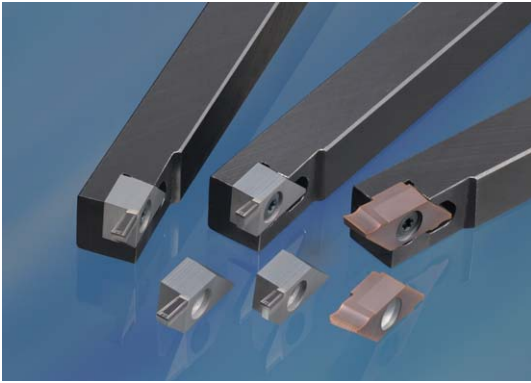
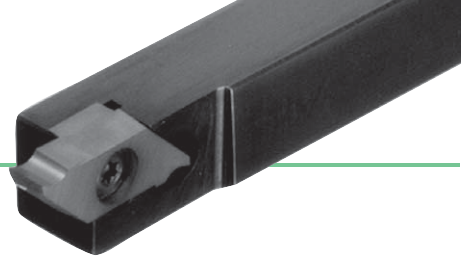


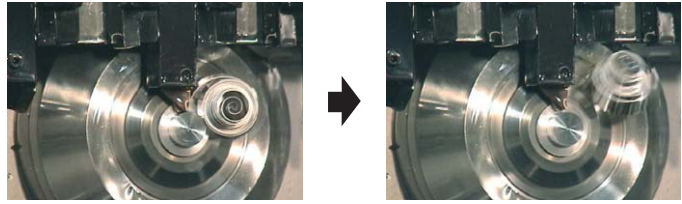
# SEC-Wide Tool Holders SGW Type

Expanded



## Features

- Enables efficient roughing of components with long shank
- Produces coin-shaped chips that will not tangle with the machinery or the work piece



## SUMIDIA Multifunctional Tools With Chipbreakers SUMIDIA Break Master LD Type

New

- Achieves excellent chip control during traverse cutting/grooving of aluminum alloy
- Greatly improves work efficiency through eliminating problems caused by chips
- Stability and long tool life achieved through using high strength material SUMIDIA DA1000

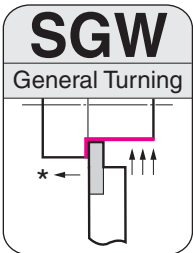
## Application Examples

LD Type + DA1000

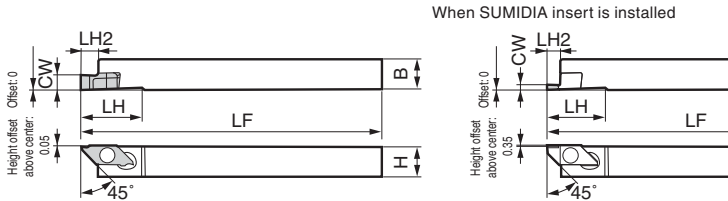
Conventional chipbreaker

Work material: Valve (A6061) Tool Cat. No.: KGV R2004-LD (DA1000)  
Cutting conditions:  $v_c = 250$  m/min  $f = 0.10$  mm/rev  $a_p = 0.5$  mm Wet

## Multifunctional External Machining (Grooving / Traverse cutting)



Note: Use the SUMIDIA insert when performing traverse cutting.



## Holders

Cat. No.	Stock	Dimensions (mm)					Screw	Wrench
		H	B	LF	LH2	LH		
SGW R1212	●	12	12	120	7.0	24.5	BFTX0410T8R	1.1
SGW R1616	●	16	16	120	7.0	24.5		

## Inserts (Carbide)

Cat. No.	Coated carbide		Edge width CW	Length L	Length LF	Depth of cut LH2	Stem LH	Effective Length
	AC1030U	AC530U						
KGV R400	●	●	4.0	21.0	120	7.0	24.5	6.3
KGV R500	●	●	5.0	21.0	120	7.0	24.5	6.3
KGV R600	●	●	6.0	21.0	120	7.0	24.5	6.3

## Inserts (SUMIDIA)

Cat. No.	SUMIDIA	Edge width CW	Length L	Length LF	Depth of cut LH2	Stem LH	Effective Length
KGV R2004-LD	●	2.0	19.7	118.7	5.7	23.2	4.0
KGV R2504-LD	●	2.5	19.7	118.7	5.7	23.2	4.0
KGV R2506-LD	●	2.5	21.2	120.2	7.2	24.7	5.5

## Recommended Cutting Conditions

Work material	P M N		N
	AC1030U		DA1000
Grade	AC1030U		DA1000
Machining details	Grooving		Grooving / Traverse cutting
Rotation speed $n$ (min <sup>-1</sup> )	4,000 - 6,000		4,500 - 8,000
Feed rate $f$ (mm/rev)	0.05 - 0.15		0.07 - 0.15
Coolant	Wet		

Note: Use caution in regards to the spindle power when using this. If this tool is used with a small lathe, the machine may stop during machining due to insufficient spindle power. Please use caution especially when machining carbon steel and stainless steel.

D  
Small Product  
Machining



Recommended tightening torque (N·m)

Caution: Re-grinding the cutting edges of the SUMIDIA BreakMaster LD type may affect the chip control performance. ● mark: Standard stock (expanded product)