



***Carmex***  
*Precision Tools Ltd.*  
*x-treme thread cutting™*

# **Groove Milling**

## **New Products**



## Carmex expands the MG Groove Milling line with new full carbide cutters.

### Precision Ground Profile

- 6 flutes minimize cycle time and increase productivity
- Spiral flutes reduce cutting forces and provide smooth cutting actions
- Large flute space for effective chip evacuation
- High stability to prevent vibration
- Internal coolant bore

### Applications

- Machining deep holes
- Allows high overhang
- Can fit on small or large machining centers and Swiss type lathe machines
- Same tool for internal and external grooving

### Carbide grade: MT8

Sub-Micron grade with advance PVD triple coating (ISO K10-K20).

Extremely high heat and wear resistance for high performance, and normal machining conditions.

General purpose for all materials.

## Groove Milling

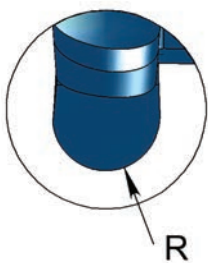


Ordering Code	W ±0.02	R	T (max.)	Groove Dia. (min.)	d	D	No. of Flutes	L
MGD 10195 F W15	1.5	0.1	4.5	Ø > 19.5	10	19.4	6	133
MGD 10195 F W20	2.0							
MGD 10195 F W30	3.0							
MGD 10195 F W35	3.5							
MGD 10195 F W40	4.0							
MGD 10195 F W50	5.0							

## Special Tools

We offer a large variety of special tools in compliance with customer requirements

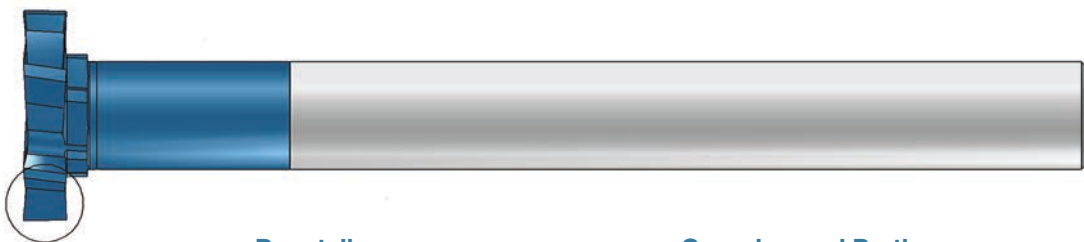
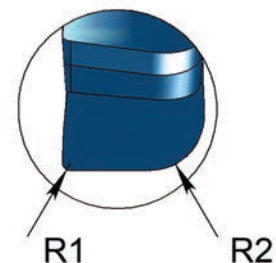
Round Groove



Chamfering



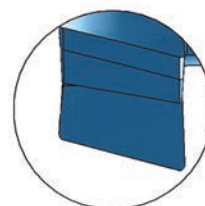
Grooving and Profiling



Dovetail



Grooving and Parting



## Cutting Data

ISO Standard	Material	Cutting Speed m/min	Feed mm/tooth
<b>P</b>	Low & Medium Carbon Steels <0.55%C	60-120	0.15-0.20
	High Carbon Steels ≥0.55%C	60-90	0.15-0.20
	Alloy Steels, Treated Steels	50-80	0.11-0.16
<b>M</b>	Stainless Steel-Free Cutting	70-100	0.10-0.15
	Stainless Steel-Austenitic	60-90	0.10-0.15
	Cast Steels	70-90	0.11-0.16
<b>K</b>	Cast Iron	40-80	0.15-0.20
<b>N</b>	Aluminium ≤12%Si, Copper	100-200	0.15-0.20
	Aluminium >12%Si	60-140	0.11-0.16
	Synthetics, Duroplastics, Thermoplastics	50-200	0.17-0.22
<b>S</b>	Nickel alloys, Titanium alloys.	20-40	0.05-0.10
<b>H</b>	Hardened Steel, 45-50HRc	60-70	0.08-0.13



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