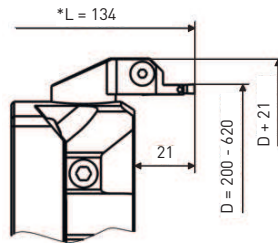
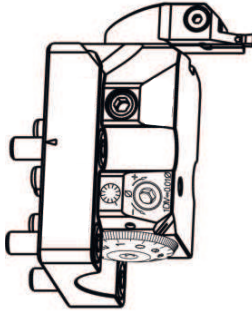


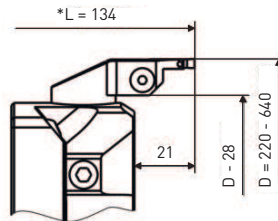


318.04

Operating instruction Face grooving Series 318



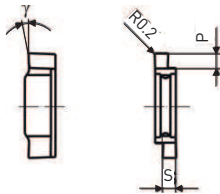
Order No.: 626.938



Order No.: 626.948



Inserts

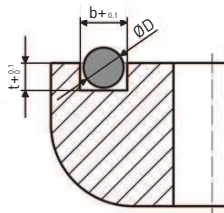


S	P	ST / GG *		Aluminium	
		Y	Order No.	Y	Order No.
2.5	2.7	5°	958.425	15°	958.475
3.0	3.3	5°	958.430	15°	958.480
3.3	3.6	5°	958.433	15°	958.483
3.5	3.8	5°	958.435	15°	958.485
4.0	4.3	5°	958.440	15°	948.490

* ST = Steel / GG = Cast iron

Groove dimensions

Recommended groove dimensions for given cross section diameters of O-Rings, for static sealing.



Seal ring ØD	Groove width b	Groove depth t
1.78	2.5	1.3
2.0	2.5	1.6
2.5	3.3	1.9
2.62	3.5	2.05
3.0	4.0	2.4

Cutting data

The given cutting data are guide values. We recommend to start with the lower values. Under favorable conditions they can be increased to the maximum.

Work piece material	v_c	f_n
	[m / min]	[mm / rev]
Construction- / Heat treatable steels	120 - 240	0.08 - 0.12
Stainless steels	60 - 120	0.06 - 0.10
GGG / GGG	120 - 240	0.10 - 0.20
AL / Non-ferrous metals	200 - 400	0.10 - 0.20