



#### Quick Modifications Guide for Standard Threading and Grooving Inserts

<b>E</b> - Back Distance or Maximum Depth of Cut	<b>FA</b> - Face Angle **
<b>W</b> - Width of Cut	<b>V</b> - Threading or Grooving Angle **
<b>R1</b> - Outer Corner Radius *	<b>FC</b> - Increased Face Clearance Angle
<b>R2</b> - Inner Corner Radius *	<b>SC1</b> - Outer Side Clearance Angle
<b>FNR</b> - Full Nose Radius **	<b>SC2</b> - Inner Side Clearance Angle
<b>RK/LK</b> - 10° - 20° Chip Curler - RH or LH Inserts **	<b>BC1</b> - Outer Back Clearance Angle *
<b>P</b> - 10° Positive Rake - Standard Rake is 5° **	<b>BC2</b> - Inner Back Clearance Angle *

\* Width of Cut may change with modifications

\*\* Width and/or Depth of Cut may change with modifications

#### Uncoated Inserts modified in 1 to 3 Working Days - Please add 3 to 10 Days for Coatings.

Horizon can provide inserts with any commercially available coating. Some coated Inserts can be re-coated after modification: PVD TIN can be re-coated with TIN, TiCN or TiALN coatings: TiALN coated Inserts can be re-coated with PVD TIN. Note: PVD re-coating can chip or flake off due to excess coating thickness. Performance is not guaranteed on recoated inserts.

Some Insert modifications don't require re-coating. Aside from cosmetics, the removal of PVD coating from the periphery of a Carbide Insert has minimal effect on it's performance in most applications so long as the coating on the Top Surface of the Insert remains intact.

**Please Contact Horizon Carbide Tool for Price and Delivery on Modified Standard Inserts**