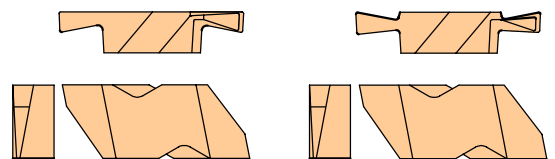
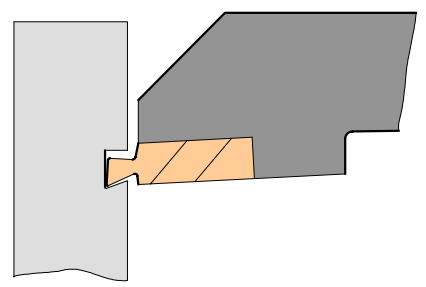
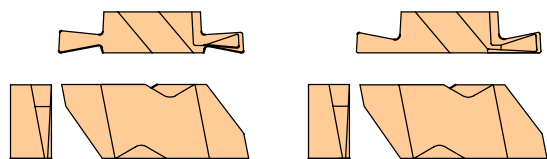


Left Hand Inserts for Counterclockwise Rotation



Right Hand Inserts for Clockwise Rotation



CORRECT
Ramp in with
Multiple Passes



Infeed for Dovetail
Face Grooving

WRONG
Can Result in
Insert Breakage



Dovetail Face Grooves are used in the High Vacuum and Hydraulic Industries to retain O-Ring Seals in Plates and Flanges. There is no Industry Standard for these types of grooves. Dovetail Grooving Inserts are made to Print. Horizon Stocks a number of Special Inserts in frequently used sizes. Call for availability.

TiALN Coated Grade 310 is the First Choice for Face Grooving tough materials. Start at 150 to 300 SFM with a Feed Rate of .0005 to .001 Per Rev. Ramp into the cut as shown above. For best results machine an entry groove with a Standard Face Grooving Insert the width of the top of the Dovetail Groove.