

Technical Information - Face Grooving

Recommendations for face grooving and Special face grooving circumstances: trepanning operations: - cutting speed 80% of cutting speed for parting-off Close to a boss: - feed 50% of feed for parting-off - R.H. turning / L.H. tool - apply sufficient cooling directly on cutting edge - L.H. turning / R.H. tool (use STANDARD support Profile and contour turning: blades and clamps. 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. In a blind hole: Trepanning: - R.H. turning / R.H. tool When trepanning it is recommendable to stop cutting just before the tool - L.H. turning / L.H. tool penetrates through, then the slug can be knocked out with a hammer. (use CONTRA support blades and clamps). Note. Outer Ø of groove 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. C. = CONTRA FACE GROOVING C. = CONTRA FACE GROOVING **LEFT RIGHT** RIGHT **LEFT RIGHT** LEFT **HAND HAND HAND HAND HAND HAND** HOLDER HOLDER HOLDER **HOLDER TURNING TURNING** 90° CRANKED 90° CRANKED RIGHT HAND LEFT HAND HOLDER HOLDER

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