

GROOVING

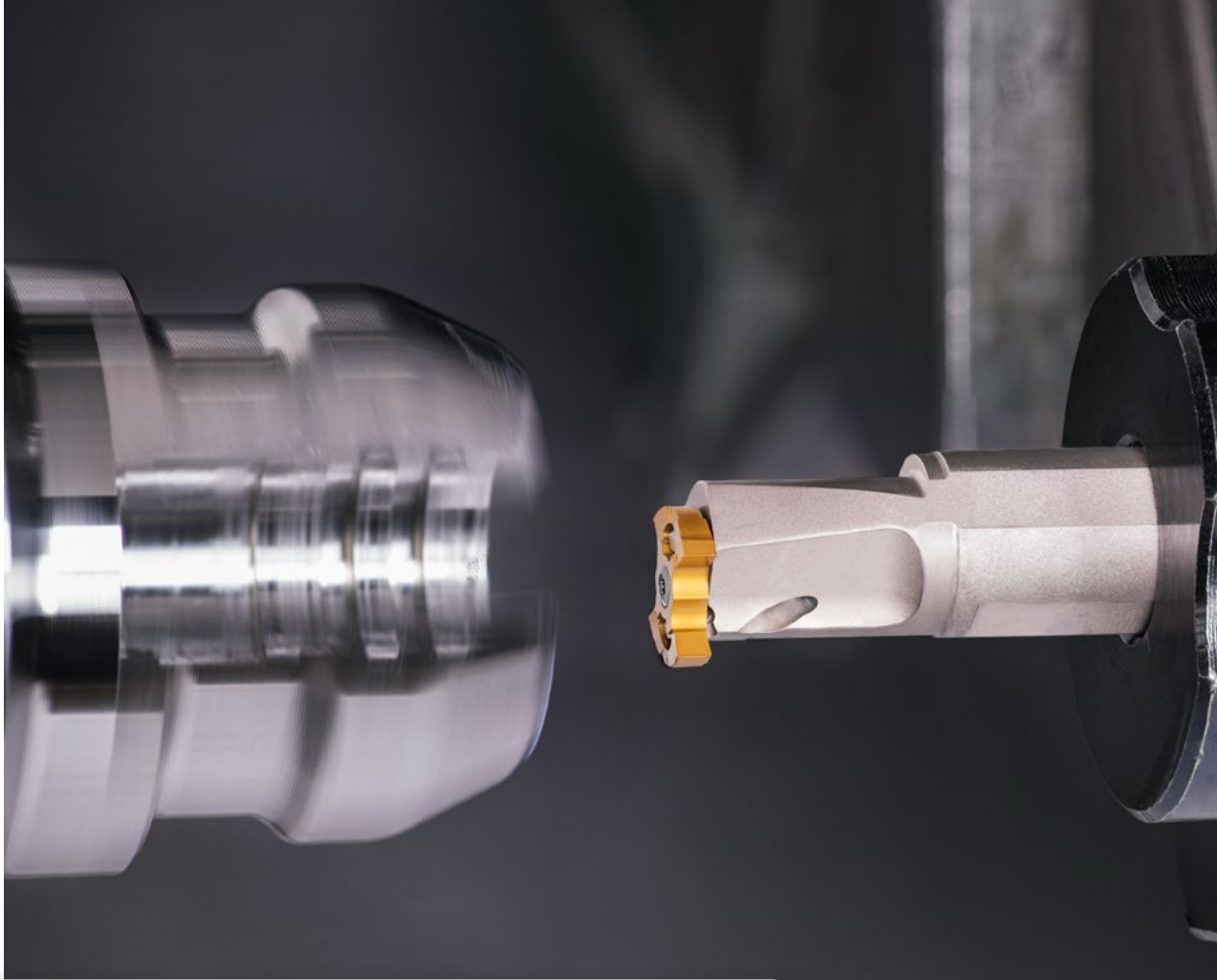
17-2024

MAY 2024

METRIC

NPA

New Product Announcement



Double Sided
Insert



Cost Effective



High Productivity



QUICK*I***GROOVE**

New Line of Inserts with 4 Cutting Edges that Mount on Unique Toolholders for Internal Grooving and Turning Operations

Double Sided
Insert

Cost Effective

High Productivity
Inserts

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QUICK I GROOVE

Highlights

New Inserts with Four Cutting Edges for Groove-Turn Operations

ISCAR is enhancing its solutions for internal grooving and turning applications with the introduction of new precision-ground inserts. These inserts feature four cutting edges and are mounted on dedicated holders that feature an internal cooling system. The holders are available for shank diameters of 16 and 20mm.

Main Features

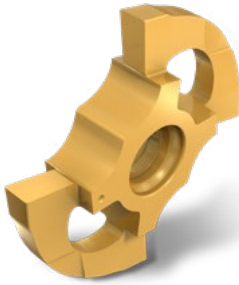
- Precision ground 4 cutting edged inserts in a width range of 1, 1.5, 2, 2.5, 3mm.
- Machining internal turning and grooving operations with a minimum bore diameter of 16.5mm for a 16mm holder shank and 24mm for a 20mm holder's shank.
- Internal coolant supply directed to the cutting zone provides better tool life and improved chip control.
- 4 effective cutting edges provide excellent cost effectiveness.
- Insert designation – GQIN...
- Holder designation – GQHINR/L...
- All inserts are available in grade IC808G

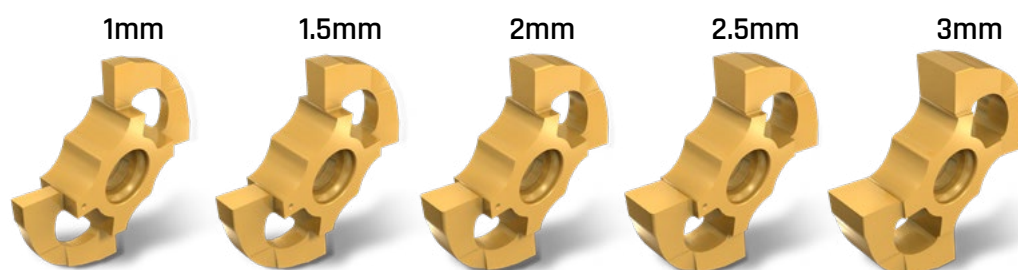

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Application: Grooving Part Material: SAE 4340 Bore Diameter: 18mm Cooling Pressure: 10Bar		Competitor
Toolholder	GQHINR 16C-16.5-20	
Insert	GQIN 3.00-0.20 IC808G	
Cutting Speed (m/min)	120	120
Feed (mm/rev)	0.12	0.12
Depth of Groove (mm)	2.2	2.2
Number of Grooves	170	110
Wear Type	Flank Wear	Edge Breakage



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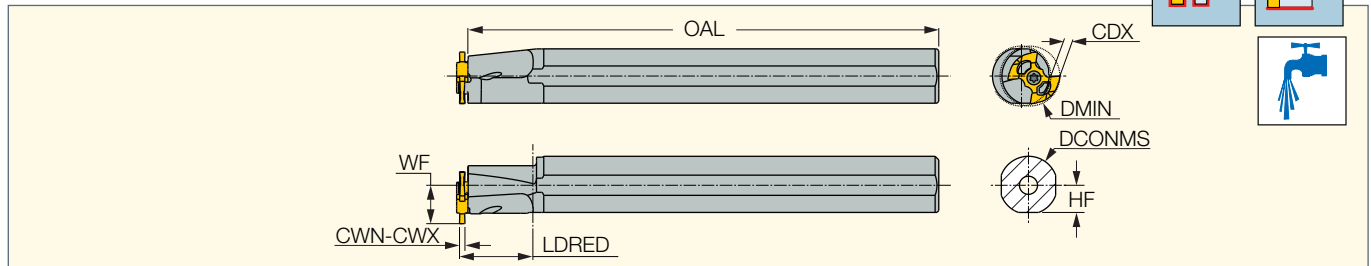
MAY 2024

METRIC

GQHINR/L

Internal Grooving and Turning Bars on Which Inserts with 4 Cutting Edges Are Mounted.

<https://www.iscar.com/eCatalog/Family.aspx?fnun=5295&mapp=TG&app=0&GFSTYP=M>



Designation	CWN ⁽¹⁾	CWX ⁽²⁾	DCONMS	DMIN	CDX ⁽³⁾	OAL	LDRED	WF	HF
GQHINR/L 16C-16.5-20	1.00	3.00	16.00	16.50	2.50	130.00	20.0	10.60	7.5
GQHINR/L 16C-16.5-40	1.00	3.00	16.00	16.50	2.50	150.00	40.0	10.60	7.5
GQHINR/L 20C-24	1.00	3.00	20.00	24.00	2.50	160.00	60.0	13.00	9.0

⁽¹⁾ Minimum cutting width

⁽²⁾ Maximum cutting width

⁽³⁾ Cutting depth maximum

Spare Parts

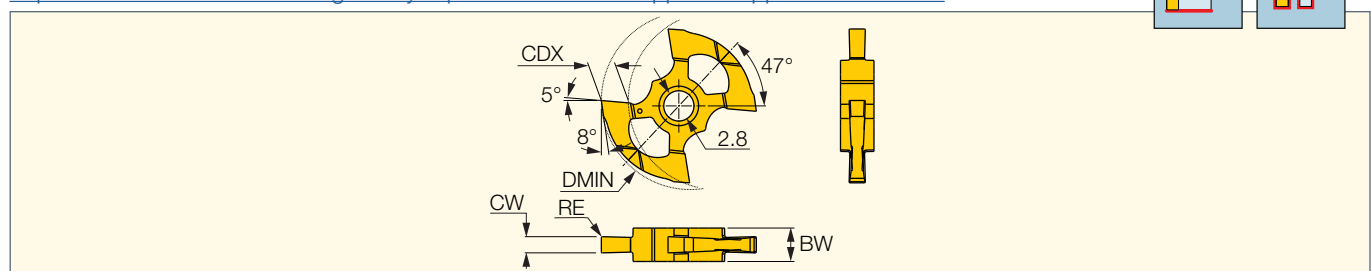


Designation	Screw	Key	Fitting
GQHINR/L 16C-16.5-20	SR 14-560	T-8/5	PL 16
GQHINR/L 16C-16.5-40	SR 14-560	T-8/5	PL 16
GQHINR/L 20C-24	SR 14-560	T-8/5	PL 20

GQIN

4 Cutting Edges Precision Grounded Inserts for Internal Grooving and Recessing Operations

<https://www.iscar.com/eCatalog/Family.aspx?fnun=5297&mapp=TG&app=0&GFSTYP=M>



Designation	Dimensions					IC809G
	CW	RE	DMIN	CDX	BW	
GQIN 1.00-0.05	1.00	0.05	16.50	2.50	3.10	•
GQIN 1.50-0.10	1.50	0.10	16.50	2.50	3.10	•
GQIN 2.00-0.20	2.00	0.20	16.50	2.50	3.10	•
GQIN 2.50-0.20	2.50	0.20	16.50	2.50	3.10	•
GQIN 3.00-0.20	3.00	0.20	16.50	2.50	3.10	•

• Cutting edge with high positive rake, suitable for parting tubes, thin walled parts and for small diameters • Suitable for machining soft materials and bearing steel at low to medium feeds