

# 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.

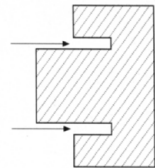
**Trepanning:**

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:**

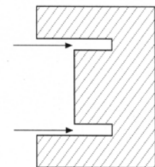
Close to a boss:

- 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.

