



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