

GROOVING

Grades selection guide .C2

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ISO 513	CARBIDE			PCBN	DIAMOND
	CVD COATED	PVD COATED	UNCOATED	UNCOATED	PCD
P Steel	P01				
	P10		JPS120		
	P20	JG8025	JPS120		
	P30		JPS125 JPS130		
	P40				
M Stainless steel	M01				
	M10		JPS120		
	M20		JPS125		
	M30		JPS130		
	M40				
K Cast iron	K01			NBH450U	
	K10	JG7010	JPS120		
	K20		JPS125		
	K30				
N Non-ferrous materials	N01				
	N10				ND120
	N20			JUG015	
	N30				
S HRSA	S01		JPS120		
	S10		JPS125		
	S20				
	S30				

ISO 513		CARBIDE			PCBN	DIAMOND
		CVD COATED	PVD COATED	UNCOATED	UNCOATED	PCD
H	H01					
	H10					
	H20				NBH450U	
	H30				NB350	

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GRADE	SUBSTRATE	HARDNESS HV	COATING		APPLICATION	FEATURES
			TECHNOLOGY	COMPOSITION		
JC7010	carbide	1.830	CVD	TiCN+Al ₂ O ₃	K K05 K25	<ul style="list-style-type: none"> High wear resistance. First choice for grey cast iron general machining. Elevata resistenza all'usura. Prima scelta per lavorazioni generali di ghisa grigia. Hohe Verschleißfestigkeit. Erste Wahl für die allgemeine Bearbeitung von Grauguss. Haute résistance à l'usure. Premier choix pour usinage général de fonte grise.
JC8025	carbide	1.700	CVD	TiCN+Al ₂ O ₃ +TiN	P P20 P30	<ul style="list-style-type: none"> All around grade suitable for a wide range of applications. Excellent reliability even on medium interrupted cut. Grado universale consigliato per un ampio campo di applicazioni. Eccellente affidabilità anche con taglio mediamente interrotto. Universelle Qualität, empfohlen für eine breite Palette von Anwendungen. Hervorragende Zuverlässigkeit auch bei mittleren Schnittunterbrechungen. Nuance universelle recommandée pour une large gamme d'applications. Excellente fiabilité y compris en cas de coupe moyennement interrompue.
JP5120	micrograin carbide	1.830	PVD	TiAlN	P P10 P20	<ul style="list-style-type: none"> Excellent performances on Stainless and HRSA thanks to special coating technology. The post-coating surface treatment effectively prevents built-up edge. Tecnologia speciale di rivestimento che bilancia resistenza all'usura e tenacità. Il trattamento superficiale post rivestimento previene efficacemente la formazione del tagliente di riporto. Die spezielle Beschichtungstechnologie sorgt für ein ausgewogenes Verhältnis zwischen Verschleißfestigkeit und Robustheit. Die Oberflächenbehandlung nach der Beschichtung verhindert die Bildung der Aufbauschneide effektiv. Technologie de revêtement spéciale équilibrant résistance à l'usure et ténacité. Le traitement de surface post-revêtement empêche efficacement la formation d'arêtes de coupe rapportées.
					M M10 M20	
JP5125	micrograin carbide	1.830	PVD	TiAlN	P P20 P30	<ul style="list-style-type: none"> High Co micrograin carbide substrate with high toughness and latest coating technology. Universal use with great reliability and long tool life. Substrato in metallo duro micrograna ad alto contenuto di Co ad alta tenacità e avanzata tecnologia di rivestimento. Uso universale con eccellente affidabilità e lunga vita utensile. Hochfestes mikrokörnige Hartmetallmaterial mit hohem Co-Gehalt und innovativer Beschichtungstechnologie. Universeller Einsatz mit ausgezeichneter Zuverlässigkeit und langer Standzeit. Substrat en carbure micro-grain haute teneur en Co à haute ténacité et technologie de revêtement avancée. Application universelle à excellente fiabilité et longue durée de vie.
					M M20 M30	
					S S01 S10	

GRADE	SUBSTRATE	HARDNESS HV	COATING		APPLICATION	FEATURES
			TECHNOLOGY	COMPOSITION		
JP5130	micrograin carbide	1.830	PVD	TiAlN	P P20 P35	<ul style="list-style-type: none"> High toughness substrate combined with super-smooth coating designed for precision applications. Substrato molto tenace combinato a rivestimento super-liscio progettato per applicazioni di precisione.
					M M20 M35	<ul style="list-style-type: none"> Sehr robustes Grundmaterial in Kombination mit einer besonders glatten Beschichtung, die für Präzisionsanwendungen entwickelt wurde. Substrat très résistant combiné à un revêtement mince conçu pour des applications de précision.
JU6015	micrograin carbide	1.950	-	-	N N10 N20	<ul style="list-style-type: none"> Uncoated carbide for universal use, from finishing to roughing, on non-ferrous materials. Metallo duro non rivestito per uso universale, dalla finitura alla sgrossatura, su materiali non ferrosi. Unbeschichtetes Hartmetall für den universellen Einsatz, von der Schlichtbearbeitung bis zum Schruppen, bei Nichteisenmaterialien. Carbure non revêtu pour application universelle, de la finition à l'ébauche, sur des matériaux non ferreux.
NB350	Low volume CBN 75%	3.400	-	-	H H20 H35	<ul style="list-style-type: none"> Hardened steel machining with a perfect combination between toughness and wear resistance. Available only for BGF system. Lavorazione di acciai temprati con perfetta combinazione tra tenacità e resistenza all'usura. Disponibile solo per il sistema BGF. Bearbeitung von gehärteten Stählen mit perfekter Kombination aus Robustheit und Verschleißfestigkeit. Nur für das BGF-System verfügbar. Usinage d'aciers trempés avec une combinaison parfaite entre ténacité et résistance à l'usure. Disponible uniquement pour le système BGF.
NBH450U	High volume CBN 95%	4.400	-	-	K K01 K20	<ul style="list-style-type: none"> Grey cast iron machining at very high cutting condition and with great wear resistance. Available only for BGF system. Lavorazioni di ghisa grigia con velocità di taglio molto elevate ed eccellente resistenza all'usura. Disponibile solo per il sistema BGF. Bearbeitung von Grauguss mit sehr hohen Schnittgeschwindigkeiten und hervorragender Verschleißfestigkeit. Nur für das BGF-System verfügbar. Usinage de fonte grise à des vitesses de coupe très élevées et une excellente résistance à l'usure. Disponible uniquement pour le système BGF.
ND120	diamond 95%	6.000	-	-	N N10 N30	<ul style="list-style-type: none"> High productivity grooving of non-ferrous materials. Available only for BGF system. Scanalatura a elevata produttività di materiali non ferrosi. Disponibile solo per il sistema BGF. Hochproduktives Nutenfräsen von Nichteisenmaterialien. Nur für das BGF-System verfügbar. Usinage de gorges haute productivité de matériaux non ferreux. Disponible uniquement pour le système BGF.

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	NDB	NCG	BGF
	<input type="checkbox"/> C10	<input type="checkbox"/> C16	<input type="checkbox"/> C19
	<div style="display: flex; flex-direction: column; align-items: center;"> <div style="margin-bottom: 20px;">  <p>EXTERNAL</p> </div> <div>  <p>INTERNAL</p> </div> </div>	<div style="display: flex; flex-direction: column; align-items: center;"> <div style="margin-bottom: 20px;">  <p>EXTERNAL</p> </div> <div>  <p>INTERNAL</p> </div> </div>	<div style="display: flex; flex-direction: column; align-items: center;"> <div style="margin-bottom: 20px;">  <p>EXTERNAL</p> </div> </div>
Pressed type inserts	✓	✗	✗
Ground type inserts	✓	✓	✓
Available sizes (CW)	2.00 / 3.00 / 4.00 / 5.00 / 6.00 / 8.00 mm	1.10 ÷ 2.15 mm	1.00 ÷ 4.00 mm
Maximum depth (CDX)	14 / 20 / 25 / 25 / 30 / 30 mm	1.30 ÷ 1.85 mm	1.80 ÷ 4.50 mm
Coolant holes	✓	✗	✗
Workpiece material	P M K N	P M	K N H
No. of cutting edges	2	3	1
No. of geometries	6	1	2
Special features	All-around system	Can be installed on threading tool holders	Easy tailor-made
Grooving 	✓	✓	✓
Turning 	✓	✗	✗
Profiling 	✓	✗	✗
Cut-off 	✓	✗	✗
Versatility	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■ □
Strength	■ ■ ■ ■ □	■ ■ ■ □ □	■ ■ ■ ■ ■
Precision	■ ■ ■ □ □	■ ■ ■ ■ ■	■ ■ ■ ■ □
Finishing	■ ■ ■ ■ □	■ ■ ■ ■ □	■ ■ ■ ■ □
Range	■ ■ ■ ■ □	■ ■ ■ □ □	■ ■ ■ □ □

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GROOVING NDB

Inserts .C8

Holders .C10

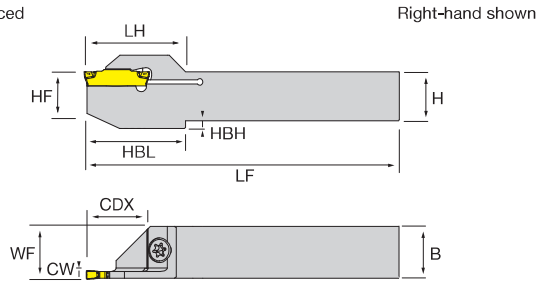
Parameters .C13

NDB E

NDB system

- External holders for NDB double sided grooving insert
- Different grooving depth (CDX) available for different groove width
- Clamp fastened and loosened by screw
- Improved holding system, automatically positioned, reliable and efficient

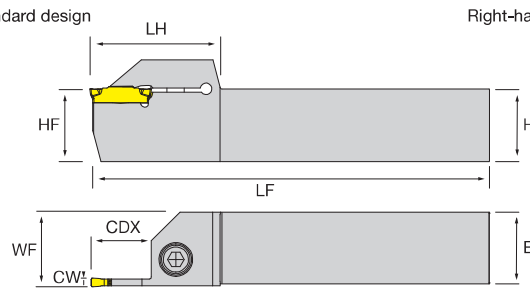
Radial reinforced



Right-hand shown



Standard design



Right-hand shown



Designation	CW	CDX	H	B	WF	LF	LH	HF	HBL	HBH	Stock
LEFT-HAND WITH RADIAL REINFORCEMENT											
NDB EL1212-2-CDX14	2	14	12	12	12.2	120	29	12	26	2	●
NDB EL1616-2-CDX14	2	14	16	16	16.2	120	29	16	26	2	●
NDB EL1616-3-CDX20	3	20	16	16	16.3	120	35	16	32	2	●
LEFT-HAND											
NDB EL2020-2-CDX14	2	14	20	20	21	125	38	20	-	-	●
NDB EL1616-3-CDX10	3	10	16	16	16.2	120	35	16	-	-	●
NDB EL2020-3-CDX10	3	10	20	20	21	125	38	20	-	-	●
NDB EL2020-3-CDX20	3	20	20	20	21	125	40	20	-	-	●
NDB EL2525-3-CDX10	3	10	25	25	26	150	40	25	-	-	●
NDB EL2525-3-CDX20	3	20	25	25	26	150	45	25	-	-	●
NDB EL2020-4-CDX10	4	10	20	20	21	125	35	20	-	-	●
NDB EL2020-4-CDX25	4	25	20	20	21	125	50	20	-	-	●
NDB EL2525-4-CDX10	4	10	25	25	26	150	40	25	-	-	●
NDB EL2525-4-CDX25	4	25	25	25	26	150	50	25	-	-	●
NDB EL2525-5-CDX10	5	10	25	25	26	150	40	25	-	-	●
NDB EL2525-5-CDX25	5	25	25	25	26	150	50	25	-	-	●
NDB EL2525-6-CDX15	6	15	25	25	26	150	45	25	-	-	●
NDB EL2525-6-CDX30	6	30	25	25	26	150	56	25	-	-	●
NDB EL2525-8-CDX15	8	15	25	25	26.5	150	43	25	-	-	●
NDB EL2525-8-CDX30	8	30	25	25	27	150	55	25	-	-	●
RIGHT-HAND WITH RADIAL REINFORCEMENT											
NDB ER1212-2-CDX14	2	14	12	12	12.2	120	29	12	26	2	●
NDB ER1616-2-CDX14	2	14	16	16	16.2	120	29	16	26	2	●
NDB ER1616-3-CDX20	3	20	16	16	16.3	120	35	16	32	2	●
RIGHT-HAND											
NDB ER2020-2-CDX14	2	14	20	20	21	125	38	20	-	-	●
NDB ER1616-3-CDX10	3	10	16	16	16.2	120	35	16	-	-	●
NDB ER2020-3-CDX10	3	10	20	20	21	125	38	20	-	-	●
NDB ER2020-3-CDX20	3	20	20	20	21	125	40	20	-	-	●
NDB ER2525-3-CDX10	3	10	25	25	26	150	40	25	-	-	●
NDB ER2525-3-CDX20	3	20	25	25	26	150	45	25	-	-	●
NDB ER2020-4-CDX10	4	10	20	20	21	125	35	20	-	-	●
NDB ER2020-4-CDX25	4	25	20	20	21	125	50	20	-	-	●

★ 1st choice, ☆ suitable, ● stock standard, ◎ non-stock standard (no MOQ), ○ non-stock standard (MOQ), ▲ upcoming product, ▽ stock exhaustion

Designation	CW	CDX	H	B	WF	LF	LH	HF	HBL	HBH	Stock
NDB ER2525-4-CDX10	4	10	25	25	26	150	40	25	-	-	●
NDB ER2525-4-CDX25	4	25	25	25	26	150	50	25	-	-	●
NDB ER2525-5-CDX10	5	10	25	25	26	150	40	25	-	-	●
NDB ER2525-5-CDX25	5	25	25	25	26	150	50	25	-	-	●
NDB ER2525-6-CDX15	6	15	25	25	26	150	45	25	-	-	●
NDB ER2525-6-CDX30	6	30	25	25	26	150	56	25	-	-	●
NDB ER2525-8-CDX15	8	15	25	25	26.5	150	43	25	-	-	●
NDB ER2525-8-CDX30	8	30	25	25	27	150	55	25	-	-	●

★ 1st choice, ☆ suitable, ● stock standard, ◎ non-stock standard (no MOQ), ○ non-stock standard (MOQ), ▲ upcoming product, ▽ stock exhaustion

Spare parts	Locking screw	Flag wrench	L wrench
NDB E ^{1/4} 1212-2-CDX14	NT-ST076	NT-FT15	-
NDB E ^{1/4} 1616-2-CDX14	NT-ST077	NT-FT15	-
NDB E ^{1/4} 1616-3-CDX10	NT-SC001	-	NT-WR040
NDB E ^{1/4} 1616-3-CDX20	NT-ST077	NT-FT15	-
NDB E ^{1/4} 2020- ^o -CDX ^{oo}	NT-SC001	-	NT-WR040
NDB E ^{1/4} 2525- ^o -CDX ^{oo}	NT-SC002	-	NT-WR040

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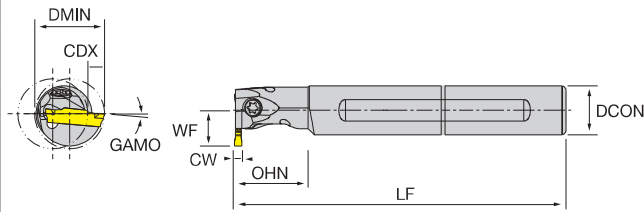
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NDB I

NDB system

- Internal holders for NDB double-headed grooving insert
- Vortex boring bar (anti-vibration steel) with coolant through
- Special chip evacuation path
- Clamp tightened by screw



Designation	CW	CDX	DMIN	DCON	WF	LF	OHN	GAMO			Stock
LEFT-HAND											
NDB IL1620V-2-CDX04	2	4	20	16	11.5	150	25	15°			●
NDB IL2025V-2-CDX06	2	6	25	20	14.5	180	30	15°			●
NDB IL2025V-3-CDX06	3	6	25	20	14.5	180	30	15°			●
NDB IL2532V-3-CDX08	3	8	32	25	19	200	40	15°			●
NDB IL3240V-3-CDX10	3	10	40	32	23.5	220	50	15°			●
NDB IL2532V-4-CDX08	4	8	32	25	19	200	40	15°			●
NDB IL3240V-4-CDX10	4	10	40	32	23.5	220	50	15°			●
RIGHT-HAND											
NDB IR1620V-2-CDX04	2	4	20	16	11.5	150	25	15°			●
NDB IR2025V-2-CDX06	2	6	25	20	14.5	180	30	15°			●
NDB IR2025V-3-CDX06	3	6	25	20	14.5	180	30	15°			●
NDB IR2532V-3-CDX08	3	8	32	25	19	200	40	15°			●
NDB IR3240V-3-CDX10	3	10	40	32	23.5	220	50	15°			●
NDB IR2532V-4-CDX08	4	8	32	25	19	200	40	15°			●
NDB IR3240V-4-CDX10	4	10	40	32	23.5	220	50	15°			●

★ 1st choice, ☆ suitable, ● stock standard, ◎ non-stock standard (no MOQ), ○ non-stock standard (MOQ), ▲ upcoming product, ▽ stock exhaustion

Spare parts	Locking screw	L wrench
NDB I/r1620V-2-CDX04	NT-ST40115T15	NT-TX15
NDB I/r○○○○V-○-CDX○○	NT-ST051	NT-TX20

ISO 513	MATERIAL	HARDNESS HB	JC8025			JP5120			JP5125						
			min	start	max	min	start	max	min	start	max				
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	○	170	250	330	●	100	150	200	○	100	140	180	
			●	160	225	290	●	90	130	170	●	80	120	160	
			⊕	140	195	250					⊕	70	100	130	
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	○	150	220	290	●	90	130	170	○	80	120	160	
			●	140	205	270	●	80	110	140	●	70	100	120	
			⊕	130	190	250					⊕	60	80	100	
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	○	140	205	270	●	80	115	150	○	70	100	130	
			●	130	190	250	●	70	100	130	●	60	90	120	
			⊕	120	170	220					⊕	60	80	100	
ISO 513	MATERIAL	HARDNESS HB	JP5120			JP5125									
			min	start	max	min	start	max	min	start	max	min	start	max	
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	●	100	150	200	○	100	140	180					
			●	90	130	170	●	80	120	160					
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	●	70	90	110	○	60	80	100					
			●	60	80	100	●	50	70	90					
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	●	70	110	150	○	60	100	140					
			●	60	100	140	●	50	90	130					
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		●	70	100	130	○	60	90	120					
			●	60	90	120	●	60	80	100					
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	●	180	280	380	●	110	150	190	○	100	140	180	
			●	150	225	300	●	90	130	170	●	80	115	150	
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	⊕	130	195	260					⊕	60	90	120	
			●	150	200	250	●	90	130	170	○	80	120	160	
K3 - K4	Austenitic and ADI cast iron (ex. 0.6660/GGL-NiCr 20 2/Ni-Resist 2, GJS-1000-5/ADI1000)	250 ÷ 500	●	130	175	220	●	80	110	140	●	70	95	120	
			●	120	165	210	●	80	110	140	●	70	105	140	
N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGAL)		⊕	110	155	200					⊕	50	75	100	
			●	140	190	240	●	80	110	140	○	70	105	140	
N2	Aluminium alloys Si > 12% (ex. 3.2382/G-AlSi12)		●	120	165	210	●	70	100	130	●	60	90	120	
			●	400	700	1000									
JUG015			●	300	500	700									
			●	200	300	400									
N1			●	200	250	300									
			●	200	250	300									
N2			●	100	150	200									
			●	200	300	400									

Complete workpiece materials p. M1.

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DESIGNATION	Grooving			Turning and Profiling						Cut-off			
	FEED RATE			DEPTH OF CUT			FEED RATE			FEED RATE			
	fn (mm/rev)			ap (mm)			fn (mm/rev)			fn (mm/rev)			
	min	start	max	min	start	max	min	start	max	min	start	max	
STRAIGHT EDGE	NDBD20R02o-Go	0.06	0.08	0.10	0.30	0.90	1.50	0.10	0.13	0.16	-	-	-
	NDBD30R04o-Go	0.07	0.10	0.13	0.40	1.20	2.00	0.16	0.18	0.20	-	-	-
	NDBD40R04o-Go	0.10	0.12	0.14	0.50	1.50	2.50	0.18	0.21	0.24	-	-	-
	NDBD50R04o-Go	0.11	0.15	0.19	0.60	1.80	3.00	0.20	0.25	0.30	-	-	-
	NDBD60R08o-Go	0.13	0.19	0.25	0.70	2.10	3.50	0.24	0.33	0.42	-	-	-
	NDBD80R08o-Go	0.18	0.26	0.34	0.80	2.65	4.50	0.32	0.44	0.56	-	-	-
FULL RADIUS	NDBD20R10o-Ro	0.06	0.09	0.12	0.00	0.50	1.00	0.14	0.18	0.22	-	-	-
	NDBD30R15o-Ro	0.08	0.11	0.14	0.00	0.75	1.50	0.18	0.23	0.28	-	-	-
	NDBD40R20o-Ro	0.10	0.13	0.16	0.00	1.00	2.00	0.20	0.27	0.34	-	-	-
	NDBD50R25o-Ro	0.12	0.16	0.20	0.00	1.25	2.50	0.24	0.33	0.42	-	-	-
	NDBD60R30o-Ro	0.13	0.19	0.25	0.00	1.50	3.00	0.24	0.37	0.50	-	-	-
	NDBD80R40o-Ro	0.18	0.26	0.34	0.00	2.00	4.00	0.32	0.49	0.66	-	-	-
CONCAVE EDGE	NDBD20R02M-CA	-	-	-	-	-	-	-	-	-	0.04	0.06	0.08
	NDBD30R04M-CA	-	-	-	-	-	-	-	-	-	0.06	0.08	0.10
	NDBD30R04M-CT	-	-	-	-	-	-	-	-	-	0.08	0.13	0.18



GROOVING NCG

Inserts .C16



GROOVING BGF

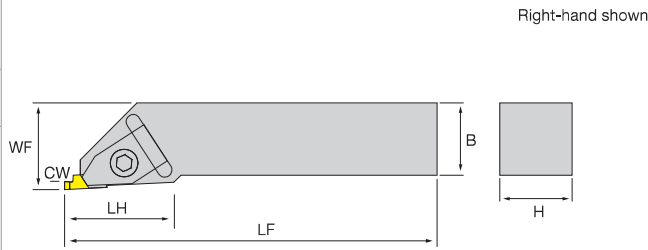
Inserts .C18

Holdings .C19

BGF-HLD

Advanced Grooving

- External holders for tangential mounted advanced grooving insert
- Clamp tightened by screw



Designation	H	B	WF	LF	LH	WT						Stock
LEFT-HAND												
BGF-HLD 2020L	20	20	30	150	45	-						☉
BGF-HLD 2525L	25	25	30	150	45	-						☉
RIGHT-HAND												
BGF-HLD 2020R	20	20	30	150	45	-						●
BGF-HLD 2525R	25	25	30	150	45	-						☉

★ 1st choice, ☆ suitable, ● stock standard, ☉ non-stock standard (no MOQ), ○ non-stock standard (MOQ), ▲ upcoming product, ▽ stock exhaustion

Spare parts	Insert screw	Flag wrench	Clamp	Clamp screw	L wrench
BGF-HLD ○○○○L	NT-ST50110T20	NT-FT15	NT-CS300L	NT-SC300	NT-WR040
BGF-HLD ○○○○R	NT-ST50110T20	NT-FT15	NT-CS300R	NT-SC300	NT-WR040

RELIABLE CLAMPING

1. Install the insert and screw lightly
2. Firmly fix the clamp
3. Tighten the insert screw completely.

HOLDER AND INSERT COUPLING

Holder R → Insert R
Holder L → Insert L

INDEXABLE

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS