

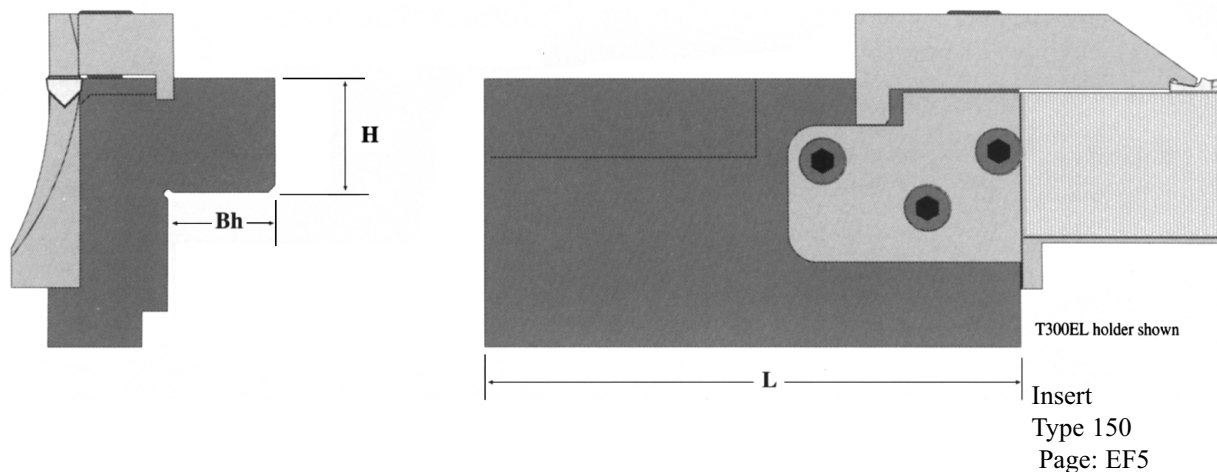
*Premier*

Manufacturers of Precision Ground Cutting Tools



Face Grooving  
**T300 System**  
e - Catalogue

## Type T300 Toolholder

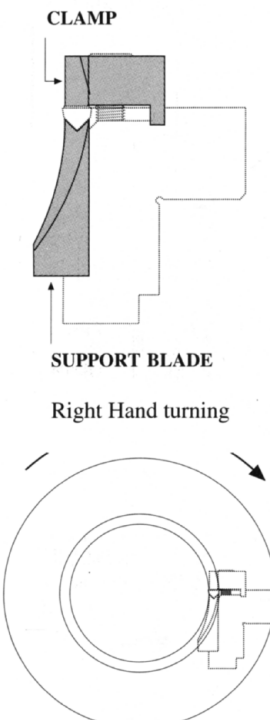
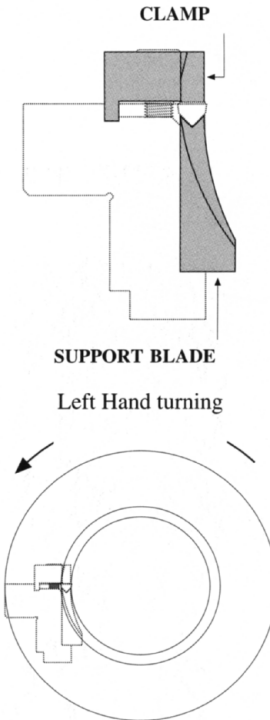


## T300 basic toolholder

Part No.	CW max.	CD max.	Dimensions			Insert Type	Spare parts for the entire T300 system			
			H	Bh	L		Clamp Screw	Clamp-Screw Key	Support Blade Screw	Blade Screw Key
T300ER/L 2525	10	75	25	25	150	150	M10X30MC	Hex M8	M8x20MK	Hex M5
T300ER/L 3232	10	100	32	32	150	150	M10X30MC	Hex M8	M8x20MK	Hex M5
T300ER/L 4040	10	100	40	40	150	150	M10X30MC	Hex M8	M8x20MK	Hex M5

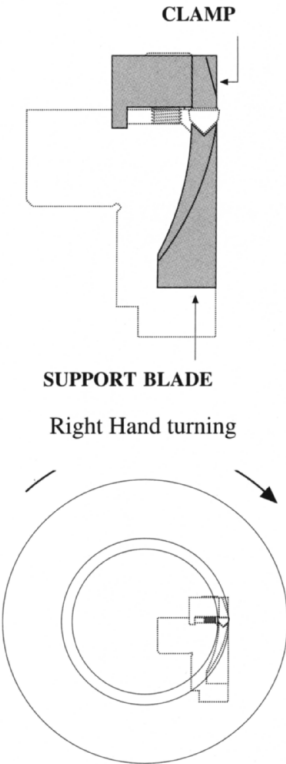
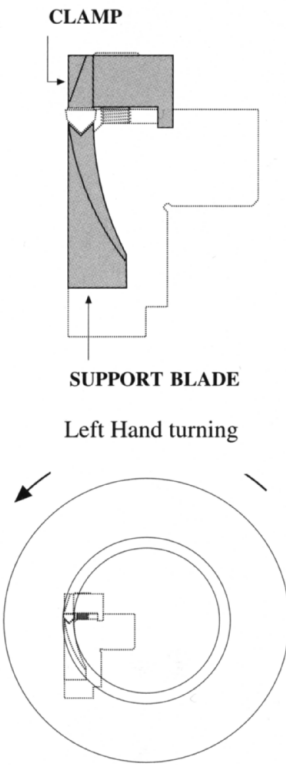
NOTE: Toolholders are supplied with screws for support blade and clamp only. Clamps, support blades and inserts must be ordered separately. For clamps and support blades, see page

## T300 system support blades and clamps

LH HOLDER RH TURNING	Outer-Ø* mm.	CW	CD	Insert Type	Support blade	Clamp
 <p>CLAMP</p> <p>SUPPORT BLADE</p> <p>Right Hand turning</p>	70-100	6	40	150	1502-54006-1	1503-54006-1
		10	40	150	1502-54010-1	1503-54010-1
		10	50	150	1502-55010-1	1503-55010-1
	100-140	6	40	150	1502-54006-2	1503-54006-1
		10	40	150	1502-54010-2	1503-54010-1
		10	60	150	1502-56010-2	1503-56010-1
	135-190	6	50	150	1502-55006-3	1503-55006-3
		10	50	150	1502-55010-3	1503-55010-3
		10	70	150	1502-57010-3	1503-57010-3
	170-250	6	50	150	1502-55006-4	1503-55006-3
		10	50	150	1502-55010-4	1503-55010-3
		10	85	150	1502-58510-4	1503-58510-3
	245-400	6	50	150	1502-55006-5	1503-55006-3
		10	50	150	1502-55010-5	1503-55010-3
		10	100	150	1502-510010-5	1503-510010-3
	395-∞	6	50	150	1502-55006-6	1503-55006-3
		10	50	150	1502-55010-6	1503-55010-3
		10	100	150	1502-510010-6	1503-510010-3
RH HOLDER LH TURNING	Outer-Ø* mm.	CW	CD	Insert Type	Support blade	Clamp
 <p>CLAMP</p> <p>SUPPORT BLADE</p> <p>Left Hand turning</p>	70-100	6	40	150	1502-64006-1	1503-64006-1
		10	40	150	1502-64010-1	1503-64010-1
		10	50	150	1502-65010-1	1503-65010-1
	100-140	6	40	150	1502-64006-2	1503-64006-1
		10	40	150	1502-64010-2	1503-64010-1
		10	60	150	1502-66010-2	1503-66010-1
	135-190	6	50	150	1502-65006-3	1503-65006-3
		10	50	150	1502-65010-3	1503-65010-3
		10	70	150	1502-67010-3	1503-67010-3
	170-250	6	50	150	1502-65006-4	1503-65006-3
		10	50	150	1502-65010-4	1503-65010-3
		10	85	150	1502-68510-4	1503-68510-3
	245-400	6	50	150	1502-65006-5	1503-65006-3
		10	50	150	1502-65010-5	1503-65010-3
		10	100	150	1502-610010-5	1503-610010-3
	395-∞	6	50	150	1502-65006-6	1503-65006-3
		10	50	150	1502-65010-6	1503-65010-3
		10	100	150	1502-610010-6	1503-610010-3

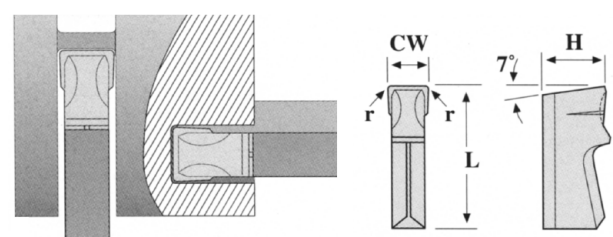


## T300 system support blades and clamps

RH HOLDER RH TURNING	Outer- Ø* mm.	CW	CD	Insert Type	Support blade	Clamp
 <p>CLAMP</p> <p>SUPPORT BLADE</p> <p>Right Hand turning</p>	70-100	6	40	150	1502-54006-1	1503-54006-1C
		10	40	150	1502-54010-1	1503-54010-1C
		10	50	150	1502-55010-1	1503-55010-1C
	100-140	6	40	150	1502-54006-2	1503-54006-1C
		10	40	150	1502-54010-2	1503-54010-1C
		10	60	150	1502-56010-2	1503-56010-1C
	135-190	6	50	150	1502-55006-3	1503-55006-3C
		10	50	150	1502-55010-3	1503-55010-3C
		10	70	150	1502-57010-3	1503-57010-3C
	170-250	6	50	150	1502-55006-4	1503-55006-3C
		10	50	150	1502-55010-4	1503-55010-3C
		10	85	150	1502-58510-4	1503-58510-3C
	245-400	6	50	150	1502-55006-5	1503-55006-3C
		10	50	150	1502-55010-5	1503-55010-3C
		10	100	150	1502-510010-5	1503-510010-3C
	395-∞	6	50	150	1502-55006-6	1503-55006-3C
		10	50	150	1502-55010-6	1503-55010-3C
		10	100	150	1502-510010-6	1503-510010-3C
LH HOLDER LH TURNING	Outer- Ø* mm.	CW	CD	Insert Type	Support blade	Clamp
 <p>CLAMP</p> <p>SUPPORT BLADE</p> <p>Left Hand turning</p>	70-100	6	40	150	1502-64006-1	1503-64006-1C
		10	40	150	1502-64010-1	1503-64010-1C
		10	50	150	1502-65010-1	1503-65010-1C
	100-140	6	40	150	1502-64006-2	1503-64006-1C
		10	40	150	1502-64010-2	1503-64010-1C
		10	60	150	1502-66010-2	1503-66010-1C
	135-190	6	50	150	1502-65006-3	1503-65006-3C
		10	50	150	1502-65010-3	1503-65010-3C
		10	70	150	1502-67010-3	1503-67010-3C
	170-250	6	50	150	1502-65006-4	1503-65006-3C
		10	50	150	1502-65010-4	1503-65010-3C
		10	85	150	1502-68510-4	1503-68510-3C
	245-400	6	50	150	1502-65006-5	1503-65006-3C
		10	50	150	1502-65010-5	1503-65010-3C
		10	100	150	1502-610010-5	1503-610010-3C
	395-∞	6	50	150	1502-65006-6	1503-65006-3C
		10	50	150	1502-65010-6	1503-65010-3C
		10	100	150	1502-610010-6	1503-610010-3C

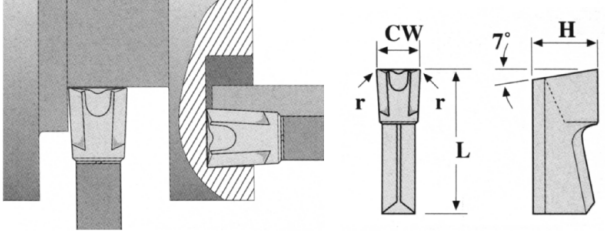
For current stock availability, refer to our latest price list

## Type 150 Inserts



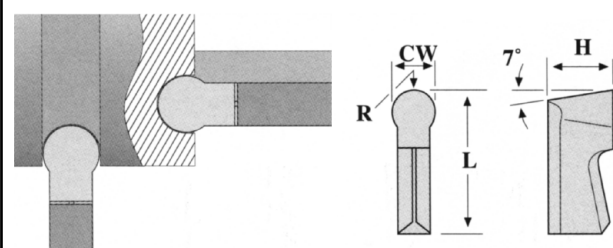
**150 standard insert with chip-control**

CW + 0,1	Part No.	H - 0,1	L	r	Available grades			
					P30C	K10C	P30	K10
6,0	<b>150.6</b>	6,0	14	0,3	●	●	●	●
10,0	<b>150.10</b>	7,5	16	0,3	●	●	●	●



**150 GT Grooving and side turning insert**

CW + 0,1	Part No.	H - 0,1	L	r	Available grades			
					P30C	K10C	P30	K10
6,0	<b>150.6.GT</b>	6,0	14	0,3	●		●	
10	<b>150.10.GT</b>	10	14	0,3	●	●	●	●



**150 standard Radius insert**

CW - 0,1	Part No.	H - 0,1	L	R - 0,05	Available grades			
					P30C	K10C	P30	K10
5,6	<b>150.6.RD</b>	6,0	14	2,8	●	●	●	●
9,5	<b>150.10.RD</b>	7,5	16	4,75	●	●	●	●

## Recommendations for face grooving

MATERIAL	RECOMMENDED CARBIDE GRADE	FEED MM REV			
		0,025	0,05	0,1	0,2
		CUTTING SPEED M/MIN			
Low carbon steel	P30C	130	100	90	90
Carbon steel	P30C	160	140	110	
Alloyed steel	P30C		110	80	75
Stainless steel	P30C		100	90	70
Cast steel	P30C		80	65	50
Heat resistant Iron-based alloys	K10C	100	65	60	40
Hard steel (Manganese steel)	K10		20	15	
Malleable Iron	K10C	130	130	110	
Cast Iron	K10C	110	110	95	
Aluminium alloys	K10		240	200	
Heat resistant Nickel-based alloys	K10	30	20	12	
Heat resistant Cobalt-based alloys	K10	30	20	12	
Non-Ferrous materials	K10	240	160	120	

### NOTE

The above data are for guidance only.  
Actual performance depends on various factors,  
such as mounting stability, workpiece shape  
and specific material characteristics.

# Technical Information - Face Grooving

## Recommendations for face grooving and trepanning operations:

- cutting speed 80% of cutting speed for parting-off
- feed 50% of feed for parting-off
- apply sufficient cooling directly on cutting edge

## Profile and contour turning:

The initial face groove must be made within the diameter range of assembly. From this first groove it is possible to turn toward larger or smaller diameters.

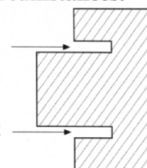
## Trepanning:

When trepanning it is recommendable to stop cutting just before the tool penetrates through, then the slug can be knocked out with a hammer.

## Special face grooving circumstances:

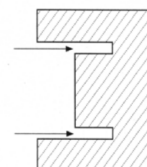
Close to a boss:

- R.H. turning / L.H. tool
  - L.H. turning / R.H. tool
- (use STANDARD support blades and clamps.



In a blind hole:

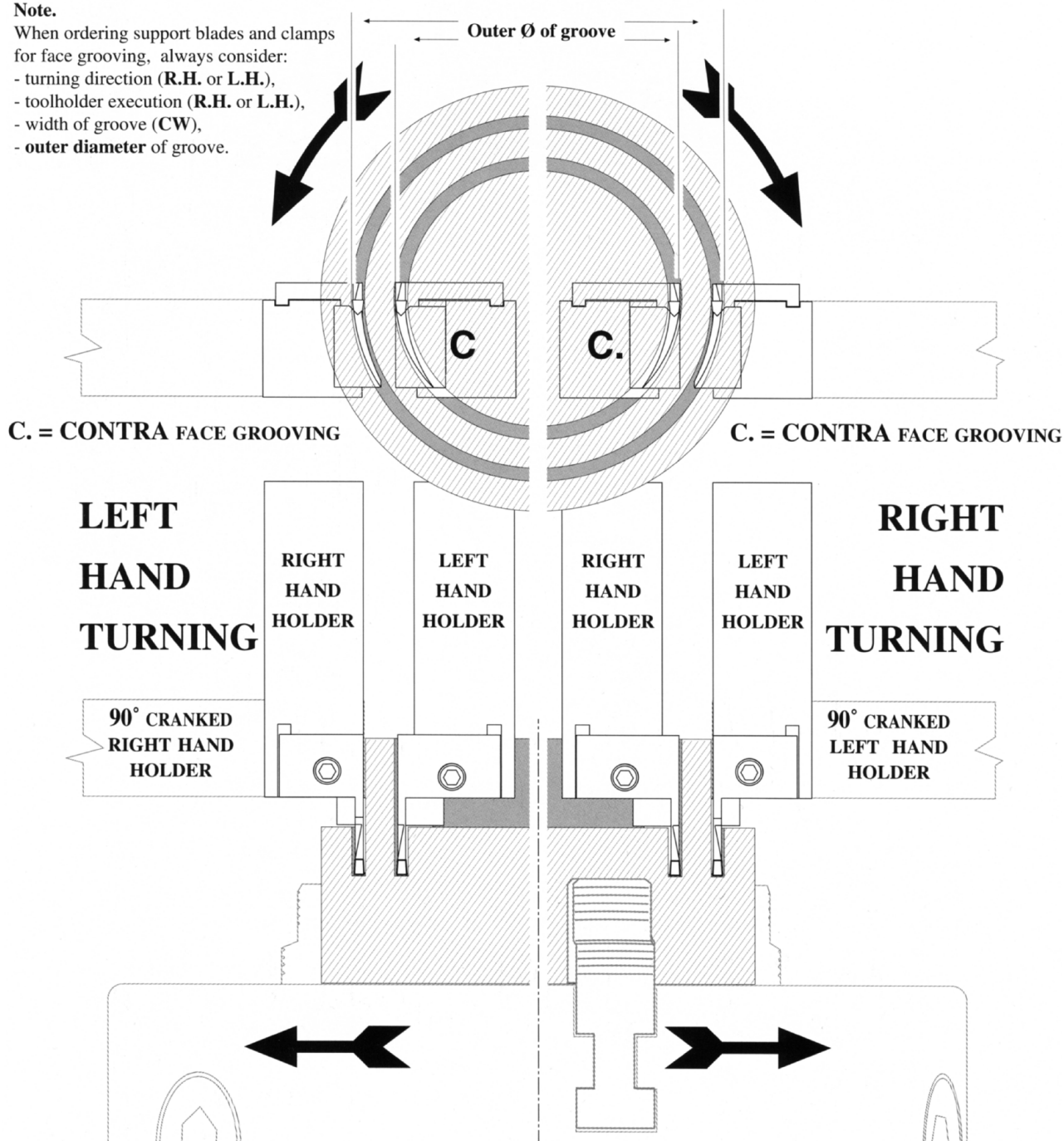
- R.H. turning / R.H. tool
  - L.H. turning / L.H. tool
- (use CONTRA support blades and clamps).



## Note.

When ordering support blades and clamps for face grooving, always consider:

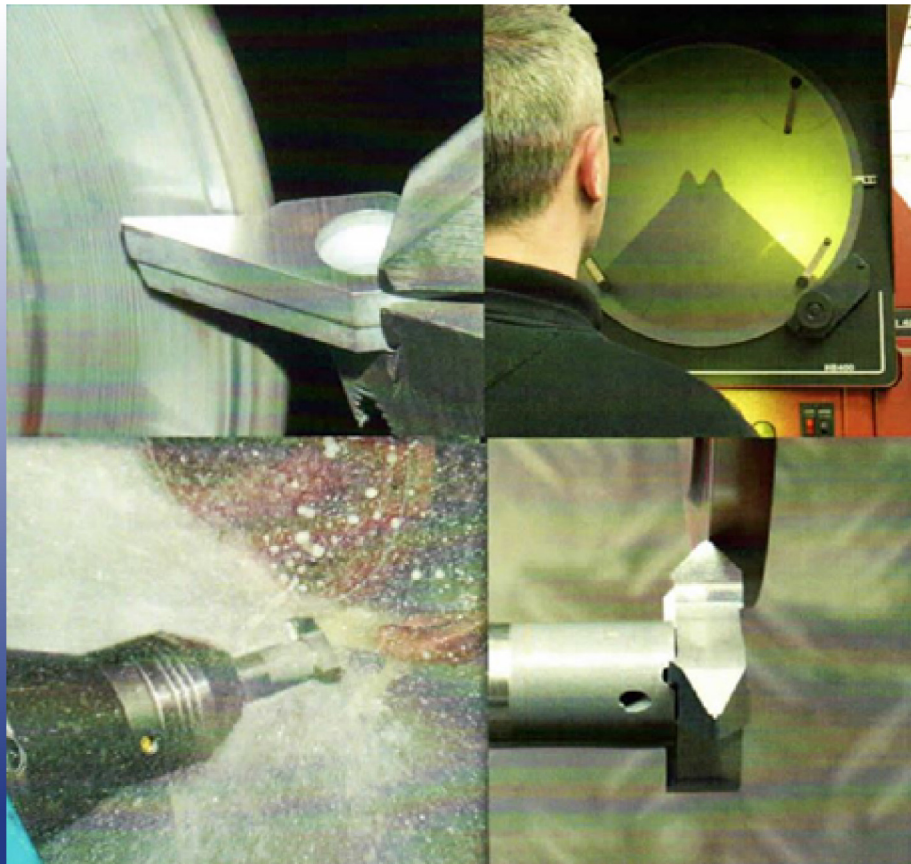
- turning direction (R.H. or L.H.),
- toolholder execution (R.H. or L.H.),
- width of groove (CW),
- outer diameter of groove.







Manufacturers of Precision Ground Cutting Tools



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