



GrooveLine

Expansion 3

TUNGCUT

Tungaloy Report No. 391S3-US

COMPLETE METALWORKING SOLUTIONS

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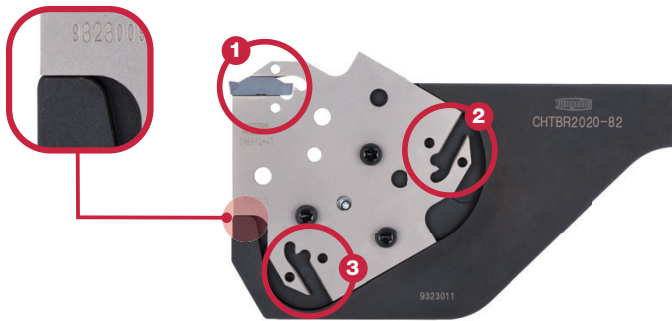
Now offers **TungFeed-Blade** holders for grooving and parting-off





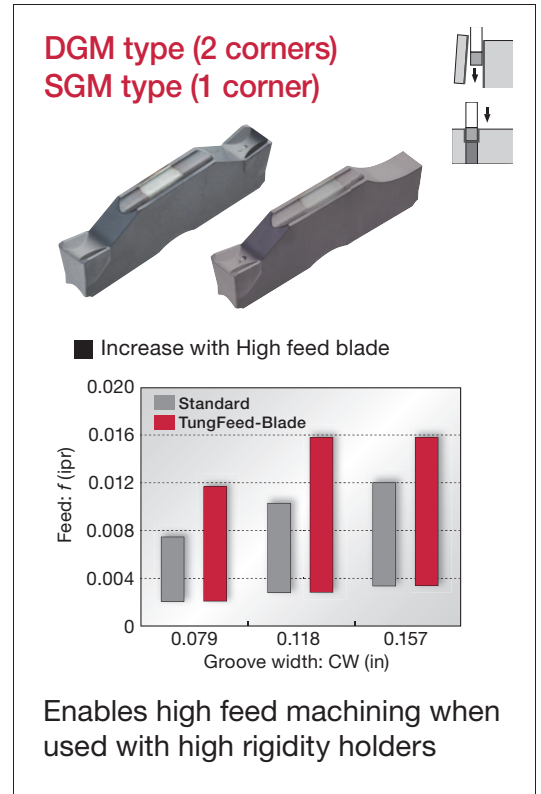
Strong holder design ensures excellent stability and productivity during demanding applications

- 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.

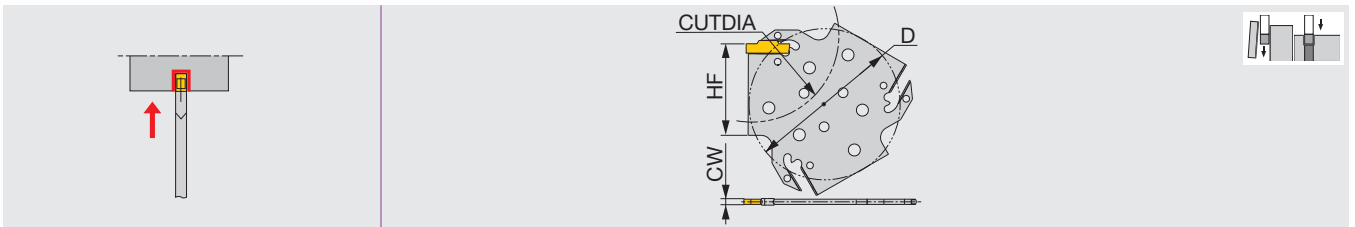


New

CHGP

Parting-off and external grooving blade

TUNGFÄBLADE



Metric	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

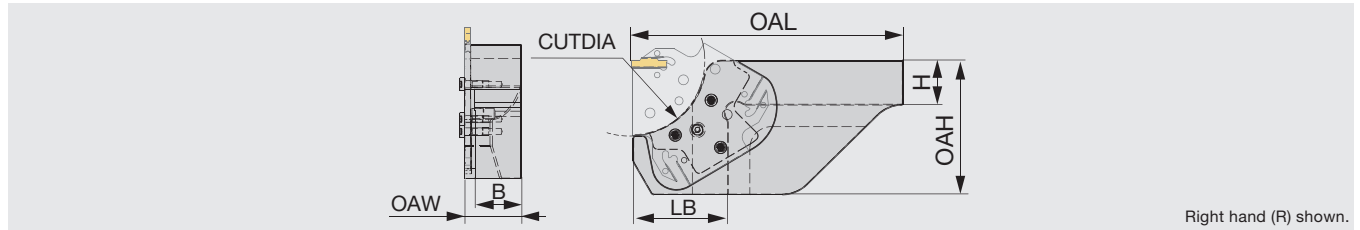
When depth is deeper than insert length - 1.5mm, 1 corner type is recommended.

SPARE PARTS



Designation	Wrench (Option)
CHGP...	CRW33

Tool block for CHGP blade



Inch	CUTDIA	H	B	OAL	OAH	OAW	LB
CHTBR/L12-52	2.047	0.750	0.770	4.000	1.970	1.000	1.457
CHTBR/L16-52	2.047	1.000	1.020	5.000	1.970	1.250	1.457
CHTBR/L12-82	3.228	0.750	0.770	5.500	2.950	1.000	2.087
CHTBR/L16-82	3.228	1.000	1.020	6.000	2.950	1.250	2.087
Metric	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

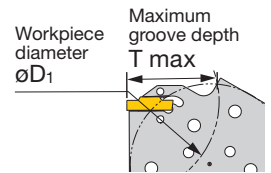
SPARE PARTS

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



Maximum groove depth (T max) as function of workpiece diameter (øD1)

Designation	øD1 (in)																	
CHTBR/L****-D52	2.087	2.126	2.165	2.205	2.283	2.362	2.441	2.559	2.677	2.835	3.071	3.307	3.622	4.016	4.528	5.236	6.260	7.795
CHTBR/L****-D82	4.094	4.252	4.409	4.567	4.764	5.000	5.276	5.591	5.945	6.378	6.929	7.559	8.346	9.331	10.630	12.323	14.764	18.425
T max	0.827	0.787	0.748	0.709	0.669	0.630	0.591	0.551	0.512	0.472	0.433	0.394	0.354	0.315	0.276	0.236	0.197	0.157

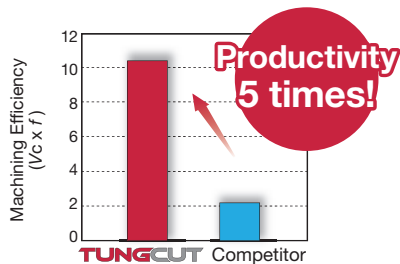
Designation	øD1 (in)											
CHTBR/L****-D82	3.268	3.307	3.346	3.386	3.425	3.504	3.543	3.622	3.701	3.780	3.858	3.976
T max	1.339	1.299	1.220	1.181	1.142	1.102	1.063	1.024	0.984	0.945	0.906	0.866



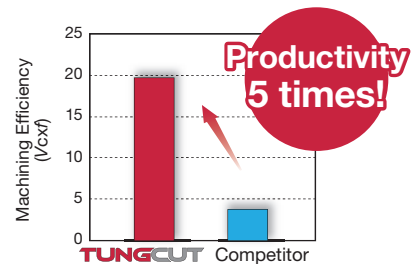
PRACTICAL EXAMPLES

Workpiece type	Bolt parts	Elevator parts	
Toolholder	CHGP82-4T / CHTBR2525-82	CHGP52-3T / CHTBR2020-52	
Insert	SGS4-030	SGM3-020	
Grade	AH7025	AH7025	
	S45C / C45	STKM13A	
Workpiece material	 P	 P	
Cutting conditions	Grooving width : CW (in)	0.157	0.118
	Cutting speed : Vc (sfm)	230	623
	Feed : f (ipr)	0.006	0.004
	Cutting edge depth : CDX (in)	0.984	0.197
	Machining	Parting off	Parting off
	Coolant	Wet	Wet

Results



TungFeed-Blade doubled tool life, while also increasing feed rate 5 times when used with the high rigidity CHTBR holder.



The high rigidity holder increased feed rate by 5 times and tool life by 3 times.

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