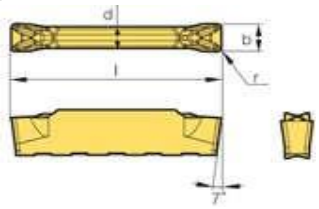
PARTING OFF AND GROOVING INSERTS NANOSPEED

KGNN 3 GF110 NANO

H.BILZ

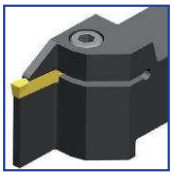
KGNN
System GF110



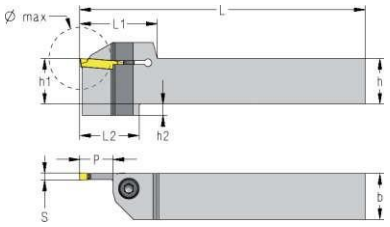


WG300 Ref.	GF110 NANOSPEED		L	R	S	α°
KGNN 3	54429	N	20	0,4	3,00 +0,10	0

Holders for parting off, grooving and turning for cutting width 3 mm



ADKT-KGNN



Easy ordering:

Please, mark the holder you need and fill in the information requested completely. When you have done this, please send it by Fax or E-Mail to us.

Ref.	Listprice EUR/pc.	ID-Nr.	Your Choice
KGNN 3 GF110 NANOSPEED		54429	
KGNN 3 GF110 NANOSPEED		54439	
KGNN 3 GF110 NANOSPEED		54449	
KGNN 3 GF110 NANOSPEED		54459	
KGNN 3 GF110 NANOSPEED		54469	
KGNN 3 GF110 NANOSPEED		54479	
KGNN 3 GF110 NANOSPEED		54489	

WG380 Ref.	ID-Nr.		Ø max	h	h1	h2	b	P	S	L	L1	L2
ADKT-KG-L1212-3-R12-K-S	09291	L	24	12	12	0	12	12	3,0	125	34,0	0
ADKT-KG-L1616-3-T20	09292	L	40	16	16	0	16	20	3,0	125	37,0	0
ADKT-KG-L2020-3-T20	09293	L	40	20	20	0	20	20	3,0	125	37,0	0
ADKT-KG-L2525-3-T22	09294	L	44	25	25	0	25	22	3,0	150	40,0	0
ADKT-KG-R1212-3-R12-K-S	09295	R	24	12	12	0	12	12	3,0	125	40,0	0
ADKT-KG-R1616-3-T20	09296	R	40	16	16	0	16	20	3,0	125	34,0	0
ADKT-KG-R2020-3-T20	09297	R	40	20	20	0	20	20	3,0	125	37,0	0
ADKT-KG-R2525-3-T22	09298	R	44	25	25	0	25	22	3,0	150	40,0	0



THE parting off geometry

- Strong clamping + Higher machining reliability
- Self-centering + Higher accuracy
- Anti-chattering design + Fine surface finish





Steel	Vc : 60-220 mm/min
Stainless Steel	Vc : 70-125 mm/min
Cast iron	Vc : 55-160 mm/min

PARTING OFF AND GROOVING INSERTS NANOSPEED

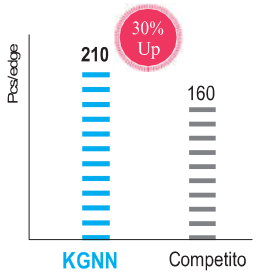
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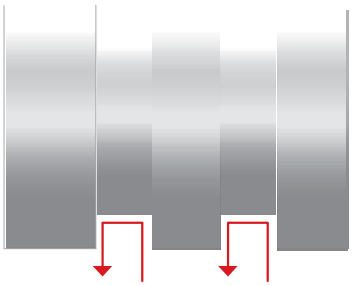
Cutting Performance

Multi-function machining

Turning + Grooving repetition

- **Workpiece** C45
- **Cutting condition** vc = 170(m/min)
  fn = 0.15(mm/rev)
  ap = 2mm
  W = 3mm
  wet
- **Designation** **KGNN 3 GF110 NANOSPEED**



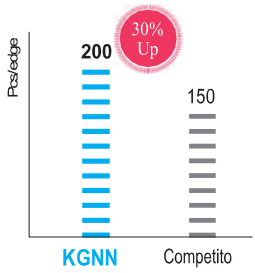


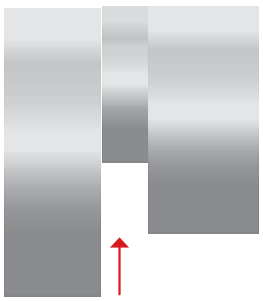
Optimized geometry for turning + grooving → High efficiency.

Grooving

Shoulder Grooving

- **Workpiece** X5CrNI18-9
- **Cutting condition** vc = 120(m/min)
  fn = 0.12(mm/rev)
  ap = 5mm
  W = 4mm
  wet
- **Designation** **KGNN 3 GF110 NANOSPEED**



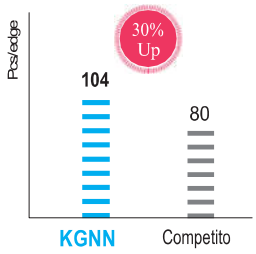


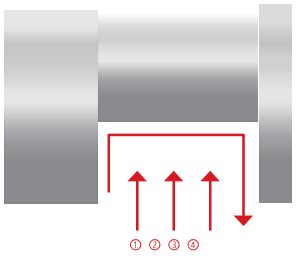
Tough geometry for interrupted and deep grooving.

Shaft machining

Grooving(Roughing)&Turning(Finishing)

- **Workpiece** 42CrM04
- **Cutting condition** vc = 150(m/min)
  fn = 0.15(mm/rev)
  ap = 5mm
  W = 3mm x 3
  wet
- **Designation** **KGNN 3 GF110 NANOSPEED**



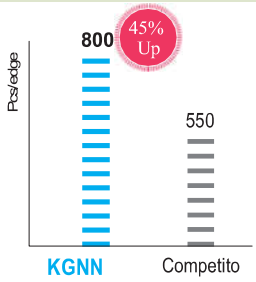


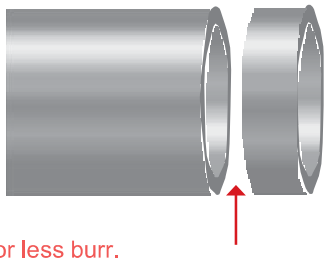
Excellent chip control for higher efficiency.

Parting off

Pipe Parting-off

- **Workpiece** X5CrNi18-9
- **Cutting condition** vc = 140(m/min)
  fn = 0.15(mm/rev)
  ap = 2mm
  W = 3mm
  wet
- **Designation** **KGNN 3 GF110 NANOSPEED**





Exclusive parting-off chip breaker for longer tool life. / Sharp geometry for less burr.