TOOLFLO
Member IMC Group

FACE GROOVING

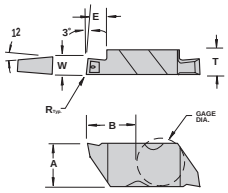
FACE GROOVING

FLF-CB

w/Patented chipbreaker

Exclusive patented design!

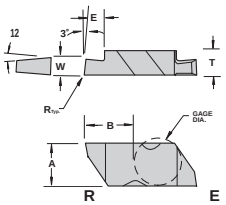
Features:
- Patented chipbreaker - Patent No. 6,146,064
- Maximum chip control
- Industry standard widths



RH Shown

Description	EDP Code	W	R	E	T	A	B	Gage Dia.	Uncoated C3	TiN Coated GP3	TiN Coated GP50	AlTiN Coated AC3	AlTiN Coated AC50
FLF-3M200R-CB	553M200PR	2.00	0.13/0.25	3.31	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3M200L-CB	553M200PL	2.00	0.13/0.25	3.31	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3M300R-CB	553M300PR	3.00	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3M300L-CB	553M300PL	3.00	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3125R-CB	563025PR	3.18	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3125L-CB	563025PL	3.18	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3156R-CB	563056PR	3.96	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3156L-CB	563056PL	3.96	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3188R-CB	563088PR	4.77	0.51/0.64	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3188L-CB	563088PL	4.77	0.51/0.64	4.57	4.95	8.74	10.29	9.53		●	●	●	●

FLF



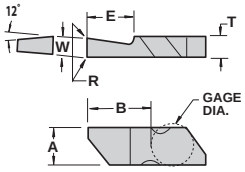
RH SHOWN

For holders see next page.

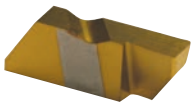
Description	EDP Code	W	R	E	T	A	B	Gage Dia.	Uncoated C3	TiN Coated GP3	TiN Coated GP50	AlTiN Coated AC3	AlTiN Coated AC50
FLF-3M200R	553M200R	2.00	0.13/0.25	3.31	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3M200L	553M200L	2.00	0.13/0.25	3.31	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3M300R	553M300R	3.00	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3M300L	553M300L	3.00	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3125R	563025R	3.18 (.125)	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3125L	563025L	3.18 (.125)	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3156R	563056R	3.96 (.156)	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3156L	563056L	3.96 (.156)	0.13/0.25	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3188R	563088R	4.77 (.188)	0.51/0.64	4.57	4.95	8.74	10.29	9.53		●	●	●	●
FLF-3188L	563088L	4.77 (.188)	0.51/0.64	4.57	4.95	8.74	10.29	9.53		●	●	●	●

FLFD

Single ended - Deep Grooving



RH SHOWN



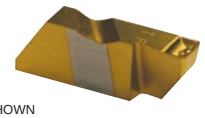
For holders see next page.

Description	EDP Code	W	R	T	E	A	B	Gage Dia	Uncoated C3	Uncoated C6H	TiN Coated GP3	TiN Coated GP50	AlTiN Coated AC3	AlTiN Coated AC50
FLFD-3M300R	633M300R	3.00	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	●
FLFD-3M300L	633M300L	3.00	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	●
FLFD-3125R	6338125R	3.18 (.125)	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	●
FLFD-3125L	6338125L	3.18 (.125)	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	●
FLFD-4189R	6348189R	4.80 (.189)	0.51/0.64	6.48	9.91	11.51	19.33	9.53			●	●	●	●
FLFD-4189L	6348189L	4.80 (.189)	0.51/0.64	6.48	9.91	11.51	19.33	9.53			●	●	●	●
FLFD-4250R	6348250R	6.35 (.250)	0.51/0.64	6.48	13.21	11.51	22.50	9.53			●	●	●	●
FLFD-4250L	6348250L	6.35 (.250)	0.51/0.64	6.48	13.21	11.51	22.50	9.53			●	●	●	●

FLFD-CB

Single ended - Deep Grooving
w/Patented chipbreaker

Exclusive patented design!



RH SHOWN

For holders see next page.

Description	EDP Code	W	R	T	E	A	B	Gage Dia	Uncoated C3	Uncoated C6H	TiN Coated GP3	TiN Coated GP50	AlTiN Coated AC3	AlTiN Coated AC50
FLFD-3M300R-CB	633M300PR	3.00	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	●
FLFD-3M300L-CB	633M300PL	3.00	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	●
FLFD-3125R-CB	6338125PR	3.18 (.125)	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	●
FLFD-3125L-CB	6338125PL	3.18 (.125)	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	●
FLFD-4189R-CB	6348189PR	4.80 (.189)	0.51/0.64	6.48	9.91	11.51	19.33	9.53			●	●	●	●
FLFD-4189L-CB	6348189PL	4.80 (.189)	0.51/0.64	6.48	9.91	11.51	19.33	9.53			●	●	●	●
FLFD-4250R-CB	6348250PR	6.35 (.250)	0.51/0.64	6.48	12.70	11.51	22.50	9.53			●	●	●	●
FLFD-4250L-CB	6348250PL	6.35 (.250)	0.51/0.64	6.48	12.70	11.51	22.50	9.53			●	●	●	●

In an effort to improve our stock standard grade offering, there are periodic changes.
Please see current price list for up to date grade offering.

● High performance choice in optimal conditions.
▲ Recommended grade under general conditions.

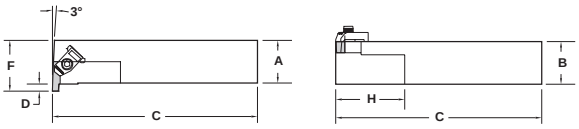
Cast Iron			▲		●	
Non-Ferrous			●		▲	
Stainless/High Temp			▲		●	
Steel				▲		●

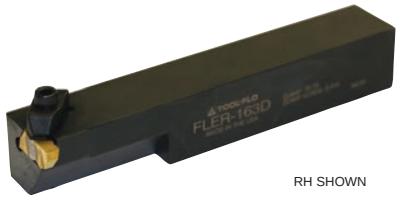
EXTERNAL HOLDERS

FLER/L

90˚ for FLF/FLFD inserts

See coolant fed clamps available
(TF-CP clamps on page 60)





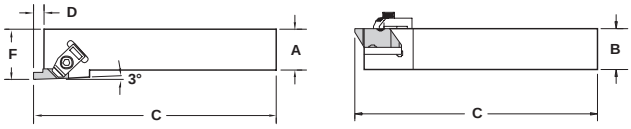
RH SHOWN

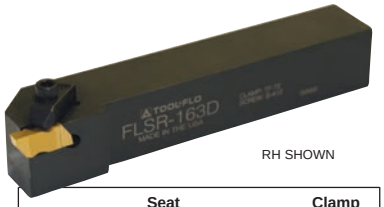
Description	EDP Code	Insert	A	B	C	D	F	H	Clamp	Clamp Screw
FLER-2020M3B	931020M16B	FL-3L	20.00	20.00	114.00	5.33	28.58	38.10	TF-73	SSM-51
FLEL-2020M3B	930020M16B	FL-3R	20.00	20.00	114.00	5.33	28.58	38.10	TF-72	SSM-51
FLER-2525M3D	931025M16D	FL-3L	25.00	25.00	152.00	5.33	31.75	50.80	TF-73	SSM-51
FLEL-2525M3D	930025M16D	FL-3R	25.00	25.00	152.00	5.33	31.75	50.80	TF-72	SSM-51
FLER-3232M3D	931032M16D	FL-3L	32.00	32.00	152.00	5.33	38.10	50.80	TF-73	SSM-51
FLEL-3232M3D	930032M16D	FL-3R	32.00	32.00	152.00	5.33	38.10	50.80	TF-72	SSM-51
FLER-2525M4D	931025M20D	FL-4L	25.00	25.00	152.00	7.37	34.93	50.80	TF-73	SSM-51
FLEL-2525M4D	930025M20D	FL-4R	25.00	25.00	152.00	7.37	34.93	50.80	TF-72	SSM-51
FLER-3232M4D	931032M20D	FL-4L	32.00	32.00	152.00	7.37	41.28	50.80	TF-73	SSM-51
FLEL-3232M4D	930032M20D	FL-4R	32.00	32.00	152.00	7.37	41.28	50.80	TF-72	SSM-51
FLER-3232M6D	931032M28D	FL-6L	32.00	32.00	152.00	7.37	41.28	50.80	TF-121	SSM-51
FLEL-3232M6D	930032M28D	FL-6R	32.00	32.00	152.00	7.37	41.28	50.80	TF-120	SSM-51

FLSR/L

Straight for FLF/FLFD inserts

See coolant fed clamps available
(TF-CP clamps on page 60)





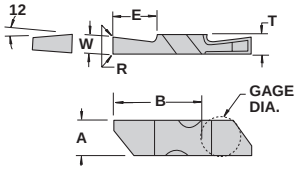
RH SHOWN

Description	EDP Code	Insert	A	B	C	D	F*	Seat	Seat Screw	Clamp	Clamp Screw
FLSR-2020M3B	934020M16B	FL-3R	20.00	20.00	114.00	5.33	25.40	---	---	TF-72	SSM-51
FLSL-2020M3B	933020M16B	FL-3L	20.00	20.00	114.00	5.33	25.40	---	---	TF-73	SSM-51
FLSR-2525M3C	934025M16C	FL-3R	25.00	25.00	127.00	5.33	31.75	---	---	TF-72	SSM-51
FLSL-2525M3C	933025M16C	FL-3L	25.00	25.00	127.00	5.33	31.75	---	---	TF-73	S-412
FLSR-2525M3D	934025M16D	FL-3R	25.00	25.00	152.00	5.33	31.75	---	---	TF-72	S-412
FLSL-2525M3D	933025M16D	FL-3L	25.00	25.00	152.00	5.33	31.75	---	---	TF-73	S-412
FLSR-3232M3D	934032M16D	FL-3R	32.00	32.00	152.00	5.33	38.10	---	---	TF-72	S-412
FLSL-3232M3D	933032M16D	FL-3L	32.00	32.00	152.00	5.33	38.10	---	---	TF-73	S-412
FLSR-2525M4D	934025M20D	FL-4R	25.00	25.00	152.00	7.37	31.75	SM-420	SL-344	TF-72	S-412
FLSL-2525M4D	933025M20D	FL-4L	25.00	25.00	152.00	7.37	31.75	SM-420	SL-344	TF-73	S-412
FLSR-3232M4D	934032M20D	FL-4R	32.00	32.00	152.00	7.37	38.10	SM-420	SL-344	TF-72	S-412
FLSL-3232M4D	933032M20D	FL-4L	32.00	32.00	152.00	7.37	38.10	SM-420	SL-344	TF-73	S-412
FLSR-3232M6D	934032M28D	FL-6R	32.00	32.00	152.00	7.37	38.10	SM-416	SL-111	TF-120	S-412
FLSL-3232M6D	933032M28D	FL-6L	32.00	32.00	152.00	7.37	38.10	SM-416	SL-111	TF-121	S-412

FACE/DEEP GROOVING

FLFT

Double ended - Deep Face Grooving



RH SHOWN

Description	EDP Code	W	R	T	E	A	B	Gage Dia	Uncoated C3	Uncoated C6H	TiN Coated GP3	TiN Coated GP50	AlTiN Coated AC3	AlTiN Coated AC50
FLFT-3125R	6339125R	3.18 (.125)	0.13/0.25	4.95	9.53	8.74	21.72	9.53			●	●	●	
FLFT-3125L	6339125L	3.18 (.125)	0.13/0.25	4.95	9.53	8.74	21.72	9.53			●	●	●	
FLFT-4189R	6349189R	4.80 (.189)	0.51/0.64	6.48	13.97	11.51	28.85	9.53			●	●	●	
FLFT-4189L	6349189L	4.80 (.189)	0.51/0.64	6.48	13.97	11.51	28.85	9.53			●	●	●	
FLFT-4250R	6349250R	6.35 (.250)	0.51/0.64	6.48	13.97	11.51	28.85	9.53			●	●	●	
FLFT-4250L	6349250L	6.35 (.250)	0.51/0.64	6.48	13.97	11.51	28.85	9.53			●	●	●	

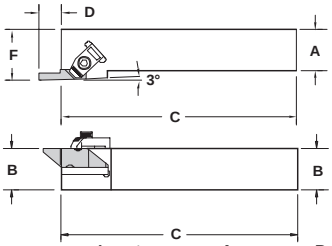
Cast Iron			▲		●	
Non-Ferrous		●		▲		
Stainless/High Temp		▲		●		
Steel			▲		●	

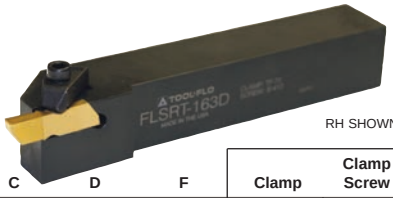
EXTERNAL HOLDERS

FLSRT/LT

Straight for FLFT inserts

See coolant fed clamps available
(TF-CP clamps on page 60)





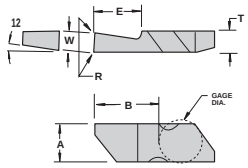
RH SHOWN

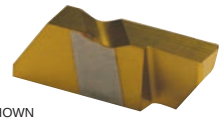
Description	EDP Code	Insert	A	B	C	D	F	Clamp	Clamp Screw
FLSRT-2525M3D	934325M16D	FL_T-3R	25.00	25.00	152.00	11.18	31.75	TF-72	SSM-51
FLSLT-2525M3D	934225M16D	FL_T-3L	25.00	25.00	152.00	11.18	31.75	TF-73	SSM-51
FLSRT-3232M3D	934332M16D	FL_T-3R	32.00	32.00	152.00	11.18	38.10	TF-72	SSM-51
FLSLT-3232M3D	934232M16D	FL_T-3L	32.00	32.00	152.00	11.18	38.10	TF-73	SSM-51
FLSRT-2525M4D	934325M20D	FL_T-4R	25.00	25.00	152.00	14.22	31.75	TF-72	SSM-51
FLSLT-2525M4D	934225M20D	FL_T-4L	25.00	25.00	152.00	14.22	31.75	TF-73	SSM-51
FLSRT-3232M4D	934332M20D	FL_T-4R	32.00	32.00	152.00	14.22	38.10	TF-72	SSM-51
FLSLT-3232M4D	934232M20D	FL_T-4L	32.00	32.00	152.00	14.22	38.10	TF-73	SSM-51

INTERNAL FACE GROOVING

FLFD-I

Single ended - Internal Deep/Face Grooving





RH SHOWN

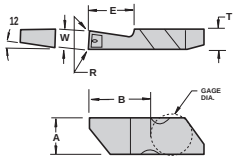
Description	EDP Code	W	R	T	E	A	B	Gage Dia	Uncoated C3	Uncoated C6H	TiN Coated GP3	TiN Coated GP50	AlTiN Coated AC3	AlTiN Coated AC50
FLFD-3125RI	6338125RI	3.18 (.125)	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	
FLFD-3125LI	6338125LI	3.18 (.125)	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	
FLFD-3189RI	6338189RI	4.80 (.189)	0.51/0.64	4.95	6.86	8.74	12.83	9.53			●	●	●	
FLFD-3189LI	6338189LI	4.80 (.189)	0.51/0.64	4.95	6.86	8.74	12.83	9.53			●	●	●	

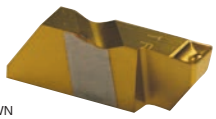
INTERNAL FACE GROOVING

FLFD-I-CB

Single ended - Internal Deep/Face Grooving
w/Patented chipbreaker

Exclusive patented design!





RH SHOWN

Description	EDP Code	W	R	T	E	A	B	Gage Dia	Uncoated C3	Uncoated C6H	TiN Coated GP3	TiN Coated GP50	AlTiN Coated AC3	AlTiN Coated AC50
FLFD-3125RI-CB	6338125PRI	3.18 (.125)	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	
FLFD-3125LI-CB	6338125PLI	3.18 (.125)	0.13/0.25	4.95	6.86	8.74	12.83	9.53			●	●	●	
FLFD-3189RI-CB	6338189PRI	4.80 (.189)	0.51/0.64	4.95	6.86	8.74	12.83	9.53			●	●	●	
FLFD-3189LI-CB	6338189PLI	4.80 (.189)	0.51/0.64	4.95	6.86	8.74	12.83	9.53			●	●	●	

In an effort to improve our stock standard grade offering, there are periodic changes.
Please see current price list for up to date grade offering.

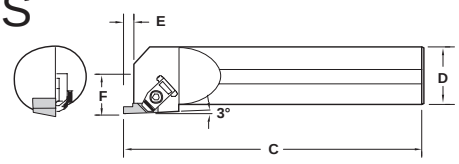
● High performance choice in optimal conditions.
▲ Recommended grade under general conditions.

Cast Iron			▲		●	
Non-Ferrous			●		▲	
Stainless/High Temp			▲		●	
Steel				▲		●

INTERNAL BARS

A-FLSR/L

For FLFD-I inserts
w/Coolant hole

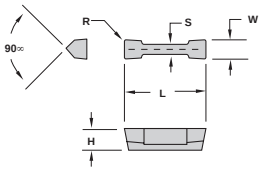


RH SHOWN

Description	EDP Code	Insert	Min. Bore	E	D	C	F	Clamp	Clamp Screw
A25M-FLSR3	965225M16	FLFD-3RI	57.15	7.37	25.00	300.00	16.26	TF-72	SSM-51
A25M-FLSL3	964225M16	FLFD-3LI	57.15	7.37	25.00	300.00	16.26	TF-73	SSM-51
A32M-FLSR3	965232M16	FLFD-3RI	57.15	7.37	32.00	350.00	19.43	TF-72	SSM-51
A32M-FLSL3	964232M16	FLFD-3LI	57.15	7.37	32.00	350.00	19.43	TF-73	SSM-51
A40M-FLSR3	965240M16	FLFD-3RI	57.15	7.37	40.00	350.00	22.61	TF-72	SSM-51
A40M-FLSL3	964240M16	FLFD-3LI	57.15	7.37	40.00	350.00	22.61	TF-73	SSM-51
A45M-FLSR3	965245M16	FLFD-3RI	57.15	7.37	45.00	350.00	25.78	TF-72	SSM-51
A45M-FLSL3	964245M16	FLFD-3LI	57.15	7.37	45.00	350.00	25.78	TF-73	SSM-51
A50M-FLSR3	965250M16	FLFD-3RI	60.33	7.37	50.00	400.00	32.54	TF-72	SSM-51
A50M-FLSL3	964250M16	FLFD-3LI	60.33	7.37	50.00	400.00	32.54	TF-73	SSM-51

FACE GROOVING

VDB



Description	EDP Code	W	R	L	H	S	Uncoated C25	Uncoated C3	TiN Coated GP3	TiN Coated GP50	AlTiN Coated AC3	AlTiN Coated AC50
VDB 125 A008	79125A08	3.18 (.125)	0.20	28.58	6.35	2.69				●		
VDB 125 A015	79125A	3.18 (.125)	0.38	28.58	6.35	2.69	●		●	●	●	●
VDB 156 A008	79156A08	3.96 (.156)	0.20	28.58	6.35	2.69				●		
VDB 156 A015	79156A	3.96 (.156)	0.38	28.58	6.35	2.69			●	●	●	●
VDB 188 A008	79188A08	4.78 (.188)	0.20	28.58	6.35	3.66	●			●		●
VDB 188 A015	79188A	4.78 (.188)	0.38	28.58	6.35	3.66	●		●	●	●	●
VDB 188 A031	79188A031	4.78 (.188)	0.79	28.58	6.35	3.66			●	●	●	●
VDB 218-A015	79218A	5.54 (.218)	0.38	28.58	6.35	3.66			●	●	●	●
VDB 250 A015	79250A	6.35 (.250)	0.38	28.58	6.35	3.66	●		●	●	●	●
VDB 250 B015	79250B	6.35 (.250)	0.38	28.58	8.56	3.66	●		●	●	●	●
VDB 250 B031	79250B031	6.35 (.250)	0.79	28.58	8.56	3.66			●	●	●	●
VDB 281 B015	79281B	7.14 (.281)	0.38	28.58	8.56	5.13				●	●	
VDB 312 B015	79312B	7.92 (.312)	0.38	28.58	8.56	5.13			●	●	●	●
VDB 312 B031	79312B031	7.92 (.312)	0.79	28.58	8.56	5.13			●	●	●	●
VDB 344 B015	79344B	8.74 (.344)	0.38	28.58	8.56	7.01				●		
VDB 344 B031	79344B031	8.74 (.344)	0.79	28.58	8.56	7.01				●		
VDB 375 B015	79375B	9.53 (.375)	0.38	28.58	8.56	7.01			●	●	●	●
VDB 375 B031	79375B031	9.53 (.375)	0.79	28.58	8.56	7.01				●	●	

In an effort to improve our stock standard grade offering, there are periodic changes.
Please see current price list for up to date grade offering.

● High performance choice in optimal conditions.
▲ Recommended grade under general conditions.

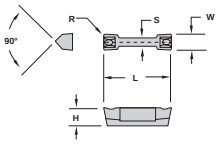
Cast Iron			▲		●	
Non-Ferrous		●		▲		
Stainless/High Temp		▲		●		
Steel			▲		●	

FACE GROOVING

VDB-CB

w/Patented chipbreaker

Exclusive patented design!



Description	EDP Code	W	R	L	H	S	Uncoated C25	Uncoated C3	TiN Coated GP3	TiN Coated GP50	AlTiN Coated AC3	AlTiN Coated AC50
VDB 125 A008-CB	79125A08P	3.18 (.125)	0.20	28.58	6.35	2.69				●		
VDB 125 A015-CB	79125AP	3.18 (.125)	0.38	28.58	6.35	2.69	●		●	●	●	●
VDB 156 A008-CB	79156A08P	3.96 (.156)	0.20	28.58	6.35	2.69				●		
VDB 156 A015-CB	79156AP	3.96 (.156)	0.38	28.58	6.35	2.69			●	●	●	●
VDB 188 A008-CB	79188A08P	4.78 (.188)	0.20	28.58	6.35	3.66	●					●
VDB 188 A015-CB	79188AP	4.78 (.188)	0.38	28.58	6.35	3.66	●		●	●	●	●
VDB 188 A031-CB	79188A031P	4.78 (.188)	0.79	28.58	6.35	3.66			●	●	●	●
VDB 218-A015-CB	79218AP	5.54 (.218)	0.38	28.58	6.35	3.66			●	●	●	●
VDB 250 B015-CB	79250BP	6.35 (.250)	0.38	28.58	8.56	3.66			●	●	●	●
VDB 250 B031-CB	79250B031P	6.35 (.250)	0.79	28.58	8.56	3.66			●	●	●	●
VDB 312 B015-CB	79312BP	7.92 (.312)	0.38	28.58	8.56	5.13			●		●	●
VDB 312 B031-CB	79312B031P	7.92 (.312)	0.79	28.58	8.56	5.13			●	●	●	●
VDB 375 B015-CB	79375BP	9.53 (.375)	0.38	28.58	8.56	7.01			●	●	●	●
VDB 375 B031-CB	79375B031P	9.53 (.375)	0.79	28.58	8.56	7.01			●	●	●	●

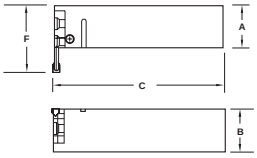
In an effort to improve our stock standard grade offering, there are periodic changes. Please see current price list for up to date grade offering.

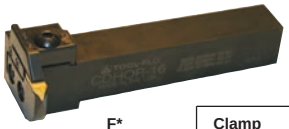
● High performance choice in optimal conditions.
▲ Recommended grade under general conditions.

Cast Iron			▲		●	
Non-Ferrous		●		▲		
Stainless/High Temp		▲		●		
Steel			▲		●	

EXTERNAL 90° HOLDER

CDHOR/L (RH HOLDERS USE LH COMPONENTS)





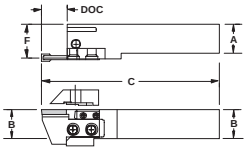
RH SHOWN

Description	EDP Code	A	B	C	F* .312(1)	F* .812(1)	Clamp Screw	Stop Screw	Anvil Screw
CDHOR-25M	921025M00	25.0	25.0	152.00	33.32	46.02	SB90	SS20	SF95
CDHOL-25M	920025M00	25.0	25.0	152.00	33.32	46.02	SB90	SS20	SF95
CDHOR-32M	921032M00	32.0	32.0	152.00	39.67	52.37	SB90	SS20	SF95
CDHOL-32M	920032M00	32.0	32.0	152.00	39.67	52.37	SB90	SS20	SF95
CDHOR-40M	921040M00	40.0	40.0	152.00	46.02	58.72	SB90	SS20	SF95
CDHOL-40M	920040M00	40.0	40.0	152.00	46.02	58.72	SB90	SS20	SF95

*The "f" dimension is determined by the D.O.C. of the anvil.

EXTERNAL STRAIGHT HOLDER

CDVOR/L (RH HOLDERS USE RH COMPONENTS)



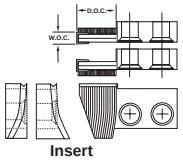
RH SHOWN

Description	EDP Code	A	B	C	F	Clamp Screw	Stop Screw	Anvil Screw
CDVOR-25M	924025M00	25.0	25.0	*	29.21	SBM90	SSM20	SFM95
CDVOL-25M	923025M00	25.0	25.0	*	29.21	SBM90	SSM20	SFM95
CDVOR-32M	924032M00	32.0	32.0	*	35.56	SBM90	SSM20	SFM95
CDVOL-32M	923032M00	32.0	32.0	*	35.56	SBM90	SSM20	SFM95
CDVOR-40M	924040M00	40.0	40.0	*	41.91	SBM90	SSM20	SFM95
CDVOL-40M	923040M00	40.0	40.0	*	41.91	SBM90	SSM20	SFM95

*The "C" dimension is determined by the D.O.C. of the anvil.

FACE GROOVING COMPONENTS

FOR CDHOR/L AND CDVOR/L



INSIDE

OUTSIDE

RH SHOWN

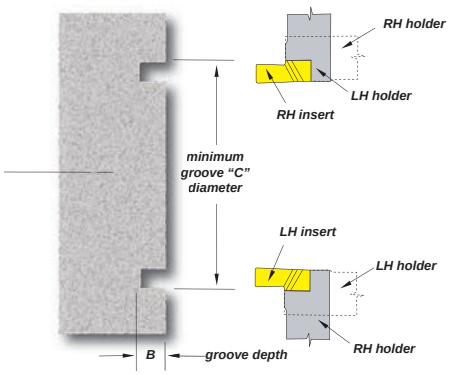
Description	EDP Code	Insert	Outside Dia. Range	DOC	WOC	Clamp	Stop Block
AFHR-128-I	91211281	DBP24/VDB125	69.85-76.20	16.51	2.67-3.18	CHRF-282I	SBH-2
AFHR-128-O	91211280	DBP24/VDB125	69.85-76.20	16.51	2.67-3.18	CHRF-282O	SBH-2
AFHL-128-I	91201281	DBP24/VDB125	69.85-76.20	16.51	2.67-3.18	CHLF-282I	SBH-2
AFHL-128-O	91201280	DBP24/VDB125	69.85-76.20	16.51	2.67-3.18	CHLF-282O	SBH-2
AFHR-138-I	91211381	DBP34/VDB188	76.20-101.60	16.51	4.32-4.78	CHRF-382I	SBH-2
AFHR-138-O	91211380	DBP34/VDB188	76.20-101.60	16.51	4.32-4.78	CHRF-382O	SBH-2
AFHL-138-I	91201381	DBP34/VDB188	76.20-101.60	16.51	4.32-4.78	CHLF-382I	SBH-2
AFHL-138-O	91201380	DBP34/VDB188	76.20-101.60	16.51	4.32-4.78	CHLF-382O	SBH-2
AFHR-148-I	91211481	VDB250A	76.20-101.60	20.62	5.59-6.35	CHRF-482I	SBH-1
AFHR-148-O	91211480	VDB250A	76.20-101.60	20.62	5.59-6.35	CHRF-482O	SBH-1
AFHL-148-I	91201481	VDB250A	76.20-101.60	20.62	5.59-6.35	CHLF-482I	SBH-1
AFHL-148-O	91201480	VDB250A	76.20-101.60	20.62	5.59-6.35	CHLF-482O	SBH-1
AFHR-248-I	91212481	DBP45/VDB250B	101.60-152.40	20.62	6.35-7.93	CHRF-482I	SBH-1
AFHR-248-O	91212480	DBP45/VDB250B	101.60-152.40	20.62	6.35-7.93	CHRF-482O	SBH-1
AFHL-248-I	91202481	DBP45/VDB250B	101.60-152.40	20.62	6.35-7.93	CHLF-482I	SBH-1
AFHL-248-O	91202480	DBP45/VDB250B	101.60-152.40	20.62	6.35-7.93	CHLF-482O	SBH-1
AFHR-268-I	91212681	DBP65/VDB375	152.40-304.80	20.62	8.89-9.53	CHRF-582I	SBH-1
AFHR-268-O	91212680	DBP65/VDB375	152.40-304.80	20.62	8.89-9.53	CHRF-582O	SBH-1
AFHL-268-I	91202681	DBP65/VDB375	152.40-304.80	20.62	8.89-9.53	CHLF-582I	SBH-1
AFHL-268-O	91202680	DBP65/VDB375	152.40-304.80	20.62	8.89-9.53	CHLF-582O	SBH-1

Guidelines for Face Grooving Operations

EXTERNAL

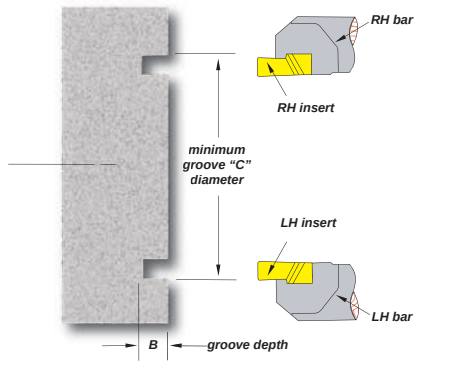
STANDARD FLF/FLFD INSERTS		
insert type	maximum groove depth "B"	minimum groove diameter "C"
FLF-3	1.52	23.88
FLF-3	2.29	30.48
FLF-3	3.18	36.07
FLF-3	3.81	41.28
FLFD-3	6.35	47.63
FLF-4/6	1.52	23.88
FLF-4/6	2.29	30.48
FLF-4/6	3.18	36.07
FLF-4/6	3.81	41.28
FLF-4/6	4.78	47.63
FLF-4/6	6.35	57.15
FLFD-4	9.53	57.15
FLFD-4	12.70	57.15

external toolholders

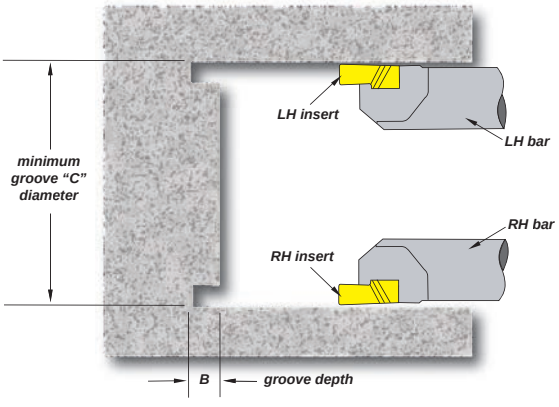


STANDARD FLG/FLGD INSERTS		
insert type	maximum groove depth "B"	minimum groove diameter "C"
FLG-2	1.52	53.98
FLG-2	2.39	88.90
FLG-3	2.39	101.60
FLG-3	3.18	127.00
FLG-3	3.81	139.70
FLGD-3	6.35	174.63
FLG-4	3.81	152.40
FLG-4	6.35	209.55
FLGD-4	9.53	222.25
FLGD-4	12.70	222.25
FLG-5	9.53	330.20

internal bars



INTERNAL

insert type	maximum groove depth "D"	minimum groove diameter "E"
FLFD-3-R	6.35	57.15 Also check minimum bore diameter of boring bar.

internal bars