

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.

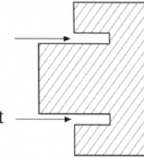
Trepanning:

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

Special face grooving circumstances:

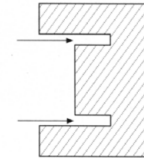
Close to a boss:

- 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.

