



Quick Modifications Guide for Standard Threading and Grooving Inserts

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