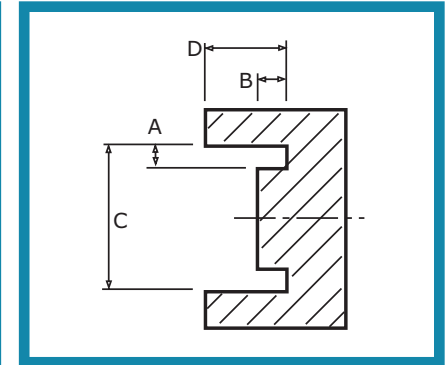
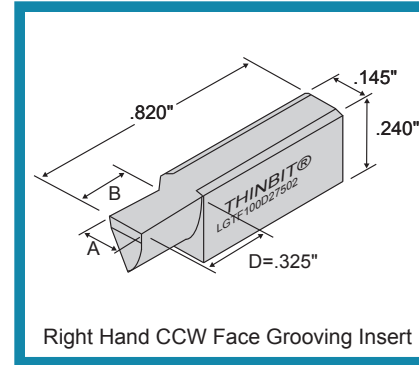
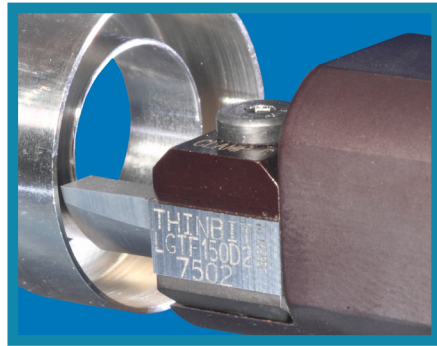


Right Hand Counter-Clockwise Face Grooving Inserts



Internal Face Groove Machined with a Right Hand CCW Insert

For additional options in our standard face grooving lines, please see Section 2 of our catalog.

Custom made face grooving tooling available. See page 8-2 or send us a drawing for a fast quote.

- Back Clearance: 2 1/2° both sides
- Side Clearance: .004" - .019" - 0° ID Side; .020" - .150" - 5° ID Side
- Radius: Sharp corner through full radius available
- Top Rake: 0°
- Lead Angle: 0°
- Modifications Available, See Page 8-2
- Delivery Stock to 5 working days for uncoated inserts

SPECIFICATIONS				ORDER CODE			INFO.		
Insert Orientation	Insert Width 'A' ± .001"	Depth of Cut 'B'	Major Diameter 'C' Can be used on any diameter equal to or greater than listed	Insert Grades See Page 9-5 for expanded material descriptions and Page 9-12 for Speeds and Feeds information		Add-ons Use 'Order Code' and Add			Toolholder Catalog Section 7 Use Toolholders Beginning With
				DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Non-ferrous	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6	
Right Hand/ Counter-Clockwise	.004" - .150"	<u>Width</u> <u>D.O.C.</u> .004"-.033" = 3 x 'A' .034"-.039" = .100" .040"-.100" = 2.5 x 'A' .101"-.150" = .250"	.300"	LGTF ___ D23002	LGTF ___ D53002	add 'FR'	add 'CR_ ___' (indicate size in .xxx")	TiN add 'C'	'L' Use right hand straight holder or right hand 90° holder
			.750"	LGTF ___ D27502	LGTF ___ D57502			TiCN add 'D'	
			1.250"	LGTF ___ D212502	LGTF ___ D512502			TiAIN add 'E'	
			3.000"	LGT ___ D2R	LGT ___ D5R			Diamond add 'F'	