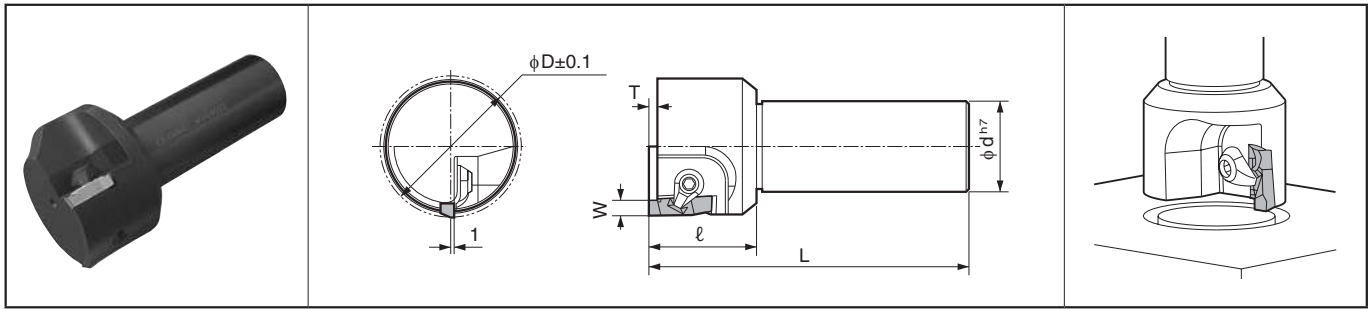


Ring Grooving End Mill MVG



MVG



Toolholder Dimensions

Description	Std.	Dimension (mm)					Edge Width	Spare Parts	
		ϕD	ϕd	L	ℓ	T		W	Clamp Set
MVG									
3032	●	30						CPS-6V	LW-3
3532	●	35							
4032	●	40							
4532	●	45	32	120	40	5.2	4.00		
5032	●	50					4.90		
5532	●	55							
6032	●	60							

* Dimension T shows available grooving depth.

Applicable Inserts

Insert	Description	Dimension (mm)						Insert Grades									
		W	B	r_{ϵ}	A	L	H	Cermet			MEGA COAT	PVD Coated Carbide	Carbide				
								TN90	TC40N	TC60M	PR1225	PR930	KW10				
Handed Insert shows Right-hand																	
	GVFR 400-020B	4.00						●	●	●	●	●	●	●			
	430-020B	4.30						●	●	●	●	●	●	●			
	460-020B	4.60	5.3	0.2	5.8	20	5.0	●	●	●	●	●	●	●			
	490-020B	4.90						●	●	●	●	●	●	●			

• GVFR430B-020B is applicable for sealing groove of G-series
For other ring grooving, GVFR400B~490B-020B are applicable.
• Only Right-hand insert is applicable.

Recommended Cutting Conditions

Workpiece Material	fz (mm/t)	Recommended Insert Grades (Cutting Speed Vc: m/min)					
		Cermet			MEGA COAT	PVD Coated Carbide	Carbide
		TN90	TC40N	TC60M	PR1225	PR930	KW10
Carbon Steel	0.05~0.15		★ 120~200	☆ 100~180	★ 80~170	☆ 80~150	-
Alloy Steel	0.05~0.15		★ 120~200	☆ 100~180	★ 80~170	☆ 80~150	-
Mold Steel	0.03~0.12		★ 100~180	☆ 80~150	★ 60~150	☆ 60~130	-
Stainless Steel	0.03~0.12		☆ 100~180	☆ 80~150	★ 60~150	☆ 60~130	-
Cast Iron	0.05~0.2		-	-	-	-	★ 80~150
Non-ferrous Metals	0.05~0.2		-	-	-	-	★ 100~300

★ : 1st Recommendation ☆ : 2nd Recommendation

● : Std. Item

M

Milling

Inserts

Lead Angle 45°/20°

Lead Angle 15°

Lead Angle 0°

High Feed

Multi-Function

Slot Mill

Ball-nose Radius

Others