

GROOVE-TURN

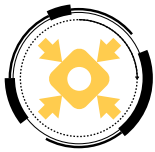
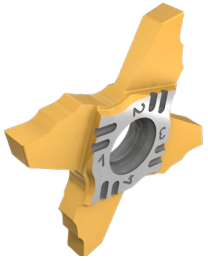
24-2024

MAY 2024

METRIC

NPA

New Product Announcement



Rigid Clamping



Cost Effective Inserts



High-Pressure Coolant



GROOVE4CUT

Unique Economical QUAD Insert with 4 Cutting Edges



Rigid Clamping



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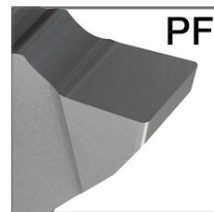
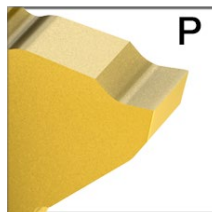
New Product Announcement

GROOVE4CUT

Highlights

Unique Economical QUAD Insert with 4 Cutting Edges for Grooving Parting & Light Turning Applications

- Unique economical **QUAD** Insert with 4 cutting edges for grooving, parting & light turning applications intended for a max depth cut up to 7mm (.275").
- New tool pocket with screw clamping provides accurate insert positioning, assures excellent cutting-edge repeatability.
- Rigid, reliable & secure clamping mechanism provides extra stability, improves surface finish & part straightness.
- Versatile jet cut tool which has 4 coolant inlets including an MC connection highly effective coolant from top, bottom and side. Reduces heat generated during machining and improves chip control.
- The insert can be tightened from both sides of the tool.
- The same insert can be clamped on right or left hand tools.
- Inserts width variety from 1mm (.039") up to 3mm (.118") fit the same holder.
- P & PF chip formers, sharp & positive cutting rake, most suitable for small parts sizes.
- The **GROOVE-4-CUT** is a door opener to gain more market share in the miniature parts industry.



[Click for Short Video](#)

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GROOVE-TURN

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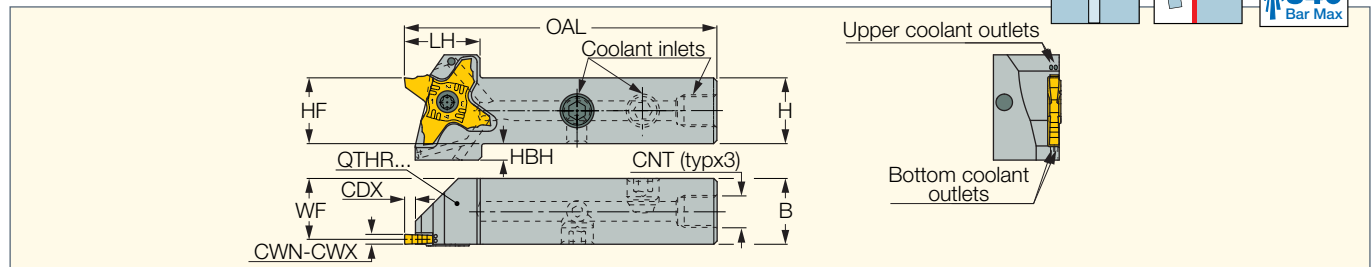
METRIC

GROOVE4CUT

QTHR/L-30-JHP-MC

Grooving and Parting Tools Carrying GROOVE 4 CUT Inserts with Inlets for High-Pressure Coolant

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5246&map=TG&GFSTYP=M&srch=1>



Designation	H	HF	B	CWN ⁽¹⁾	CWX ⁽²⁾	CDX	WF	OAL	LH	HBH	CNT	Insert
QTHR/L 16-30-JHP-MC	16.0	16.0	16.0	1.00	3.00	7.30	14.50	93.50	23.0	9.0	UNF 5/16-24	QGI 30...
QTHR/L 20-30-JHP-MC	20.0	20.0	20.0	1.00	3.00	7.30	18.50	93.50	23.0	5.0	G1/8	QGI 30...
QTHR/L 25-30-JHP-MC	25.0	25.0	25.0	1.00	3.00	7.30	23.50	108.00	23.0	-	G1/8	QGI 30...

⁽¹⁾ Minimum cutting width

⁽²⁾ Maximum cutting width

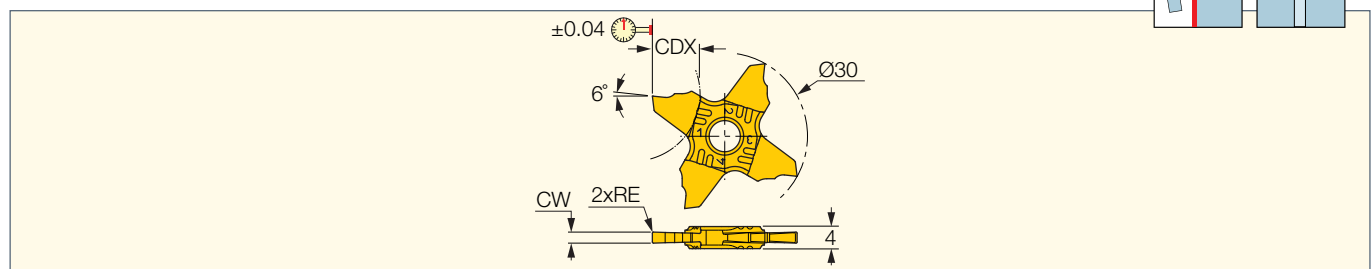
Spare Parts

Designation	Screw	Key	Plug	Key 1	Screw 1	Key 2	Plug 1
QTHR/L 16-30-JHP-MC	SR 16-212-01397	T-2010/5	SR M6X4 DIN913	HW 5/32"	SR M4X3 DIN913	HW 3.0	SR 5/16UNF TL360
QTHR/L 20-30-JHP-MC	SR 16-212-01397	T-2010/5	SR M6X6 DIN913 TL360	HW 5.0	SR M4X4 DIN913	HW 3.0	PLG G1/8 TL360
QTHR/L 25-30-JHP-MC	SR 16-212-01397	T-2010/5	SR M6X6 DIN913 TL360	HW 5.0	SR M4X4 DIN913	HW 3.0	PLG G1/8 TL360

QGI 30N-PF

4 Cutting Edged Inserts with a Positive Flat Rake for Parting and Precision Grooving

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5251&map=TG&GFSTYP=M&srch=1>



Designation	Dimensions					IC1008	Recommended Machining Data
	CW	RE	CWTOL ⁽¹⁾	RETOL ⁽²⁾	CDX		f groove (mm/rev)
QGI 30N100PF006	1.00	0.06	0.020	0.020	4.00	●	0.02-0.05
QGI 30N120PF000	1.20	0.00	0.020	0.020	5.00	●	0.02-0.07
QGI 30N150PF010	1.50	0.10	0.020	0.020	7.20	●	0.03-0.08
QGI 30N200PF020	2.00	0.20	0.020	0.030	7.20	●	0.03-0.10
QGI 30N247PF020	2.47	0.20	0.020	0.030	7.20	●	0.03-0.12
QGI 30N250PF020	2.50	0.20	0.020	0.030	7.20	●	0.03-0.12
QGI 30N270PF010	2.70	0.10	0.020	0.020	7.20	●	0.03-0.12
QGI 30N300PF020	3.00	0.20	0.020	0.030	7.20	●	0.03-0.12

⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)

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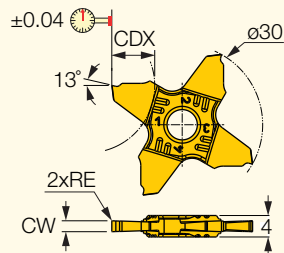
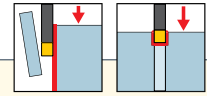
New Product Announcement

GROOVE4CUT

QGI 30N-P

4 Cutting Edged Inserts with a High Positive Flat Rake for Parting and Precision Grooving

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5252&map=TG&GFSTYP=M&srch=1>



Designation	Dimensions					IC1008	Recommended Machining Data
	CW	RE	CWTOL ⁽¹⁾	RETOL ⁽²⁾	CDX		f groove (mm/rev)
QGI 30N100P005	1.00	0.05	0.020	0.020	4.00	●	0.02-0.04
QGI 30N120P005	1.20	0.05	0.020	0.020	5.00	●	0.02-0.06
QGI 30N150P005	1.50	0.05	0.020	0.020	7.20	●	0.02-0.07
QGI 30N200P005	2.00	0.05	0.020	0.020	7.20	●	0.02-0.08
QGI 30N247P005	2.47	0.05	0.020	0.020	7.20	●	0.02-0.10
QGI 30N250P005	2.50	0.05	0.020	0.020	7.20	●	0.02-0.10
QGI 30N270P005	2.70	0.05	0.020	0.020	7.20	●	0.02-0.10
QGI 30N300P005	3.00	0.05	0.020	0.020	7.20	●	0.02-0.10

⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)