

# TUNGALLOY

Tungaloy Report No. 391S3-G

GrooveLine

Expansion 3

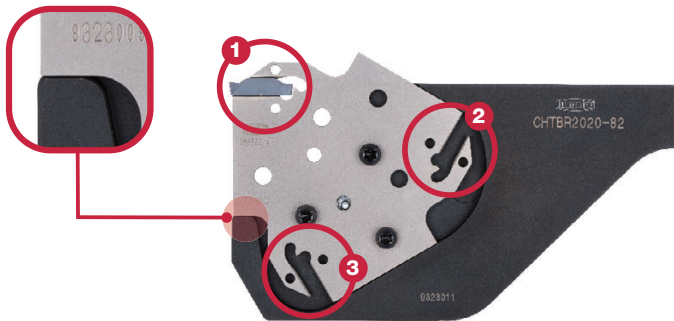
Now offers **TungFeed-Blade** holders for grooving and parting-off





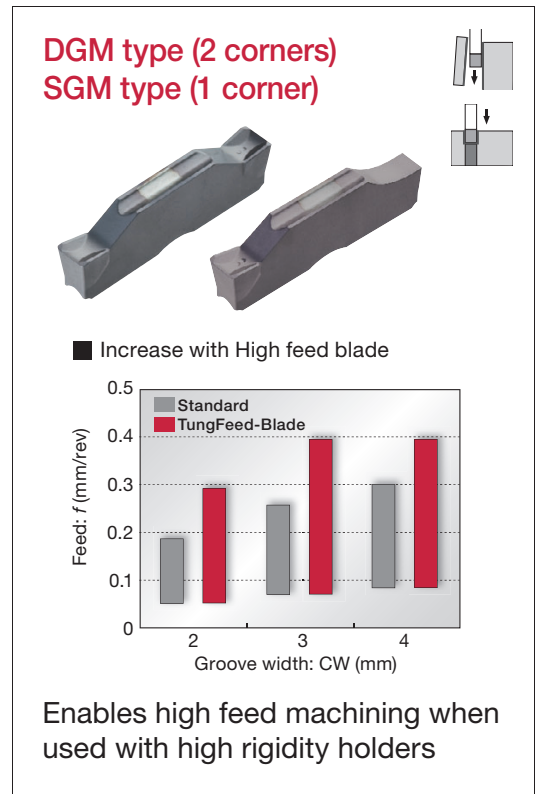
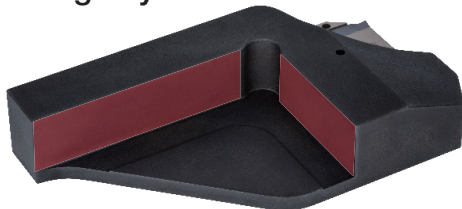
## Strong holder design ensures excellent stability and productivity during demanding applications

- 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.

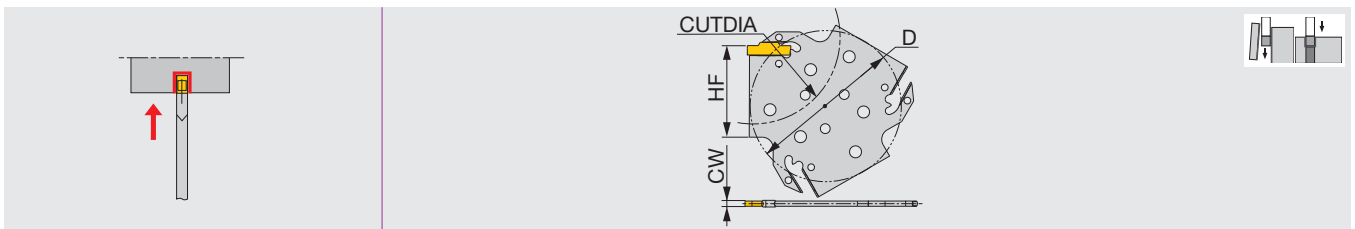


**New**

### CHGP

Parting-off and external grooving blade

### TUNGFÄBLADE



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

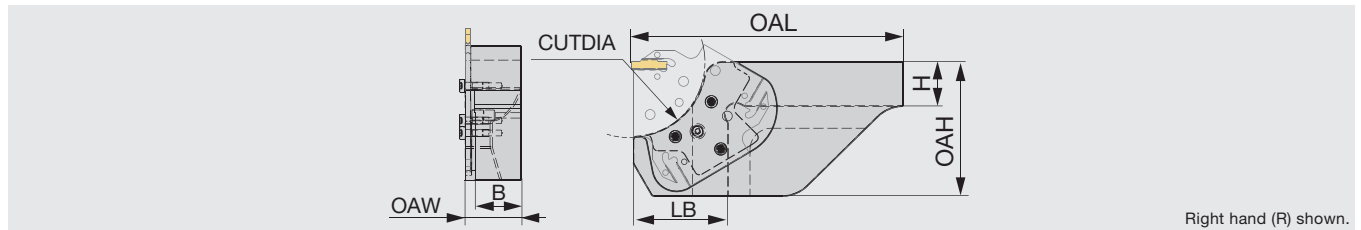
When depth is deeper than insert length - 1.5mm, 1 corner type is recommended.

#### SPARE PARTS



Designation	Wrench (Option)
CHGP...	CRW33

Tool block for CHGP blade



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

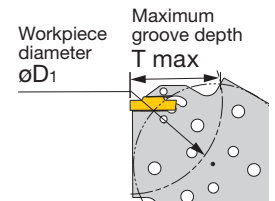
**SPARE PARTS**

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

**Maximum groove depth (T max) as function of workpiece diameter (øD<sub>1</sub>)**

Designation	øD <sub>1</sub>																	
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
<b>T max</b>	21	20	19	18	17	16	15	14	13	12	11	10	9	8	7	6	5	4

Designation	øD <sub>1</sub>											
CHTBR/L****-D82	83	84	85	86	87	89	90	92	94	96	98	101
<b>T max</b>	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
Cutting conditions			
Grooving width : CW (mm)		4	3
Cutting speed : Vc (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	Bolt parts	Elevator parts
	<p><b>Productivity 5 times!</b></p>	<p><b>Productivity 5 times!</b></p>
	<p>TungFeed-Blade doubled tool life, while also increasing feed rate 5 times when used with the high rigidity CHTBR holder.</p>	<p>The high rigidity holder increasing 5 times feed rate while also tool life by 3 times.</p>

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