

# FACE MACHINING

## New Blades for Heavy Duty Face Machining

ISCAR offers new CGFG heavy duty blades for face grooving larger diameters and large depths of cut, using the existing CUT-GRIP 8 mm single ended inserts GIMY 840 and GIMF 808.

These new blades can be mounted on

ISCAR's heavy duty tool blocks, types SGTBN, SGTBU and SGTBK, each having a 52.6 mm slot for blade mounting.

### Recommended Machining Conditions:

**Material:** Alloy Steel 200 - 375 HBN

### For Grooving Operations

Speed range = 70 - 80 m/min

Feed range = 0.12 - 0.20 mm/rev

### For Turning Operations

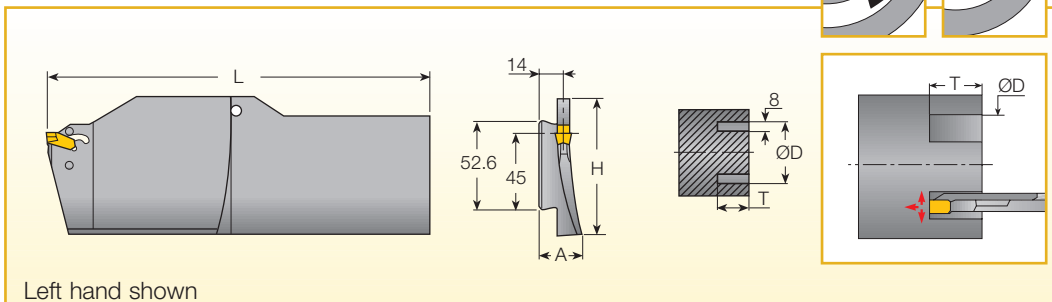
D.O.C = 2.5 mm/max

Speed range = 80 - 100 m/min

Feed range = 0.15 - 0.20 mm/rev

Both right hand and left hand tools are available.

## Blades



## CGFG 51...R/L-P8DG

Tmax	Designation	øD <sup>(1)</sup>		L	H	A	Insert
		Min.	Max.				
70	CGFG 51-180R-P8DG CGFG 51-180L-P8DG	180	240	200	60	27.5	GIMY 808 GIMY 840 GIMF 808 GIM 8V
80	CGFG 51-240R-P8DG CGFG 51-240L-P8DG	240	320	210	70	26.0	
90	CGFG 51-320R-P8DG CGFG 51-320L-P8DG	320	440	220	80	24.5	
100	CGFG 51-440R-P8DG CGFG 51-440L-P8DG	440	700	230	90	22.5	
120	CGFG 51-700R-P8DG CGFG 51-700L-P8DG	700	1500	250	100	20.0	

(1) No limitation to widening of groove in either direction after initial grooving.

Key: EDG-44A - supplied by separate order.