



Counterclockwise Spindle Rotation is the recommended method for most face grooving applications

| Horizon Face Grooving Inserts | | | | | |
|-------------------------------|-----------|----------------|------|----------------|------------------|
| Specials | Standards | Insert | W | E - Max. Depth | Min. Groove Dia. |
| Chip Curler | | HF 3062L or R | .062 | .125 | 1.000 |
| | | HF 3072L or R | .072 | .125 | 1.000 |
| | | HF 3094L or R | .094 | .185 | 1.000 |
| Full Nose Radius | | HF 3098L or R | .098 | .185 | 1.000 |
| | | HF 3110L or R | .110 | .185 | 1.125 |
| Knife Edge | | HF 3125L or R | .125 | .185 | 1.125 |
| | | HF 3156L or R | .156 | .185 | 1.200 |
| Dovetail | | HF 3189L or R | .189 | .185 | 1.200 |
| | | HF 4250L or R | .250 | .255 | 2.250 |
| | | HFD 3125L or R | .125 | .250 | 1.875 |
| | | HFD 4189L or R | .189 | .375 | 2.250 |
| | | HFD 4250L or R | .250 | .500 | 2.250 |

TiALN Coated Micrograin Grade 310 is the 1st Choice for most Face Grooving applications. In Stainless and Softer Steels start at 300 SFM and .0005 to .002 Feed; Titanium, Inconel & other High Temp Alloys start at 100 - 150 SFM and .0005 to .0015 Feed. Use Uncoated Grade C23 for Aluminum, Copper and Plastics at higher Speeds and Feeds.

| Standard Grooving Inserts can be used for Larger Diameter Face Grooving without Modification | | | |
|--|--------------|----------------------|-------------------------|
| Insert | Insert Width | Maximum Groove Depth | Minimum Groove Diameter |
| HG 20xxL or R | Under .047 | .055 | 2.125 |
| HG 20xxL or R | .047 to .062 | .080 | 2.750 |
| HG 20xxL or R | .062 and up | .115 | 3.500 |
| HG 30xxL or R | Under .047 | .055 | 2.125 |
| HG 30xxL or R | .047 to .062 | .080 | 2.750 |
| HG 30xxL or R | .062 to .094 | .115 | 3.500 |
| HG 30xxL or R | .094 to .125 | .192 | 6.00 |
| HG 31xxL or R | .125 and up | .205 | 6.500 |
| HG 4125L or R | .125 | .205 | 7.250 |
| HG 4156L or R | .156 | .205 | 7.250 |
| HG 4189L or R | .189 | .255 | 8.250 |
| HG 4250L or R | .250 | .255 | 8.250 |