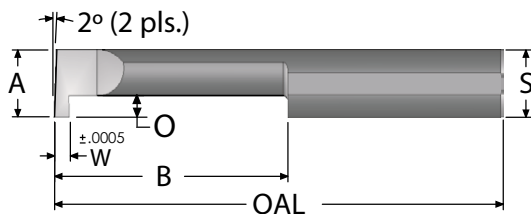


GROOVE TOOLS - RETAINING RING - SOLID CARBIDE

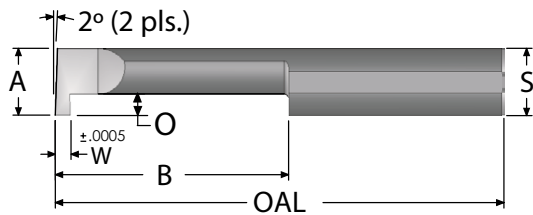


- ALTiN+ coating for higher Surface Feet per Minute
- Shank diameter is precision ground
- Made with premium submicron grade carbide

"A" MIN BORE	"W" TOOL WIDTH	"B" MAX DEPTH	"O" OFF SET	"S" SHANK DIA.	OAL	ORDER #		EDP #	
						UNCOATED	ALTiN+	UNCOATED	ALTiN+
0.060	0.0320	0.187	0.020	0.125	1.50	GT031-3	GT031-3A	220551	220611
0.060	0.0320	0.250	0.020	0.125	1.50	GT031-4	GT031-4A	220554	220614
0.060	0.0320	0.375	0.020	0.125	1.50	GT031-6	GT031-6A	220557	220617
0.090	0.0460	0.250	0.030	0.125	1.50	GT045-4	GT045-4A	220560	220620
0.090	0.0460	0.375	0.030	0.125	1.50	GT045-6	GT045-6A	220563	220623
0.090	0.0460	0.500	0.030	0.125	1.50	GT045-8	GT045-8A	220566	220626
0.120	0.0620	0.250	0.040	0.125	1.50	GT061-4	GT061-4A	220572	220632
0.120	0.0620	0.375	0.040	0.125	1.50	GT061-6	GT061-6A	220575	220635
0.120	0.0620	0.500	0.040	0.125	1.50	GT061-8	GT061-8A	220578	220638
0.120	0.0620	0.625	0.040	0.125	1.50	GT061-10	GT061-10A	220569	220629
0.187	0.0175	0.250	0.050	0.1875	2.00	GT017K-4	GT017K-4A	220644	220740
0.187	0.0175	0.375	0.050	0.1875	2.00	GT017K-6	GT017K-6A	220647	220743
0.187	0.0175	0.500	0.050	0.1875	2.00	GT017K-8	GT017K-8A	220650	220746
0.187	0.0175	0.625	0.050	0.1875	2.00	GT017K-10	GT017K-10A	220641	220737
0.187	0.0255	0.250	0.050	0.1875	2.00	GT025K-4	GT025K-4A	220656	220752
0.187	0.0255	0.375	0.050	0.1875	2.00	GT025K-6	GT025K-6A	220659	220755
0.187	0.0255	0.500	0.050	0.1875	2.00	GT025K-8	GT025K-8A	220662	220758
0.187	0.0255	0.625	0.050	0.1875	2.00	GT025K-10	GT025K-10A	220653	220749
0.187	0.0305	0.250	0.050	0.1875	2.00	GT030K-4	GT030K-4A	220668	220764
0.187	0.0305	0.375	0.050	0.1875	2.00	GT030K-6	GT030K-6A	220671	220767
0.187	0.0305	0.500	0.050	0.1875	2.00	GT030K-8	GT030K-8A	220674	220770
0.187	0.0305	0.625	0.050	0.1875	2.00	GT030K-10	GT030K-10A	220665	220761
0.187	0.0630	0.250	0.050	0.1875	2.00	GT062K-4	GT062K-4A	220680	220776
0.187	0.0630	0.375	0.050	0.1875	2.00	GT062K-6	GT062K-6A	220683	220779
0.187	0.0630	0.500	0.050	0.1875	2.00	GT062K-8	GT062K-8A	220686	220782
0.187	0.0630	0.625	0.050	0.1875	2.00	GT062K-10	GT062K-10A	220677	220773
0.250	0.0175	0.250	0.060	0.250	2.50	GT017Q-4	GT017Q-4A	220788	220908
0.250	0.0175	0.375	0.060	0.250	2.50	GT017Q-6	GT017Q-6A	220791	220911
0.250	0.0175	0.500	0.060	0.250	2.50	GT017Q-8	GT017Q-8A	220794	220914
0.250	0.0175	0.625	0.060	0.250	2.50	GT017Q-10	GT017Q-10A	220785	220905
0.250	0.0255	0.250	0.060	0.250	2.50	GT025Q-4	GT025Q-4A	220800	220920
0.250	0.0255	0.375	0.060	0.250	2.50	GT025Q-6	GT025Q-6A	220803	220923
0.250	0.0255	0.500	0.060	0.250	2.50	GT025Q-8	GT025Q-8A	220806	220926
0.250	0.0255	0.625	0.060	0.250	2.50	GT025Q-10	GT025Q-10A	220797	220917
0.250	0.0305	0.250	0.060	0.250	2.50	GT030Q-4	GT030Q-4A	220812	220932
0.250	0.0305	0.375	0.060	0.250	2.50	GT030Q-6	GT030Q-6A	220815	220935
0.250	0.0305	0.500	0.060	0.250	2.50	GT030Q-8	GT030Q-8A	220818	220938
0.250	0.0305	0.625	0.060	0.250	2.50	GT030Q-10	GT030Q-10A	220809	220929
0.250	0.0630	0.250	0.060	0.250	2.50	GT062Q-4	GT062Q-4A	220824	220944
0.250	0.0630	0.375	0.060	0.250	2.50	GT062Q-6	GT062Q-6A	220827	220947
0.250	0.0630	0.500	0.060	0.250	2.50	GT062Q-8	GT062Q-8A	220830	220950
0.250	0.0630	0.625	0.060	0.250	2.50	GT062Q-10	GT062Q-10A	220821	220941
0.250	0.0930	0.250	0.060	0.250	2.50	GT092Q-4	GT092Q-4A	220836	220956
0.250	0.0930	0.375	0.060	0.250	2.50	GT092Q-6	GT092Q-6A	220839	220959
0.250	0.0930	0.500	0.060	0.250	2.50	GT092Q-8	GT092Q-8A	220842	220962
0.250	0.0930	0.625	0.060	0.250	2.50	GT092Q-10	GT092Q-10A	220833	220953

Left-hand style available in all sizes. To order left-hand style, start order number with "LH."

GROOVE TOOLS - RETAINING RING - SOLID CARBIDE

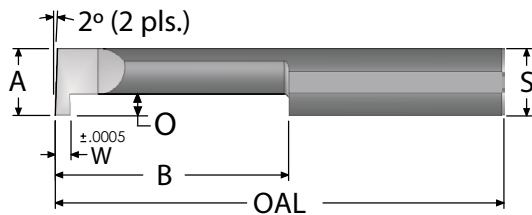


- ALTiN+ coating extends tool life
- Polished flute face for optimum performance
- Precision ground shank flat for guaranteed tool orientation

"A" MIN BORE	"W" TOOL WIDTH	"B" MAX DEPTH	"O" OFF SET	"S" SHANK DIA.	OAL	ORDER #		EDP #	
						UNCOATED	ALTiN+	UNCOATED	ALTiN+
0.312	0.0335	0.250	0.110	0.3125	2.50	GT033-4	GT033-4A	220968	221064
0.312	0.0335	0.375	0.110	0.3125	2.50	GT033-6	GT033-6A	220971	221067
0.312	0.0335	0.500	0.110	0.3125	2.50	GT033-8	GT033-8A	220974	221070
0.312	0.0335	0.750	0.110	0.3125	2.50	GT033-12	GT033-12A	220965	221061
0.312	0.0385	0.250	0.110	0.3125	2.50	GT038-4	GT038-4A	220980	221076
0.312	0.0385	0.375	0.110	0.3125	2.50	GT038-6	GT038-6A	220983	221079
0.312	0.0385	0.500	0.110	0.3125	2.50	GT038-8	GT038-8A	220986	221082
0.312	0.0385	0.750	0.110	0.3125	2.50	GT038-12	GT038-12A	220977	221073
0.312	0.0630	0.375	0.110	0.3125	2.50	GT063-6	GT063-6A	220995	221091
0.312	0.0630	0.500	0.110	0.3125	2.50	GT063-8	GT063-8A	220998	221094
0.312	0.0630	0.750	0.110	0.3125	2.50	GT063-12	GT063-12A	220989	221085
0.312	0.0630	1.000	0.110	0.3125	2.50	GT063-16	GT063-16A	220992	221088
0.312	0.1250	0.375	0.110	0.3125	2.50	GT124-6	GT124-6A	221007	221103
0.312	0.1250	0.500	0.110	0.3125	2.50	GT124-8	GT124-8A	221010	221106
0.312	0.1250	0.750	0.110	0.3125	2.50	GT124-12	GT124-12A	221001	221097
0.312	0.1250	0.500	0.110	0.3125	2.50	GT124-16	GT124-16A	221004	221100
0.375	0.040	0.250	0.110	0.375	2.50	GT039-4	GT039-4A	221118	221394
0.375	0.040	0.375	0.110	0.375	2.50	GT039-6	GT039-6A	221121	221397
0.375	0.040	0.500	0.110	0.375	2.50	GT039-8	GT039-8A	221124	221400
0.375	0.040	0.750	0.110	0.375	2.50	GT039-12	GT039-12A	221109	221385
0.375	0.040	1.000	0.110	0.375	2.50	GT039-16	GT039-16A	221112	221388
0.375	0.040	1.250	0.110	0.375	2.50	GT039-20	GT039-20A	221115	221391
0.375	0.047	0.250	0.110	0.375	2.50	GT046-4	GT046-4A	221136	221412
0.375	0.047	0.375	0.110	0.375	2.50	GT046-6	GT046-6A	221139	221415
0.375	0.047	0.500	0.110	0.375	2.50	GT046-8	GT046-8A	221142	221418
0.375	0.047	0.750	0.110	0.375	2.50	GT046-12	GT046-12A	221127	221403
0.375	0.047	1.000	0.110	0.375	2.50	GT046-16	GT046-16A	221130	221406
0.375	0.047	1.250	0.110	0.375	2.50	GT046-20	GT046-20A	221133	221409
0.375	0.056	0.250	0.110	0.375	2.50	GT055-4	GT055-4A	221154	221430
0.375	0.056	0.375	0.110	0.375	2.50	GT055-6	GT055-6A	221157	221433
0.375	0.056	0.500	0.110	0.375	2.50	GT055-8	GT055-8A	221160	221436
0.375	0.056	0.750	0.110	0.375	2.50	GT055-12	GT055-12A	221145	221421
0.375	0.056	1.000	0.110	0.375	2.50	GT055-16	GT055-16A	221148	221424
0.375	0.056	1.250	0.110	0.375	2.50	GT055-20	GT055-20A	221151	221427
0.375	0.063	0.250	0.110	0.375	2.50	GT062-4	GT062-4A	221172	221448
0.375	0.063	0.375	0.110	0.375	2.50	GT062-6	GT062-6A	221175	221451
0.375	0.063	0.500	0.110	0.375	2.50	GT062-8	GT062-8A	221178	221454
0.375	0.063	0.750	0.110	0.375	2.50	GT062-12	GT062-12A	221163	221439
0.375	0.063	1.000	0.110	0.375	2.50	GT062-16	GT062-16A	221166	221442
0.375	0.063	1.250	0.110	0.375	2.50	GT062-20	GT062-20A	221169	221445
0.375	0.070	0.250	0.110	0.375	2.50	GT069-4	GT069-4A	221190	221466
0.375	0.070	0.375	0.110	0.375	2.50	GT069-6	GT069-6A	221193	221469
0.375	0.070	0.500	0.110	0.375	2.50	GT069-8	GT069-8A	221196	221472
0.375	0.070	0.750	0.110	0.375	2.50	GT069-12	GT069-12A	221181	221457
0.375	0.070	1.000	0.110	0.375	2.50	GT069-16	GT069-16A	221184	221460
0.375	0.070	1.250	0.110	0.375	2.50	GT069-20	GT069-20A	221187	221463

Left-hand style available in all sizes. To order left-hand style, start order number with "LH."

GROOVE TOOLS - RETAINING RING - SOLID CARBIDE



- ALTiN+ coating for higher Surface Feet per Minute
- Shank diameter is precision ground
- Polished flute face for optimum performance
- Made with premium submicron grade carbide

"A" MIN BORE	"W" TOOL WIDTH	"B" MAX DEPTH	"O" OFF SET	"S" SHANK DIA.	OAL	ORDER #		EDP #	
						UNCOATED	AITiN	UNCOATED	ALTiN+
0.375	0.088	0.250	0.110	0.375	2.50	GT087-4	GT087-4A	221208	221484
0.375	0.088	0.375	0.110	0.375	2.50	GT087-6	GT087-6A	221211	221487
0.375	0.088	0.500	0.110	0.375	2.50	GT087-8	GT087-8A	221214	221490
0.375	0.088	0.750	0.110	0.375	2.50	GT087-12	GT087-12A	221199	221475
0.375	0.088	1.000	0.110	0.375	2.50	GT087-16	GT087-16A	221202	221478
0.375	0.088	1.250	0.110	0.375	2.50	GT087-20	GT087-20A	221205	221481
0.375	0.127	0.375	0.110	0.375	2.50	GT126-6	GT126-6A	221226	221502
0.375	0.127	0.500	0.110	0.375	2.50	GT126-8	GT126-8A	221229	221505
0.375	0.127	0.750	0.110	0.375	2.50	GT126-12	GT126-12A	221217	221493
0.375	0.127	1.000	0.110	0.375	2.50	GT126-16	GT126-16A	221220	221496
0.375	0.127	1.250	0.110	0.375	2.50	GT126-20	GT126-20A	221223	221499
0.375	0.158	0.375	0.110	0.375	2.50	GT157-6	GT157-6A	221241	221517
0.375	0.158	0.500	0.110	0.375	2.50	GT157-8	GT157-8A	221244	221520
0.375	0.158	0.750	0.110	0.375	2.50	GT157-12	GT157-12A	221232	221508
0.375	0.158	1.000	0.110	0.375	2.50	GT157-16	GT157-16A	221235	221511
0.375	0.158	1.250	0.110	0.375	2.50	GT157-20	GT157-20A	221238	221514
0.500	0.094	0.500	0.160	0.500	3.00	GT093-8	GT093-8A	221535	221685
0.500	0.094	0.750	0.160	0.500	3.00	GT093-12	GT093-12A	221523	221673
0.500	0.094	1.000	0.160	0.500	3.00	GT093-16	GT093-16A	221526	221676
0.500	0.094	1.250	0.160	0.500	3.00	GT093-20	GT093-20A	221529	221679
0.500	0.094	1.500	0.160	0.500	3.00	GT093-24	GT093-24A	221532	221682
0.500	0.126	0.500	0.160	0.500	3.00	GT125-8	GT125-8A	221550	221700
0.500	0.126	0.750	0.160	0.500	3.00	GT125-12	GT125-12A	221538	221688
0.500	0.126	1.000	0.160	0.500	3.00	GT125-16	GT125-16A	221541	221691
0.500	0.126	1.250	0.160	0.500	3.00	GT125-20	GT125-20A	221544	221694
0.500	0.126	1.500	0.160	0.500	3.00	GT125-24	GT125-24A	221547	221697
0.500	0.157	0.500	0.160	0.500	3.00	GT156-8	GT156-8A	221565	221715
0.500	0.157	0.750	0.160	0.500	3.00	GT156-12	GT156-12A	221553	221703
0.500	0.157	1.000	0.160	0.500	3.00	GT156-16	GT156-16A	221556	221706
0.500	0.157	1.250	0.160	0.500	3.00	GT156-20	GT156-20A	221559	221709
0.500	0.157	1.500	0.160	0.500	3.00	GT156-24	GT156-24A	221562	221712
0.500	0.188	0.500	0.160	0.500	3.00	GT187-8	GT187-8A	221580	221730
0.500	0.188	0.750	0.160	0.500	3.00	GT187-12	GT187-12A	221568	221718
0.500	0.188	1.000	0.160	0.500	3.00	GT187-16	GT187-16A	221571	221721
0.500	0.188	1.250	0.160	0.500	3.00	GT187-20	GT187-20A	221574	221724
0.500	0.188	1.500	0.160	0.500	3.00	GT187-24	GT187-24A	221577	221727
0.500	0.251	0.500	0.160	0.500	3.00	GT250-8	GT250-8A	221595	221745
0.500	0.251	0.750	0.160	0.500	3.00	GT250-12	GT250-12A	221583	221733
0.500	0.251	1.000	0.160	0.500	3.00	GT250-16	GT250-16A	221586	221736
0.500	0.251	1.250	0.160	0.500	3.00	GT250-20	GT250-20A	221589	221739
0.500	0.251	1.500	0.160	0.500	3.00	GT250-24	GT250-24A	221592	221742

Left-hand style available in all sizes. To order left-hand style, start order number with "LH."

SOLID CARBIDE BORING BAR FEED AND SPEED CHART

MATERIAL	HB/Rc	SPEED (SFM)		FEED IPR	CUTTING CONDITIONS					
		UNCOATED	ALTiN+		TOOL DIAMETER					
					.015-.045 MAX DOC	.050-.100 MAX DOC	.110-.160 MAX DOC	.180-.230 MAX DOC	.290-.320 MAX DOC	.360+ MAX DOC
CAST IRON	160 HB	75-200	200-550	.0005-.010	0.006	0.008	0.010	0.014	0.020	0.031
CARBON STEEL	18 Rc	75-200	200-450	.0005-.007	0.003	0.005	0.006	0.008	0.012	0.017
ALLOY STEEL	20 Rc	75-200	200-425	.0005-.007	0.003	0.004	0.005	0.007	0.010	0.015
TOOL STEEL	25 Rc	75-175	175-300	.0005-.005	0.002	0.003	0.004	0.006	0.008	0.012
300 STAINLESS STEEL	150 HB	75-175	175-350	.0005-.005	0.003	0.003	0.004	0.006	0.008	0.013
400 STAINLESS STEEL	195 HB	75-210	130-420	.0005-.005	0.002	0.003	0.004	0.006	0.008	0.012
HIGH TEMP ALLOY (Ni & Co BASE)	20 Rc	50-130	130-300	.0005-.004	0.002	0.003	0.003	0.005	0.007	0.010
TITANIUM	25 Rc	50-120	120-275	.0005-.005	0.003	0.004	0.005	0.006	0.009	0.014
HEAT TREATED ALLOYS (38-45Rc)	40 Rc	50-100	100-200	.0005-.005	0.002	0.002	0.003	0.004	0.006	0.009
ALUMINUM	100 HB	75-250	250-750	.0005-.015	0.011	0.015	0.019	0.026	0.038	0.056
BRASS, ZINC	80 HB	75-300	250-650	.001-.010	0.009	0.012	0.015	0.021	0.030	0.045

SFM = Surface Feet Per Minute DOC = Depth of Cut IPR = Inches Per Revolution

Starting parameters only. Length-to-diameter ratios, setup, and machine rigidity may affect performance.

$$\begin{aligned} \text{SFM} &= .262 \times \text{DIAMETER} \times \text{RPM} \\ \text{RPM} &= 3.82 \times \text{SFM} \div \text{DIAMETER} \\ \text{IPM} &= \text{FPT} \times \text{Number of Teeth} \times \text{RPM} \end{aligned}$$

$$\begin{aligned} \text{Meters/Min} &= \text{SFM} \times .3048 \\ \text{Millimeters/Rev} &= \text{IPR} \times 25.40 \end{aligned}$$

SOLID CARBIDE BORING TROUBLESHOOTING

PROBLEM	CAUSE	SOLUTION
RAPID FLANK WEAR	CUTTING CONDITIONS	Check for excessive speed and feed - See chart.
	TOOL	Select a coated tool.
	PART	Make sure prior operation did not work harden the metal.
BUILT-UP EDGE	TOOL	Select a coated tool.
	CUTTING FORCE	Check for excessive feed rate (IPR) - See chart.
	HEAT	Use the SCT coolant holder. If coolant is not available, use shop air and a coated tool.
CORNER BREAKAGE	CUTTING CONDITIONS	Check for excessive feed and speed and depth of cut - see chart.
	TOOL	Select a tool with a radius. A radius is stronger than a sharp corner.
	PART	Check the drilled hole.
SURFACE TOO ROUGH	CUTTING CONDITIONS	Check for excessive feed rate (IPR) - See chart.
	BUILT-UP EDGE	See above (Built-Up Edge).
CHATTER	SET UP	Set tool above center. Reduce the overhang ratio. Clamping length should be at least 3x the boring bar diameter. Change the speed of the machine. Speed change may break up harmonics and reduce chatter.
	BORING BAR	Select the largest diameter boring bar that will bore the required diameter.
TAPER SMALLER IN BACK	CHIP PACKING	If the boring bar is too large to allow chips to evacuate, then the chips may pack on the tool and cause the bar to deflect away from the bore.
	PROGRAM	If the taper is consistent, then the program can be altered to bore a taper in opposite direction resulting in a straight hole.
TAPER BIGGER IN BACK	CUTTING FORCES	Reduce forces. Deflecting bar below center causes hole to become larger.
	BUILT-UP EDGE	Built-up edge will cause the hole to become larger until the built edge breaks off, then the hole becomes smaller.
	PROGRAM	If taper is consistent, then the program can be altered to bore a taper in the opposite direction resulting in a straight hole.

GROOVING TOOL FEED AND SPEED CHART

MATERIAL	HB/Rc	SPEED (SFM)		CUTTING CONDITIONS				
				TOOL DIAMETER				
		UNCOATED	ALTiN+	.060 -0.080	.090 -.120	.187	.250-.312	.375+
				MAX FPR	MAX FPR	MAX FPR	MAX FPR	MAX FPR
CAST IRON	160 HB	75-200	200-550	0.0010	0.0012	0.0017	0.0031	0.0044
CARBON STEEL	18 Rc	75-200	200-450	0.0007	0.0008	0.0011	0.0022	0.0030
ALLOY STEEL	20 Rc	75-200	200-425	0.0006	0.0007	0.0010	0.0019	0.0026
TOOL STEEL	25 Rc	75-175	175-300	0.0005	0.0006	0.0008	0.0015	0.0022
300 STAINLESS STEEL	150 HB	75-175	75-350	0.0006	0.0007	0.0010	0.0019	0.0026
400 STAINLESS STEEL	195 HB	75-210	130-420	0.0005	0.0006	0.0008	0.0016	0.0023
HIGH TEMP ALLOY (NICKEL & COBALT BASE)	20 Rc	50-130	130-300	0.0004	0.0005	0.0007	0.0013	0.0017
TITANIUM	25 Rc	50-120	120-275	0.0005	0.0006	0.0008	0.0016	0.0022
HEAT TREATED ALLOYS (38-45Rc)	40 Rc	50-100	100-200	0.0004	0.0004	0.0006	0.0011	0.0016
ALUMINUM	100 HB	75-250	250-750	0.0022	0.0026	0.0037	0.0065	0.0085
BRASS, ZINC	80 HB	250-300	250-650	0.0018	0.0021	0.0030	0.0053	0.0079

SFM = Surface Feet Per Minute

FPR = Feed Per Revolution

Starting parameters only. Length-to-diameter ratios, setup, and machine rigidity may affect performance.

GROOVING TOOL TROUBLESHOOTING

PROBLEM	CAUSE	SOLUTION
RAPID FLANK WEAR	CUTTING CONDITIONS	Check for excessive speed - see chart.
	TOOL	Select a coated tool.
	PART	Make sure prior operation did not work harden the material.
BUILT-UP EDGE	TOOL	Select a coated tool.
	CUTTING FORCE	Check for excessive speed rate (IPR) - see chart.
	HEAT	Use the SCT coolant holder. If coolant is not available, use shop air and a coated tool.
CHATTER	CUTTING CONDITIONS	Reduce RPM and increase feed rate within the feed and speed chart parameters.
	CLAMPING	Clamping length should be a minimum of 3x the shank diameter in the tool holder. Check tool holding rigidity.
	TOOL	Hone cutting edge. A light hone (0.0001-0.0003 inch) will help keep force constant.
TOOL BREAKAGE	CUTTING CONDITIONS	Check for excessive feed rate (IPR) - see chart.
	CHIP PACKING	Stagger - Peck grooving.

SINGLE POINT THREADING TECHNICAL CHART

MATERIAL	HB/Rc	SPEED (SFM)		FIRST PASS DEPTH					
		UNCOATED	ALTiN+	TOOL DIAMETER					
				.040-.050	.060-.092	.120-.152	.180-.232	.290-.362	.373+
CAST IRON	160 HB	75-200	200-550	0.003	0.004	0.005	0.007	0.008	0.009
CARBON STEEL	18 Rc	75-200	200-450	0.003	0.005	0.006	0.007	0.008	0.009
ALLOY STEEL	20 Rc	75-200	200-425	0.003	0.004	0.005	0.006	0.007	0.008
TOOL STEEL	25 Rc	75-175	175-300	0.002	0.003	0.004	0.005	0.006	0.007
300 STAINLESS STEEL	150 HB	75-175	175-350	0.003	0.003	0.004	0.005	0.006	0.007
400 STAINLESS STEEL	195 HB	75-210	130-420	0.003	0.004	0.005	0.006	0.006	0.007
HIGH TEMP ALLOY (NICKEL & COBALT BASE)	20 Rc	50-130	130-300	0.002	0.003	0.003	0.004	0.005	0.005
TITANIUM	25 Rc	50-100	120-275	0.003	0.003	0.004	0.005	0.006	0.007
HEAT TREATED ALLOYS (38-45Rc)	40 Rc	50-100	100-200	0.002	0.002	0.003	0.004	0.004	0.005
ALUMINUM	100 HB	75-250	200-750	0.004	0.005	0.007	0.008	0.010	0.011
BRASS, ZINC	80 HB	75-300	250-650	0.003	0.005	0.006	0.007	0.008	0.009

Parameters are a starting point based on machinability rating at hardness listed.
Check machinability rating of the material to be machined and adjust First Pass Depth.

Helpful Formulas and Information

$$\text{PITCH} = \frac{1}{\text{TPI}}$$

TPI = Threads Per Inch

ACME Thread Depth = Pitch × 0.5

Stub ACME Thread Depth = Pitch × 0.3

NPT Pipe Thread Depth = Pitch × 0.76

Internal 60° Thread Depth = Pitch × 0.54

Feed Rate = Pitch × Number of Thread Starts

Minimum Depth per Pass should not be less than 0.0003

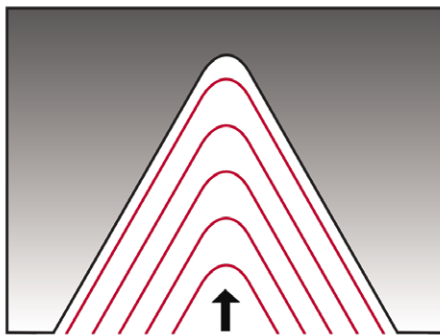
Threads not ending in a relief need at least one thread pitch length of pullout

Make sure feed rate calculation does not exceed the maximum feed rate of the machine

SINGLE POINT THREADING TROUBLESHOOTING

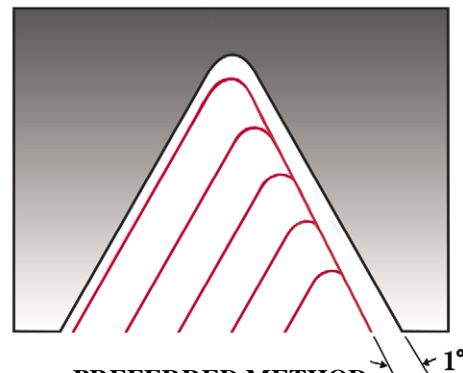
PROBLEM	CAUSE	SOLUTION
RAPID FLANK WEAR	CUTTING CONDITIONS	Check for excessive speed - see chart.
	PART	Make sure prior operation did not work harden the material.
	TOOL	Select a coated tool.
BUILT-UP EDGE	TOOL	Select a coated tool.
	CUTTING FORCE	Increase the number of passes.
	HEAT	Use the SCT coolant holder. If coolant is not available, use shop air and a coated tool.
CORNER BREAKAGE	CUTTING CONDITIONS	Reduce the depth-of-cut on the first pass.
	PROGRAM	If there is no thread relief, withdraw the tool on an angle.
	PART	End in thread relief.
CHIPS WRAPPING AROUND TOOL	TOOL	Use a tool that is at least 30% smaller than the hole diameter.

RADIAL INFEEED



NOT RECOMMENDED

MODIFIED FLANK



PREFERRED METHOD

Radial Infeed is not recommended. Modified flank at 1° is recommended.

For unfavorable length-to-diameter ratios or difficult-to-machine materials, the number of passes will need to be increased up to 40% more.

Depth of cut per pass should not be less than 0.0003 inch.

SINGLE POINT CBN & PCD TECHNICAL & APPLICATION

PCD TIPPED TOOL INFORMATION

SCT PCD tools and inserts are excellent for continuous cutting of a wide range of non-ferrous and non-metal materials. The products are precision ground for machining to sub-micron finishes with maximum tool life. PCD allows for higher cutting speeds with longer tool life.

SINGLE POINT TOOLS
TECH INFO

MATERIAL	BHN/Rc	SPEED RANGE (SFM)	FEED IPR	SINGLE POINT PCD TIPPED BARS			
				TOOL DIAMETER			
				.120-160 MAX DOC	.180-.230 MAX DOC	.290-.320 MAX DOC	.360+ MAX DOC
LOW SILICON ALUMINUM	225-350 BHN	1000-5000	.001-.007	0.015	0.021	0.03	0.045
HIGH SILICON ALUMINUM	270-425 BHN	600-3000	.001-.007	0.015	0.021	0.03	0.045
METAL MATRIX COMPOSITIES	N/A	500-2000	.001-.007	0.008	0.012	0.02	0.03
COPPER ALLOYS, BRASS, BRONZE	80-120 BHN	750-3500	.001-.007	0.015	0.021	0.03	0.045
PRESINTERED TUNGSTEN CARBIDE	140-300 BHN	100-350	.001-.005	0.003	0.005	0.007	0.012
ACRYLICS	N/A	700-1500	.001-.007	0.015	0.021	0.03	0.045
FIBERGLASS	N/A	600-1000	.001-.007	0.012	0.02	0.03	0.045
GRAPHITES	N/A	600-1000	.001-.007	0.015	0.021	0.03	0.045
NYLON, PLASTIC	N/A	700-1500	.001-.007	0.015	0.021	0.03	0.045
HARD RUBBER	N/A	500-2500	.001-.007	0.015	0.021	0.03	0.045

APPLICATION GUIDELINES
Make sure the machine and setup is rigid and solid. Chatter will cause chipping.
Tool height when boring should be slightly above center. Tool deflection will put the tool on center.
Do not stop the machine with the tool in cut. This will result in tool breakage.
Use of coolant will reduce heat and improve surface finish.
Do not contact the tool to a hard surface prior to the machining process- this will cause chipping.
Higher speeds minimize tool buildup.
Depth of cut should not exceed 70% of PCD tip length.

As the DOC decreases the feed rate can increase DOC = Depth of Cut SFM = Surface Feet per Minute

CBN TIPPED TOOL INFORMATION

SCT CBN tools and inserts are excellent for continuous cutting of a wide range of hardened steels, powdered metals, cast irons and super alloys. The products are precision ground with hones for machining to sub-micron finishes with maximum tool life. CBN tipped tools and inserts can take the place of grinding.

MATERIAL	BHN/Rc	SPEED RANGE (SFM)	FEED IPR	SINGLE POINT CBN TIPPED BARS			
				TOOL DIAMETER			
				.120-160 MAX DOC	.180-.230 MAX DOC	.290-.320 MAX DOC	.360+ MAX DOC
HEAT TREATED ALLOY	45-60Rc	200-600	.001-.005	0.003	0.004	0.006	0.009
TOOL STEEL	45-60Rc	200-600	.001-.005	0.003	0.004	0.006	0.009
NODULAR IRON	N/A	600-1500	.001-.005	0.006	0.01	0.02	0.03
PEARLITIC IRON	220-240BHN	600-2500	.001-.007	0.006	0.01	0.02	0.03
WHITE/CHILLED IRON	54-60Rc	200-500	.001-.005	0.005	0.008	0.012	0.015
SUPER ALLOY Ni BASE	240-475 BHN	200-800	.001-.005	0.003	0.004	0.006	0.025
COBOLT BASED ALLOY, STELLITE	45-55Rc	200-500	.001-.005	0.003	0.004	0.006	0.009
INCONELS	45-55Rc	200-500	.001-.005	0.003	0.004	0.006	0.009

APPLICATION GUIDELINES
Make sure the machine and setup is rigid and solid. Chatter will cause chipping
Tool height when boring should be slightly above center. Tool deflection will put the tool on center.
Do not stop the machine with the tool in cut. This will result in tool breakage.
Coolant use is not advised as it could cause thermal cracking.
Do not contact the tool to a hard surface prior to the machining process. This will cause chipping.
Depth of cut should not exceed 30% of CBN tip length.

As the DOC decreases the feed rate can increase DOC = Depth of Cut SFM = Surface Feet per Minute