

KERFOLG® TOOLHOLDERS FOR PARTING, GROOVING AND CUTTING SINGLE SIDE

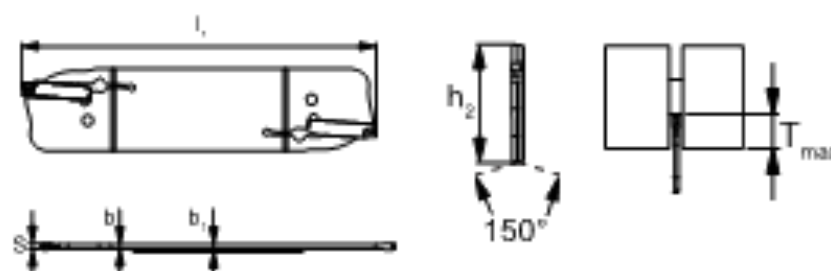
SGN...



ITEM: B2U35

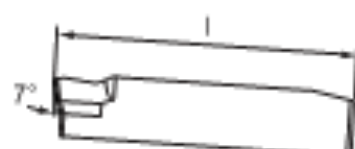
Type SGN22...
Dimension 2 mm
Clamping system Flexible
Application Grooving and parting

BL/R/N... SGN



										SPARE PARTS	
	Tech. Code		Description	h2 mm	b mm	b1 mm	s mm	l1 mm	Tmax mm	Inserts	Wrench
BL/R/N... SGN	B2U3526L02		BL2-26 SGN	26	1,4	2,4	2	110	50	SGN22...2	BRICA 215
	B2U3526R02		BR2-26 SGN								
	B2U3532L02		BL2-32 SGN	32				150	60		
	B2U3532R02		BR2-32 SGN								
	B2U3526N03		BN3-26 SGN	26	2,4	-	3	110	70	SGN22...3	
	B2U3532N03		BN3-32 SGN	32							

KERFOLG® INSERTS FOR GROOVING AND PARTING - SINGLE SIDE



			Description	Degree	Tech. Code		s mm	a max mm	l mm	r mm	Tool Holders			
GROOVING	G1		SGN22 2.00-0.20-G1	G135	B2T3502G101		2	2,5	21,35	0,2	BL2... BR2...			
				G240	B2T3502G102									
				G145	B2T3502G103									
			SGN22 3.00-0.30-G1	G135	B2T3503G101		3							BN3...
				G240	B2T3503G102									
				G145	B2T3503G103									

KERFOLG® RECOMMENDED CUTTING CONDITIONS

		P			M		K		N	S	H
Degree		<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
	G135	110 - 190	110 - 180	70 - 160			90 - 180	80 - 150			
	G145	80 - 150	70 - 120	60 - 100	70 - 120	50 - 100				25 - 50	
	G240	80 - 180	60 - 150	50 - 120	50 - 180	50 - 100	100 - 200	100 - 180			

Geometry for grooving, parting and turning		<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
	G1 - Tough cut. First choice on steels and cast irons.	○	●	●	○		●	●			
	G01 - Soft cut. First choice in case of varying materials.	●	●	○	●	○	○	○		○	
	S01 - Soft cut especially for stainless and Titanium alloy.	○	○	●	●	●				●	
	MD1 - Grooving and turning on steels and stainless.	●	●	●	●	●	●	○		○	
	MP1 - Radius grooves and copy turning.	○	●	●	●	○	●	●		○	

• RECOMMENDED FOR... ○ USABLE FOR...

Geometry		Width of cut mm	Grooving infeed mm/rev						
GROOVING	G1	2							
		3							
	G01	2							
		3							
	S01	2							
		3							

Geometry		Width of cut mm	Max depth of cut mm	Turning infeed mm/rev						
TURNING	MD1	2	0,8							
		3	1,6							
	MP1	2	0,8							
		3	1,6							