



# TOP NOTCH Grooving Inserts

## TOP NOTCH Grooving Application Guide

| Insert Style   | Application   | Rake Angle   | Page | Insert Style  | Application   | Rake Angle   | Page |
|--|---|--------------|------|---|---|--------------|------|
| <b>NG-K</b><br>   | <ul style="list-style-type: none"> <li>chip control geometry</li> <li>general purpose grooving</li> <li>o-ring grooving</li> <li>circlip grooving</li> <li>light turning</li> </ul> | 10° positive | B12  | <b>NF-K</b><br>             | <ul style="list-style-type: none"> <li>face grooving with chip control</li> <li>additional side clearance</li> </ul>  | 10° positive | B19  |
| <b>NG</b><br>     | <ul style="list-style-type: none"> <li>general purpose grooving</li> <li>o-ring grooving</li> <li>circlip grooving</li> </ul>   | neutral      | B14  | <b>NF</b><br>               | <ul style="list-style-type: none"> <li>face grooving</li> <li>additional side clearance</li> </ul>  | neutral      | B19  |
| <b>NGP</b><br>    | <ul style="list-style-type: none"> <li>general purpose grooving</li> <li>o-ring grooving</li> <li>circlip grooving</li> </ul>   | 5° positive  | B15  | <b>NFD-K</b><br>            | <ul style="list-style-type: none"> <li>deep face grooving with chip control</li> <li>additional side clearance</li> </ul>   | 10° positive | B19  |
| <b>NGD-K</b><br> | <ul style="list-style-type: none"> <li>chip control geometry</li> <li>deep grooving</li> <li>light turning</li> </ul>   | 10° positive | B16  | <b>NFD-KI</b><br>          | <ul style="list-style-type: none"> <li>internal deep face grooving with chip control</li> <li>for use in boring bars for internal face grooves</li> </ul>                               | 10° positive | B20  |
| <b>NGD</b><br>  | <ul style="list-style-type: none"> <li>deep grooving</li> </ul>   | neutral      | B16  | <b>NP-K<br/>NPD-K</b><br> | <ul style="list-style-type: none"> <li>turning</li> <li>back turning</li> <li>profiling with chip control</li> </ul>  | 10° positive | B20  |
| <b>NR-K</b><br> | <ul style="list-style-type: none"> <li>chip control geometry</li> <li>full radius grooving</li> <li>turning profiling</li> </ul>  | 10° positive | B17  | <b>NU</b><br>             | <ul style="list-style-type: none"> <li>undercutting</li> </ul>  | neutral      | B18  |
| <b>NR</b><br>   | <ul style="list-style-type: none"> <li>full radius grooving</li> <li>turning profiling</li> </ul>   | neutral      | B17  | <b>NV</b><br>             | <ul style="list-style-type: none"> <li>Poly Vee grooving</li> </ul>   | neutral      | B18  |
| <b>NRP</b><br>  | <ul style="list-style-type: none"> <li>full radius grooving</li> <li>light-turning profiling</li> </ul>   | 5° positive  | B17  | <b>NGC-K</b><br>          | <ul style="list-style-type: none"> <li>combined groove &amp; chamfered edge break in one plunge with chip control</li> <li>designed for DIN 471/472 standard circlip grooves</li> </ul> | 10° positive | B21  |
| <b>NRD</b><br>  | <ul style="list-style-type: none"> <li>deep grooving</li> <li>full radius endform</li> </ul>  | neutral      | B18  | <b>NB/NBD</b><br>         | <ul style="list-style-type: none"> <li>blanks</li> <li>blanks for deep grooving</li> <li>available only in uncoated grades</li> </ul>   | -<br>-       | B22  |