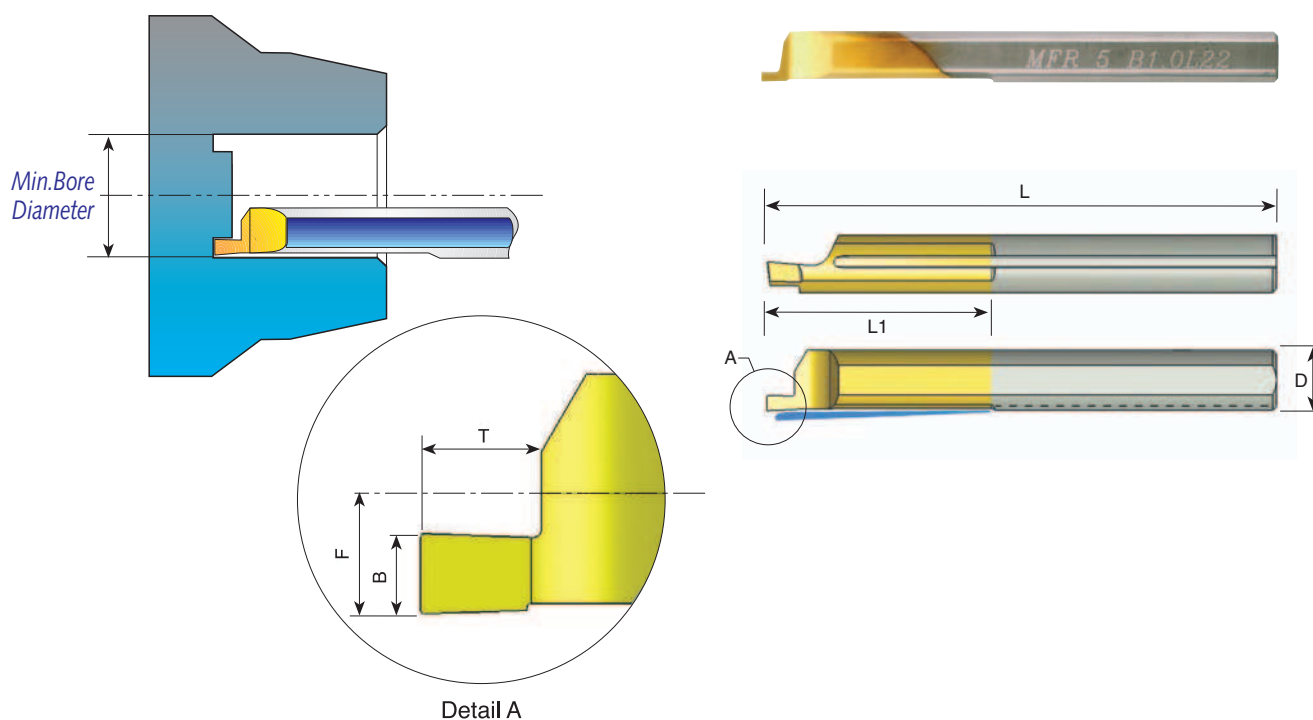


MFR Bars Face Grooving - with Coolant Channel



D	Ordering Code	L	L1	B	T	F	Min. Bore Dia.	Holder*
4.0	MFR 4 B0.75 L15	50	15	0.75	1.2	1.95	5.0	SIM 0020 H4
4.0	MFR 4 B1.0 L15	50	15	1.0	1.5	1.95	5.0	SIM 0020 H4
5.0	MFR 5 B0.75 L22	50	22	0.75	1.2	2.45	6.0	SIM 0020 H5
5.0	MFR 5 B1.0 L22	50	22	1.0	1.5	2.45	6.0	SIM 0020 H5
5.0	MFR 5 B1.5 L22	50	22	1.5	2.5	2.45	6.0	SIM 0020 H5
6.0	MFR 6 B1.0 L22	50	22	1.0	1.5	2.95	8.0	SIM 0020 H6
6.0	MFR 6 B1.5 L22	50	22	1.5	2.5	2.95	8.0	SIM 0020 H6
6.0	MFR 6 B2.0 L22	50	22	2.0	3.0	2.95	8.0	SIM 0020 H6
8.0	MFR 8 B2.5 L22	63	22	2.5	3.5	3.95	10.0	SIM 0020 H8

Order example: MFR 5 B1.0 L22 BXC

* For additional holders see page 156

Technical Section

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

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

Cutting speed for Tiny Tools

ISO Standard	Materials	Cutting Speed m/min
P	Low & Medium Carbon Steel	20-140
	High Carbon Steel	30-100
	Alloy Steels & Treated Steels	40- 90
M	Stainless Steels	20- 90
	Cast Steels	40- 90
K	Cast Iron	40-120
N	Non-Ferrous & Aluminium	50-120
S	Super alloy and Titanium	15- 30
H	Hard Materials	13- 30

Recommended Feed Rate: 0.01 - 0.03 mm/rev

Threading Passes

Pitch:	mm	0.5	0.7	0.8	1.0	1.25	1.5
	TPI	48	36	32	24	20	16
Number of Passes		6-12	7-14	7-16	8-18	8-20	10-22