



TOOL FLO

**FACE
GROOVING**

FACE GROOVING



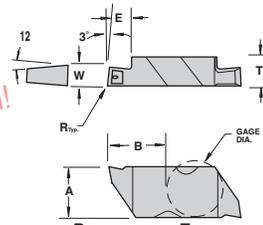
FACE GROOVING

FLF-CB

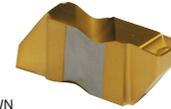
w/Patented chipbreaker

■ For holders see next page.

Exclusive patented design!



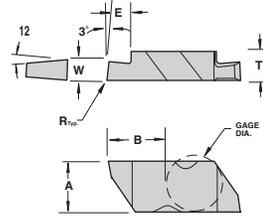
RH SHOWN



Description	EDP Code	W	R	T	E	A	B	Gage Dia	Coating					
									C3	C6H	GP3	GP50	AC3	AC50
FLF-3125R-CB	563025PR	.125	.005/.010	.195	.180	.344	.4050	.3750			●	●	●	●
FLF-3125L-CB	563025PL	.125	.005/.010	.195	.180	.344	.4050	.3750			●	●	●	●
FLF-3156R-CB	563056PR	.156	.005/.010	.195	.180	.344	.4050	.3750			●	●	●	●
FLF-3156L-CB	563056PL	.156	.005/.010	.195	.180	.344	.4050	.3750			●	●	●	●
FLF-3188R-CB	563088PR	.188	.020/.025	.195	.180	.344	.4050	.3750			●	●	●	●
FLF-3188L-CB	563088PL	.188	.020/.025	.195	.180	.344	.4050	.3750			●	●	●	●

FLF

■ For holders see next page.



RH SHOWN

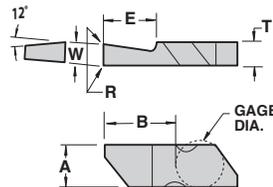


Description	EDP Code	W	R	T	E	A	B	Gage Dia	Coating					
									C3	C6H	GP3	GP50	AC3	AC50
FLF-3125R	563025R	.125	.005/.010	.195	.180	.344	.4050	.3750			●	●	●	●
FLF-3125L	563025L	.125	.005/.010	.195	.180	.344	.4050	.3750			●	●	●	●
FLF-3156R	563056R	.156	.005/.010	.195	.180	.344	.4050	.3750			●	●	●	●
FLF-3156L	563056L	.156	.005/.010	.195	.180	.344	.4050	.3750			●	●	●	●
FLF-3188R	563088R	.188	.020/.025	.195	.180	.344	.4050	.3750			●	●	●	●
FLF-3188L	563088L	.188	.020/.025	.195	.180	.344	.4050	.3750			●	●	●	●
FLF-4250R	564250R	.250	.020/.025	.255	.290	.453	.6360	.3750			●	●	●	●
FLF-4250L	564250L	.250	.020/.025	.255	.290	.453	.6360	.3750			●	●	●	●
FLF-6218R	566218R	.218	.030/.035	.383	.290	.453	.6360	.3750						
FLF-6218L	566218L	.218	.030/.035	.383	.290	.453	.6360	.3750						
FLF-6250R	566250R	.250	.030/.035	.383	.290	.453	.6360	.3750						
FLF-6250L	566250L	.250	.030/.035	.383	.290	.453	.6360	.3750						
FLF-6375R	566475R	.375	.030/.035	.383	.290	.453	.6360	.3750						
FLF-6375L	566475L	.375	.030/.035	.383	.290	.453	.6360	.3750						

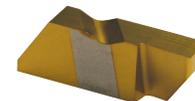
FLFD

Single ended - Deep Grooving

■ For holders see next page.



RH SHOWN



Description	EDP Code	W	R	T	E	A	B	Gage Dia	Coating					
									C3	C6H	GP3	GP50	AC3	AC50
FLFD-3125R	6338125R	.125	.005/.010	.195	.270	.344	.5050	.3750			●	●	●	●
FLFD-3125L	6338125L	.125	.005/.010	.195	.270	.344	.5050	.3750			●	●	●	●
FLFD-4189R	6348189R	.189	.020/.025	.255	.390	.453	.7610	.3750			●	●	●	●
FLFD-4189L	6348189L	.189	.020/.025	.255	.390	.453	.7610	.3750			●	●	●	●
FLFD-4250R	6348250R	.250	.020/.025	.255	.520	.453	.8860	.3750			●	●	●	●
FLFD-4250L	6348250L	.250	.020/.025	.255	.520	.453	.8860	.3750			●	●	●	●

FLFD-CB

Single ended - Deep Grooving

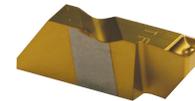
w/Patented chipbreaker

■ For holders see next page.

Exclusive patented design!



RH SHOWN



Description	EDP Code	W	R	T	E	A	B	Gage Dia	Coating					
									C3	C6H	GP3	GP50	AC3	AC50
FLFD-3125R-CB	6338125PR	.125	.005/.010	.195	.270	.344	.5050	.3750			●	●	●	●
FLFD-3125L-CB	6338125PL	.125	.005/.010	.195	.270	.344	.5050	.3750			●	●	●	●
FLFD-4189R-CB	6348189PR	.189	.020/.025	.255	.390	.453	.7610	.3750			●	●	●	●
FLFD-4189L-CB	6348189PL	.189	.020/.025	.255	.390	.453	.7610	.3750			●	●	●	●
FLFD-4250R-CB	6348250PR	.250	.020/.025	.255	.500	.453	.8860	.3750			●	●	●	●
FLFD-4250L-CB	6348250PL	.250	.020/.025	.255	.500	.453	.8860	.3750			●	●	●	●

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.

Material	C3	C6H	GP3	GP50	AC3	AC50
Cast Iron			▲			●
Non-Ferrous		●		▲		
Stainless/High Temp		▲		●		
Steel			▲		●	



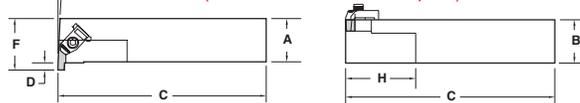
FACE GROOVING

EXTERNAL HOLDERS

Most holders available with coolant port
(ie: Add CP to end of description)

FLER/L

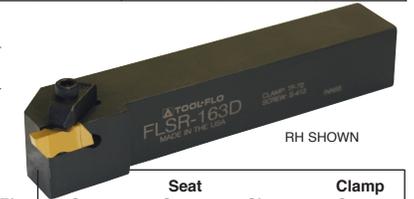
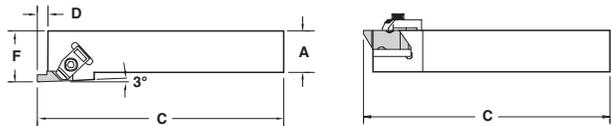
90° for FLF/FLFD inserts



Description	EDP Code	Insert	A	B	C	D	F	H	Clamp	Clamp Screw
FLER-123B	93101216B	FL-3L	.750	.750	4.500	.210	1.125	1.500	TF-73	S-412
FLER-123B	93001216B	FL-3R	.750	.750	4.500	.210	1.125	1.500	TF-72	S-412
FLER-163D	93101616D	FL-3L	1.000	1.000	6.000	.210	1.250	2.000	TF-73	S-412
FLER-163D	93001616D	FL-3R	1.000	1.000	6.000	.210	1.250	2.000	TF-72	S-412
FLER-203D	93102016D	FL-3L	1.250	1.250	6.000	.210	1.500	2.000	TF-73	S-412
FLER-203D	93002016D	FL-3R	1.250	1.250	6.000	.210	1.500	2.000	TF-72	S-412
FLER-164D	93101620D	FL-4L	1.000	1.000	6.000	.290	1.375	2.000	TF-73	S-412
FLER-164D	93001620D	FL-4R	1.000	1.000	6.000	.290	1.375	2.000	TF-72	S-412
FLER-204D	93102020D	FL-4L	1.250	1.250	6.000	.290	1.625	2.000	TF-73	S-412
FLER-204D	93002020D	FL-4R	1.250	1.250	6.000	.290	1.625	2.000	TF-72	S-412
FLER-206D	93102028D	FL-6L	1.250	1.250	6.000	.290	1.625	2.000	TF-121	S-412
FLER-206D	93002028D	FL-6R	1.250	1.250	6.000	.290	1.625	2.000	TF-120	S-412

FLSR/L

Straight for FLF/FLFD inserts



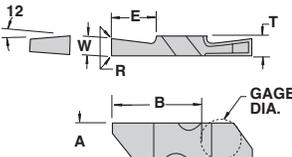
Most holders available with coolant port (ie: Add CP to end of description)

Description	EDP Code	Insert	A	B	C	D	F*	Seat	Seat Screw	Clamp	Clamp Screw
FLSR-123B	93401216B	FL-3R	.750	.750	4.500	.210	1.000	---	---	TF-72	S-412
FLSL-123B	93301216B	FL-3L	.750	.750	4.500	.210	1.000	---	---	TF-73	S-412
FLSR-163C	93401616C	FL-3R	1.000	1.000	5.000	.210	1.250	---	---	TF-72	S-412
FLSL-163C	93301616C	FL-3L	1.000	1.000	5.000	.210	1.250	---	---	TF-73	S-412
FLSR-163D	93401616D	FL-3R	1.000	1.000	6.000	.210	1.250	---	---	TF-72	S-412
FLSL-163D	93301616D	FL-3L	1.000	1.000	6.000	.210	1.250	---	---	TF-73	S-412
FLSR-203D	93402016D	FL-3R	1.250	1.250	6.000	.210	1.500	---	---	TF-72	S-412
FLSL-203D	93302016D	FL-3L	1.250	1.250	6.000	.210	1.500	---	---	TF-73	S-412
FLSR-164D	93401620D	FL-4R	1.000	1.000	6.000	.290	1.250	SM-420	SL-344	TF-72	S-412
FLSL-164D	93301620D	FL-4L	1.000	1.000	6.000	.290	1.250	SM-420	SL-344	TF-73	S-412
FLSR-204D	93402020D	FL-4R	1.250	1.250	6.000	.290	1.500	SM-420	SL-344	TF-72	S-412
FLSL-204D	93302020D	FL-4L	1.250	1.250	6.000	.290	1.500	SM-420	SL-344	TF-73	S-412
FLSR-206D	93402028D	FL-6R	1.250	1.250	6.000	.290	1.500	SM-416	SL-111	TF-120	S-412
FLSL-206D	93302028D	FL-6L	1.250	1.250	6.000	.290	1.500	SM-416	SL-111	TF-121	S-412

FACE/DEEP GROOVING

FLFT

Double ended - Deep Face Grooving

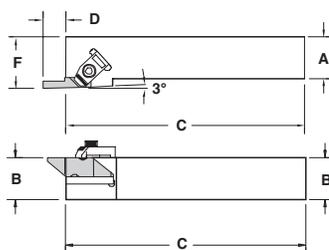


Description	EDP Code	W	R	T	E	A	B	Gage Dia	Coating					
									C3	C6H	GP3	GP50	AC3	AC50
FLFT-3125R	6339125R	.125	.005/.010	.195	.375	.344	.855	.3750						
FLFT-3125L	6339125L	.125	.005/.010	.195	.375	.344	.855	.3750			●	●	●	
FLFT-4189R	6349189R	.189	.020/.025	.255	.550	.453	1.136	.3750			●	●	●	
FLFT-4189L	6349189L	.189	.020/.025	.255	.550	.453	1.136	.3750			●	●	●	
FLFT-4250R	6349250R	.250	.020/.025	.255	.550	.453	1.136	.3750			●	●	●	
FLFT-4250L	6349250L	.250	.020/.025	.255	.550	.453	1.136	.3750			●	●	●	

EXTERNAL HOLDERS

FLSRT/LT

Straight for FLFT inserts



	Uncoated	TIN Coated	AITN Coated
Cast Iron		▲	●
Non-Ferrous	●	▲	
Stainless/High Temp	▲	●	
Steel		▲	●



Description	EDP Code	Insert	A	B	C	D	F	Clamp	Clamp Screw
FLSRT-163D	93431616D	FL_T-3R	1.000	1.000	6.000	.440	1.250	TF-72	S-412
FLSLT-163D	93421616D	FL_T-3L	1.000	1.000	6.000	.440	1.250	TF-73	S-412
FLSRT-203D	93432016D	FL_T-3R	1.250	1.250	6.000	.440	1.500	TF-72	S-412
FLSLT-203D	93422016D	FL_T-3L	1.250	1.250	6.000	.440	1.500	TF-73	S-412
FLSRT-164D	93431620D	FL_T-4R	1.000	1.000	6.000	.560	1.250	TF-72	S-412
FLSLT-164D	93421620D	FL_T-4L	1.000	1.000	6.000	.560	1.250	TF-73	S-412
FLSRT-204D	93432020D	FL_T-4R	1.250	1.250	6.000	.560	1.500	TF-72	S-412
FLSLT-204D	93422020D	FL_T-4L	1.250	1.250	6.000	.560	1.500	TF-73	S-412

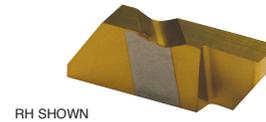
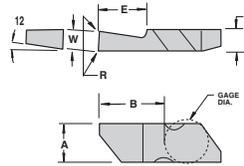
FACE GROOVING



INTERNAL FACE GROOVING

FLFD-I

Single ended - Internal Deep/Face Grooving



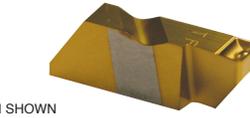
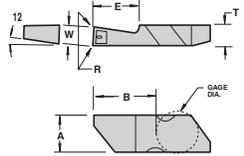
Description	EDP Code	W	R	T	E	A	B	Gage Dia	Coatings						
									C3	C6H	GP3	GP50	AC3	AC50	
FLFD-3125RI	6338125RI	.125	.005/.010	.195	.270	.344	.5050	.3750							
FLFD-3125LI	6338125LI	.125	.005/.010	.195	.270	.344	.5050	.3750			●	●	●	●	
FLFD-3189RI	6338189RI	.189	.020/.025	.195	.270	.344	.5050	.3750			●	●	●	●	
FLFD-3189LI	6338189LI	.189	.020/.025	.195	.270	.344	.5050	.3750			●	●	●	●	

INTERNAL FACE GROOVING

FLFD-I-CB

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

Exclusive patented design!



Description	EDP Code	W	R	T	E	A	B	Gage Dia	Coatings						
									C3	C6H	GP3	GP50	AC3	AC50	
FLFD-3125RI-CB	6338125PRI	.125	.005/.010	.195	.270	.344	.5050	.3750			●	●	●	●	
FLFD-3125LI-CB	6338125PLI	.125	.005/.010	.195	.270	.344	.5050	.3750			●	●	●	●	
FLFD-3189RI-CB	6338189PRI	.189	.020/.025	.195	.270	.344	.5050	.3750			●	●	●	●	
FLFD-3189LI-CB	6338189PLI	.189	.020/.025	.195	.270	.344	.5050	.3750			●	●	●	●	

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.

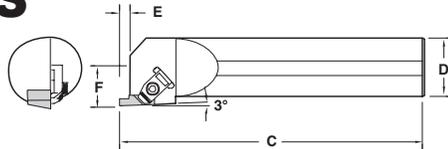
- High performance choice in optimal conditions.
- ▲ Recommended grade under general conditions.

Material	C3	C6H	GP3	GP50	AC3	AC50
Cast Iron			▲			●
Non-Ferrous		●		▲		
Stainless/High Temp		▲		●		
Steel			▲			●

INTERNAL BARS

A-FLSR/L

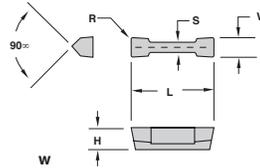
For FLFD-I inserts w/Coolant hole



Description	EDP Code	Insert	Min. Bore	E	D	C	F	Clamp	
								Clamp	Screw
A16-FLSR3	96521616	FLFD-3RI	2.250	.290	1.000	12.000	.640	TF-72	S-412
A16-FLSL3	96421616	FLFD-3LI	2.250	.290	1.000	12.000	.640	TF-73	S-412
A20-FLSR3	96522016	FLFD-3RI	2.250	.290	1.250	14.000	.765	TF-72	S-412
A20-FLSL3	96422016	FLFD-3LI	2.250	.290	1.250	14.000	.765	TF-73	S-412
A24-FLSR3	96522416	FLFD-3RI	2.250	.290	1.500	14.000	.890	TF-72	S-412
A24-FLSL3	96422416	FLFD-3LI	2.250	.290	1.500	14.000	.890	TF-73	S-412
A28-FLSR3	96522816	FLFD-3RI	2.250	.290	1.750	14.000	1.015	TF-72	S-412
A28-FLSL3	96422816	FLFD-3LI	2.250	.290	1.750	14.000	1.015	TF-73	S-412
A32-FLSR3	96523216	FLFD-3RI	2.375	.290	2.000	16.000	1.281	TF-72	S-412
A32-FLSL3	96423216	FLFD-3LI	2.375	.290	2.000	16.000	1.281	TF-73	S-412

FACE GROOVING

VDB



Description	EDP Code	Inch	Metric	R	L	H	S	Coatings						
								C25	C3	GP3	GP50	AC3	AC50	
VDB 125 A008	79125A08	.125	3,18	.008	1.125	.250	.106							
VDB 125 A015	79125A	.125	3,18	.015	1.125	.250	.106	●						
VDB 156 A008	79156A08	.156	3,96	.008	1.125	.250	.106							
VDB 156 A015	79156A	.156	3,96	.015	1.125	.250	.106							
VDB 188 A008	79188A08	.188	4,78	.008	1.125	.250	.144	●						
VDB 188 A015	79188A	.188	4,78	.015	1.125	.250	.144	●						
VDB 188 A031	79188A031	.188	4,78	.031	1.125	.250	.144							
VDB 218-A015	79218A	.218	5,54	.015	1.125	.250	.144							
VDB 250 A015	79250A	.250	6,35	.015	1.125	.250	.144	●						
VDB 250 B015	79250B	.250	6,35	.015	1.125	.337	.144	●						
VDB 250 B031	79250B031	.250	6,35	.031	1.125	.337	.144							
VDB 281 B015	79281B	.281	7,14	.015	1.125	.337	.202							
VDB 312 B015	79312B	.312	7,92	.015	1.125	.337	.202							
VDB 312 B031	79312B031	.312	7,92	.031	1.125	.337	.202							
VDB 344 B015	79344B	.344	8,74	.015	1.125	.337	.276							
VDB 344 B031	79344B031	.344	8,74	.031	1.125	.337	.276							
VDB 375 B015	79375B	.375	9,53	.015	1.125	.337	.276							
VDB 375 B031	79375B031	.375	9,53	.031	1.125	.337	.276							

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

Material	C25	C3	GP3	GP50	AC3	AC50
Cast Iron			▲			●
Non-Ferrous		●		▲		
Stainless/High Temp		▲		●		
Steel			▲			●

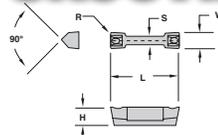


FACE GROOVING

FACE GROOVING VDB-CB

w/Patented chipbreaker

Exclusive patented design!



Description	EDP Code	Inch	Metric	R	L	H	S	Coatings					
								C25	C3	GP3	GP50	AC3	AC50
VDB 125 A008-CB	79125A08P	.125	3,18	.008	1.125	.250	.106	●			●	●	●
VDB 125 A015-CB	79125AP	.125	3,18	.015	1.125	.250	.106	●			●	●	●
VDB 156 A008-CB	79156A08P	.156	3,96	.008	1.125	.250	.106				●	●	●
VDB 156 A015-CB	79156AP	.156	3,96	.015	1.125	.250	.106				●	●	●
VDB 188 A008-CB	79188A08P	.188	4,78	.008	1.125	.250	.144				●	●	●
VDB 188 A015-CB	79188AP	.188	4,78	.015	1.125	.250	.144	●			●	●	●
VDB 188 A031-CB	79188A031P	.188	4,78	.031	1.125	.250	.144				●	●	●
VDB 218-A015-CB	79218AP	.218	5,54	.015	1.125	.250	.144				●	●	●
VDB 250 B015-CB	79250BP	.250	6,35	.015	1.125	.337	.144				●	●	●
VDB 250 B031-CB	79250B031P	.250	6,35	.031	1.125	.337	.144				●	●	●
VDB 312 B015-CB	79312BP	.312	7,92	.015	1.125	.337	.202				●	●	●
VDB 312 B031-CB	79312B031P	.312	7,92	.031	1.125	.337	.202				●	●	●
VDB 375 B015-CB	79375BP	.375	9,53	.015	1.125	.337	.276				●	●	●
VDB 375 B031-CB	79375B031P	.375	9,53	.031	1.125	.337	.276				●	●	●

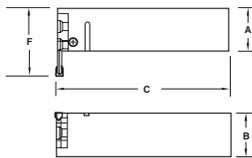
In an effort to improve our stock standard grade offering, there are periodic changes. Please see current price list for up to date grade offering.

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

Material	C25	C3	GP3	GP50	AC3	AC50
Cast Iron			▲			●
Non-Ferrous		●		▲		
Stainless/High Temp		▲		▲		
Steel			▲		●	

EXTERNAL 90° HOLDER

CDHOR/L (RH HOLDERS USE LH COMPONENTS)



RH SHOWN

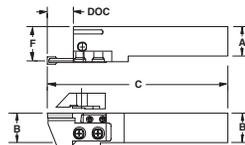
Metric holders on page 216.

Description	EDP Code	A	B	C	F*		Clamp Screw	Stop Screw	Anvil Screw
					.312(1)	.812(1)			
CDHOR-16	92101600	1	1	6	1.312	1.812	SB90	SS20	SF95
CDHOL-16	92001600	1	1	6	1.312	1.812	SB90	SS20	SF95
CDHOR-20	92102000	1-1/4	1-1/4	6	1.562	2.062	SB90	SS20	SF95
CDHOL-20	92002000	1-1/4	1-1/4	6	1.562	2.062	SB90	SS20	SF95
CDHOR-24	92102400	1-1/2	1-1/2	6	1.812	2.312	SB90	SS20	SF95
CDHOL-24	92002400	1-1/2	1-1/2	6	1.812	2.312	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)



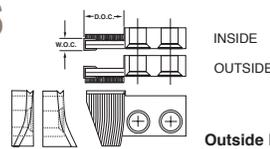
RH SHOWN

Metric holders on page 216.

Description	EDP Code	A	B	C	F	Clamp Screw	Stop Screw	Anvil Screw
CDVOL-16	92301600	1	1	*	1.150	SB90	SS20	SF95
CDVOR-20	92402000	1-1/4	1-1/4	*	1.400	SB90	SS20	SF95
CDVOL-20	92302000	1-1/4	1-1/4	*	1.400	SB90	SS20	SF95
CDVOR-24	92402400	1-1/2	1-1/2	*	1.650	SB90	SS20	SF95
CDVOL-24	92302400	1-1/2	1-1/2	*	1.650	SB90	SS20	SF95

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

FACE GROOVING COMPONENTS FOR CDHOR/L AND CDVOR/L



RH SHOWN

Description	EDP Code	Insert	Range	DOC	WOC	Clamp	Stop Block
AFHR-128-O	91211280	DBP24/VDB125	2.750-3.000	.650	.105-.125	CHRF-282O	SBH-2
AFHL-128-I	91201281	DBP24/VDB125	2.750-3.000	.650	.105-.125	CHLF-282I	SBH-2
AFHL-128-O	91201280	DBP24/VDB125	2.750-3.000	.650	.105-.125	CHLF-282O	SBH-2
AFHR-138-I	91211381	DBP34/VDB188	3.000-4.000	.650	.170-.188	CHRF-382I	SBH-2
AFHR-138-O	91211380	DBP34/VDB188	3.000-4.000	.650	.170-.188	CHRF-382O	SBH-2
AFHL-138-I	91201381	DBP34/VDB188	3.000-4.000	.650	.170-.188	CHLF-382I	SBH-2
AFHL-138-O	91201380	DBP34/VDB188	3.000-4.000	.650	.170-.188	CHLF-382O	SBH-2
AFHR-148-I	91211481	VDB250A	3.000-4.000	.812	.220-.250	CHRF-482I	SBH-1
AFHR-148-O	91211480	VDB250A	3.000-4.000	.812	.220-.250	CHRF-482O	SBH-1
AFHL-148-I	91201481	VDB250A	3.000-4.000	.812	.220-.250	CHLF-482I	SBH-1
AFHL-148-O	91201480	VDB250A	3.000-4.000	.812	.220-.250	CHLF-482O	SBH-1
AFHR-248-I	91212481	DBP45/VDB250B	4.000-6.000	.812	.250-.312	CHRF-482I	SBH-1
AFHR-248-O	91212480	DBP45/VDB250B	4.000-6.000	.812	.250-.312	CHRF-482O	SBH-1
AFHL-248-I	91202481	DBP45/VDB250B	4.000-6.000	.812	.250-.312	CHLF-482I	SBH-1
AFHL-248-O	91202480	DBP45/VDB250B	4.000-6.000	.812	.250-.312	CHLF-482O	SBH-1
AFHR-268-I	91212681	DBP65/VDB375	6.000-12.000	.812	.350-.375	CHRF-582I	SBH-1
AFHR-268-O	91212680	DBP65/VDB375	6.000-12.000	.812	.350-.375	CHRF-582O	SBH-1
AFHL-268-I	91202681	DBP65/VDB375	6.000-12.000	.812	.350-.375	CHLF-582I	SBH-1
AFHL-268-O	91202680	DBP65/VDB375	6.000-12.000	.812	.350-.375	CHLF-582O	SBH-1

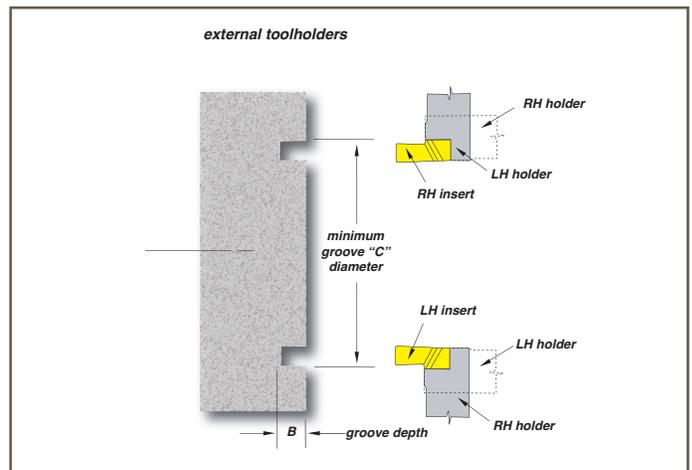


Guidelines for Face Grooving Operations

EXTERNAL

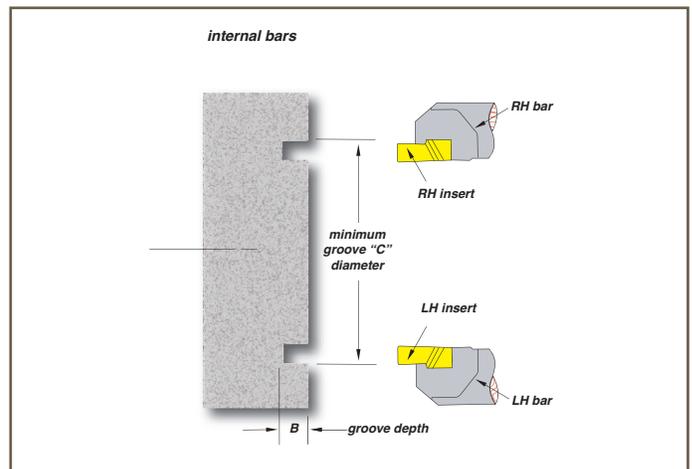
STANDARD FLF/FLFD INSERTS

insert type	maximum groove depth "B"	minimum groove diameter "C"
FLF-3	.060	.940
FLF-3	.090	1.200
FLF-3	.125	1.420
FLF-3	.150	1.625
FLFD-3	.250	1.875
FLF-4/6	.060	.940
FLF-4/6	.090	1.200
FLF-4/6	.125	1.420
FLF-4/6	.150	1.625
FLF-4/6	.188	1.875
FLF-4/6	.250	2.250
FLFD-4	.375	2.250
FLFD-4	.500	2.250



STANDARD FLG/FLGD INSERTS

insert type	maximum groove depth "B"	minimum groove diameter "C"
FLG-2	.060	2.125
FLG-2	.094	3.500
FLG-3	.094	4.000
FLG-3	.125	5.000
FLG-3	.150	5.500
FLGD-3	.250	6.875
FLG-4	.150	6.000
FLG-4	.250	8.250
FLGD-4	.375	8.750
FLGD-4	.500	8.750
FLG-5	.375	13.000



INTERNAL

insert type	maximum groove depth "D"	minimum groove diameter "E"
FLFD-3-R	.250	2.250 Also check minimum bore diameter of boring bar.

