

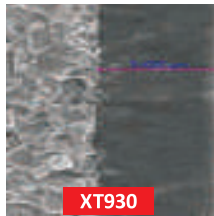
# 3 Edge Grooving Inserts



## Features & Benefits:

- The X-TGF32 grooving inserts are particularly versatile, precise, and efficient.
- They are excellent for machining steel, stainless steel, and cast iron.
- The 3 cutting edges ensure high efficiency and cost-effectiveness.
- Suitable for shallow depth machining.
- Excellent chip control and superior surface finish.

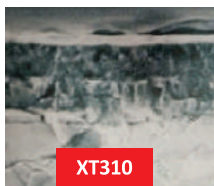
## | Grade Information



XT930

P15-P30 | M15-M30 | S05-S15

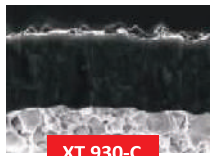
Ultra-fine grain matrix, nano-multilayer coating of ALTiMeN with good wear resistance and oxidation resistance. Stable, long-life turning of steel and stainless steel. Can also work on softer super alloys.



XT310

P10-P25 | K10-K25

PVD coating with optimal thermal resistance & added strength. Tough carbide substrate designed for demanding application. Suitable for all materials from steels to superalloys.



XT 930-C

P15-P35 | M15-M35 | H05-H15

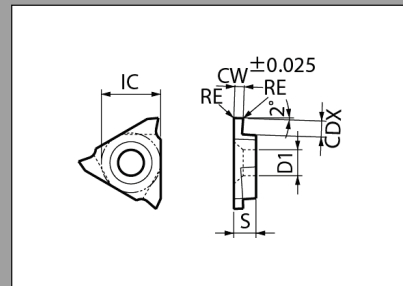
used for supplementary machining of soft steels. for general-purpose machining of stainless steel. It can be Ultra Dnd grade with Nano coating for high heat resistance and toughness. Special ALTiMeN coating gives it a bronze shade and higher temperature resistance! The 1st choice

## | Cutting Speed Recommendation

Workpiece Material	Hardness HB	Coated Carbide			
		XT310	XT930	XT930-C	
P	Non Alloyed Steel 0.15%-0.45%C	150 - 250	80-180	110-190	110-190
	Low Alloy Steel Tempered	250 - 300	60-160	110-180	110-180
	High Alloy Steel Tempered	350	50-120	70-160	100-180
	Corrosion Resistant Steel Annealed	200		120-200	120-200
M	Annealed Pearlitic	200		120-200	120-200
	Quenched Austenitic	180		100-170	100-170
	Quenched Duplex	230-260		70-110	70-110
	Hardened Martensitic	330		60-90	60-90
K	Grey Cast Iron	180	100-200		
	Spheroidal	160	100-180		100-160
	Malleable Pearlitic	130	80-160		80-150
S	Fe, Ni or co Based			60-80	
	Titanium and Ti-alloy based			40-70	

## Insert Specifications & Dimensions

Insert	Size	Dimensions (mm)			XT310	XT930	XT930-C
		CW	CDX	r			
X-TGF32R/L	050-005	0.5	1.2	0.05	●	●	○
X-TGF32R/L	055-005	0.55	1.2		○	○	○
X-TGF32R/L	060-005	0.6	2		●	●	○
X-TGF32R/L	065-005	0.65	2		○	○	○
X-TGF32R/L	070-005	0.7	2		●	●	○
X-TGF32R/L	075-005	0.75	2	0.1	○	○	○
X-TGF32R/L	080-010	0.8	2		●	●	○
X-TGF32R/L	085-010	0.85	2		○	○	○
X-TGF32R/L	090-010	0.9	2		●	●	○
X-TGF32R/L	095-010	0.95	2		○	○	○
X-TGF32R/L	100-010	1	2		●	●	○
X-TGF32R/L	110-010	1.1	2		●	●	○
X-TGF32R/L	120-010	1.2	2		●	●	○
X-TGF32R/L	130-010	1.3	2		●	●	○
X-TGF32R/L	140-010	1.4	2		●	●	○
X-TGF32R/L	150-010	1.5	2		●	●	○
X-TGF32R/L	160-010	1.6	2		●	●	○
X-TGF32R/L	170-010	1.7	2		●	●	○
X-TGF32R/L	175-010	1.75	2		●	●	○
X-TGF32R/L	180-010	1.8	2		●	●	○
X-TGF32R/L	190-010	1.9	2	0.15	●	●	○
X-TGF32R/L	200-015	2	2		●	●	○
X-TGF32R/L	210-015	2.1	2.5		●	●	○
X-TGF32R/L	220-015	2.2	2.5		●	●	○
X-TGF32R/L	225-015	2.25	2.5		●	●	○
X-TGF32R/L	230-015	2.3	2.5		●	●	○
X-TGF32R/L	240-015	2.4	2.5		●	●	○
X-TGF32R/L	250-015	2.5	2.5		●	●	○
X-TGF32R/L	260-015	2.6	2.5		●	●	○
X-TGF32R/L	270-015	2.7	2.5		●	●	○
X-TGF32R/L	280-015	2.8	2.5		●	●	○
X-TGF32R/L	290-015	2.9	2.5	●	●	○	
X-TGF32R/L	300-015	3	2.5	●	●	○	



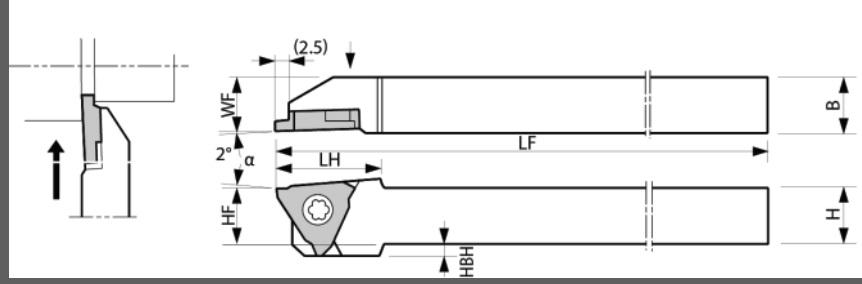
(mm)		
IC	S	D1
9.525	3.18	4.4

● Stockable ○ Non Stockable

## Radius Insert Specifications & Dimensions

Insert	Size	Dimension(mm)		
		CW	CDX	r
X-TGF32R/L	100-005	1	1.2	0.5
X-TGF32R/L	150-075	1.5	2	0.75
X-TGF32R/L	200-100	2	2	1
X-TGF32R/L	300-125	2.5	2.5	1.25
X-TGF32R/L	300-150	3	2.5	1.5

# Holder Specifications & Dimensions

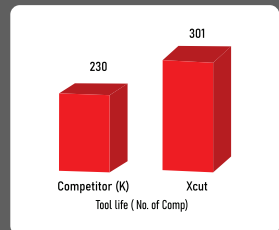


Designation	Dimensions (mm)						Spare Parts		Stock	
	H	HBH	HF	LF	LH	H	Screw	Wrench		
X-KTGFR/L	1010JX-16F	10	2	10	120	18.5	10	M3.5×9	T-8	●
	1212JX-16F	12	-	12	120	18.5	12	M3.5×9	T-8	●
	1616JX-16F	16	-	16	120	18.5	16	M3.5×9	T-8	●
	1212F-16F	12	-	12	85	18.5	12	M3.5×9	T-8	●
X-KTGFR/L X-JSTGR/L	1010F-16	10	4	10	80	18.5	12	M3.5×9	T-10	●
	1212H-16	12	2	12	100	18.5	16	M3.5×9	T-10	●
	1616H-16	16	-	16	100	18.5	20	M3.5×9	T-10	●
	2020K-16	20	-	20	125	20	25	M3.5×9	T-10	●
	2525M-16	25	-	25	150	20	32	M3.5×9	T-10	●

● Stockable ○ Non Stockable

## 3 Edge Grooving Case Study

Product Description	X-TGF32R-200-010-XT930	
Material & Hardness	SAE1018	
Parameters	Competitor (K)	X-CUT
Depth of Cut	0.5mm(4 pass), 1.8mm	0.5mm(4 pass), 1.8mm
Vc: m/min	129	129
Fz: mm/tooth	0.08	0.08
<b>Tool Life Increased By 30%</b>		



Plot No. 8, Ground Floor, Gyan Bhavan, Kumta Street, Ballard Estate,  
Mumbai - 400001, Maharashtra, India  
Tel. no.: +91-8879640290 E-mail: contact@xceedgroup.in Website: www.xcut.in

### OUR NETWORK

• AHMEDABAD • AURANGABAD • BENGALURU • CHENNAI • COIMBATORE • DELHI  
• DUBAI • INDORE • KOLHAPUR • MUMBAI\* • PUNE • RAJKOT • BARODA • BELGAUM • HYDERABAD  
• HOSUR • NAGPUR • NASHIK • SURAT • RAIPUR • KOLKATA • JAMSHEDPUR