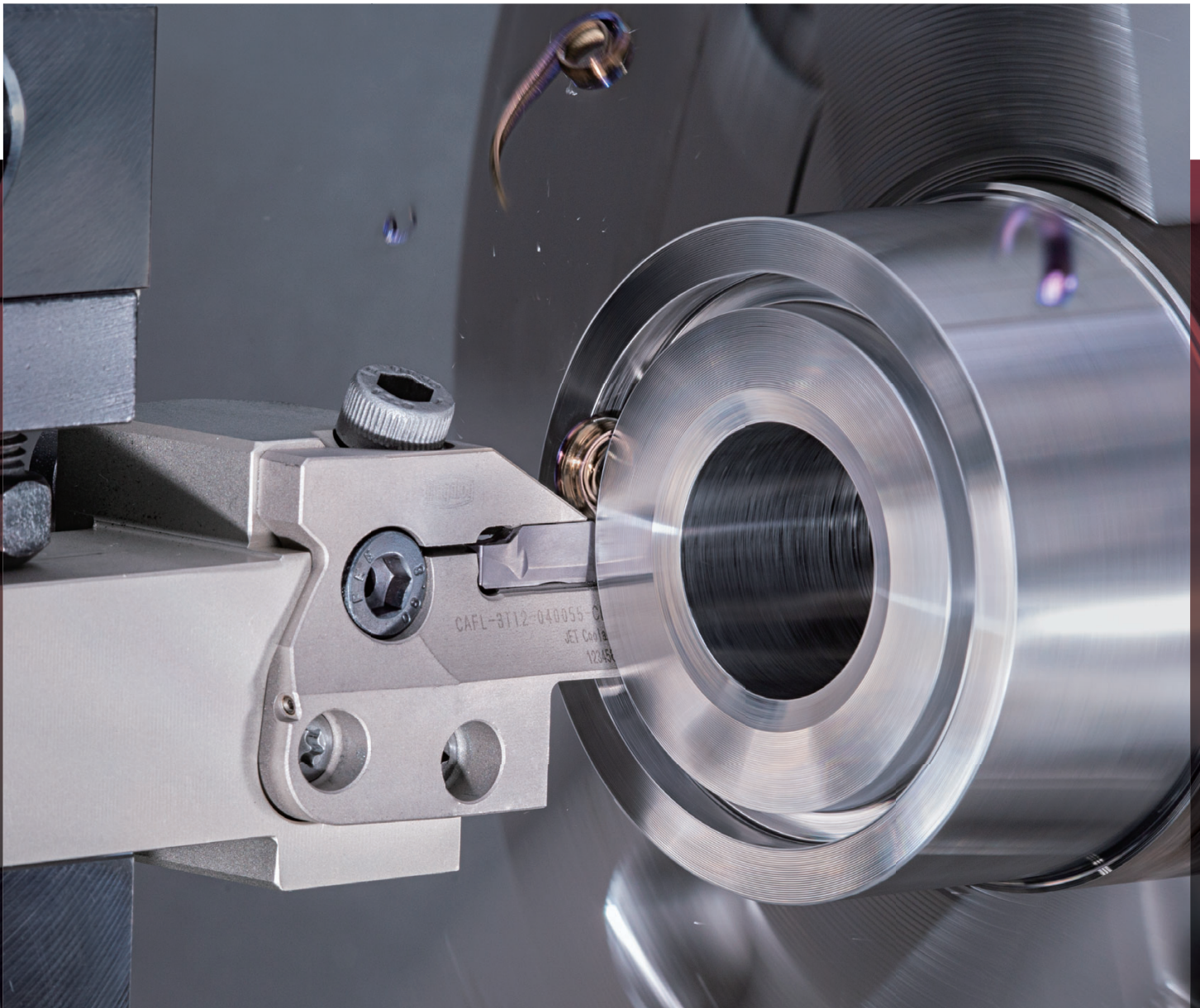


TUNG CUT

Tungaloy Report No. 391S4-US

Expansion of TungModular Adapter Line for OD and Face Grooving





For more information

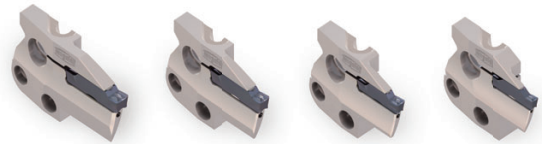
■ Highly rigid insert clamping provides stability in all OD and face grooving processes

■ Through-coolant technology provides improved chip evacuation

■ Modular tooling provides customers with reduced cycle time and tool cost



For Face Grooving (CHP)



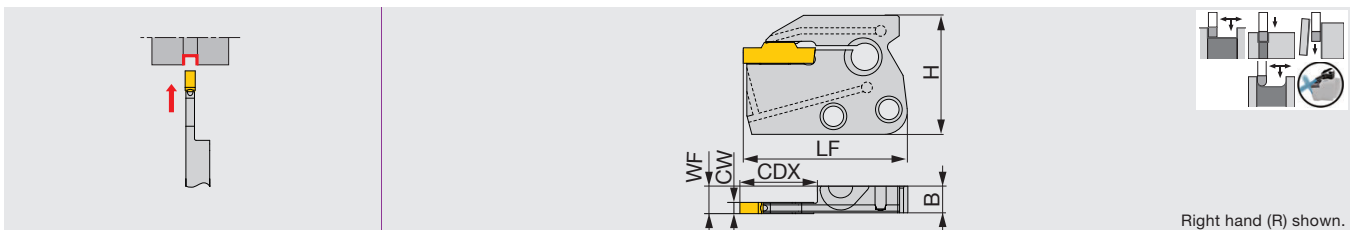
For External Grooving (Non CHP)



CAER/L-CHP

TUNG^{MODULAR}**SYSTEM**

Modular-type external grooving and parting adapter, with high pressure coolant capability



Right hand (R) shown.

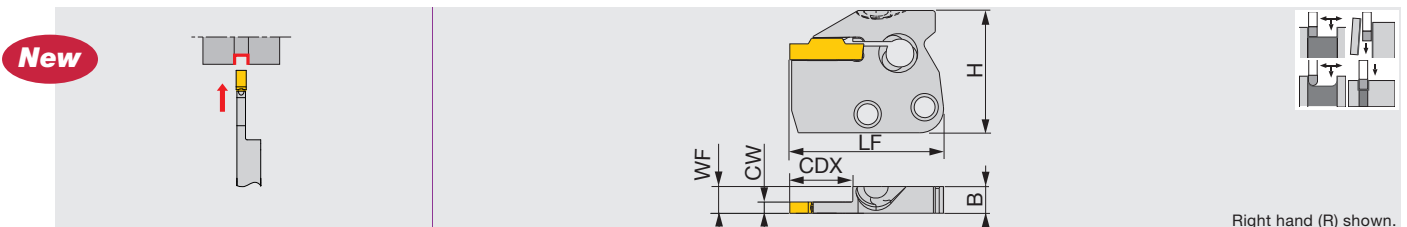
	Metric	CW	Seat size	CDX	H	B	LF	WF ⁽¹⁾
New	CAER/L-8T25-CHP	8	8	25	33	7.2	51.1	8.3

(1) WF is calculated with the groove width (CW) in the above table.

CAER/L-MD

TUNG^{MODULAR}**SYSTEM**

Modular-type external grooving and parting adapter



Right hand (R) shown.

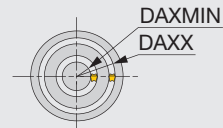
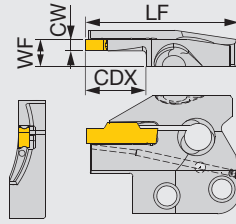
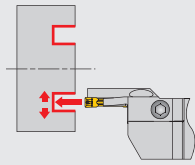
	Metric	CW	Seat size	CDX	H	B	LF	WF ⁽¹⁾
New	CAER/L-2T16-MD	2	2	16	33	7.2	41.5	7.3
	CAER/L-3T16-MD	3	3	16	33	7.2	41.5	7.4
	CAER/L-4T16-MD	4	4	16	33	7.2	41.5	7.7
	CAER/L-5T20-MD	5	5	20	33	7.2	46.3	7.8
	CAER/L-6T20-MD	6	6	20	33	7.2	46.3	7.8
	CAER/L-8T25-MD	8	8	25	33	7.2	51.1	8.3

(1) WF is calculated with the groove width (CW) in the above table.

CAFR/L-CHP

Modular-type Face grooving and turning adapter

New



Right hand (R) shown.

Metric	CW	DAXMIN	DAXX	Seat size	CDX	LF	WF ⁽¹⁾
CAFR/L-3T12-040055-CHP	3	40	55	3	12	43	7.5
CAFR/L-3T12-055075-CHP	3	55	75	3	12	43	7.5
CAFR/L-3T12-075100-CHP	3	75	100	3	12	43	7.5
CAFR/L-3T12-100140-CHP	3	100	140	3	12	43	7.5
CAFR/L-3T12-140200-CHP	3	140	200	3	12	43	7.5
CAFR/L-4T16-050070-CHP	4	50	70	4	16	43	8
CAFR/L-4T16-070100-CHP	4	70	100	4	16	43	8
CAFR/L-4T16-100150-CHP	4	100	150	4	16	43	8
CAFR/L-4T16-150250-CHP	4	150	250	4	16	43	8
CAFR/L-5T20-055080-CHP	5	55	80	5	20	47	8.5
CAFR/L-5T20-080120-CHP	5	80	120	5	20	47	8.5
CAFR/L-5T20-120180-CHP	5	120	180	5	20	47	8.5
CAFR/L-5T20-180300-CHP	5	180	300	5	20	47	8.5
CAFR/L-5T20-300000-CHP	5	300	∞	5	20	47	8.5
CAFR/L-6T25-060090-CHP	6	60	90	6	25	52	9
CAFR/L-6T25-090150-CHP	6	90	150	6	25	52	9
CAFR/L-6T25-150250-CHP	6	150	250	6	25	52	9
CAFR/L-6T25-250400-CHP	6	250	400	6	25	52	9

When groove depth is larger than (insert length - 1.5 mm), please use 1-cornered insert.

Max. groove depth will be 15 mm with DTF insert.

Use the right-hand insert for the right-hand holder with DTF insert.

(1) WF is calculated with the groove width (CW) in the above table.

(2) Seat sizes of DTF are only 3 and 4.

Combination of adapter and toolholder

Toolholder	adapter			
	CAER...	CAEL...	CAFR...	CAFL...
CHSR...	●			●
CHSL...		●	●	
CHFVR...		●	●	
CHFVL...	●			●

● : Corresponding

Insert	Groove width CW	Face grooving Min. machining dia. DAXMIN
DGM / DGS / SGN / DGL	3	92
DGM / DGS / SGN / DGL	4	37
DGM / DGS / DGL	5	60
DGM / DGS / DGL	6	57
DTE / DGG / DTM	3	62
DTE / DGG / DTM	4	42
DTE / DGG / DTM	5	64
DTE / DGG / DTM	6	61
DTR	3	44
DTR	4	32
DTR	5	48
DTR	6	48
DTX	3	22
DTX	4	20
DTX	5	20
DTX	6	23
DTF	3	20
DTF	4	20

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