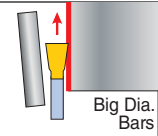
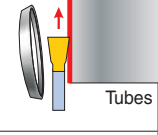
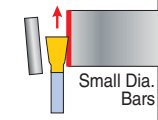
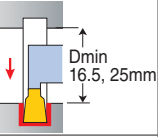
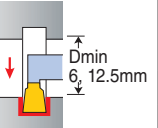


PARTING & GROOVING Selection Guide

Tool Selection by Application

			P Steel (HB 200-220)	K Cast iron (HB 220-250)	M Stainless steel (HB 180-200)	S High temp. alloys (HB 300-350)	N Non-ferrous	H Hardened steel
Parting	Deep Parting Deep Grooving		  SFC TT9080 TDC TT9080 (Vc 150-100, fn 0.1-0.4)	  TDC TT9080 TDCT TT6080 (Vc 180-120, fn 0.1-0.4)	  SFC TT9080 TDC TT9080 (Vc 120-80, fn 0.1-0.15)	  SFJ TT9080 TDJ TT9080 (Vc 60-30, fn 0.08-0.12)	 TDJ K10 (Vc 330-150, fn 0.1-0.5)	 TSG-H TB2015 (Vc 60-120, fn 0.02-0.16)
	Tube Parting		  SFC TT9080 TDC TT9080 (Vc 150-100, fn 0.1-0.4)	  TDC TT9080 TDCT TT6080 (Vc 180-120, fn 0.1-0.4)	  SFJ TT9080 TDJ TT9080 (Vc 120-80, fn 0.1-0.15)	  SFJ TT9080 TDJ TT9080 (Vc 60-30, fn 0.08-0.12)	 TDJ K10 (Vc 330-150, fn 0.1-0.5)	 TSG-H TB2015 (Vc 60-120, fn 0.02-0.16)
	Shallow Parting Shallow Grooving Precision Grooving		  TQC TT9080 TQS TT4430 (Vc 150-100, fn 0.06-0.15)	 TQC TT9080 (Vc 180-120, fn 0.1-0.4)	  TQJ TT9080 TQJ TT4430 (Vc 120-80, fn 0.05-0.13)	  TQJ TT9080 TQJ TT4430 (Vc 60-30, fn 0.08-0.12)	 TQS TT4430 (Vc 330-150, fn 0.1-0.5)	 TSG-H TB2015 (Vc 60-120, fn 0.02-0.16)
Grooving			  TDC TT9080 TDXU TT9080 (Vc 150-100, fn 0.1-0.4)	  TDCT TT6080 TDXT TT6080 (Vc 180-120, fn 0.1-0.4)	  TDJ TT9080 TDXU TT9080 (Vc 120-80, fn 0.1-0.15)	  TDCT TT9080 TDXU TT3010 (Vc 60-30, fn 0.08-0.12)	  TDJ K10 TDXU K10 (Vc 330-150, fn 0.1-0.5)	 TSG-H TB2015 (Vc 60-120, fn 0.02-0.16)
Groove Turning			  TDXU TT9080 TDCT TT9080 (Vc 150-100, fn 0.1-0.4)	  TDCT TT6080 TDXT TT6080 (Vc 180-120, fn 0.1-0.4)	  TDCT TT9080 TDXU TT9080 (Vc 120-80, fn 0.1-0.15)	  TDCT TT9080 TDXU TT3010 (Vc 60-30, fn 0.1-0.15)	  TDCT K10 TDXU K10 (Vc 330-150, fn 0.1-0.5)	  TSG-H TB2015 TSG-HF TB2015 (Vc 60-120, fn 0.08-1.20)
Face Grooving			  TDCT TT9080 TDFX TT9080 (Vc 150-100, fn 0.1-0.4)	  TDCT TT6080 TDXT TT6080 (Vc 180-120, fn 0.1-0.3)	  TDCT TT9080 TDFX TT9080 (Vc 120-80, fn 0.1-0.15)	  TDCT TT9080 TDFX TT9080 (Vc 60-30, fn 0.1-0.15)	  TDCT K10 TDXU K10 (Vc 330-150, fn 0.1-0.4)	 TSG-H TB2015 (Vc 50-100, fn 0.02-0.14)
Profiling			  TDT-RU TT9080 TDT-RS TT9080 (Vc 150-100, fn 0.1-0.4)	 TDT-RU TT6080 (Vc 180-120, fn 0.1-0.4)	  TDT-RS TT9080 TDT-RU TT9080 (Vc 120-80, fn 0.1-0.15)	  TDT-RS TT3010 TDT-RU TT3010 (Vc 60-30, fn 0.1-0.15)	 TDA K10 (Vc 330-150, fn 0.1-0.4)	 TSG-H TB2015 (Vc 60-120, fn 0.03-0.30)
Internal Grooving			  TQIS TT9080 TDXU TT9080 (Vc 150-100, fn 0.1-0.4)	  TQIS TT9080 TDCT TT6080 (Vc 180-120, fn 0.1-0.3)	  TQIS TT9080 TDXU TT9080 (Vc 120-80, fn 0.1-0.15)	  TDCT TT9080 TDXU TT3010 (Vc 60-30, fn 0.1-0.15)	  TDCT K10 TDXU K10 (Vc 330-150, fn 0.1-0.4)	 TSG-H TB2015 (Vc 60-120, fn 0.02-0.16)
			  TMIR/L TT4430 TDIM TT9080 (Vc 50-100, fn 0.01-0.1)	  TDIM TT9080 TDIP TT9080 (Vc 70-110, fn 0.02-0.1)	  TMIR/L TT4430 TDIM TT9080 (Vc 40-70, fn 0.01-0.1)	  TMIR/L TT4430 TDIP TT9080 (Vc 20-40, fn 0.01-0.1)	  TMIR/L TT4430 TDIP TT9080 (Vc 100-300, fn 0.01-0.1)	

(Vc cutting speed: m/min, fn feed rate: mm/rev)