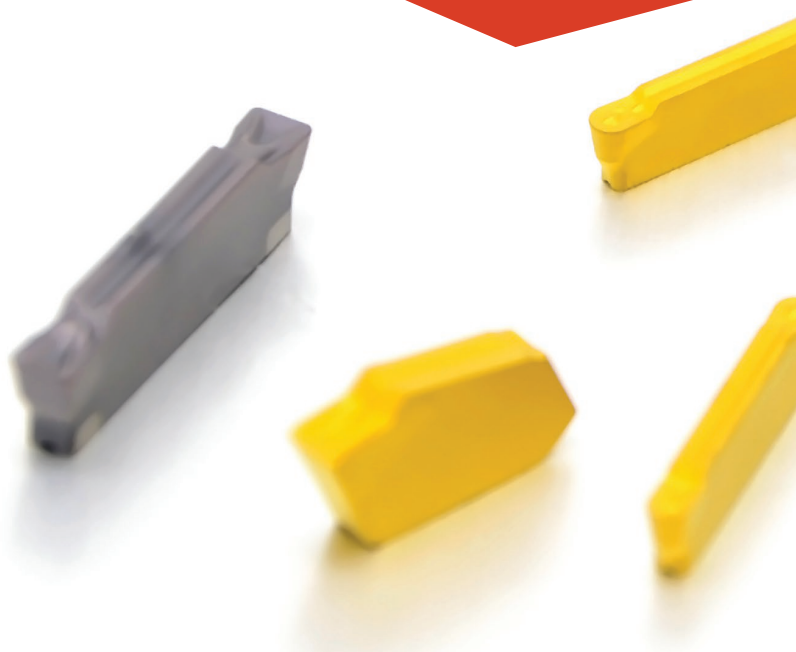
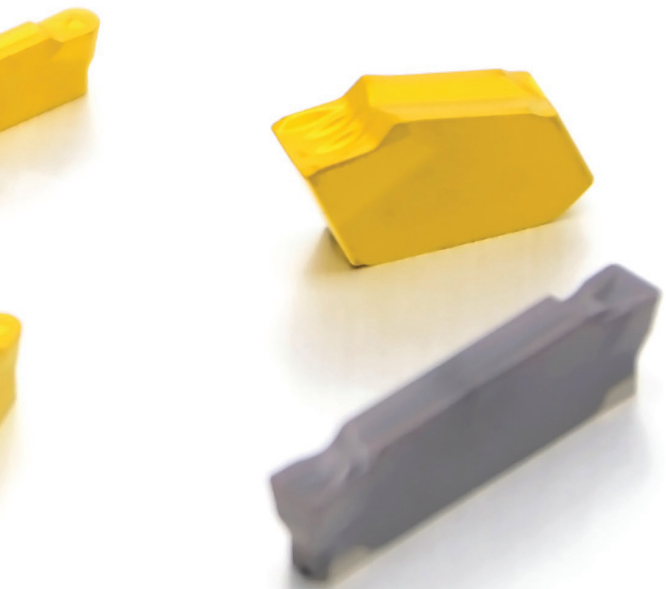




GROOVING INSERTS





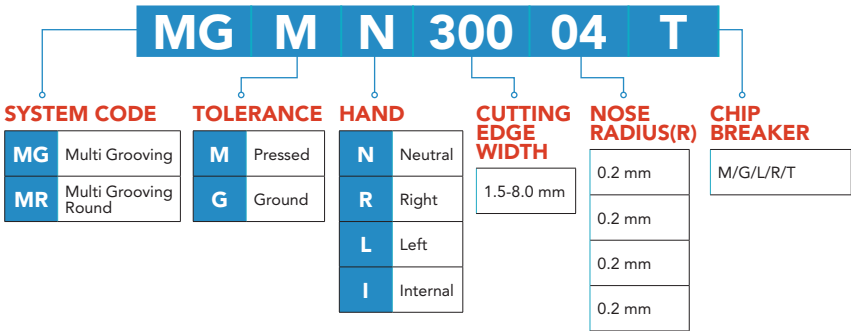
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GROOVING INSERTS

CODE KEY



HOW TO CHOOSE A GROOVING INSERT

THE GROOVE/SURFACE	THE COMPONENT	THE MACHINE
<p>Consider the following quality demands of the groove or surface to be machined:</p> <ul style="list-style-type: none"> Type of application (e.g. parting off or internal grooving) Cutting depth Cutting width Corner radius Quality demand (tolerance, surface finish etc.). Do we need a Wiper design insert to reach acceptable surface finish? A Wiper insert will offer better surface finish at maintained cutting data 	<p>After considering the quality demands, look at the component:</p> <ul style="list-style-type: none"> Cutting depth Cutting width Corner radius Quality demand (tolerance, surface finish etc.). Do we need a Wiper design insert to reach acceptable surface finish? A Wiper insert will offer better surface finish at maintained cutting data 	<p>Machine considerations include:</p> <ul style="list-style-type: none"> Stability, power and torque, especially for larger components Cutting fluid and coolant supply Is high pressure coolant for chip-breaking in long chipping materials necessary? Tool changing times/ number of tools in turret Limitations in rpm, especially for bar feed magazine and small diameters Sub-spindle, or tail stock available?



CHIP BREAKER GEOMETRY

<p>MGM(G)N-M</p>  <ul style="list-style-type: none">• Specially designed chip breaker allows a smoother chip flow versus conventional flat-top geometries through the use of 2 central chip breaker• Specially placed convex dots assists with chip control in external machining, for a smoother chip flow• Chip breaker designed for turning & grooving applications	<p>MGMN-L</p>  <ul style="list-style-type: none">• Sharp cutting edge• Low cutting resistance• For auto CNC machine• For small Dia. processing
<p>MGMN-G</p>  <ul style="list-style-type: none">• Specially designed chip breaker allows narrower chips to promote better chip flow• Specifically designed for grooving applications	<p>MGMN-R</p>  <ul style="list-style-type: none">• Strong cutting edge• For high Feed rate processing
<p>MRMN-M</p>  <ul style="list-style-type: none">• Full radius geometry for applications that require profiling• Available for relief machining	<p>MGMN-T</p>  <ul style="list-style-type: none">• For turning & grooving• Reduced chip width & smooth chip control by dot designed on the top corner



GROOVING INSERTS

NICHE CVD NC (CVD COATING)

GRADE	ISO	FEATURES
NC3215	P10~P15	<ul style="list-style-type: none"> • Continuous machining of general steel and forged steel at high speed • Substrate with excellent thermal crack/plastic deformation resistance, coating with improved chipping resistance for continuous machining • MT-TiCN + Al₂O₃ + TiN
NC3225	P15~P25	<ul style="list-style-type: none"> • Universal grade for general steel and forged steel • 1st Recommended grade for general machining with the use of high toughness substrate and coating layer with improved welding/chipping resistance • MT-TiCN + Al₂O₃ + TiN
NC3120	P20~P25	<ul style="list-style-type: none"> • Medium to roughing for steel • Combining excellent fracture resistance substrate with chipping resistance and heat resistance Al₂O₃ increased stability • MT-TiCN + TiC + Al₂O₃
NC3030	P25~P35	<ul style="list-style-type: none"> • Medium to low speed machining of steel and interrupted roughing • Harmony between substrate with excellent wear/fracture resistance and Al₂O₃ film with excellent thermal/chipping resistance • Increased stability in wide ranges of cutting conditions • MT-TiCN + TiC + Al₂O₃ + TiN
NC5330	P30~P35	• Stainless Steel – General cutting for mild steel & forging steel
	M25~M35	• Excellent cutting performance in hard to cut materials which are vulnerable to built up edge, due to the high tough substrate with improved fracture resistance and the coated layers
	K15~K25	
	S15~S25	• MT-TiCN + Al ₂ O ₃ + TiN
NC9125	M20~M30	<ul style="list-style-type: none"> • General cutting of stainless steel and heat resistant alloys • MT-TiCN + Al₂O₃ + TiN
NC6315	K10~K15	<ul style="list-style-type: none"> • Universal grade for ductile and gray cast Iron • Excellent performance thanks to the alumina (Al₂O₃) coating's improved grip on the tough substrat • MT-TiCN + Al₂O₃

WORKPIECE MATERIAL





NICHE PVD NP (PVD COATING)

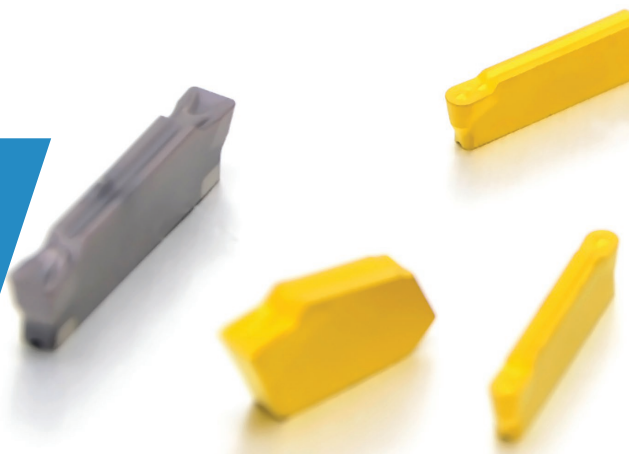
GRADE	ISO	FEATURES
NP8105	M05~M15	<ul style="list-style-type: none"> For high speed and continuous finishing of hard-to-cut materials Excellent cutting performance with high wear resistance and oxidation resistance Ultra fine substrate and the new TiAlN coating layer
	S01~S10	
	H01~H05	
NP8110	M10~M20	<ul style="list-style-type: none"> For high speed and continuous medium cutting of hard-to-cut materials and STS Excellent tool life with high wear/plastic deformation resistance at high temperature New TiAlN coating layer and substrate with excellent thermal resistance
	S05~S15	
	H01~H10	
NP8115	M15~M25	<ul style="list-style-type: none"> For medium to low speed and medium to rough cutting of hard-to-cut materials and STS Excellent tool life with high wear resistance and chipping resistance Ultra fine substrate and the new TiAlN coating layer
	S10~S20	
	H05~H15	
NP5300	P30~P40	<ul style="list-style-type: none"> Universal grade for stainless,HRSA,steel and interrupted cast iron machining High chipping and welding resistance for longer tool life New TiAlN coating and ultra fine grain substrate adopted
	M20~M30	
	K20~K25	
	S15~S25	
NP9030	M25~M35	<ul style="list-style-type: none"> Medium,roughing and heavy interrupted cutting for stainless steel TiAlN coating and ultra fine grain substrate adopted High chipping and welding resistance for stable machining
NP5400	P35~P45	<ul style="list-style-type: none"> For medium cutting for hard-to-cut materials, stainless steel, steel, and cast iron at medium or low speed Stable machinability with chipping resistance, fracture resistance and welding resistance Ultra fine substrate with high toughness and new AlCIN layer
	M30~M40	
	K30~K35	
	S25~S35	

NICHE UNCOATED NU (NO COATING)

GRADE	ISO	FEATURES
NU810	N	For aluminium alloy

WORKPIECE MATERIAL

P M K N S H



SPECIFICATION	DIMENSION					CONFIGURATION	APPLICATION
	b	r	l	d	t		
MGMN150-G	1,5	0,15	16,0	1,2	3,5		GROOVING
MGMN200-G	2,0	0,2	16,0	1,6	3,5		
MGMN250-G	2,5	0,2	18,5	2,0	3,85		
MGMN300-G	3,0	0,3	21,0	2,35	4,8		
MGMN400-G	4,0	0,3	21,0	3,3	4,8		
MGMN500-G	5,0	0,5	26,0	4,1	5,8		
MGMN600-G	6,0	0,8	26,0	5,0	5,8		GROOVING TURNING
MGMN200-M	2,0	0,2	16,0	1,6	3,5		
MGMN250-M	2,5	0,2	18,5	2,0	3,85		
MGMN300-02-M	3,0	0,2	21,0	2,35	4,8		
MGMN300-M	3,0	0,4	21,0	2,35	4,8		
MGMN350-03-M	3,5	0,3	21,0	2,9	4,8		
MGMN400-02-M	4,0	0,2	21,0	3,3	4,8		
MGMN400-M	4,0	0,4	21,0	3,3	4,8		
MGMN500-04-M	5,0	0,4	26,0	4,1	5,8		
MGMN500-M	5,0	0,8	26,0	4,1	5,8		
MGMN600-M	6,0	0,8	26,0	5,0	5,8		
MGMN800-M	8,0	0,8	31,0	6,0	6,5		

SPECIFICATION	DIMENSION					CONFIGURATION	APPLICATION
	b	r	l	d	t		
MGMN200-02-L	2,0	0,2	16,0	1,6	3,5		GROOVING
MGMN300-02-L	3,0	0,2	21,0	2,35	4,8		
MGMN400-02-L	4,0	0,2	21,0	3,3	4,8		
MGMN200-04-L	2,0	0,4	20,0	1,7	3,5		
MGMN300-04-L	3,0	0,4	20,0	2,3	4,0		
MGMN400-04-L	4,0	0,4	20,0	3,3	4,0		GROOVING PARTING OFF
MGMN500-04-L	5,0	0,4	26,0	4,1	5,8		
MGMN200-02-R	2,0	0,2	16,0	1,6	3,5		
MGMN300-02-R	3,0	0,2	21,0	2,35	4,8		
MGMN400-02-R	4,0	0,2	21,0	3,3	4,8		
MGMN200-04-R	2,0	0,4	20,0	1,7	3,5		GROOVING TURNING
MGMN300-04-R	3,0	0,4	20,0	2,3	4,0		
MGMN400-04-R	4,0	0,4	20,0	3,3	4,0		
MGMN500-04-R	5,0	0,4	26,0	4,1	5,8		
MGMN200-T	2,0	0,2	16,0	1,6	3,5		
MGMN300-T	3,0	0,4	21,0	2,35	4,8		RELIEFING PROFILING
MGMN400-T	4,0	0,4	21,0	3,3	4,8		
MGMN500-T	5,0	0,8	26,0	4,1	5,8		
MRMN200-M	2,0	1,0	16,0	1,5	3,5		
MRMN300-M	3,0	1,5	21,0	2,35	4,8		
MRMN400-M	4,0	2,0	21,0	3,3	4,8		
MRMN500-M	5,0	2,5	26,0	4,1	5,8		RELIEFING PROFILING
MRMN600-M	6,0	3,0	26,0	5,0	5,8		
MRMN800-M	8,0	4,0	31,0	6,0	6,5		



GROOVING INSERTS

SPECIFICATION	DIMENSION			CONFIGURATION	APPLICATION
	W	l	r		
SP160	1,6	7,8	0,16		PARTING OFF
SP180	1,8	9,3	0,16		
SP200	2,2	9,3	0,20		
SP200R	2,2	9,3	0,20		
SP200L	2,2	11,3	0,20		
SP300	3,1	11,3	0,20		
SP300R	3,1	11,3	0,20		
SP300L	3,1	11,3	0,20		
SP400	4,1	11,3	0,25		
SP400R	4,1	11,3	0,25		
SP400L	4,1	11,3	0,25		
SP500	5,1	11,4	0,30		
SP500R	5,1	11,4	0,30		
SP500L	5,1	11,4	0,30		
SP600	6,4	11,4	0,35		
SP600R	6,4	11,4	0,35		
SP600L	6,4	11,4	0,35		

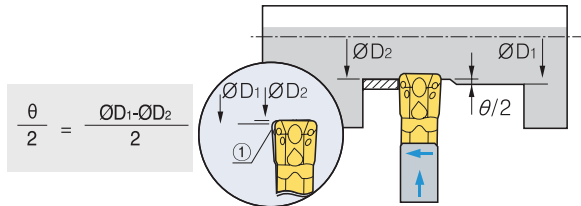


SELECTION OF INSERT

Feed Rate	<ul style="list-style-type: none"> Decide maximum feed rate after considering the insert's characteristics and machine capabilities ($F_{max} = W \times 0.075$) Max feed rate should not be larger than the corner radius of the insert In grooving applications, chip evacuation problems can be remedied by using step feed methods at small intervals 	
Depth of Cut	<ul style="list-style-type: none"> The minimum depth of cut should be bigger than corner radius of insert When deciding on the max depth of cut, consider the machine's cutting load Depending on the shape of the insert, deflection of work piece and clearance angle can be changed 	

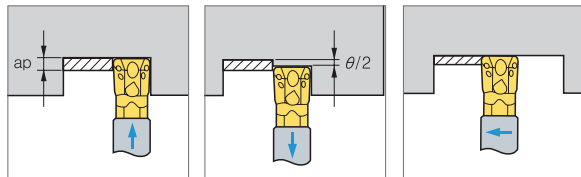
NOTICE FOR FINISHING (OFFSET NEED FINAL QUALITY)

- After desired diameter is grooved, continuous turning operation might cause some deflection of the workpiece. In these cases follow the given formula, offsetting these factors enables the desired diameter that you want
- Follow these steps:
 - Groove to the desired diameter
 - Pull the tool back a total distance of $\frac{1}{2}$
 - Continue the external turning operation to desired diameter



INCORRECT USAGE

- To eliminate the difference in the machined diameter by utilizing the clearance angle (which is commonly generated during the final turning operation) follow the directions above when machining



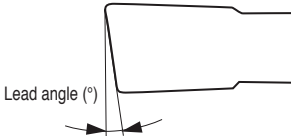


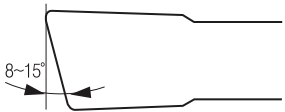


GROOVING INSERTS

INSERT SELECTION CONSIDERATIONS

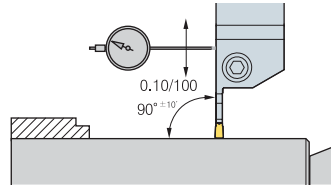
<p>To properly match the insert and cutting condition, the following factors should be considered</p> <ul style="list-style-type: none"> • Width of insert • Chip breaker • Grade and nose 	<p>The relationship between the cutting width and cutting depth</p> <ul style="list-style-type: none"> • Neutral type, inserts with a 0-degree lead angle are best when used in applications maximum depth of cut • In general alloy steel, the maximum depth of cut = $W \times 0.8$ 	<p>Insert with lead angle</p> <ul style="list-style-type: none"> • To reduce burrs, we recommend using an insert with a lead angle. Inserts that have larger lead angles reduce burrs but will also decrease tool life • In the case where burrs are acceptable, we recommend using a neutral type insert
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INSERT

LEAD ANGLE APPLICATIONS	LEAD ANGLE 0° (NEUTRAL)
	
<ul style="list-style-type: none"> • 4°- Pipe (Tubing and hollow bar) • 6°- Pipe and solid bar • 8°- Solid bar • 15°- Small diameter Solid bar 	<ul style="list-style-type: none"> • Parting off on solid bar type • Occurring the center stub when parting off • Prevent to be deflected workpiece by cutting direction during parting off • Available for use deep parting depth
LEAD ANGLE 4° ~ 8°	LEAD ANGLE 8° ~ 15°
	
<ul style="list-style-type: none"> • Reduce the center stub when parting off on solid bar type • Reduce the burr when parting off on tubing or hollow bar type 	<ul style="list-style-type: none"> • Parting off on small diameter and hollow bar type • Reduce the burr and center stub when parting off on small diameter solid bar type

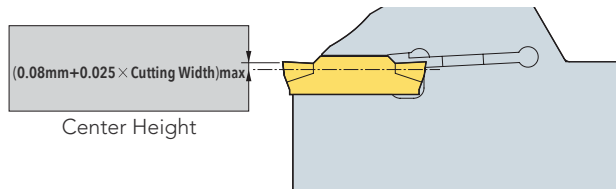
SETTING OF HOLDERS

- The cutting position should be exactly mounted on machined axis in order to create a perpendicular direction or 90 to minimize vibration



SETTING OF PARTING OFF

- The edge height of an insert should be set within $\pm 0.1\text{mm}$ based on the center line
- Parting off should be done as close to the chuck as possible to minimize vibration



NOTICE

- Keep a consistent cutting speed and feed
- Use proper amounts of coolant for better performance
- Properly clean the insert pocket before mounting insert

USAGE

- If insert is worn, immediately replace with a new insert. This is to prevent the damage on the workpiece
- If the holder seat is worn or damaged replace with a new one immediately for stable clamping
- Do not grind or regrind the holder seat



TROUBLESHOOTING

Problem/Issue	Solution
Rough surface	<ul style="list-style-type: none">• Use a short and stable tool• Use geometry with good chip control• Check speed / feed guidelines• Use wiper geometry• Check tool set-up
Roug surface on aluminium	<ul style="list-style-type: none">• Select the sharpest geometry• Use geometry with good chip control• Select a special soluble oil for the material
Poor chip breakage	<ul style="list-style-type: none">• Change geometry• Select a higher feed• Use dwelling (pecking)• Increase coolant
Vibration	<ul style="list-style-type: none">• Use a stable set-up• Check speed/feed guidelines• Use shorter overhang• Change geometry• Check tool condition• Check tool set-up
Poor tool life	<ul style="list-style-type: none">• Check centre height• Check angle between tool and component• Check condition of the blade. If the blade is old, the insert could be unstable in the tip-seat



INSERT WEAR (EDGE)

Problem/Issue	Cause	Solution
Built-up edge (B.U.E) When parting to centre and on stainless material, it is almost impossible to avoid BUE. It is important to minimize this by following the solutions.	<ul style="list-style-type: none"> • Cutting edge temperature too low 	<ul style="list-style-type: none"> • Increase cutting speed and/or feed
	<ul style="list-style-type: none"> • Unsuitable geometry or grade 	<ul style="list-style-type: none"> • Choose a geometry with a sharper edge preferably a PVD-coated grade
Chipping/breakage	<ul style="list-style-type: none"> • Too hard grade 	<ul style="list-style-type: none"> • Choose a softer grade
	<ul style="list-style-type: none"> • Too weak geometry 	<ul style="list-style-type: none"> • Choose a geometry for higher feed area
	<ul style="list-style-type: none"> • Unstable conditions 	<ul style="list-style-type: none"> • Reduce overhang. Check centre height
	<ul style="list-style-type: none"> • Too high cutting data 	<ul style="list-style-type: none"> • Reduce cutting data
Plastic deformation (PD)	<ul style="list-style-type: none"> • Excessive temperature in cutting zone 	<ul style="list-style-type: none"> • Reduce cutting speed and/or feed
	<ul style="list-style-type: none"> • Unsuitable grade 	<ul style="list-style-type: none"> • Choose more wear resistant grade
	<ul style="list-style-type: none"> • Lack of coolant supply 	<ul style="list-style-type: none"> • Increase coolant supply
Flank wear	<ul style="list-style-type: none"> • Cutting speed too high 	<ul style="list-style-type: none"> • Decrease cutting speed
	<ul style="list-style-type: none"> • Too soft grade 	<ul style="list-style-type: none"> • Choose a more wear resistant grade
	<ul style="list-style-type: none"> • Lack of coolant supply 	<ul style="list-style-type: none"> • Increase coolant supply
Crater wear	<ul style="list-style-type: none"> • Cutting speed too high 	<ul style="list-style-type: none"> • Decrease cutting speed
	<ul style="list-style-type: none"> • Too soft grade 	<ul style="list-style-type: none"> • Choose more wear resistant grade
	<ul style="list-style-type: none"> • Feed too high 	<ul style="list-style-type: none"> • Decrease feed
	<ul style="list-style-type: none"> • Lack of coolant supply 	<ul style="list-style-type: none"> • Increase coolant supply
Notch wear	<ul style="list-style-type: none"> • Oxidation at the cutting depth 	<ul style="list-style-type: none"> • Use varying cutting depths (ramping)
	<ul style="list-style-type: none"> • Cutting edge temperature too high 	<ul style="list-style-type: none"> • Reduce cutting speed



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