

KERFOLG® INSERTS FOR GROOVING AND PARTING - SINGLE SIDE



		Description	Degree	Tech. Code	s mm	a max mm	l mm	r mm	Tool Holders
G	SGN25 4,00-0.30-G1		G135	B2T4504G101	4	3	24,3	0,3	BN4...
			G240	B2T4504G102					
			G145	B2T4504G103					

KERFOLG® RECOMMENDED CUTTING CONDITIONS

		P			M		K		N	S	H
Degree		<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
G135		110 - 190	110 - 180	70 - 160			90 - 180	80 - 150			
G145		80 - 150	70 - 120	60 - 100	70 - 120	50 - 100				25 - 50	
G240		80 - 180	60 - 150	50 - 120	50 - 180	50 - 100	100 - 200	100 - 180			
Geometry for grooving, parting off and turning		<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
G1 - Tough cut. First choice on steels and cast irons.		○	●	●	○		●	●			
G01 - Soft cut. First choice in case of varying materials.		●	●	○	●	○	○	○		○	
S01 - Soft cut especially for stainless and Titanium alloy.		○	○		●	●				●	
MD1 - Grooving and turning on steels and stainless.		●	●	●	●	●	●	○		○	
MP1 - Radius grooves and copy turning.		○	●	●	●	○	●	●		○	

● RECOMMENDED FOR... ○ USABLE FOR...

	Geometry	Width of cut mm	Grooving infeed mm/rev							
GROOVING	G1	4								
	G01									
	S01									
			0	0.05	0.10	0.15	0.20	0.25	0.30	

	Geometry	Width of cut mm	Max depth of cut mm	Turning infeed mm/rev												
TURNING	MD1	4	2,5													
	MP1		2,0													
				0	0.05	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.45	0.50	0.55	0.60

KERFOLG® TOOL BLOCK FOR PARTING BLADES

Tronca

ITEM: B2U07

Blade type

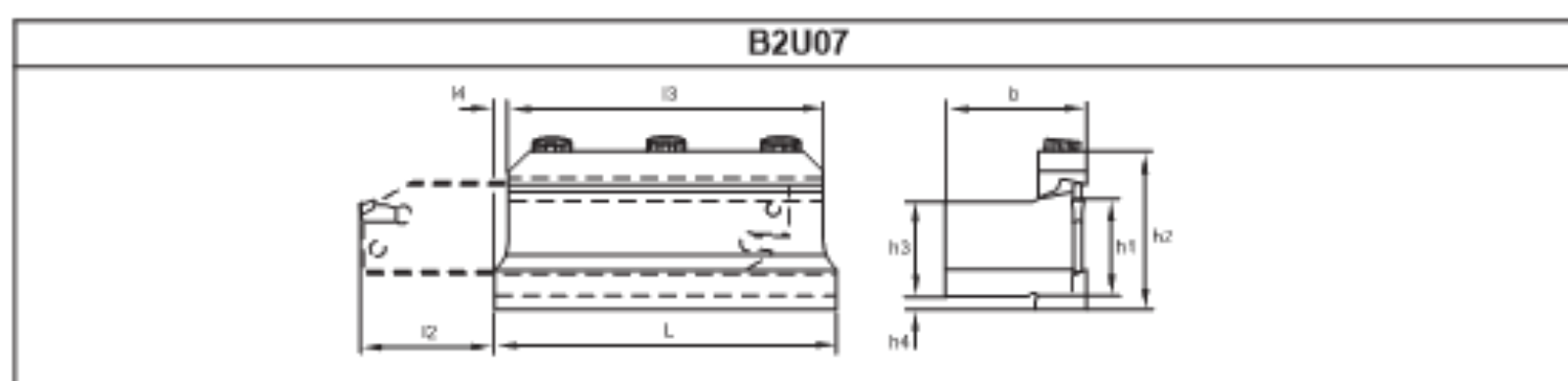
B2U25 - B2U35 - B2U45

Blade dim.

26 - 32

Application

Parting off



	Tech. Code	L mm	l2 max mm	l3 mm	l4 mm	h1 mm	h2 mm	h3 mm	h4 mm	b mm	Blades h mm
B2U07	B2U07262020	80	45	70	5	20	45.5	20	10	38	26
	B2U07323232	120	80	110		32	54.5	32	5	50	32