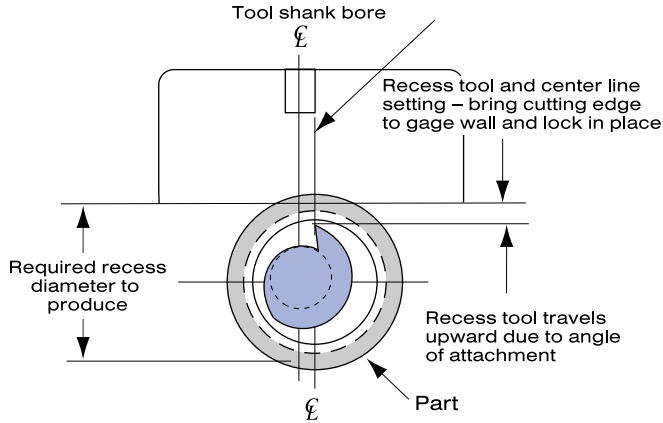
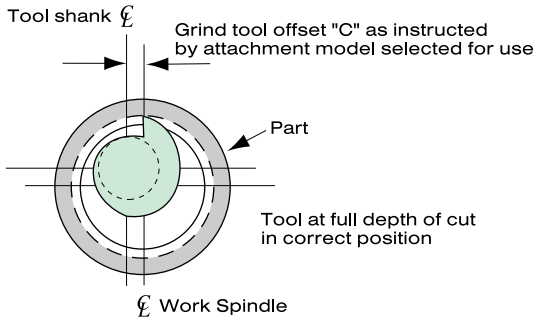


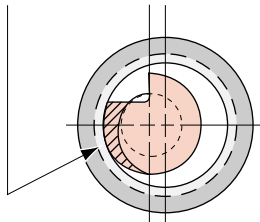
HOOK RAKE TOOL GEOMETRY



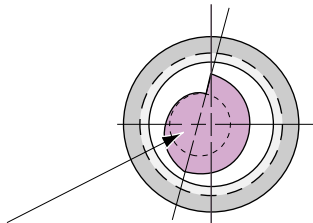
STANDARD STRAIGHT RAKE TOOL GEOMETRY



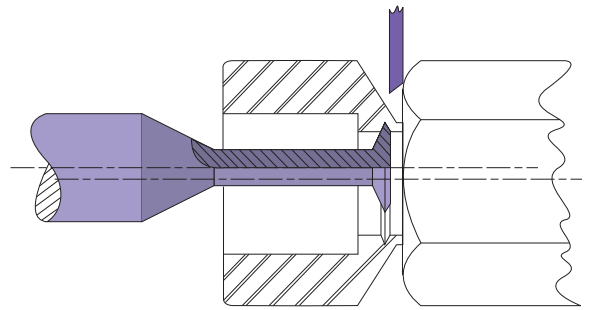
Remove shaded area by hand grinding, tool shank will rub due to lack of clearance



Properly ground tool with cutting edge offset according to size of holder provides peripheral clearance needed on circular tools.



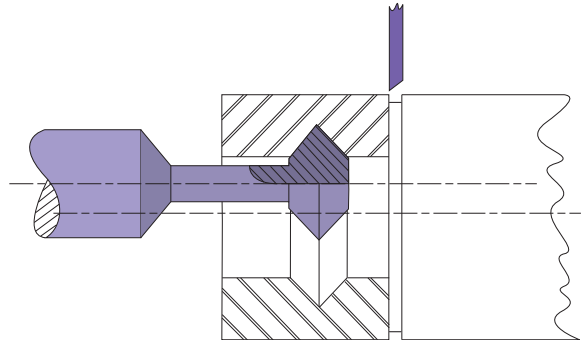
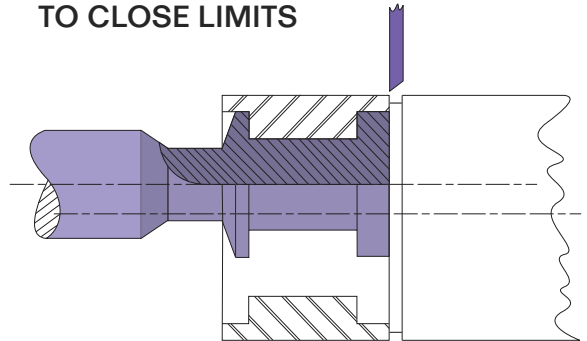
Cutting edge ground to centerline of tool shank when rotated to centerline of work gives negative rake. Suggested on softer materials when negative rake is desired.



RECESS CHAMFER BEFORE CUTOFF

When recessing adjust recess tool from line of cut-off blade to .005 beyond (maximum) .002 to .005 flat on crest of recess tool.

RECESS & SIZING SHOULDER TO CLOSE LIMITS



RECESS "V" GROOVE

