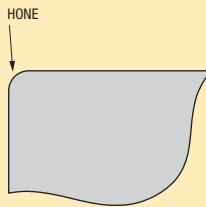
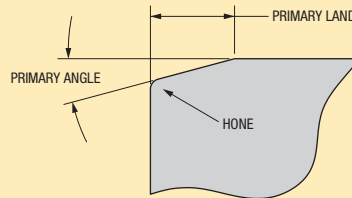


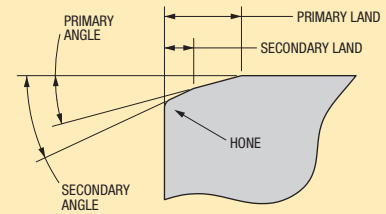
Edge Preparation and Application Guide



HONE



PRIMARY ANGLE



SECONDARY ANGLE

Edge Prep	Hone	Primary Land	Primary Angle	Application
A	.0005 - .001" R.			For light finishing and grooving, also added to designated negative lands (i.e. T1, T2, T9).
T1		.002 - .004"	20°	General purpose for turning and light milling in clean high-temp. alloys and materials <50R/C.
T1A	.0005 - .001" R.	.002 - .004"	20°	Used where more protection is needed than T1 such as in scale and light interruptions, hard turning.
T2		.006 - .008"	20°	General purpose chamfer for light to medium feed rates, cast-iron machining.
T2A	.0005 - .001" R.	.006 - .008"	20°	Scale applications, light interruptions, weld overlays, finish turning and milling of hardened materials.

Tolerance on land angles is +/- 1/2°, except T1 is +/- 1°.

Tolerance on land widths not specified is +/- .001".

See page ATI 19 for other Greenleaf edge preps or call Greenleaf Technical Service for application concerns.