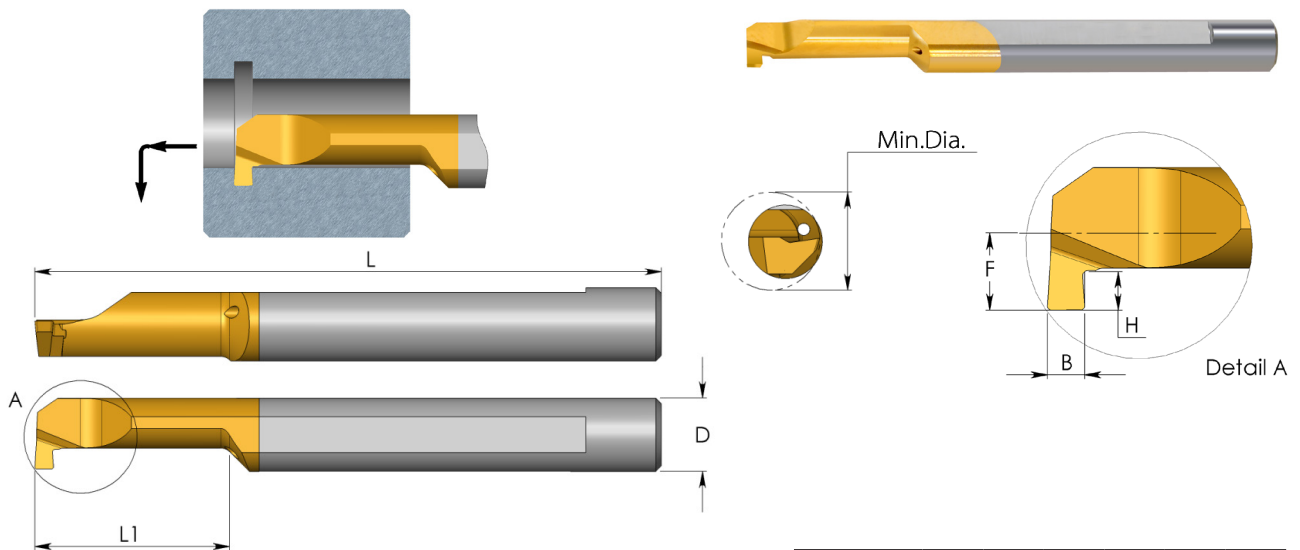


MGR Bars Grooving



Grade	P	M	K	N	S	H
K20		○	○	●	○	
BXC	●	●	●	○	●	●
BMK	●	●	●	○	●	●

D	Ordering Code	L	L1	B		H	F	Min. Dia.	Holder
				mm	in				
4.0	MGR 2 B0.5 L10	51	10	0.5	.020	0.5	0.9	2.1	SIM ... H4
3.0	MGR 3 B0.5 L10	39	10	0.5	.020	0.5	1.3	3.1	SIM ... H3
	MGR 3 B0.7 L10	39	10	0.7	.028	0.6	1.3	3.1	
4.0	MGR 4 B0.5 L10	51	10	0.5	.020	0.5	1.7	4.1	SIM ... H4
	MGR 4 B0.5 L15	51	15	0.5	.028	0.5	1.7	4.1	
	MGR 4 B0.7 L10	51	10	0.7	.028	0.6	1.7	4.1	
	MGR 4 B0.79 L15	51	15	0.79	.031	0.9	1.7	4.1	
	MGR 4 B0.79 L22	51	22	0.79	.031	0.9	1.7	4.1	
	MGR 4 B1.0 L10	51	10	1.0	.039	1.0	1.7	4.1	
	MGR 4 B1.0 L15	51	15	1.0	.039	1.0	1.7	4.1	
	MGR 4 B1.0 L22	51	22	1.0	.039	1.0	1.7	4.1	
	MGR 4 B1.5 L10	51	10	1.5	.059	1.0	1.7	4.1	
	MGR 4 B1.5 L15	51	15	1.5	.059	1.0	1.7	4.1	
5.0	MGR 5 B0.79 L15	51	15	0.79	.031	1.0	2.3	5.1	SIM ... H5
	MGR 5 B0.79 L22	51	22	0.79	.031	1.0	2.3	5.1	
	MGR 5 B1.0 L15	51	15	1.0	.039	1.2	2.3	5.1	
	MGR 5 B1.0 L22	51	22	1.0	.039	1.2	2.3	5.1	
	MGR 5 B1.19 L15	51	15	1.19	.047	1.2	2.3	5.1	
	MGR 5 B1.19 L22	51	22	1.19	.047	1.2	2.3	5.1	
	MGR 5 B1.5 L15	51	15	1.5	.059	1.2	2.3	5.1	
	MGR 5 B1.5 L22	51	22	1.5	.059	1.2	2.3	5.1	
	MGR 5 B1.59 L15	51	15	1.59	.063	1.2	2.3	5.1	
	MGR 5 B1.59 L22	51	22	1.59	.063	1.2	2.3	5.1	
	MGR 5 B2.0 L15	51	15	2.0	.079	1.2	2.3	5.1	
	MGR 5 B2.0 L22	51	22	2.0	.079	1.2	2.3	5.1	

For additional holders see page A06-32 to 41

● First choice

○ Alternative

MGR Bars Grooving

D	Ordering Code	L	L1	B		H	F	Min. Dia.	Holder
				mm	in				
6.0	MGR 6 B1.0 L15	51	15	1.0	.039	1.4	2.8	6.1	SIM ... H6
	MGR 6 B1.0 L22	51	22	1.0	.039	1.4	2.8	6.1	
	MGR 6 B1.5 L15	51	15	1.5	.059	1.4	2.8	6.1	
	MGR 6 B1.5 L22	51	22	1.5	.059	1.4	2.8	6.1	
	MGR 6 B2.0 L15	51	15	2.0	.079	1.4	2.8	6.1	
	MGR 6 B2.0 L22	51	22	2.0	.079	1.4	2.8	6.1	
6.0	MGR 6 B0.79 L17	51	17	0.79	.031	1.8	2.8	6.1	SIM ... H6
	MGR 6 B0.79 L23	51	23	0.79	.031	1.8	2.8	6.1	
	MGR 6 B1.0 L17	51	17	1.0	.039	1.8	2.8	6.1	
	MGR 6 B1.19 L17	51	17	1.19	.047	1.8	2.8	6.1	
	MGR 6 B1.19 L23	51	23	1.19	.047	1.8	2.8	6.1	
	MGR 6 B1.5 L17	51	17	1.5	.059	1.8	2.8	6.1	
	MGR 6 B1.5 L23	51	23	1.5	.059	1.8	2.8	6.1	
	MGR 6 B1.59 L17	51	17	1.59	.063	1.8	2.8	6.1	
	MGR 6 B1.59 L23	51	23	1.59	.063	1.8	2.8	6.1	
	MGR 6 B2.0 L17	51	17	2.0	.079	1.8	2.8	6.1	
	MGR 6 B2.0 L23	51	23	2.0	.079	1.8	2.8	6.1	
7.0	MGR 7 B1.0 L15	62	15	1.0	.039	2.5	3.3	7.1	SIM ... H7
	MGR 7 B1.0 L22	62	22	1.0	.039	2.5	3.3	7.1	
	MGR 7 B1.0 L30	62	30	1.0	.039	2.5	3.3	7.1	
	MGR 7 B1.19 L22	62	22	1.19	.047	2.5	3.3	7.1	
	MGR 7 B1.19 L30	62	30	1.19	.047	2.5	3.3	7.1	
	MGR 7 B1.5 L15	62	15	1.5	.059	2.5	3.3	7.1	
	MGR 7 B1.5 L22	62	22	1.5	.059	2.5	3.3	7.1	
	MGR 7 B1.5 L30	62	30	1.5	.059	2.5	3.3	7.1	
	MGR 7 B1.59 L22	62	22	1.59	.063	2.5	3.3	7.1	
	MGR 7 B1.59 L30	62	30	1.59	.063	2.5	3.3	7.1	
	MGR 7 B2.0 L15	62	15	2.0	.079	2.5	3.3	7.1	
	MGR 7 B2.0 L22	62	22	2.0	.079	2.5	3.3	7.1	
	MGR 7 B2.0 L30	62	30	2.0	.079	2.5	3.3	7.1	
8.0	MGR 8 B1.0 L22	64	22	1.0	.039	1.7	3.8	8.1	SIM ... H8
	MGR 8 B1.5 L22	64	22	1.5	.059	1.7	3.8	8.1	
	MGR 8 B2.0 L15	64	15	2.0	.079	2.6	3.8	8.1	
	MGR 8 B2.0 L22	64	22	2.0	.079	2.6	3.8	8.1	
	MGR 8 B2.38 L15	64	15	2.38	.094	2.6	3.8	8.1	
	MGR 8 B2.38 L22	64	22	2.38	.094	2.6	3.8	8.1	

Tolerance: B±0.025 mm/.001"

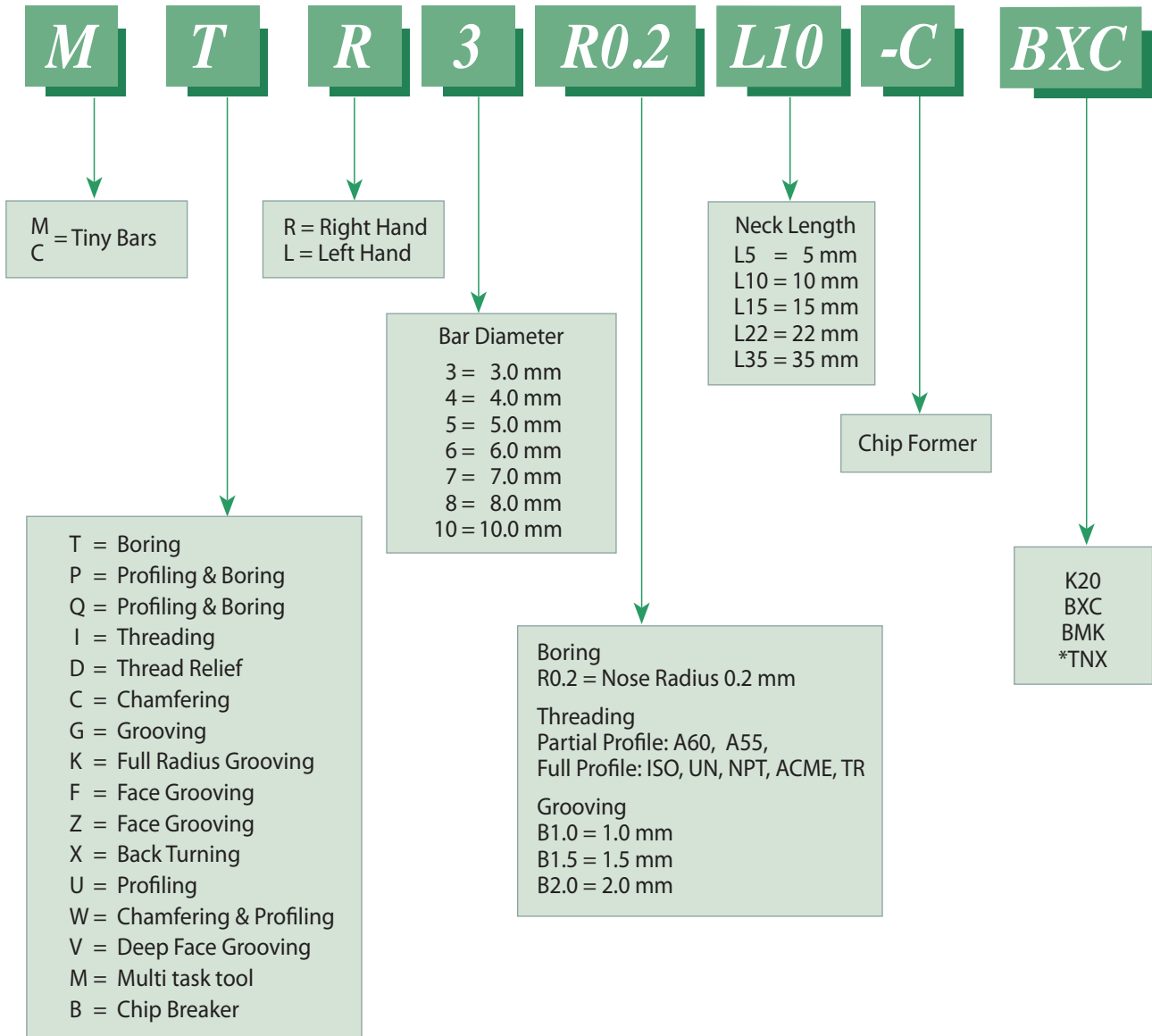
Order example: MGR 5 B1.5 L15 BXC

For L.H. bars specify MGL instead of MGR

For additional holders see page A06-32 to 41

Product Identification

Tiny Bars Ordering Codes



* Available only for CBR bars

Technical Section

Carbide Grades:

BXC (P30 - P50, K25 - K40)

PVD TiN coated grade for low cutting speed.
Works well with a wide range of stainless steels.

BMK (K10 - K20)

Sub-micron grade with advanced PVD triple coating. Extremely high heat resistant and smooth cutting operation, for high performance, and normal machining conditions. General purpose for all materials.

K20 (K10 - K30)

Uncoated Carbide grade for non ferrous metals, aluminum and cast iron.

TNX

New advanced carbide grade **TNX** for higher feeds and high performance, at medium to high cutting speed. Extra fine grain size with high hardness and toughness combined with triple layer reddish coating, provides high edge stability and better chip flow. Available only for CBR bars.



Cutting speed for Tiny Tools

ISO Stan- dard	Material		Condition	Cutting Speed m/min			
				BXC	BMK	K20	TNX
P	Non-Alloy steel and cast steel, free cutting steel	<%0.25C	Annealed	25 - 70	30 - 80		36 - 80
		≥%0.25C	Annealed				
		< %0.55C	Quenched and tempered				
		≥%0.55C	Annealed				
		≥%0.55C	Quenched and tempered				
	Low alloy steel and cast steel (less than %5 alloying elements)		Annealed	20 - 40	25 - 50		30 - 50
			Quenched and tempered				
	High alloy steel, cast steel, and tool steel		Annealed	20 - 40	25 - 50		30 - 50
Quenched and tempered							
M	Stainless steel and cast steel		Ferritic/martensitic	25 - 40	30 - 60		36 - 60
			Martensitic				
			Austenitic				
K	Cast iron nodular (GGG)		Ferritic/pearlitic	25 - 60	30 - 80		36 - 80
			Pearlitic				
	Grey cast iron (GG)		Ferritic	30 - 70	30 - 80		36 - 80
			Pearlitic				
	Malleable cast iron		Ferritic	20 - 40	20 - 50		24 - 50
Pearlitic							
N	Aluminum-wrought alloy		Not cureable	50 - 100	60 - 120	30 - 50	72 - 120
			Cured				
	Aluminum- cast, alloyed	≤%12 Si	Not cureable	40 - 80	50 - 90	20 - 40	60 - 90
			Cured				
		>%12 Si	High temperature				
	Copper alloys	>%1 Pb	Free cutting	30 - 60	30 - 70	20 - 40	36 - 70
			Brass				
			Electrolytic copper				
Non metallic		Duroplastics, fiber plastics	40 - 80		20 - 40		
		Hard rubber					
S	High temp. alloys, Super alloys	Fe based	Annealed	15 - 30	15 - 40		18 - 40
			Cured				
		Ni or Co based	Annealed				
			Cured				
	Titanium, Titanium alloys		Cast				
H	Hardened steel		Hardened 45-50 HRc	10 - 30	14 - 40		18 - 40
			Hardened 51-55 HRc				
			Hardened 56-62 HRc				
	Chilled cast iron		Cast	10 - 30	10 - 30		12 - 30
	Cast iron		Hardened	10 - 20	10 - 20		12 - 20

Recommended Feed Rate: 0.01 - 0.03 mm/rev

For CMR Tiny Tools see page A06-45