

Grooving and parting-off tool

TUNGCUT

Tungaloy Report No. 391S3-G

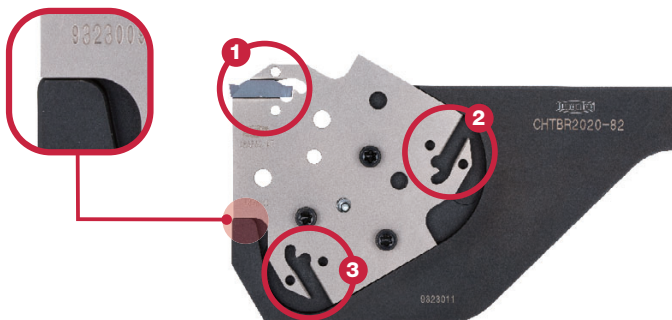
Now offers **TungFeed-Blade** holders
for grooving and parting-off



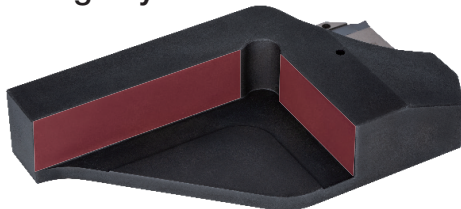


Strong holder design ensures excellent stability and productivity during demanding applications

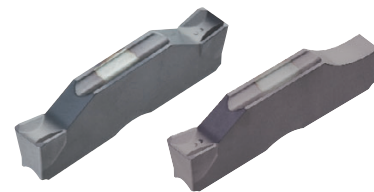
- The support blade is designed to eliminate chatter during machining, providing better surface finish and straightness of the groove.



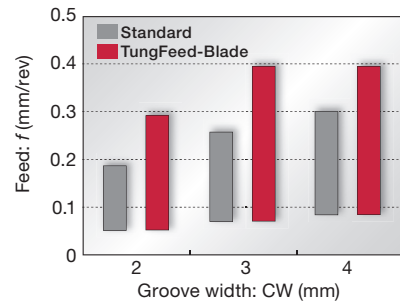
- Each blade has three insert seats for tool economy.
- The holder has two contact faces for enhanced rigidity.



DGM type (2 corners)
SGM type (1 corner)



■ Increase with High feed blade

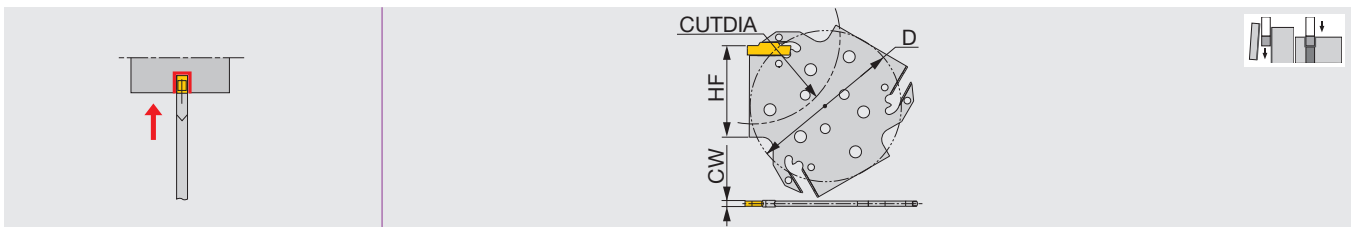


Enables high feed machining when used with high rigidity holders

CHGP

Parting-off and external grooving blade

TUNGF^{BLADE}



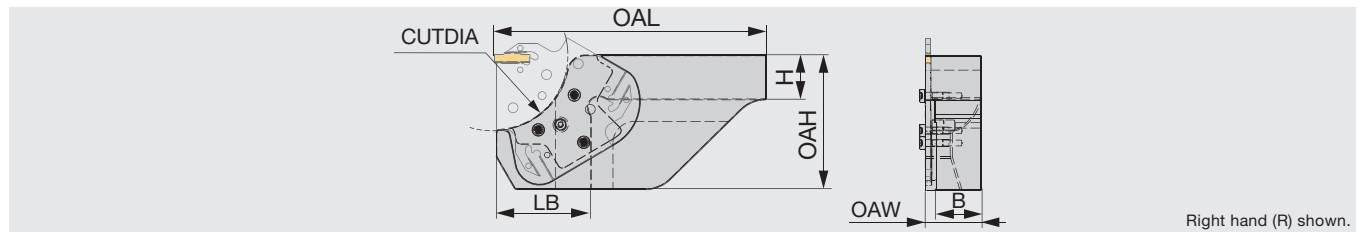
Designation	CW	Seat size	CUTDIA	HF	D
CHGP52-2T	2	2	52	27	48.3
CHGP52-3T	3	3	52	27	48.3
CHGP82-3T	3	3	82	42	69.3
CHGP82-4T	4	4	82	42	69.3

When depth is deeper than insert length - 1.5mm, 1 corner type is recommended.

SPARE PARTS

Designation	Wrench (Option)
CHGP...	CRW33





Designation	CUTDIA	H	B	OAL	OAH	OAW	LB
CHTBR/L2020-52	52	20	20.5	100	50	26.5	37
CHTBR/L2525-52	52	25	25.5	125	50	31.5	37
CHTBR/L2020-82	82	20	20.5	140	75	26.5	53
CHTBR/L2525-82	82	25	25.5	150	75	31.5	53

Note: The blade clamping screw heads protrude out for as much as 3.1 mm over the insert cutting edge point.
Maintain the clearance from the chucking device to avoid interference.

SPARE PARTS

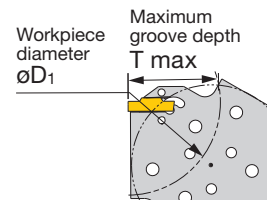


Designation	Clamping screw	Grip	Torx bit
CHTBR/L...	SR-ISO14580M4X10	SW6-SD	BLDT20/S7

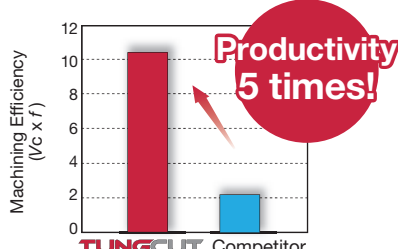
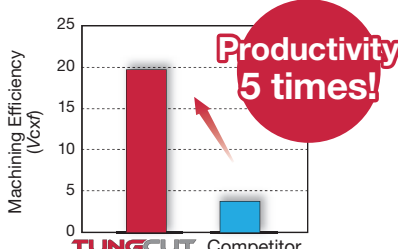
Maximum groove depth (T max) as function of workpiece diameter (øD₁)

Designation	øD ₁																	
CHTBR/L****-D52	53	54	55	56	58	60	62	65	68	72	78	84	92	102	115	133	159	198
CHTBR/L****-D82	104	108	112	116	121	127	134	142	151	162	176	192	212	237	270	313	375	468
T max	21	20	19	18	17	16	15	14	13	12	11	10	9	8	7	6	5	4

Designation	øD ₁											
CHTBR/L****-D82	83	84	85	86	87	89	90	92	94	96	98	101
T max	34	33	31	30	29	28	27	26	25	24	23	22



PRACTICAL EXAMPLES

Workpiece type		Bolt parts	Elevator parts
Toolholder		CHGP82-4T / CHTBR2525-82	CHGP52-3T / CHTBR2020-52
Insert		SGS4-030	SGM3-020
Grade		AH7025	AH7025
Workpiece material		S45C / C45	STKM13A
		 P	 P
Cutting conditions	Grooving width : CW (mm)	4	3
	Cutting speed : V _c (m/min)	70	190
	Feed : f (mm/rev)	0.15	0.1
	Cutting edge depth : CDX (mm)	25	5
	Machining	Parting off	Parting off
	Coolant	Wet	Wet
Results		 TungFeed-Blade doubled tool life, while also increasing feed rate 5 times when used with the high rigidity CHTBR holder.	 The high rigidity holder increasing 5 times feed rate while also tool life by 3 times.

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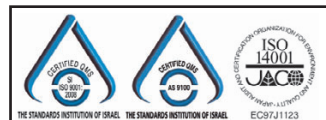
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