cutting Speeds for Grooving Tools

Carbide Grade: BXC (P30 - P50, K25 - K40)

PVD TiN coated grade for low cutting speed. Works well with a wide range of stainless steels.



ISO Standard	Materials	Cutting Speed m/min
P	Low & Medium Carbon Steel	20-100
	High Carbon Steel	30-80
	Alloy Steels and Treated Steels	40-90
M	Stainless Steels	30-80
	Cast Steels	30-90
K	Cast Iron	30-90
N	Non-Ferrous & Aluminium	20-200

For grooving small bores see pages 150-155

