

Cutting Off and Grooving System **GY/GW Series**

Monoblock Holder for Swiss-Type Automatic Lathes

Series
Expansion

Solutions to Cutting Off Problems

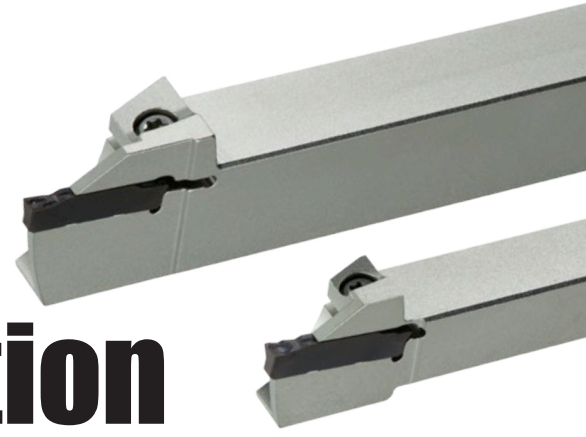
New high rigidity geometry is ideal for
deep grooving.

Grooving System

GY Series

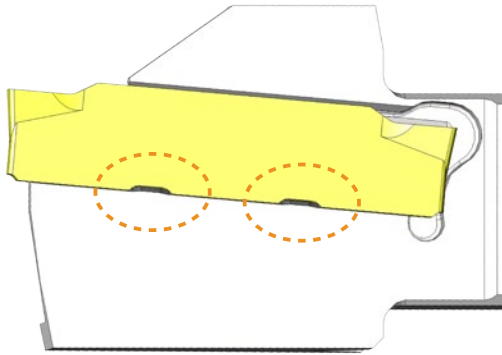
Grooving Revolution

Innovative clamping system ensures reliable grooving.

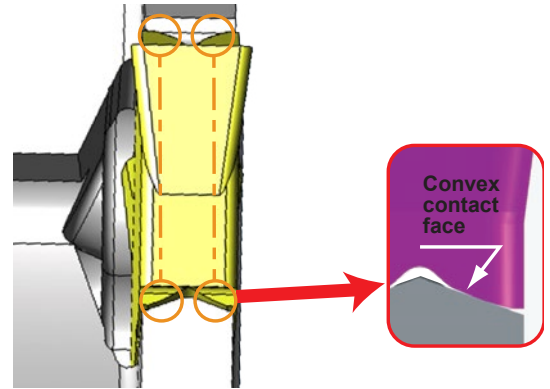


Highly Reliable Insert Clamp

The safety key locks the insert and prevents movement.



The convex geometry ensures high precision clamping.

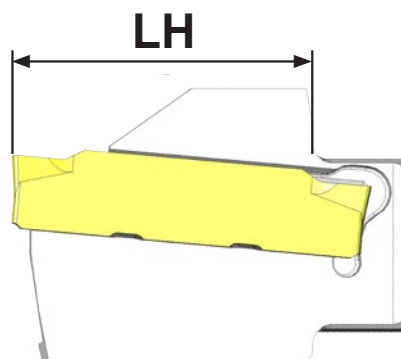


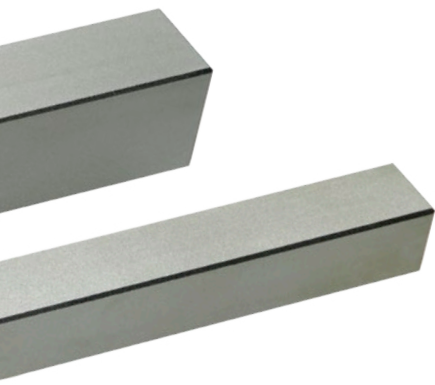
Monoblock Holder for Swiss-Type Automatic Lathes

The new geometry with greatly improved rigidity suppresses vibrations and dimensional changes, thereby solving common cutting off problems.

Overhang Length Compatible with Swiss-Type Automatic Lathes

Head length corresponding to the maximum machining diameter of CNC Swiss-type automatic lathes and turret machines.

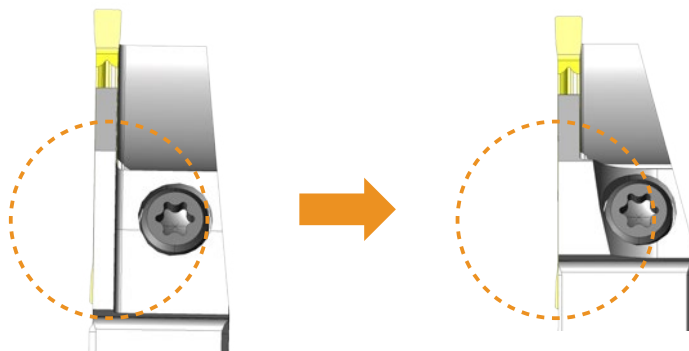




Features of the High Rigidity Holder

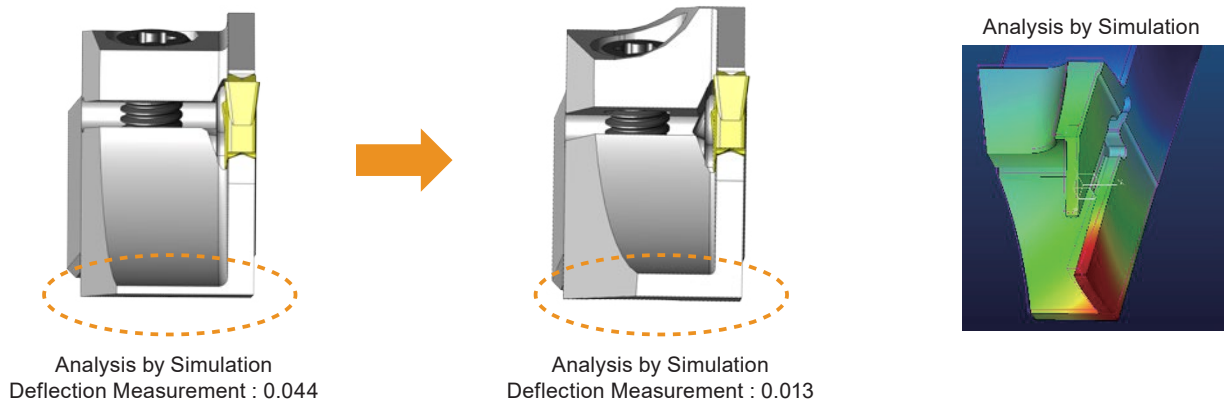
Strong Clamp Bridge

The strong design of the clamp bridge suppresses chatter and vibration.



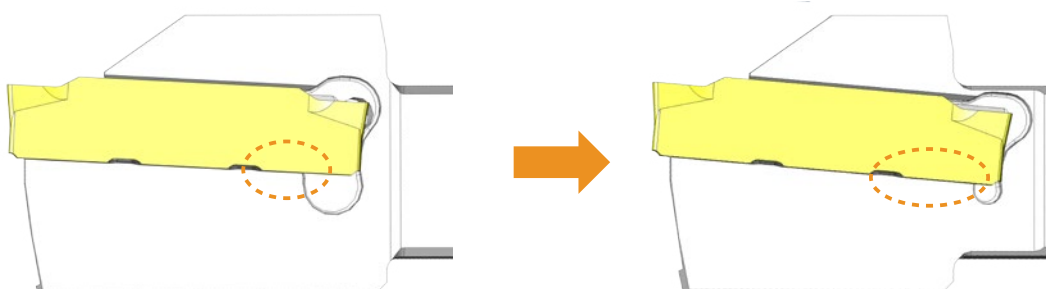
Thicker Tool Base

Tool deflection caused by cutting resistance is greatly reduced.



Strengthening of the Insert Clamp

The seating face of the insert becomes wider, reducing the deformation of the workpiece material.

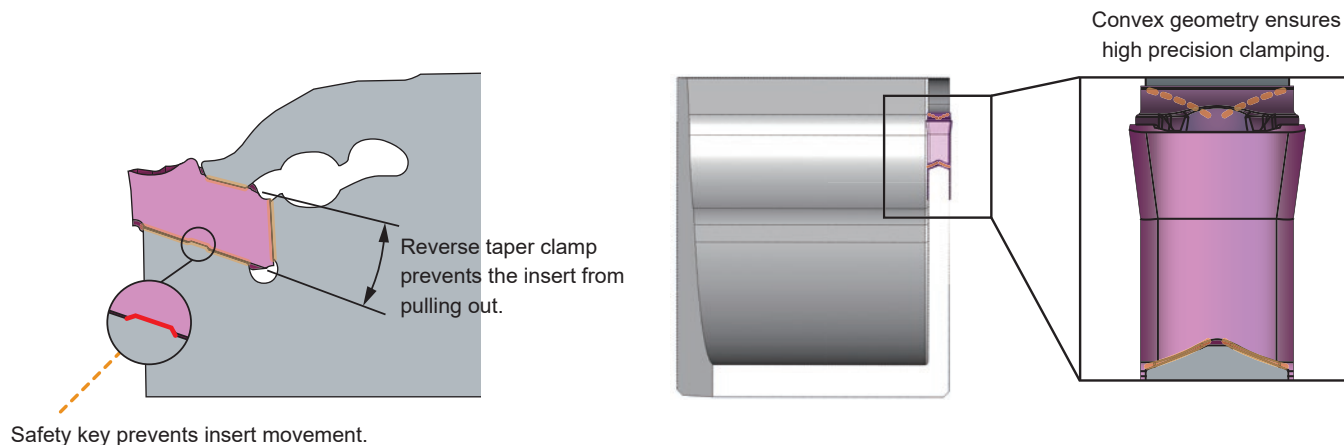


Cutting Off and Grooving System

GW Series

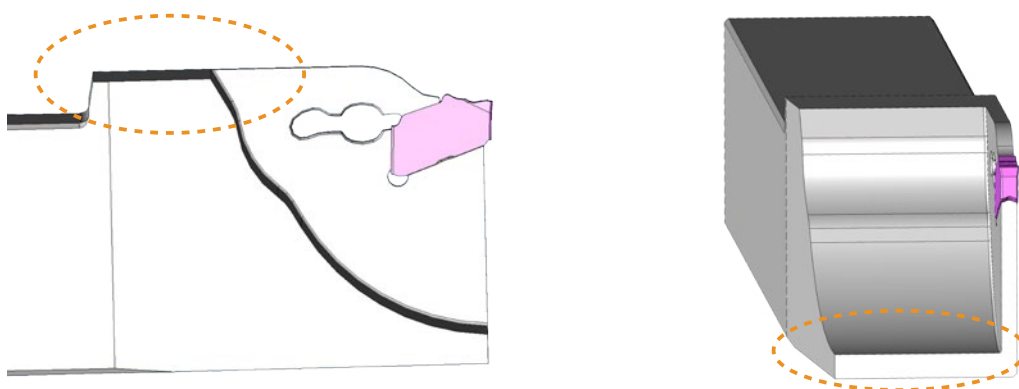


Highly Reliable Insert Clamping



High Rigidity Holder

Tool deflection caused by cutting resistance and the remaining material pip in the centre are greatly reduced.



New Low Resistance and High Lead Angle Insert

New inserts with a lead angle of 8° have been added to the range to reduce burrs and the remaining material pip in the centre.



New Line-up

NEW

Low Feed Breaker



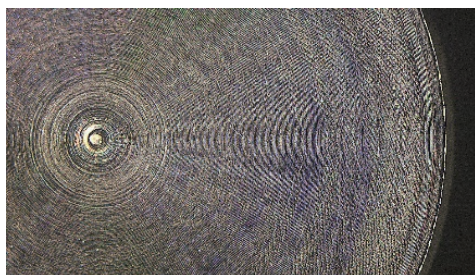
GS Breaker for Lead Angles 8° and 15°

By improving dimensional accuracy, the amount of remaining centre pip is reduced and good surface finishes are achieved.

Cutting Performance

SUS304 Comparison of Cutting Off and Remaining Material

GY GS Breaker



Completely cut off



Remaining pip in the centre : $\phi 0.49$ mm
RZ : 0.009 mm

Conventional A

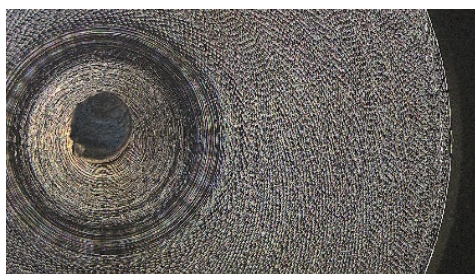


Not completely cut off



Remaining pip in the centre : $\phi 0.58$ mm
RZ : 0.043 mm

Conventional B



Not completely cut off



Remaining pip in the centre : $\phi 1.42$ mm
RZ : 0.015 mm

<Cutting Conditions>

Workpiece Material : SUS304 $\phi 16$ mm

Tool : Cutting Width CW=2mm
Lead Angle 15°

Cutting Speed : $vc=100$ m/min

Feed per Rev. : $f=0.03$ mm/rev

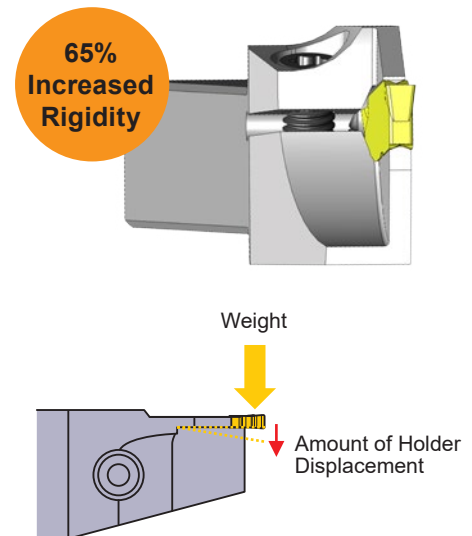
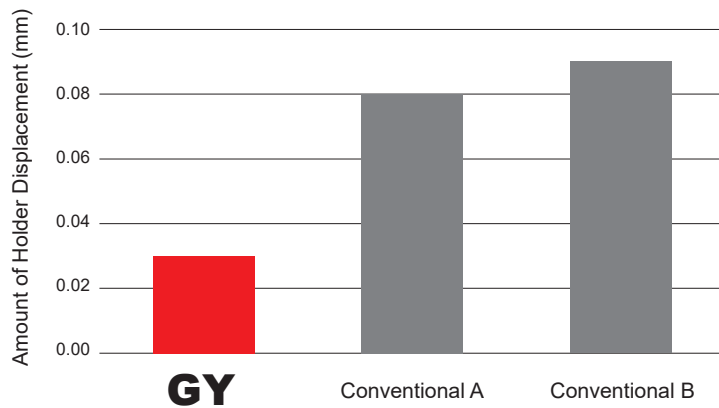
Cutting Mode : Wet Cutting

Cutting Performance

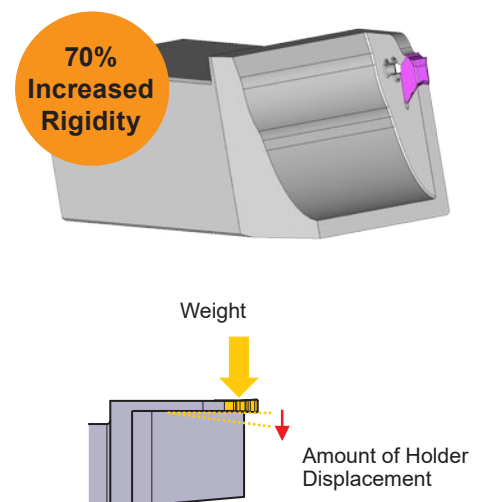
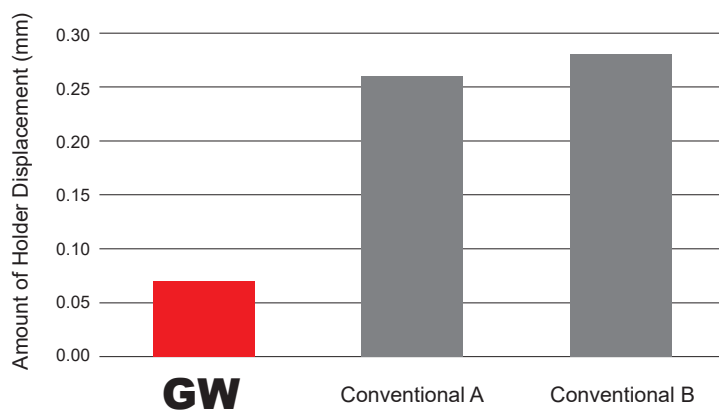
Tool Holder Deflection Comparison

The high rigidity of the tool reduces chatter and vibration thereby improving the component surface finish and also reduces the remaining pip in the centre.

GY Holder



GW Holder

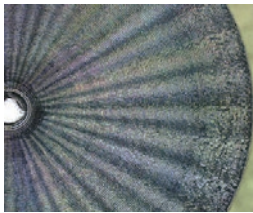


Surface Finish Comparison when Cutting Off : JIS SUS304

The high rigidity holder suppresses vibration and tool deflection, improving the finished surface.

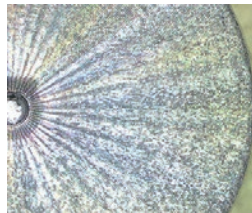
GY Holder

GY



Rz 1.8 μm

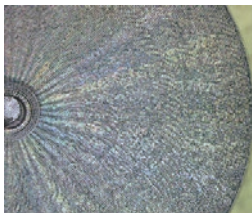
Conventional A



Rz 5.6 μm

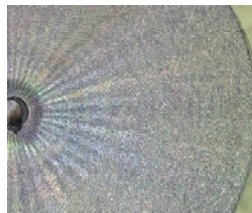
**Excellent
Surface
Finish**

Conventional B



Rz 4.1 μm

Conventional C



Rz 5.7 μm

<Cutting Conditions>

Workpiece Material : SUS304 $\phi 25\text{mm}$

Tool : Cutting Width CW=2mm

RE=0.2mm

16 $\times$ 16

Cutting Speed : $v_c=120\text{m/min}$

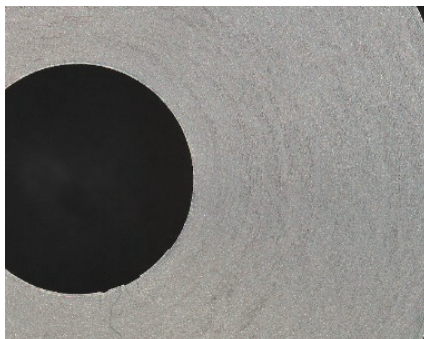
Feed per Rev. : $f=0.10\text{mm/rev}$

Cutting Mode : Wet Cutting

GW Holder

GW

Lead Angle 8°



Rz 7.9 μm

Conventional Lead Angle 6°



Rz 11.3 μm

**High
Lead Angle
Effect**

<Cutting Conditions>

Workpiece Material : SUS304 $\phi 38\text{mm}$

Tool : Cutting Width CW=2mm

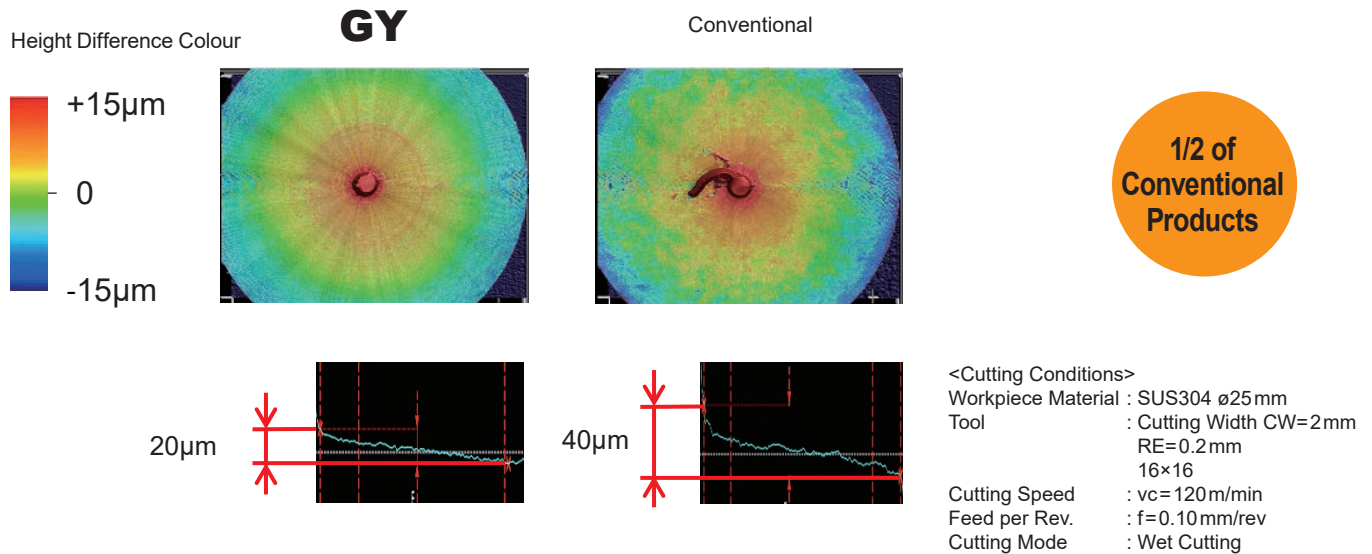
Cutting Speed : $v_c=120\text{m/min}$

Feed per Rev. : $f=0.11\text{mm/rev}$

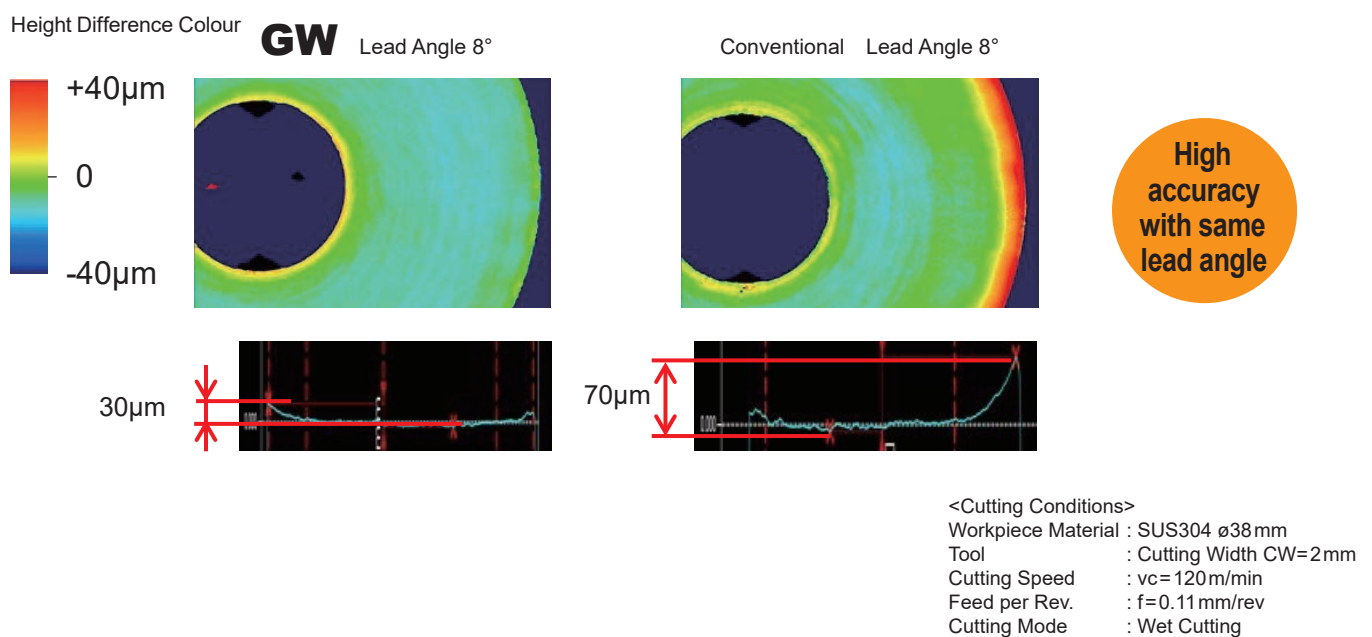
Cutting Mode : Wet Cutting

Comparison of the Accuracy of the Workpiece When Cutting Off : JIS SUS304

GY Holder



GW Holder

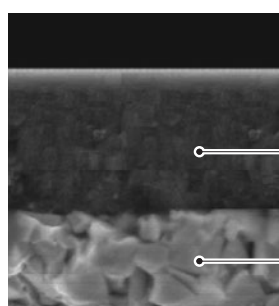


ISO Turning Inserts for Difficult-to-Cut Materials

PVD Coated Carbide Grades

MP9015/MP9025

Excellent Wear Resistance when Machining Heat Resistant Super Alloys



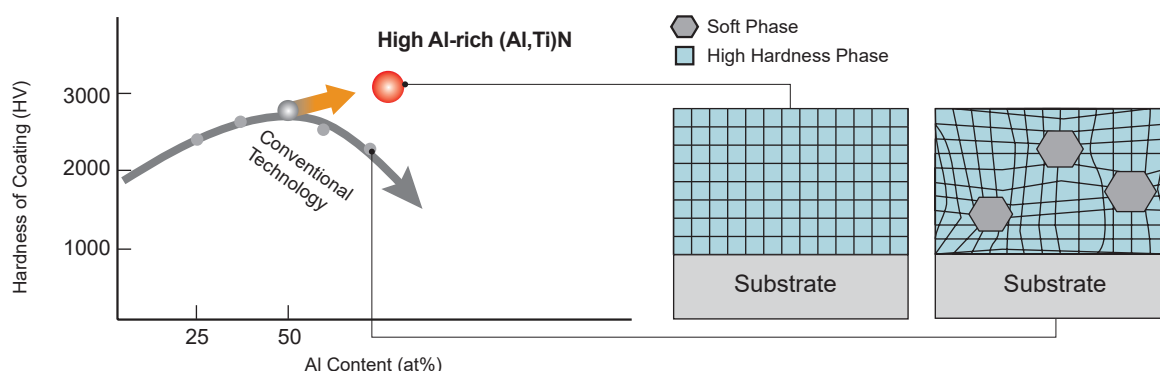
High Al-rich (Al,Ti)N Single Layer Coating Technology

Special Cemented Carbide Substrate

MP9015/MP9025

Comparison of High Al and Conventional Coating

The high Al-rich (Al,Ti)N single layer coating provides stabilization of the high hardness phase and succeeds in dramatically improving wear, crater and welding resistance.



ISO Grade	Grade	Concept	Application
S10	MP9015	First recommendation for general applications.	Heat Resistant Alloys
S30	MP9025	Prevents severe damage for increased stability.	Heat Resistant Alloys

Insert Grade

GY Series

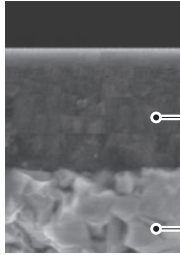
	P Steel	M Stainless Steel	K Cast Iron	N Aluminium Alloy	S Heat Resistant Alloy / Titanium Alloy	H Hardened Steel
Stable Cutting ↑ Cutting Conditions ↓ Unstable Cutting	NX2525 MY5015 VP10RT VP20RT	 VP10RT VP20RT	 MY5015 VP10RT VP20RT	 RT9010	MP9015 RT9010 MP9025	BC8110

GW Series

	P Steel	M Stainless Steel	K Cast Iron	S Heat Resistant Alloy / Titanium Alloy
Stable Cutting ↑ Cutting Conditions ↓ Unstable Cutting	MY5015 VP10RT VP20RT VP30RT	 VP10RT VP20RT VP30RT	MY5015 VP10RT VP20RT	VP10RT VP20RT

GY/GW Series Insert Grade

MP9000 Series

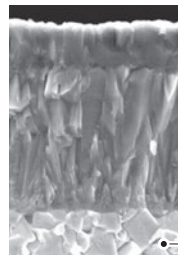


The high Al-rich (Al,Ti)N single layer coating provides stabilization of the high hardness phase and succeeds in dramatically improving wear, crater and welding resistance.

High Al-rich (Al,Ti)N Single Layer Coating Technology

Special Cemented Carbide Substrate

MY5015

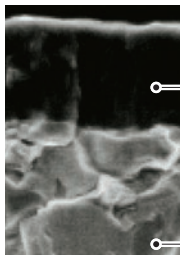


MY5015 is a CVD coated grade with excellent wear resistance even at high temperatures. It provides longer tool life when machining cast and ductile cast irons. Also suitable for high-speed, continuous cutting of steel.

CVD Coated Carbide

Tough cemented carbide substrate

VP20RT



PVD coated grade suitable for a wide range of applications. The combination of a special tough cemented carbide substrate with MIRACLE coating provides an excellent balance of wear and fracture resistance.

MIRACLE Coating

Tough cemented carbide substrate (90.5HRA)

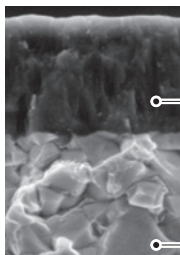
RT9010

RT9010 is a non-coated cemented carbide grade. Suitable for processing non-ferrous metals.

NX2525

NX2525, a cermet grade for finish machining of steel and for good surface finishes at lower cutting speeds.

VP10RT



PVD coated grade with a cemented carbide substrate harder than VP20RT. For use on difficult-to-cut materials and for extending tool life.

MIRACLE Coating

Tough cemented carbide substrate (92.0HRA)

BC8110

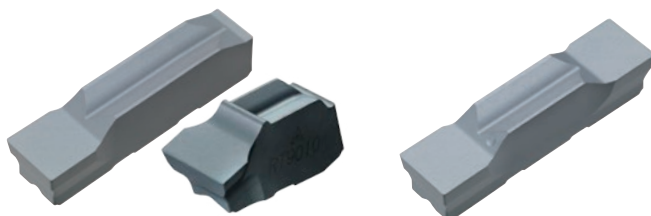
A CBN coated grade for continuous cutting, which provides longer life when machining hardened steel.

MB8025

MB8025 is a sintered CBN grade for hardened steel.

BLANK INSERTS

Blank inserts for custom grinding



1 Edge Type

2 Edge Type

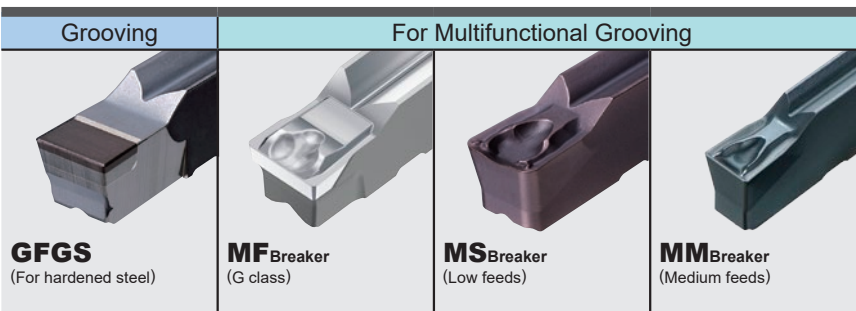
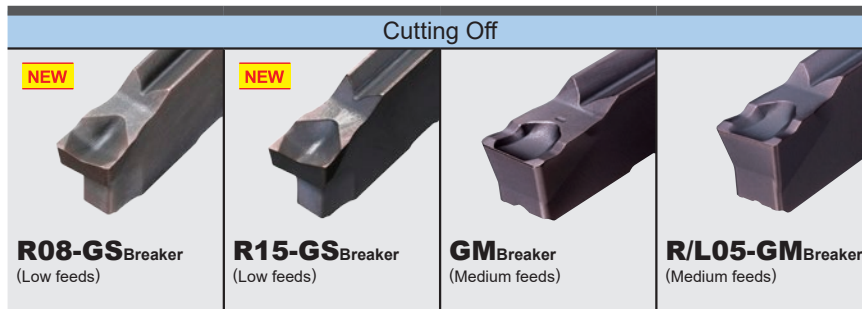
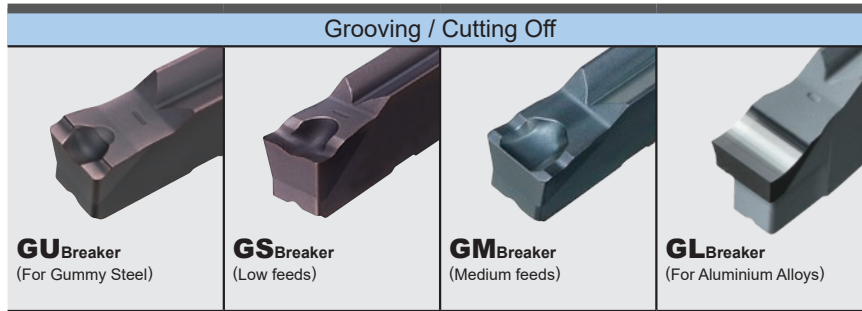
* Blank Inserts are not suitable for machining without grinding.

RT9010/RT9020 for insert blank

First recommendation for blank inserts is RT9020 due to the tougher carbide substrate and is suitable for a wide range of applications. RT9010 is a harder substrate than RT9020 and is ideal for long tool life on stable cutting applications. Coating is recommended for machining steel, stainless steel and cast iron materials.

GY Series

Breaker System



For Grooving / Cutting Off

GL Breaker (For Aluminium Alloys)

G Class Breaker

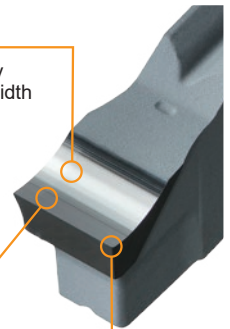
Improved chip control by narrowing the breaker width

High Rake Angle

Achieves low cutting resistance

Sharp Edge

Improved welding resistance for aluminium alloys

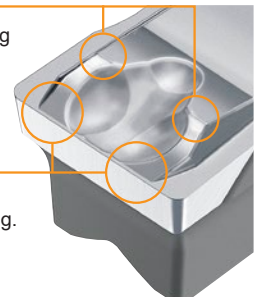


For Multifunctional Grooving

MF Breaker (For Finish Machining)

Efficient chip breaking when cross-feed machining.

Chips are controlled when finish machining.



GW Series

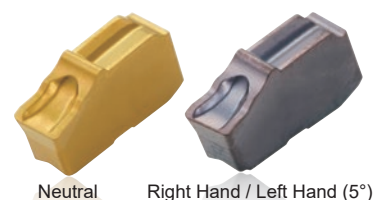
Breaker System Offering Excellent Chip Disposal Properties

Low Feeds



GS Breaker

Medium Feeds



GM Breaker

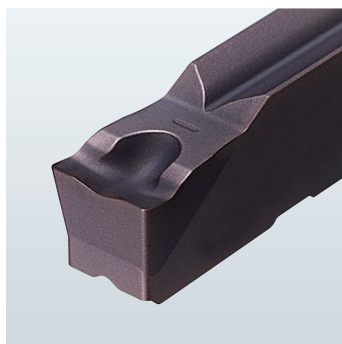
Correct Use of GY Series GS Breaker

First Recommendation

Reduction of Cutting Resistance

Cutting Off of Holes and Small Parts

Reduction of Burrs and Core Residue

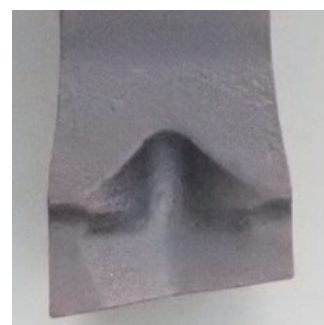


Correct Use of GW Series Inserts

First Recommendation

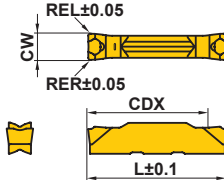
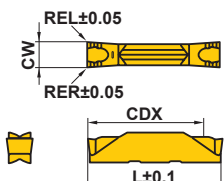
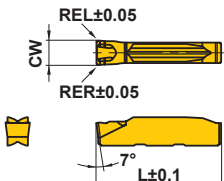
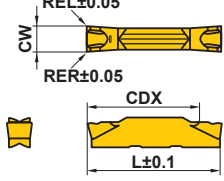
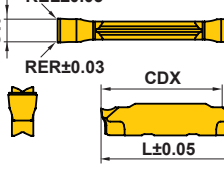
Improved Fracture Resistance

Reduction of Burrs and Core Residue



GY Series Inserts

(mm)

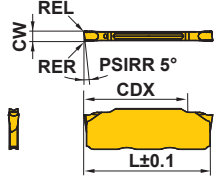
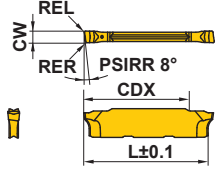
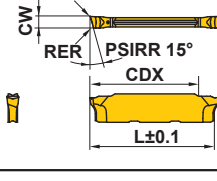
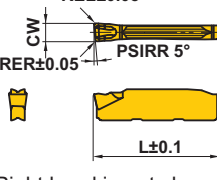
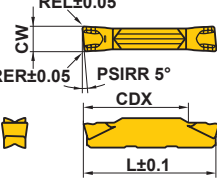
Applications	Geometry	Order Number	Stock								Seat Size	CW		RER/L	CDX	*2 L
			Coated				Cermet		Carbide			Cutting Width	Tolerance			
			MP9015	MP9025	VP10RT	VP20RT	MY5015	NX2525		RT9010						
For Grooving / Cutting Off	GU Breaker (For gummy steel) 	GY2M0200D020N-GU			●	●	●				D	2.00	±0.03	0.2	19.7	20.70
		GY2M0239E020N-GU			●	●	●				E	2.39	±0.03	0.2	19.8	20.70
		GY2M0250E020N-GU			●	●	●				E	2.50	±0.03	0.2	19.5	20.70
		GY2M0300F030N-GU			●	●	●				F	3.00	±0.03	0.3	19.3	20.70
		GY2M0318F030N-GU			●	●	●				F	3.18	±0.03	0.3	19.3	20.70
	GS Breaker (Low feeds) 	NEW GY2M0120B010N-GS			●	●					B	1.20	±0.03	0.1	12.2	14.70
		GY2M0150C010N-GS			●	●	●				C	1.50	±0.03	0.1	13.4	14.70
		GY2M0200D020N-GS			●	●	●				D	2.00	±0.03	0.2	18.7	20.70
		GY2M0239E020N-GS			●	●	●				E	2.39	±0.03	0.2	18.5	20.70
		GY2M0250E020N-GS			●	●	●				E	2.50	±0.03	0.2	18.5	20.70
		GY2M0300F020N-GS			●	●	●				F	3.00	±0.03	0.2	18.5	20.70
		GY2M0318F020N-GS			●	●	●				F	3.18	±0.03	0.2	18.5	20.70
	GM Breaker (Medium feeds) 	GY1M0200D020N-GM	●	●	●	●	●				D	2.00	±0.03	0.2	—	20.70
		GY1M0250E020N-GM	●	●	●	●	●				E	2.50	±0.03	0.2	—	20.70
		GY1M0300F030N-GM	●	●	●	●	●				F	3.00	±0.03	0.3	—	20.70
	GM Breaker (Medium feeds) 	GY2M0150C020N-GM	●	●	●	●	●				C	1.50	±0.03	0.2	13.9	14.70
		GY2M0200D020N-GM	●	●	●	●	●	●			D	2.00	±0.03	0.2	19.4	20.70
		GY2M0239E020N-GM	●	●	●	●	●	●			E	2.39	±0.03	0.2	19.4	20.70
		GY2M0250E020N-GM	●	●	●	●	●	●			E	2.50	±0.03	0.2	19.4	20.70
		GY2M0300F030N-GM	●	●	●	●	●	●			F	3.00	±0.03	0.3	19.4	20.70
		GY2M0318F030N-GM	●	●	●	●	●	●			F	3.18	±0.03	0.3	19.4	20.70
GL Breaker (For Aluminium Alloys) 	GY2G0200D005N-GL							●		D	2.00	±0.02	0.05	19.5	21.05	
	GY2G0250E005N-GL							●		E	2.50	±0.02	0.05	19.1	21.05	
	GY2G0300F005N-GL							●		F	3.00	±0.02	0.05	18.9	21.05	

*2 The dimension depends on the breaker. Refer to page 16 "L dimension tolerance conversion table".

● : Inventory maintained in Japan.

(10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

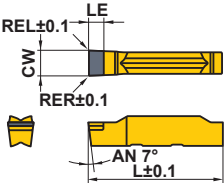
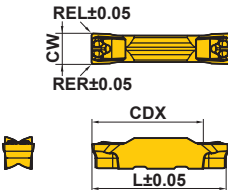
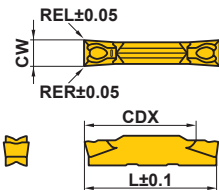
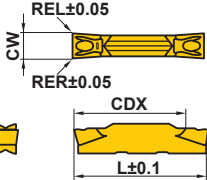
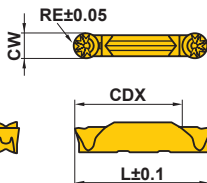
(mm)

Applications	Geometry	Order Number	Stock					Seat Size	CW		Corner R				CDX	*2 L
			Coated						Cutting Width	Tolerance	REL	Tolerance	RER	Tolerance		
			MP9015	MP9025	VP10RT	VP20RT	MY5015									
For Cutting off	R05-GS Breaker NEW (Low feeds) 	GY2M0120B010R05-GS			●	●		B	1.20	±0.03	0.1	±0.05	0.1	±0.05	12.22	14.70
	R08-GS Breaker NEW (Low feeds) 	GY2G0150C010R08-GS			●	●		C	1.50	±0.02	0.1	±0.03	0.1	—	13.17	15.23
		GY2G0200D020R08-GS			●	●		D	2.00	±0.03	0.2	±0.05	0.2	—	18.85	21.33
		GY2G0250E020R08-GS			●	●		E	2.50	±0.03	0.2	±0.05	0.2	—	19.04	21.46
		GY2G0300F020R08-GS			●	●		F	3.00	±0.03	0.2	±0.05	0.2	—	18.62	21.53
	R15-GS Breaker NEW (Low feeds) 	GY2G0150C003R15-GS			●	●		C	1.50	±0.02	0.03	+0.03 -0.02	0.1	—	13.17	15.23
		GY2G0150C010R15-GS			●	●		C	1.50	±0.02	0.1	±0.03	0.1	—	13.17	15.23
		GY2G0200D003R15-GS			●	●		D	2.00	±0.03	0.03	+0.03 -0.02	0.1	—	18.85	21.32
		GY2G0200D010R15-GS			●	●		D	2.00	±0.03	0.1	±0.03	0.1	—	18.85	21.30
		GY2G0250E003R15-GS			●	●		E	2.50	±0.03	0.03	+0.03 -0.02	0.1	—	19.04	21.46
		GY2G0250E020R15-GS			●	●		E	2.50	±0.03	0.2	±0.05	0.1	—	19.04	21.46
		GY2G0300F003R15-GS			●	●		F	3.00	±0.03	0.03	+0.03 -0.02	0.1	—	18.62	21.58
		GY2G0300F020R15-GS			●	●		F	3.00	±0.03	0.2	±0.05	0.1	—	18.62	21.53
	R/L05-GM Breaker  Right hand insert shown.	GY1M0200D020R05-GM			●	●		D	2.00	±0.03	0.2	±0.05	0.2	±0.05	—	20.80
		GY1M0200D020L05-GM			●	●		D	2.00	±0.03	0.2	±0.05	0.2	±0.05	—	20.80
		GY1M0300F030R05-GM			●	●		F	3.00	±0.03	0.3	±0.05	0.3	±0.05	—	20.85
		GY1M0300F030L05-GM			●	●		F	3.00	±0.03	0.3	±0.05	0.3	±0.05	—	20.85
	R/L05-GM Breaker  Right hand insert shown.	GY2M0200D020R05-GM			●	●		D	2.00	±0.03	0.2	±0.05	0.2	±0.05	19.5	20.80
		GY2M0200D020L05-GM			●	●		D	2.00	±0.03	0.2	±0.05	0.2	±0.05	19.5	20.80
		GY2M0250E020R05-GM			●	●		E	2.50	±0.03	0.2	±0.05	0.2	±0.05	19.5	20.825
		GY2M0250E020L05-GM			●	●		E	2.50	±0.03	0.2	±0.05	0.2	±0.05	19.5	20.825
		GY2M0300F030R05-GM			●	●		F	3.00	±0.03	0.3	±0.05	0.3	±0.05	19.5	20.85
		GY2M0300F030L05-GM			●	●		F	3.00	±0.03	0.3	±0.05	0.3	±0.05	19.5	20.85

*2 The dimension depends on the breaker. Refer to page 16 "L dimension tolerance conversion table".

GY Series Inserts

(mm)

Applications	Geometry	Order Number	Stock								Seat Size	CW		RER/L	CDX	*2 L	LE	
			Coated				Cermet	Carbide	CBN	Cutting Width		Tolerance						
			MP9015	MP9025	VP10RT	VP20RT	MY5015	NX2525	RT9010				RT9020					BC8110
For Grooving	Flat Top (For hardened steel) 	GY1G0200D020N-GFGS									●	D	2.00	±0.03	0.2	—	20.70	2.7
		GY1G0239E020N-GFGS									●	E	2.39	±0.03	0.2	—	20.70	2.7
		GY1G0250E020N-GFGS									●	E	2.50	±0.03	0.2	—	20.70	2.7
		GY1G0300F020N-GFGS									●	F	3.00	±0.03	0.2	—	20.70	2.7
		GY1G0318F020N-GFGS									●	F	3.18	±0.03	0.2	—	20.70	2.7
For Multifunctional Grooving	MF Breaker (Finishing) 	GY2G0200D020N-MF			●	●		●		●		D	2.00	±0.02	0.2	19.5	21.05	—
		*1 GY2G0224D015N-MF			●	●		●		●		D	2.24	±0.02	0.15	19.8	21.05	—
		GY2G0239E020N-MF			●	●		●		●		E	2.39	±0.02	0.2	19.2	21.05	—
		GY2G0250E020N-MF			●	●		●		●		E	2.50	±0.02	0.2	19.4	21.05	—
		*1 GY2G0274E020N-MF			●	●		●		●		E	2.74	±0.02	0.2	19.7	21.05	—
		GY2G0300F020N-MF			●	●		●		●		F	3.00	±0.02	0.2	19.5	21.05	—
		GY2G0300F040N-MF			●	●		●		●		F	3.00	±0.02	0.4	19.3	21.05	—
		GY2G0318F020N-MF			●	●		●		●		F	3.18	±0.02	0.2	19.5	21.05	—
		GY2G0318F040N-MF			●	●		●		●		F	3.18	±0.02	0.4	19.3	21.05	—
		*1 GY2G0324F020N-MF			●	●		●		●		F	3.24	±0.02	0.2	19.5	21.05	—
	MS Breaker (Low feeds) 	GY2M0200D020N-MS			●	●	●	●				D	2.00	±0.03	0.2	19.1	20.70	—
		GY2M0250E020N-MS			●	●	●	●				E	2.50	±0.03	0.2	19.1	20.70	—
		GY2M0300F020N-MS			●	●	●	●				F	3.00	±0.03	0.2	19.2	20.70	—
		GY2M0300F040N-MS			●	●	●	●				F	3.00	±0.03	0.4	18.9	20.70	—
	MM Breaker (Medium feeds) 	GY2M0200D020N-MM		●	●	●	●	●				D	2.00	±0.03	0.2	19.1	20.70	—
		GY2M0250E020N-MM		●	●	●	●	●				E	2.50	±0.03	0.2	19.1	20.70	—
		GY2M0300F020N-MM		●	●	●	●	●				F	3.00	±0.03	0.2	19.1	20.70	—
		GY2M0300F040N-MM		●	●	●	●	●				F	3.00	±0.03	0.4	18.9	20.70	—
GY2M0300F080N-MM			●	●	●	●	●				F	3.00	±0.03	0.8	18.5	20.70	—	
For Copying / For Recessing	BM Breaker 	GY2M0200D100N-BM		●	●	●	●	●	●			D	2.00	±0.03	1.00	19.5	20.90	—
		GY2M0250E125N-BM		●	●	●	●	●	●			E	2.50	±0.03	1.25	19.3	20.90	—
		GY2M0300F150N-BM		●	●	●	●	●	●			F	3.00	±0.03	1.50	19.0	20.90	—
		GY2M0318F159N-BM		●	●	●	●	●	●			F	3.18	±0.03	1.59	18.9	20.90	—

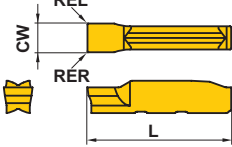
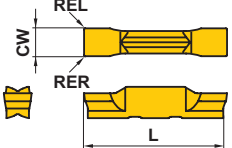
*1 Circlip corresponding width of cut

● : Inventory maintained in Japan.

(10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

Blank Inserts

(mm)

Geometry	Order Number	Cermet Carbide			Seat Size	CW		RER	REL	L
		NX2525	RT9010	RT9020		Groove Width	Tolerance			
1 Edge Type 	GY1B0220D020N	●	●	●	D	2.20	±0.10	0.2	0.2	21.07
	GY1B0270E020N	●	●	●	E	2.70	±0.10	0.2	0.2	21.10
	GY1B0340F020N	●	●	●	F	3.40	±0.10	0.2	0.2	21.00
2 Edge Type 	GY2B0220D020N	●	●	●	D	2.20	±0.10	0.2	0.2	21.05
	GY2B0250D020N	●	●	●	D	2.55	±0.10	0.2	0.2	21.28
	GY2B0270E020N	●	●	●	E	2.70	±0.10	0.2	0.2	21.05
	GY2B0300E020N	●	●	●	E	3.05	±0.10	0.2	0.2	21.28
	GY2B0340F020N	●	●	●	F	3.40	±0.10	0.2	0.2	21.05
	GY2B0360F020N	●	●	●	F	3.60	±0.10	0.2	0.2	21.28

* Insert blank is not suitable for machining without grinding.

GY Series “ L ” Dimension Tolerance Conversion Table

(mm)

Cutting Width CW	*1 Dimensions L	*2 Dimensional tolerance versus standard dimension " L " of each breaker									
		GU	GS/GM	MS/MM	R05-GS	R08/15-GS	R/L-GM	Flat Top	MF	BM	GL
1.20	14.70		0		0						
1.50	14.70		0			0.50					
2.00	20.70	0	0	0		0.60	0.10	0	0.35	0.20	0.35
2.24	*3 (20.70)								0.35		
2.39	20.70	0	0					0	0.35		
2.50	20.70	0	0	0		0.80	0.125	0	0.35	0.20	0.35
2.74	*3 (20.70)								0.35		
3.00	20.70	0	0	0		0.80	0.15	0	0.35	0.20	0.35
3.18	20.70	0	0					0	0.35	0.20	
3.24	*3 (20.70)								0.35		

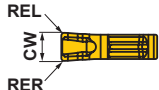
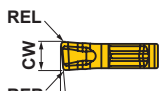
*1 This value is used at the described holder dimension.

*2 when there is no applicable breaker.

*3 The standard dimensions shown here use an approximate insert width.

GW Series Inserts

(mm)

Application	Order Number	Stock						CW		REL	RER	PSIRR PSIRL	Geometry
		Coating				Carbide		Cutting Width	Tolerance				
		MY5015	VP10RT	VP20RT	VP30RT	RT9010	RT9020						
Grooving, Cutting Off	GW1M0200D020N-GS		●	●	●			2.00	±0.03	0.2	0.2	—	
Grooving, Cutting Off	GW1M0239E020N-GS		●	●	●			2.39	±0.03	0.2	0.2	—	
Grooving, Cutting Off	GW1M0300F020N-GS		●	●	●			3.00	±0.03	0.2	0.2	—	
Grooving, Cutting Off	GW1M0400G020N-GS		●	●	●			4.00	±0.04	0.2	0.2	—	
Grooving, Cutting Off	GW1M0200D020N-GM	●	●	●	●			2.00	±0.03	0.2	0.2	—	
Grooving, Cutting Off	GW1M0239E020N-GM	●	●	●	●			2.39	±0.03	0.2	0.2	—	
Grooving, Cutting Off	GW1M0300F030N-GM	●	●	●	●			3.00	±0.03	0.3	0.3	—	
Grooving, Cutting Off	GW1M0400G030N-GM	●	●	●	●			4.00	±0.04	0.3	0.3	—	
Cutting off, Low Feed	GW1M0200D020R05-GS		●	●	●			2.00	±0.03	0.2	0.2	5	
Cutting off, Low Feed	GW1M0239E020R05-GS		●	●	●			2.39	±0.03	0.2	0.2	5	
Cutting off, Low Feed	GW1M0300F020R05-GS		●	●	●			3.00	±0.03	0.2	0.2	5	
Cutting off Low Feed, Lead Angle 8°	GW1M0200D003R08-GS		●	●	●			2.00	±0.03	0.03	0.03	8	
Cutting off Low Feed, Lead Angle 8°	GW1M0239E003R08-GS		●	●	●			2.39	±0.03	0.03	0.03	8	
Cutting off Low Feed, Lead Angle 8°	GW1M0300F003R08-GS		●	●	●			3.00	±0.03	0.03	0.03	8	
Cutting Off	GW1M0200D020R05-GM		●	●	●			2.00	±0.03	0.2	0.2	5	
Cutting Off	GW1M0200D020L05-GM		●	●	●			2.00	±0.03	0.2	0.2	5	
Cutting Off	GW1M0239E020R05-GM		●	●	●			2.39	±0.03	0.2	0.2	5	
Cutting Off	GW1M0239E020L05-GM		●	●	●			2.39	±0.03	0.2	0.2	5	
Cutting Off	GW1M0300F030R05-GM		●	●	●			3.00	±0.03	0.3	0.3	5	
Cutting Off	GW1M0300F030L05-GM		●	●	●			3.00	±0.03	0.3	0.3	5	
Cutting Off	GW1M0400G030R05-GM		●	●	●			4.00	±0.04	0.3	0.3	5	
Cutting Off	GW1M0400G030L05-GM		●	●	●			4.00	±0.04	0.3	0.3	5	
Right hand insert shown.													

Right hand insert shown.

Blank Inserts

(mm)

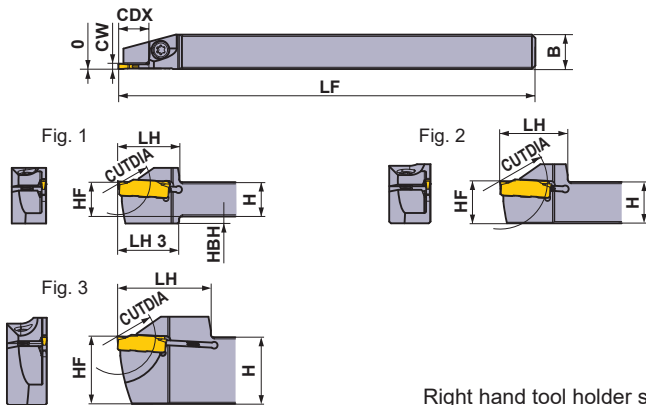
Geometry	Order Number	Carbide		CW		RER	REL
		RT9010	RT9020	Grooving Width	Tolerance		
1 Edge Type REL CW RER  <td>GW1B0320D020N</td> <td>●</td> <td>●</td> <td>3.24</td> <td>±0.10</td> <td>0.2</td> <td>0.2</td>	GW1B0320D020N	●	●	3.24	±0.10	0.2	0.2
	GW1B0440F020N	●	●	4.44	±0.10	0.2	0.2
	GW1B0540G020N	●	●	5.44	±0.10	0.2	0.2

Note 1) Blank inserts to be ground by customers.

● : Inventory maintained in Japan.

(10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

GY SERIES (External for Swiss-Type lathes)



Right hand tool holder shown.

Spare Parts

Holder Type		
	Clamp Screw	Wrench
GYSR/L1010JX00	CS350990T	TKY10R
GYSR/L1212JX00	CS350990T	TKY10R
GYSR/L1616JX00	TS4SBL	TKY15R
GYSR/L1915K00	TS4SBL	TKY15R
GYSR/L2012JX00	CS350990T	TKY10R
GYSR/L2020K00	HSC05018	HKY40R
GYSR/L2525K00	HSC05018	HKY40R

Seat Size	CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number	Stock	Dimensions (mm)							Fig.
								H	B	LF	LH	LH 3	HF	HBH	
B	1.20	8	16	Mono Block	R	NEW GYSR1010JX00-B08	●	10	10	120	17.5	17.5	10	2	1
		8	16		L	NEW GYSL1010JX00-B08	●	10	10	120	17.5	17.5	10	2	1
		8	16	Mono Block	R	NEW GYSR1212JX00-B08	●	12	12	120	19.5	—	12	—	2
		8	16		L	NEW GYSL1212JX00-B08	●	12	12	120	19.5	—	12	—	2
		12	24	Mono Block	R	NEW GYSR1212JX00-B12	●	12	12	120	19.5	19.5	12	2	1
		12	24		L	NEW GYSL1212JX00-B12	●	12	12	120	19.5	19.5	12	2	1
		8	16	Mono Block	R	NEW GYSR1616JX00-B08	●	16	16	120	25	—	16	—	2
		8	16		L	NEW GYSL1616JX00-B08	●	16	16	120	25	—	16	—	2
C	1.50	13	26	Mono Block	R	NEW GYSR1616JX00-B13	●	16	16	120	25	—	16	—	2
		13	26		L	NEW GYSL1616JX00-B13	●	16	16	120	25	—	16	—	2
		8	16	Mono Block	R	GYSR1010JX00-C08	●	10	10	120	17.5	17.5	10	2	1
		8	16		L	GYSL1010JX00-C08	●	10	10	120	17.5	17.5	10	2	1
		8	16	Mono Block	R	GYSR1212JX00-C08	●	12	12	120	19.5	—	12	—	2
		8	16		L	GYSL1212JX00-C08	●	12	12	120	19.5	—	12	—	2
		12	24	Mono Block	R	GYSR1212JX00-C12	●	12	12	120	19.5	19.5	12	2	1
		12	24		L	GYSL1212JX00-C12	●	12	12	120	19.5	19.5	12	2	1
D	2.00 2.24	13	26	Mono Block	R	GYSR1616JX00-C13	●	16	16	120	25	—	16	—	2
		13	26		L	GYSL1616JX00-C13	●	16	16	120	25	—	16	—	2
		13	26	Mono Block	R	GYSR2012JX00-C13	●	20	12	120	28	—	20	—	3
		13	26		L	GYSL2012JX00-C13	●	20	12	120	28	—	20	—	3
		10	20	Mono Block	R	GYSR1010JX00-D10	●	10	10	120	17.5	17.5	10	2	1
		10	20		L	GYSL1010JX00-D10	●	10	10	120	17.5	17.5	10	2	1
		12	24	Mono Block	R	GYSR1212JX00-D12	●	12	12	120	19.5	19.5	12	2	1
		12	24		L	GYSL1212JX00-D12	●	12	12	120	19.5	19.5	12	2	1
		13	26	Mono Block	R	GYSR1616JX00-D13	●	16	16	120	25	—	16	—	2
		13	26		L	GYSL1616JX00-D13	●	16	16	120	25	—	16	—	2
		16	32	Mono Block	R	GYSR1616JX00-D16	●	16	16	120	28	—	16	—	2
		16	32		L	GYSL1616JX00-D16	●	16	16	120	28	—	16	—	2
		17	34	Mono Block	R	GYSR1915K00-D17	●	19.05	15.875	125	28	—	19.05	—	3
		17	34		L	GYSL1915K00-D17	●	19.05	15.875	125	28	—	19.05	—	3
		17	34	Mono Block	R	GYSR2012JX00-D17	●	20	12	120	28	—	20	—	3
		17	34		L	GYSL2012JX00-D17	●	20	12	120	28	—	20	—	3
		17	34	Mono Block	R	GYSR2020K00-D17	●	20	20	125	35	—	20	—	2
		17	34		L	GYSL2020K00-D17	●	20	20	125	35	—	20	—	2
		17	34	Mono Block	R	GYSR2525M00-D17	●	25	25	150	40	—	25	—	2
		17	34		L	GYSL2525M00-D17	●	25	25	150	40	—	25	—	2

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

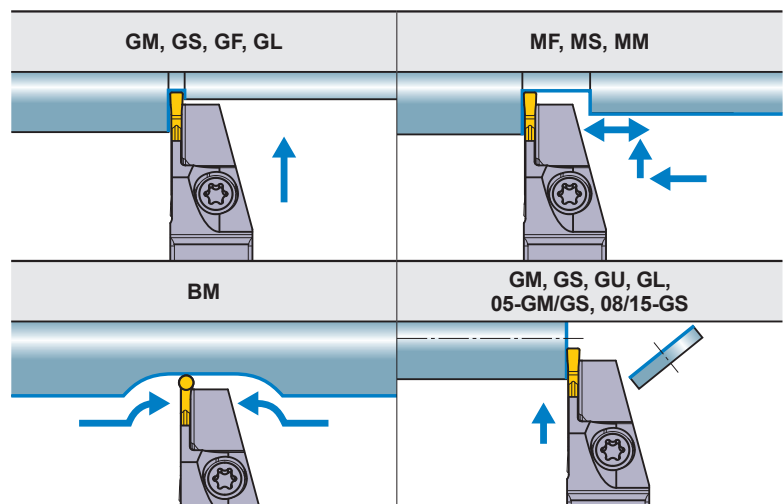
- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages 13—15.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 13—15.
- *3 Dimensions shown are when the standard insert is used. If other insert geometries are used then LF, LH and LH 3 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page 13—15.

GY SERIES (External for Swiss-Type lathes)

															(mm)
Seat Size	CW	*4 CDX	CUTDIA	Type	Hand (R/L)	Order Number	Stock	Dimensions (mm) *3							Fig.
								H	B	LF	LH	LH 3	HF	HBH	
E	2.39 2.50 2.74	10	20	Mono Block	R	GYSR1010JX00-E10	●	10	10	120	17.5	17.5	10	2	1
		10	20		L	GYSL1010JX00-E10	●	10	10	120	17.5	17.5	10	2	1
		12	24	Mono Block	R	GYSR1212JX00-E12	●	12	12	120	19.5	19.5	12	2	1
		12	24		L	GYSL1212JX00-E12	●	12	12	120	19.5	19.5	12	2	1
		13	26	Mono Block	R	GYSR1616JX00-E13	●	16	16	120	25	—	16	—	2
		13	26		L	GYSL1616JX00-E13	●	16	16	120	25	—	16	—	2
		16	32	Mono Block	R	GYSR1616JX00-E16	●	16	16	120	28	—	16	—	2
		16	32		L	GYSL1616JX00-E16	●	16	16	120	28	—	16	—	2
		17	34	Mono Block	R	GYSR1915K00-E17	●	19.05	15.875	125	28	—	19.05	—	3
		17	34		L	GYSL1915K00-E17	●	19.05	15.875	125	28	—	19.05	—	3
		17	34	Mono Block	R	GYSR2012JX00-E17	●	20	12	120	28	—	20	—	3
		17	34		L	GYSL2012JX00-E17	●	20	12	120	28	—	20	—	3
		17	34	Mono Block	R	GYSR2020K00-E17	●	20	20	125	35	—	20	—	2
		17	34		L	GYSL2020K00-E17	●	20	20	125	35	—	20	—	2
		17	34	Mono Block	R	GYSR2525M00-E17	●	25	25	150	40	—	25	—	2
		17	34		L	GYSL2525M00-E17	●	25	25	150	40	—	25	—	2
F	3.00 3.18 3.24	12	24	Mono Block	R	GYSR1212JX00-F12	●	12	12	120	19.5	19.5	12	2	1
		12	24		L	GYSL1212JX00-F12	●	12	12	120	19.5	19.5	12	2	1
		13	26	Mono Block	R	GYSR1616JX00-F13	●	16	16	120	25	—	16	—	2
		13	26		L	GYSL1616JX00-F13	●	16	16	120	25	—	16	—	2
		16	32	Mono Block	R	GYSR1616JX00-F16	●	16	16	120	28	—	16	—	2
		16	32		L	GYSL1616JX00-F16	●	16	16	120	28	—	16	—	2
		17	34	Mono Block	R	GYSR1915K00-F17	●	19.05	15.875	125	28	—	19.05	—	3
		17	34		L	GYSL1915K00-F17	●	19.05	15.875	125	28	—	19.05	—	3
		17	34	Mono Block	R	GYSR2012JX00-F17	●	20	12	120	28	—	20	—	3
17	34	L	GYSL2012JX00-F17		●	20	12	120	28	—	20	—	3		

Cutting Mode

Clockwise		Anticlockwise	
R		R	
L		L	



Insert Selection

Seat Size	Insert Type
B	GY○○0120B○○○○○-Breaker shown below
C	GY○○0150C○○○○○-Breaker shown below
D	GY○○0200/0224D○○○○○-Breaker shown below
E	GY○○0239/0250/0274E○○○○○-Breaker shown below
F	GY○○0300/0318/0324F○○○○○-Breaker shown below

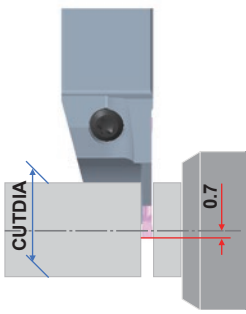
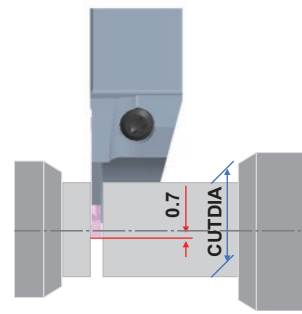
For grooving/cutting off breaker						
Seat Size	Breaker CW	GU (For gummy steel)	GS (Low)	GM (Medium)	GL (Aluminium)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	Neutral	Neutral
B	1.20mm		●			
C	1.50mm		●	●		
D	2.00mm	●	●	●	●	●
E	2.39mm	●	●	●	●	●
	2.50mm	●	●	●	●	●
F	3.00mm	●	●	●	●	●
	3.18mm	●	●	●	●	●

For cutting off breaker					
Seat Size	Breaker CW	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
		R	R	R	R/L
B	1.20mm	●			
C	1.50mm		●	●	
D	2.00mm		●	●	●
E	2.39mm				
	2.50mm		●	●	●
F	3.00mm		●	●	●
	3.18mm				

● : Standard insert with dimensions

For multifunctional grooving breaker					
Seat Size	Breaker CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
D	2.00mm	●	●	●	●
	2.24mm	●			
E	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			
F	3.00mm				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18mm				●
	RE 0.2	●			
	RE 0.4	●			
	3.24mm	●			

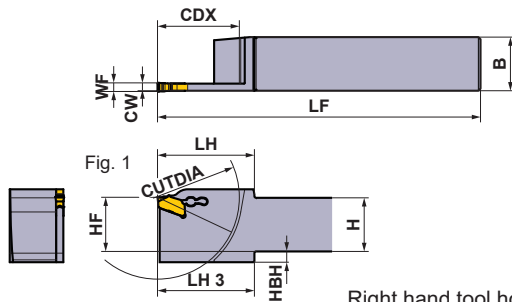
Regarding Cutting Off Depth and Maximum Cutting Off Diameter

Main Spindle Tooling	Sub Spindle Tooling
 Main Spindle	 Sub Spindle Main Spindle

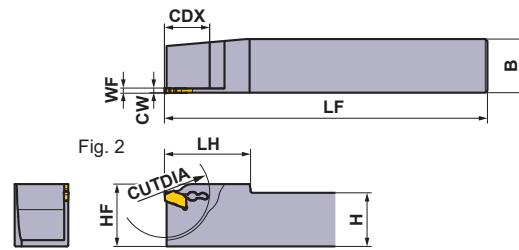
In case of parting off operations, when the cutting edge exceeds the centre of the workpiece material, keep it to 0.7 mm or less.

CUTDIA = maximum parting diameter

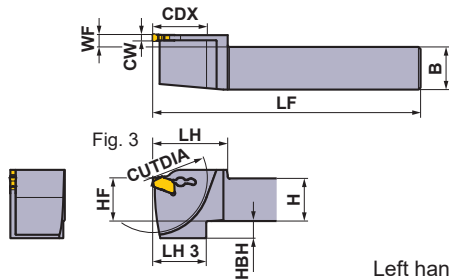
GW SERIES (External for Swiss-Type lathes)



Right hand tool holder shown.

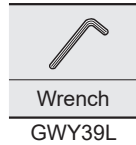


Right hand tool holder shown.



Left hand tool holder shown.

Spare Parts



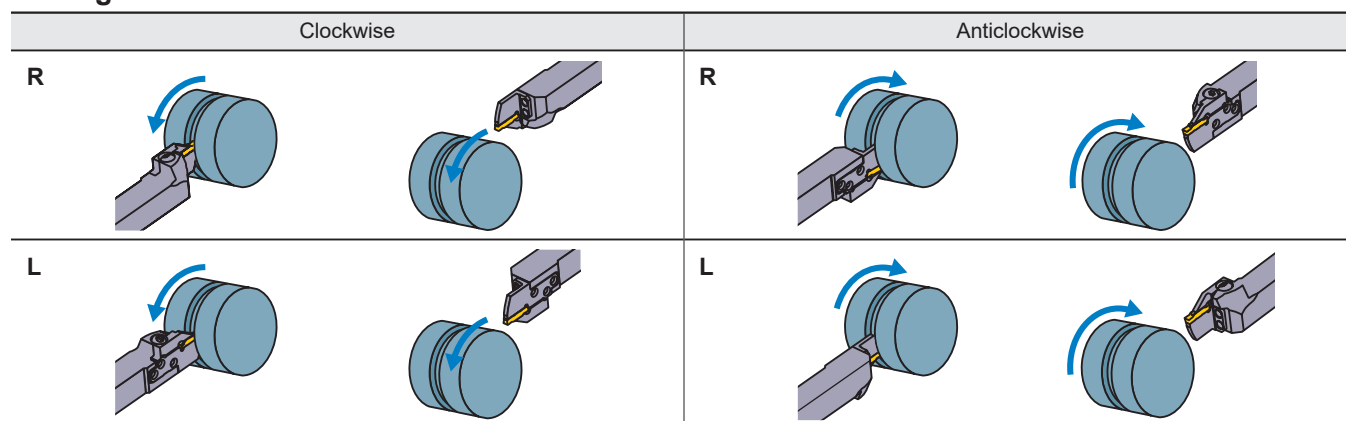
Wrench

GWY39L

Seat Size	CW	CDX	CUTDIA	Type	Hand (R/L)	Order Number	Stock	Dimensions (mm)								Fig.
								H	B	LF	LH	LH 3	HF	WF	HBH	
D	2.00	19	38	Mono Block	R	GWSR1616JX00-D38	●	16	16	120	30	30	16	0.3	6	1
		19	38		L	GWSL1616JX00-D38	●	16	16	120	30	30	16	0.3	6	1
		19	38	Mono Block	R	GWSR1915K00-D38	●	19.05	15.875	125	35	35	19.05	0.3	3	1
		19	38		L	GWSL1915K00-D38	●	19.05	15.875	125	35	35	19.05	0.3	3	1
		21	42	Mono Block	R	GWSR2020K00-D42	●	20	20	125	35	25	20	0.3	4	1
		21	42		L	GWSL2020K00-D42	●	20	20	125	35	25	20	0.3	4	1
		21	42	Mono Block	R	GWSR2012K00-D42	●	20	12	125	35	25	20	0.3	4	1
		21	42		L	GWSL2012K00-D42	●	20	12	125	35	25	20	0.3	4	1
E	2.39	21	42	Mono Block	R	GWSR2525M00-D42	●	25	25	150	40	—	25	0.3	—	2
		21	42		L	GWSL2525M00-D42	●	25	25	150	40	—	25	0.3	—	2
		19	38	Mono Block	R	GWSR1915K00-E38	●	19.05	15.875	125	35	35	19.05	0.2	3	1
		19	38		L	GWSL1915K00-E38	●	19.05	15.875	125	35	35	19.05	0.2	3	1
		21	42	Mono Block	R	GWSR2020K00-E42	●	20	20	125	35	25	20	0.2	4	1
		21	42		L	GWSL2020K00-E42	●	20	20	125	35	25	20	0.2	4	1
		21	42	Mono Block	R	GWSR2020K00-E42-M	●	20	20	125	35	25	20	5.7	8	3
		21	42		L	GWSL2020K00-E42	●	20	12	125	35	25	20	0.2	4	1
F	3.00	21	42	Mono Block	R	GWSR2012K00-E42	●	20	12	125	35	25	20	0.2	4	1
		21	42		L	GWSL2012K00-E42	●	20	12	125	35	25	20	0.2	4	1
		21	42	Mono Block	R	GWSR2525M00-E42	●	25	25	150	40	—	25	0.2	—	2
		21	42		L	GWSL2525M00-E42	●	25	25	150	40	—	25	0.2	—	2
		19	38	Mono Block	R	GWSR1915K00-F38	●	19.05	15.875	125	35	35	19.05	0.3	3	1
		19	38		L	GWSL1915K00-F38	●	19.05	15.875	125	35	35	19.05	0.3	3	1
		21	42	Mono Block	R	GWSR2012K00-F42	●	20	12	125	35	25	20	0.3	4	1
		21	42		L	GWSL2012K00-F42	●	20	12	125	35	25	20	0.3	4	1
		21	42	Mono Block	R	GWSR2020K00-F42	●	20	20	125	35	25	20	0.3	4	1
		21	42		L	GWSL2020K00-F42	●	20	20	125	35	25	20	0.3	4	1
		21	42	Mono Block	R	GWSR2020K00-F42-M	●	20	20	125	35	25	20	5.8	8	3
		21	42		L	GWSL2020K00-F42-M	●	20	20	125	35	25	20	5.8	8	3
		25.5	51	Mono Block	R	GWSR2020K00-F51	●	20	20	125	35	25	20	0.3	8	1
		25.5	51		L	GWSL2020K00-F51	●	20	20	125	35	25	20	0.3	8	1
		25.5	51	Mono Block	R	GWSR2020K00-F51-M	●	20	20	125	35	25	20	5.8	8	3
		25.5	51		L	GWSL2020K00-F51-M	●	20	20	125	35	25	20	5.8	8	3
G	4.00	25.5	51	Mono Block	R	GWSR2525M00-F51	●	25	25	150	40	40	25	0.3	3	1
		25.5	51		L	GWSL2525M00-F51	●	25	25	150	40	40	25	0.3	3	1
		32.5	65	Mono Block	R	GWSR2020M00-F65	●	20	20	150	40	33	20	0.3	10	1
		32.5	65		L	GWSL2020M00-F65	●	20	20	150	40	33	20	0.3	10	1
		38	76	Mono Block	R	GWSR2525M00-F76	●	25	25	150	45	45	25	0.3	5	1
		38	76		L	GWSL2525M00-F76	●	25	25	150	45	45	25	0.3	5	1
		38	76	Mono Block	R	GWSR2525M00-G76	●	25	25	150	45	45	25	0.4	5	1
		38	76		L	GWSL2525M00-G76	●	25	25	150	45	45	25	0.4	5	1

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

Cutting Mode

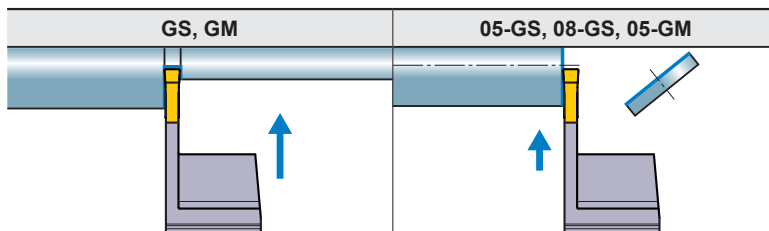


Insert Selection

Seat Size	Insert Type
D	GW1M0200D
E	GW1M0239E
F	GW1M0300F
G	GW1M0400G

For grooving/cutting off breaker						
Seat Size	Breaker CW	GS (Low)	GM (Medium)	05-GS (Low)	08-GS (Low)	05-GM (Cutting off)
		Neutral	Neutral	R	R	R/L
D	2.00mm	●	●	●	●	●
E	2.39mm	●	●	●	●	●
F	3.00mm	●	●	●	●	●
G	4.00mm	●	●	●	●	●

● : Standard insert with dimensions



GY Series

RECOMMENDED CUTTING SPEED [For External Grooving / Cutting Off]

	Workpiece Material	Hardness	Grade	Cutting Speed v_c (m/min)					
				50	100	150	200	250	300
P	Mild Steel	$\leq 160\text{HB}$	VP20RT		100		220		
			VP10RT		110		230		
			NX2525		90		210		
	Carbon Steel Alloy Steel	160–280HB	VP20RT		80		180		
			VP10RT		90		190		
			MY5015		110		250		
			NX2525		70		170		
		280HB $\leq$	VP20RT		60		140		
			VP10RT		70		150		
			MY5015		90		210		
			NX2525		55		135		
M	Stainless Steel	$\leq 270\text{HB}$	VP20RT		60		140		
			VP10RT		70		150		
K	Gray Cast Iron	Tensile Strength $\leq 300\text{MPa}$	VP20RT		80		180		
			VP10RT		90		190		
			MY5015		140		300		
	Ductile Cast Iron	Tensile Strength $\leq 800\text{MPa}$	VP20RT		60		140		
			VP10RT		70		150		
			MY5015		90		210		
S	Heat Resistant Alloy Titanium Alloy	—	MP9015		40		100		
			MP9025		30		90		
			VP20RT		30		60		
			VP10RT/ RT9010		40		70		
H	Hardened Steel	50HRC $\leq$	BC8110/MB8025		80		120		

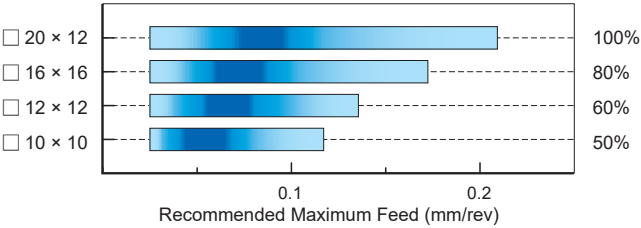
Note 1) For MP9015, MP9025, VP10RT, VP20RT and MY5015, wet cutting is recommended.

	Workpiece Material	Properties	Grade	Cutting Speed v_c (m/min)					
				50	100	200	300	400	500
N	Aluminium Alloys (A6061, 7075)	Content Si $<5\%$	RT9010			200			500
	Aluminium Alloys (AC4B)	Content 5% $\leq$ Si $\leq$ 10%	RT9010			200			500
	Aluminium Alloys (ADC12, A390)	Content Si $>10\%$	RT9010		100	200			

RECOMMENDED CUTTING CONDITIONS [For External Grooving / Cutting Off]

Recommended cutting conditions when combining a GYHR/L2525M00/90-M24R/L modular holder and GYM25R/LA-○○○○ modular blade.

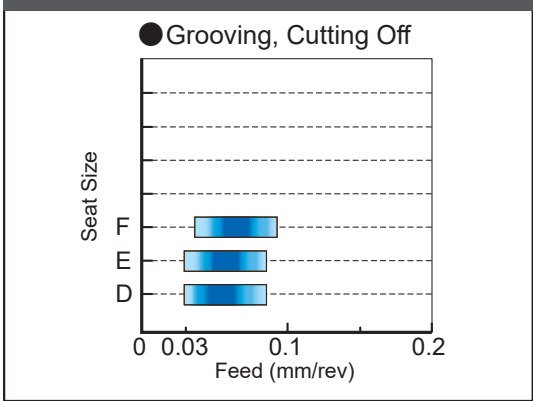
In the case of mono block type holder for Swiss style lathes



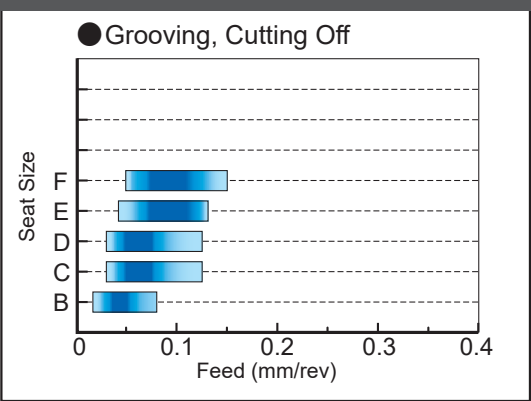
Please refer to the tables above on recommended cutting conditions for external grooving and cutting off.
Apply the percentage ratio shown on each shank size with the values in the table.

Recommended feed rate and depth of cut

GU BREAKER

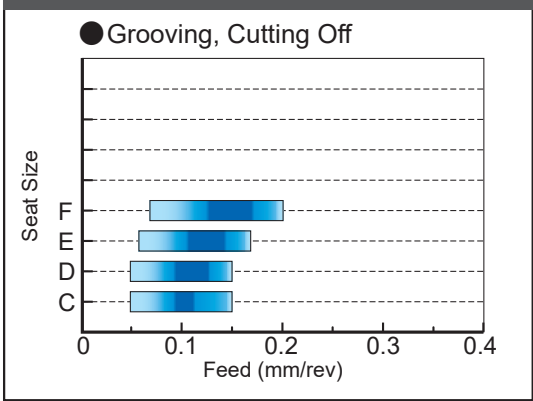


GS BREAKER

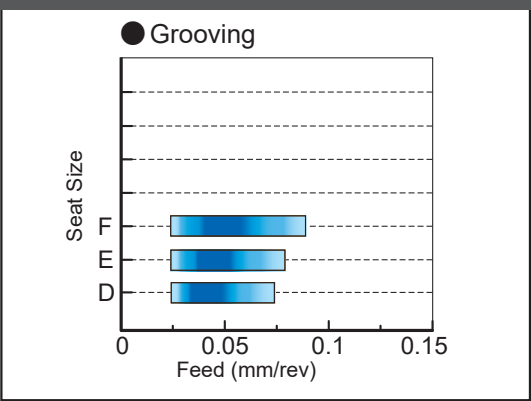


Seat Size	
Insert Width (mm)	
B	1.20
C	1.50
D	2.00
E	2.24
	2.39
	2.50
F	2.74
	3.00
	3.18
	3.24

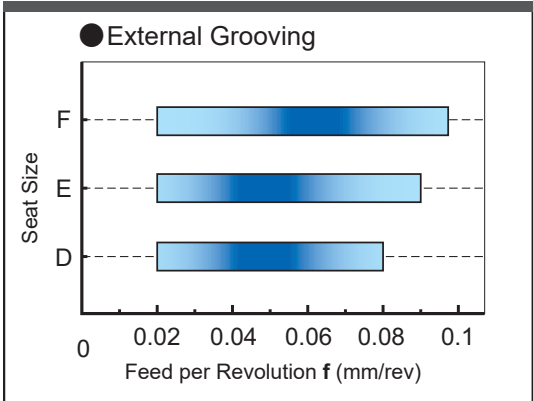
GM BREAKER



FLAT TOP GFGS (CBN)



GL BREAKER

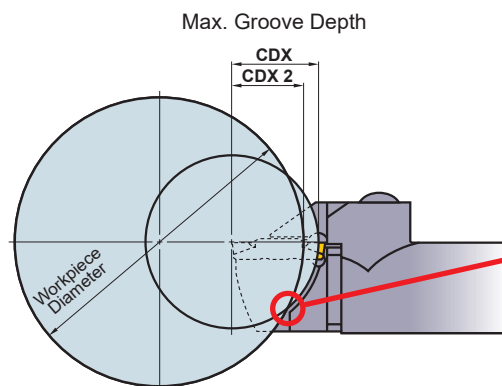


1st recommended area

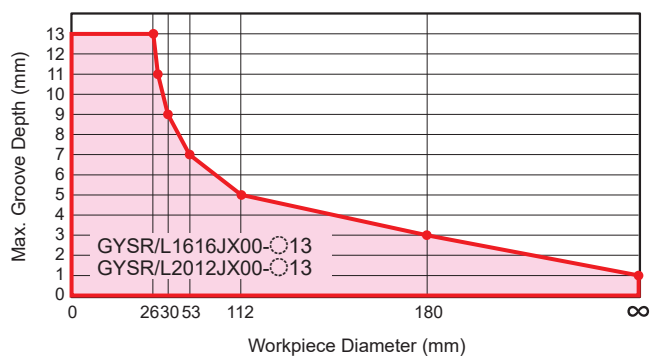
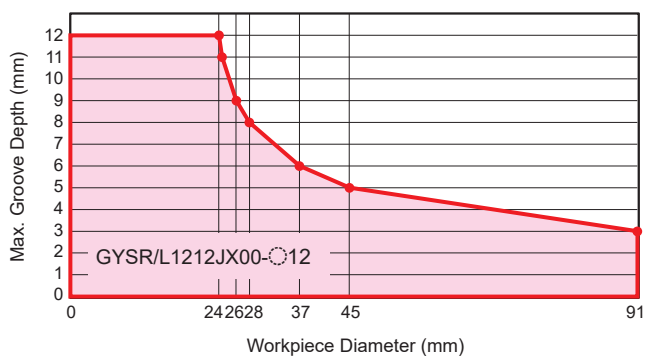
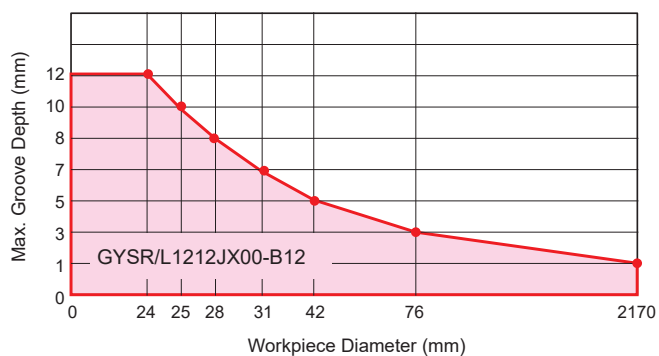
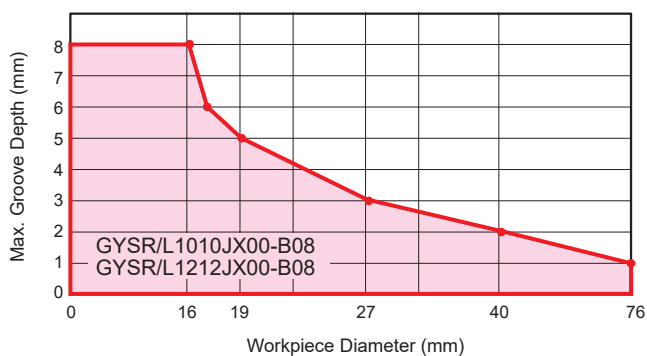
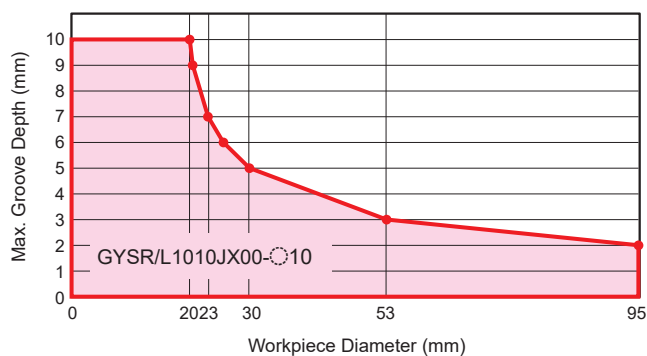
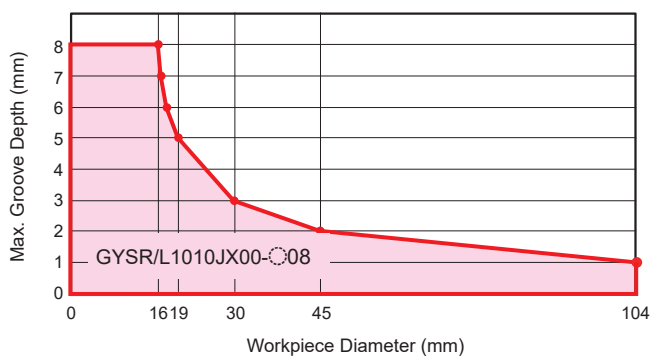
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

•In The Case of Mono Block Type Holder for Swiss-Type Lathes

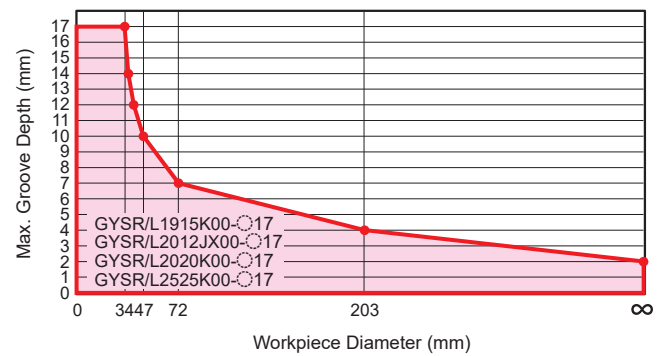
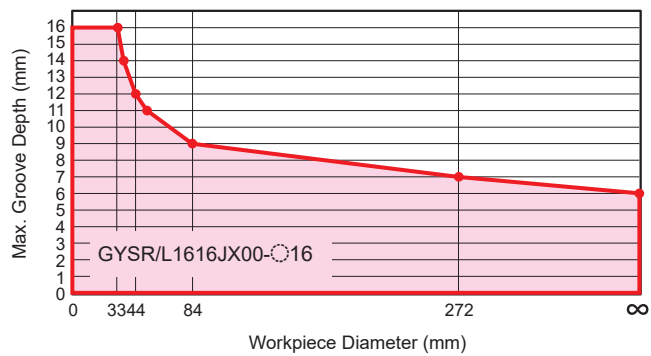
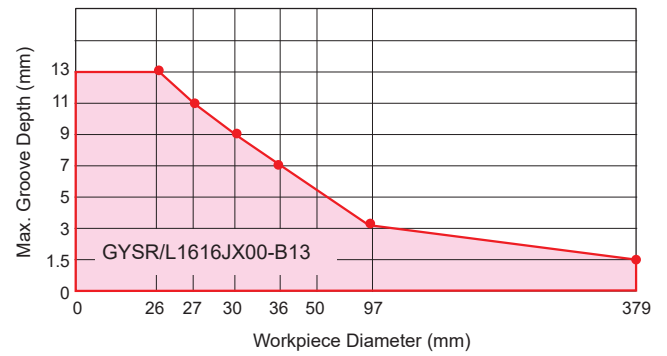
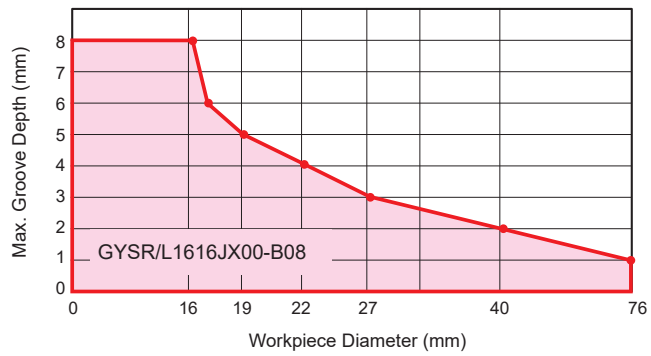
The maximum groove depth is limited by the workpiece diameter.



Due to interference, the maximum groove depth is limited by the workpiece diameter.



GY Series



GW Series

RECOMMENDED CUTTING CONDITIONS

■ Cutting Speed

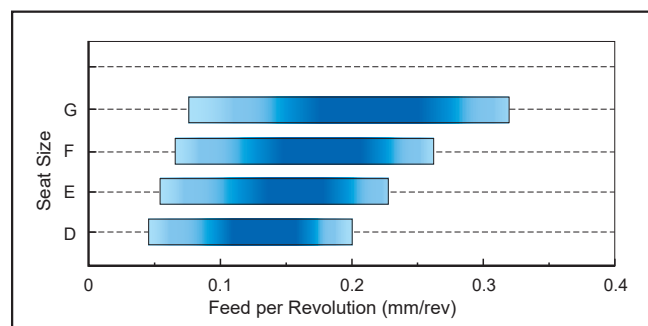
	Workpiece Material	Hardness	Grade	Cutting Speed (m/min)					
				50	100	150	200	250	300
P	Mild Steel	≤160HB	VP20RT		100		240		
			VP10RT		110		250		
	Carbon Steel Alloy Steel	160–280HB	VP20RT		80		200		
			VP10RT		90		210		
			VP30RT	60		180			
			MY5015		110		250		
		≥280HB	VP20RT	60		160			
			VP10RT		70		170		
			VP30RT	40		140			
			MY5015		90		210		
M	Stainless Steel	≤270HB	VP20RT		60		180		
			VP10RT		70		190		
			VP30RT	40		160			
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT		80		200		
			VP10RT		90		210		
			MY5015			140		300	
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	60		160			
			VP10RT		70		170		
			MY5015		90		210		
S	Heat Resistant Alloy Titanium Alloy	—	VP20RT	30	60				
			VP10RT	40	70				

Note 1) VP20RT is the first recommended grade for all materials.

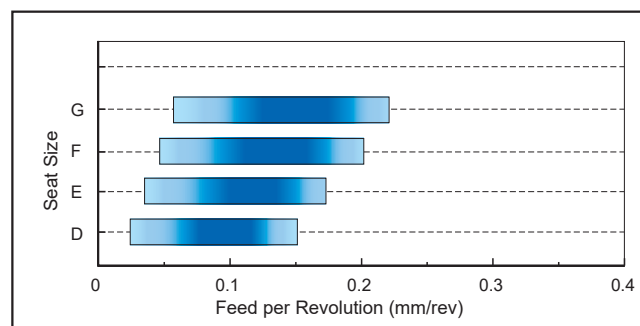
Note 2) For VP10RT, VP20RT, VP30RT and MY5015, wet cutting is recommended.

■ Feed per Revolution

GM Breaker



GS Breaker

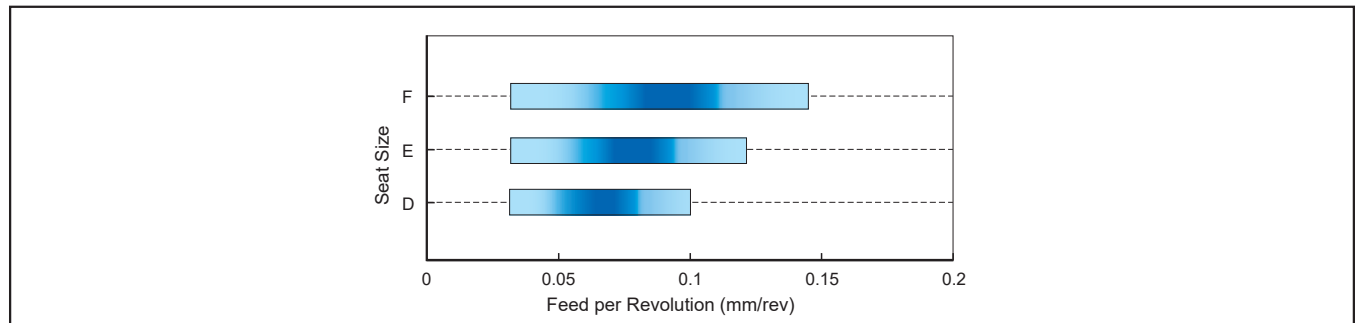


Chip Breaker	Feed per Revolution (mm/rev)			
	Seat Size D	Seat Size E	Seat Size F	Seat Size G
GM Breaker	0.05–0.20	0.06–0.23	0.07–0.26	0.08–0.32
GS Breaker	0.03–0.15	0.04–0.17	0.05–0.20	0.06–0.22

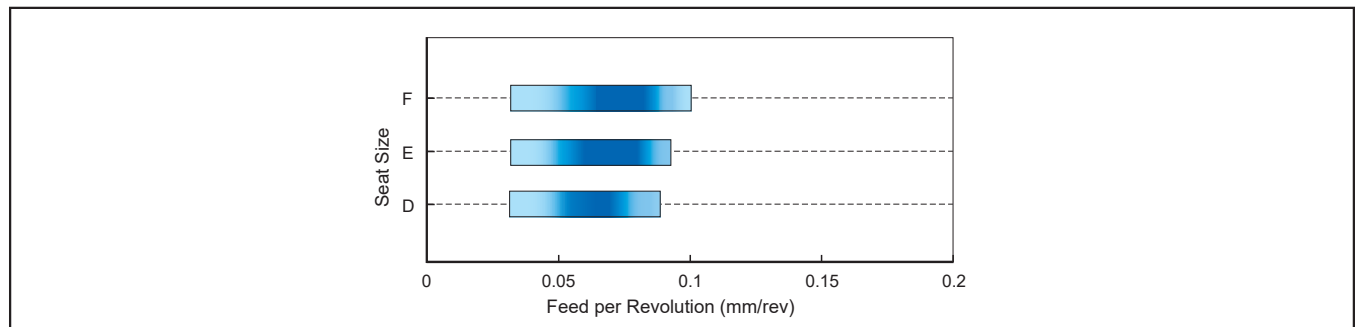
GW Series

Cutting Off Feed per Revolution

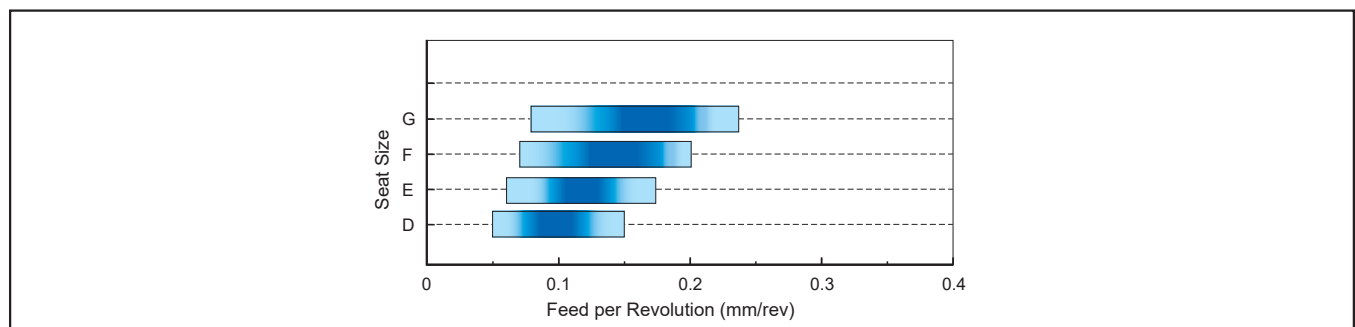
R05-GS Breaker



R08-GS Breaker



R/L05-GM Breaker

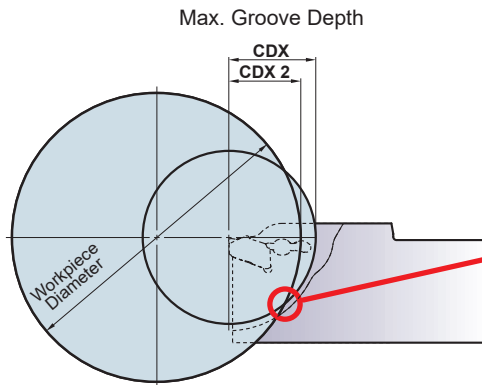


Chip Breaker	PSIPR	Hand	Feed per Revolution (mm/rev)			
			Seat Size D	Seat Size E	Seat Size F	Seat Size G
R05-GS	5°	R	0.03–0.10	0.03–0.12	0.03–0.14	–
R08-GS	8°	R	0.03–0.08	0.03–0.09	0.03–0.10	–
R05-GM	5°	R/L	0.05–0.15	0.06–0.17	0.07–0.20	0.08–0.23

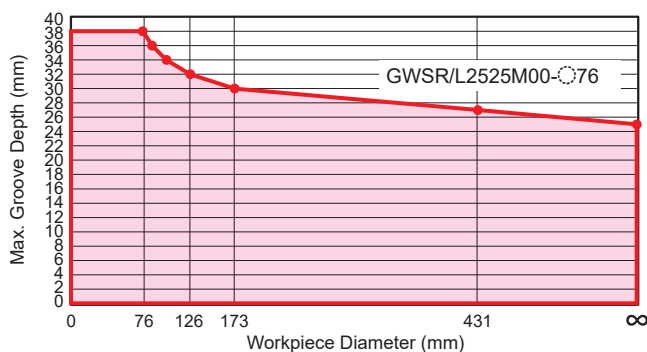
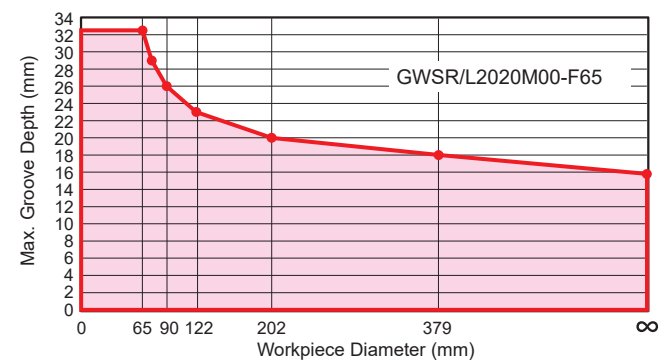
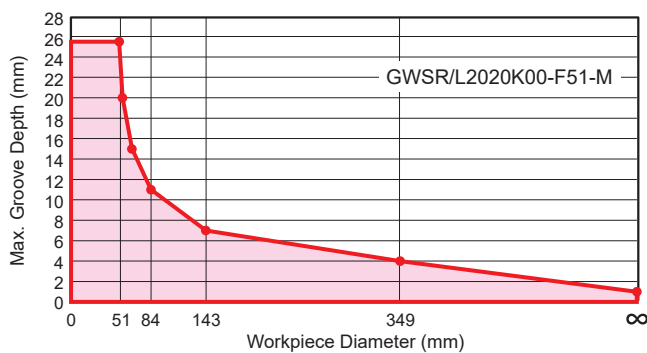
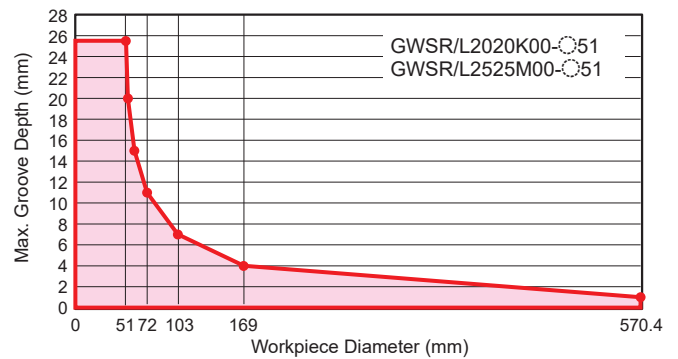
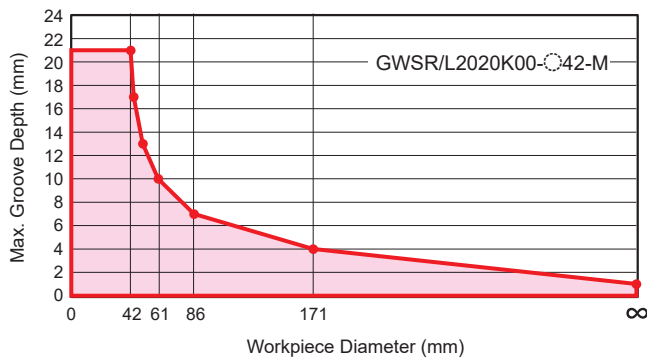
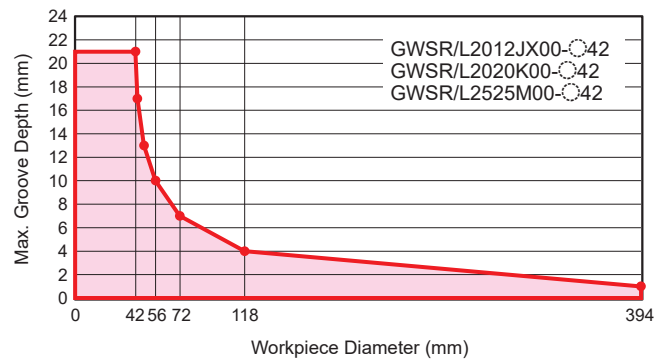
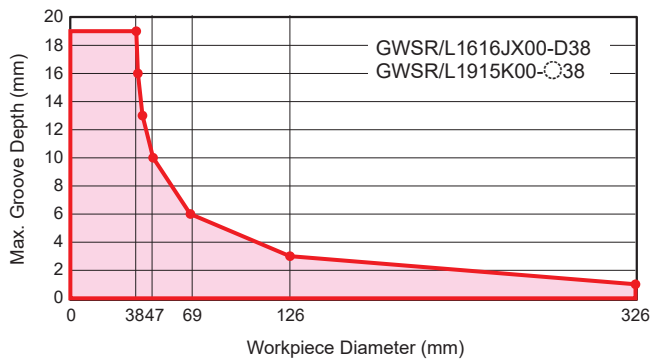
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

•In The Case of Mono Block Type Holder for Swiss-Type Lathes

The maximum groove depth is limited by the workpiece diameter.



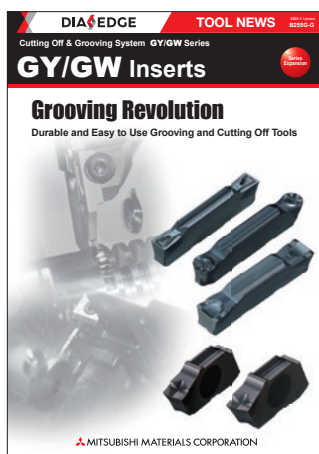
Due to interference, the maximum groove depth is limited by the workpiece diameter.



Cutting Off & Grooving System

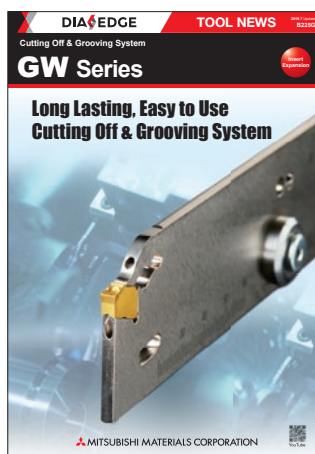
B225G-G TOOL NEWS

GY/GW Inserts



B225G TOOL NEWS

GW Series



For Your Safety

●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When attaching inserts or spare parts, please use only the correct wrench or driver. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

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