

GROOVE-TURN

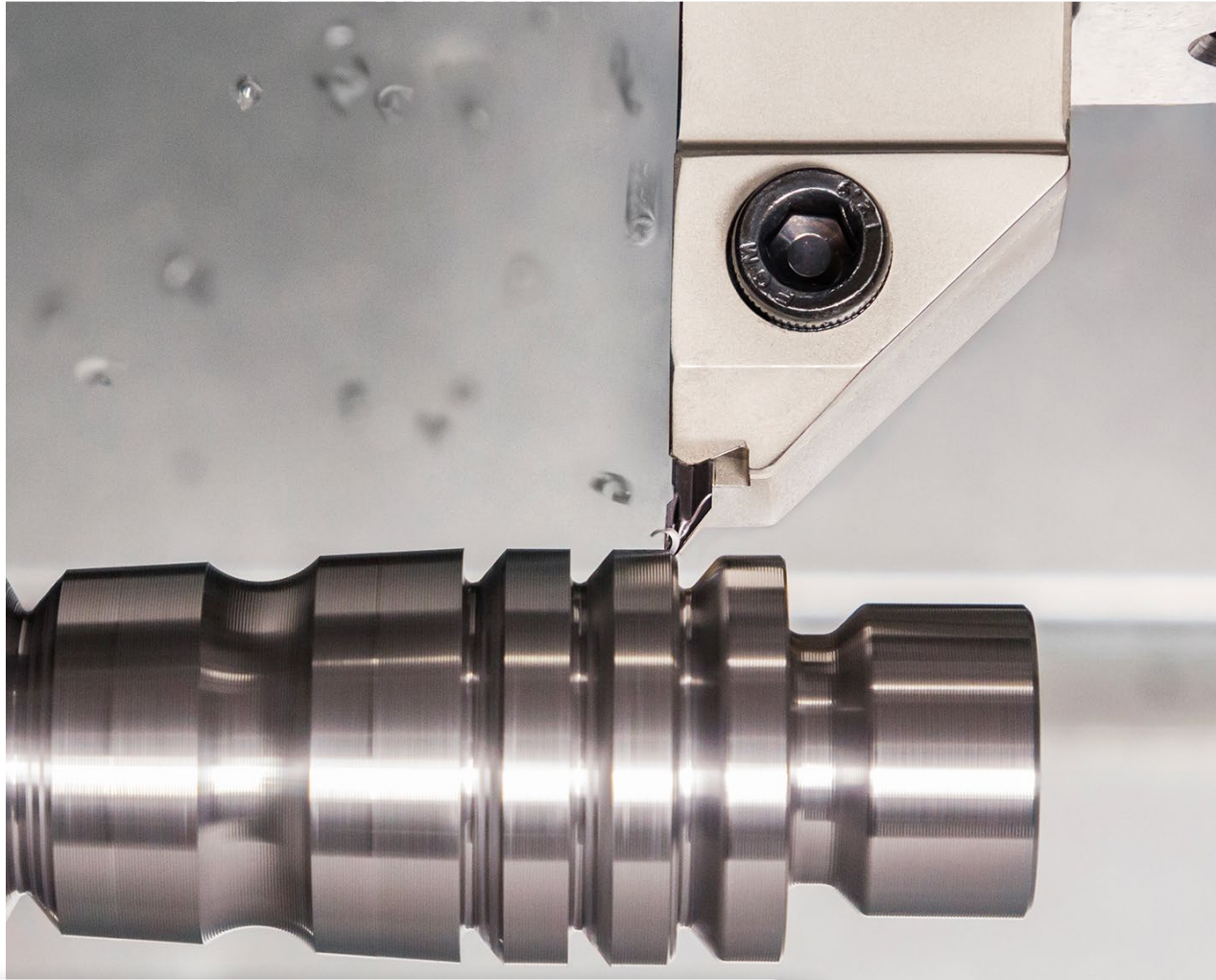
38-2024

JUNE 2024

METRIC

NPA

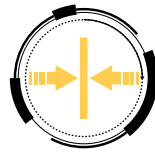
New Product Announcement



Multi-Functional Inserts



Excellent Chip Evacuation



Narrow Machining Areas



CUTVGRIP

New Multi-Functional V-Shape Inserts for External Bi-Directional Turning Operations



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New Product Announcement

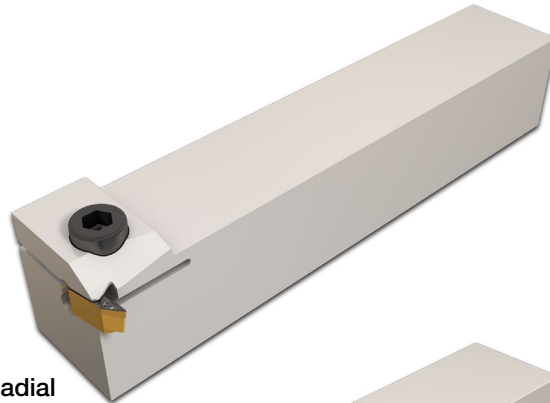
CUTVGRIP

Highlights

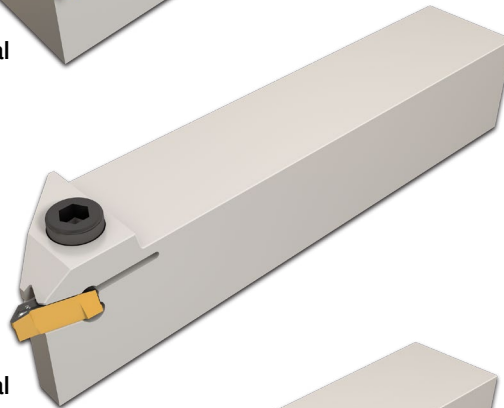
New Line of Multi-Functional V-Shape Inserts Designed for External Turning, Profiling and Chamfering Applications

Overview

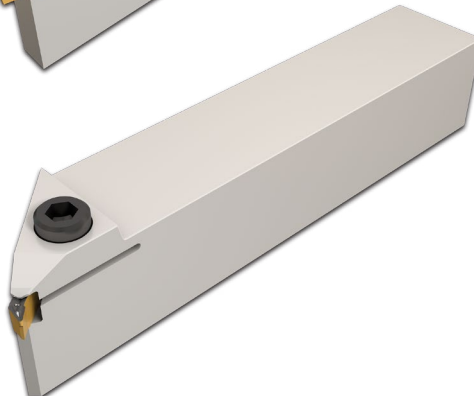
ISCAR expands its Groove-Turn products by adding unique multi-functional V-shape inserts designed for external machining. The new inserts can be used for both right and left-hand machining and can be mounted on standard M-Type **CUT-GRIP** holders.



Shallow and Radial



Shallow and Radial



45° Undercutting

METRIC



Multi-Functional Inserts



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NPA

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CUTVGRIP

Main Features

- Machining external front / back turning, chamfering, and profiling applications.
- Can be mounted on modified full insert support **CUT-GRIP** holders or standard M-Type holders.
- A unique chipformer designed for excellent chip control on diverse materials.
- Able to enter narrow machining areas where V-type ISO inserts cannot be used.
- Designations – GIVR/L...
- All inserts are available in grade IC808.

TEST REPORTS

Application: Turning

Part Material: SAE 4340

Cooling Pressure: 10Bar

Manufacturer	Competitor	ISCAR
Tool Holder		GHMR 25
Insert		GIVL 302-F1M-12P IC808
Cutting Speed (m/min)	100	100
Feed (mm/rev)	0.15	0.15
Depth of cut (mm)	1	1
Tool life (min)	20	32
Chip control	Tangled chips	Excellent



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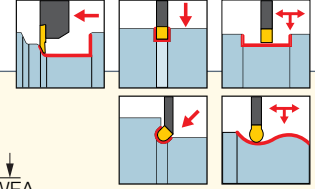
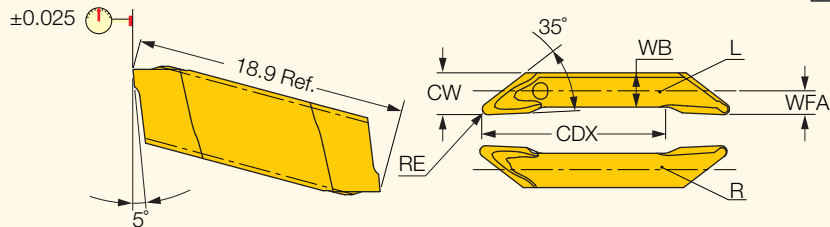
New Product Announcement

CUTVGRIP

GIVR/L

Double-Edged Groove-Turn Inserts for Back Turning, Undercutting and Profiling

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5317&mapp=TG&GFSTYP=M&srch=1>



Dimensions

Designation	RE	RETOL ⁽¹⁾	CW	CDX	WB	WFA	IC808
GIVR 302-F1M-12P	0.20	0.030	2.80	12.80	2.40	1.53	•
GIVL 302-F1M-12P	0.20	0.030	2.80	12.80	2.40	1.53	•
GIVR 304-F1M-12P	0.40	0.030	2.93	12.80	2.40	1.66	•
GIVL 304-F1M-12P	0.40	0.030	2.93	12.80	2.40	1.66	•

⁽¹⁾ Corner radius tolerance (+/-)