

HOW TO READ THE STANDARD OF GROOVING AND CUTTING OFF

● How this section page is organized

- ① Classified according to external or internal applications.
- ② Sub-classified according to product series.
(Refer to the index on the next page.)

[For External Grooving / Cutting Off]

FIGURE SHOWING THE TOOLING APPLICATION uses illustrations and arrows to depict available machining applications such as cutting off, grooving, and copying.

INDICATION OF HOLDER TYPE ACCORDING TO APPLICATION indicates the holder types, such as the standard type or the L type, according to machining application.

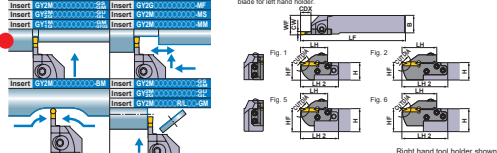
TITLE OF PRODUCT

PRODUCT SECTION

GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)

1-1 00° type holder (inch)
Note 1) For modular blades and holders, please order separately.
Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number	Fig.
D	.236	.472		Modular	R	GYHRUS10B00-M20R	3
				Modular	L	GYHLUS10B00-M20L	3
				Modular	R	GYHRUS12C00-M20R	1
				Modular	L	GYHLUS12C00-M20L	1
				Modular	R	GYHRUS12C00-M25R	3
				Modular	L	GYHLUS12C00-M25L	3
				Modular	R	GYHRUS16D00-M25R	1
				Modular	L	GYHLUS16D00-M25L	1
				Modular	R	GYHRUS16D00-M25R	3
				Modular	L	GYHLUS16D00-M25L	3
				Modular	R	GYHRUS16D00-M25R	5
				Modular	L	GYHLUS16D00-M25L	5
	.394	.787		Modular	R	GYHRUS10B00-M20R	3
				Modular	L	GYHLUS10B00-M20L	3
				Modular	R	GYHRUS12C00-M20R	1
				Modular	L	GYHLUS12C00-M20L	1
				Modular	R	GYHRUS12C00-M25R	3
				Modular	L	GYHLUS12C00-M25L	3
				Modular	R	GYHRUS16D00-M25R	1
				Modular	L	GYHLUS16D00-M25L	1
				Modular	R	GYHRUS16D00-M25R	3
				Modular	L	GYHLUS16D00-M25L	3
				Modular	R	GYHRUS16D00-M25R	5
				Modular	L	GYHLUS16D00-M25L	5
	.709	1.417		Modular	R	GYHRUS10B00-M20R	3
				Modular	L	GYHLUS10B00-M20L	3
				Modular	R	GYHRUS12C00-M20R	1
				Modular	L	GYHLUS12C00-M20L	1
				Modular	R	GYHRUS12C00-M25R	3
				Modular	L	GYHLUS12C00-M25L	3
				Modular	R	GYHRUS16D00-M25R	1
				Modular	L	GYHLUS16D00-M25L	1
				Modular	R	GYHRUS16D00-M25R	3
				Modular	L	GYHLUS16D00-M25L	3
				Modular	R	GYHRUS16D00-M25R	5
				Modular	L	GYHLUS16D00-M25L	5
	.787	1.575		Modular	R	GYHRUS10B00-M20R	3
				Modular	L	GYHLUS10B00-M20L	3
				Modular	R	GYHRUS12C00-M20R	1
				Modular	L	GYHLUS12C00-M20L	1
				Modular	R	GYHRUS12C00-M25R	3
				Modular	L	GYHLUS12C00-M25L	3
				Modular	R	GYHRUS16D00-M25R	1
				Modular	L	GYHLUS16D00-M25L	1
				Modular	R	GYHRUS16D00-M25R	3
				Modular	L	GYHLUS16D00-M25L	3
				Modular	R	GYHRUS16D00-M25R	5
				Modular	L	GYHLUS16D00-M25L	5

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 insert catalog for details.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used than LF, LH and LH 2 values may vary.

*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F106.

F018 ● : USA Stock

PRODUCT STANDARDS

indicates order numbers, stock status (per right/left hand), holders, Modular Blade, cutting widths, maximum groove depths, maximum cut-off diameters, dimensions, applicable inserts, and cutting edge shapes.

[For Internal Grooving]

PRODUCT FEATURES

MIN. CUTTING DIAMETER is color-coded to let you find, at a glance, the minimum cutting diameters for internal machining.

GEOMETRY

GROOVING / CUTTING OFF

F TYPE BORING BAR

1 Corner type (FSL108R, S110R)
2 Corner type (FSL112R, S114R, S116R)

Order Number	Stock	Insert Number	Dimensions (mm)	Max. Groove Depth (mm)	Wrench
FSL108R	●	MLG	100L 8 7 125 30 4.8 1.2 10 1.0 TS25 TKY08F	1.2	TS25 TKY08F
FSL110R	●	MLG	100L 10 9 150 40 5.8 1.5 12 1.0 TS25 TKY08F	1.5	TS25 TKY08F
FSL112R	●	MLG	140L 12 10 180 50 6.8 1.5 14 2.0 TS32 TKY08F	1.5	TS32 TKY08F
FSL114R	●	MLG	140L 14 12 180 60 7.8 2.0 16 2.0 TS32 TKY08F	2.0	TS32 TKY08F
FSL116R	●	MLG	200L 16 14 200 70 8.7 2.0 20 3.0 TS43 TKY15F	2.0	TS43 TKY15F

*DMIN : Min. Cutting Diameter

GROOVING / CUTTING OFF

FSL52 (Carbide shank) Internal grooving, Threading

Order Number	Stock	Insert Number	Dimensions (mm)	Max. Groove Depth (mm)	Wrench
FSL5208R	●	MLG	100L 8 7 125 30 4.8 1.2 10 1.0 TS25 TKY08F	1.2	TS25 TKY08F
FSL5210R	●	MLG	100L 10 9 150 40 5.8 1.5 12 1.0 TS25 TKY08F	1.5	TS25 TKY08F
FSL5212R	●	MLG	140L 12 10 180 50 6.8 1.5 14 2.0 TS32 TKY08F	1.5	TS32 TKY08F
FSL5214R	●	MLG	140L 14 12 180 60 7.8 2.0 16 2.0 TS32 TKY08F	2.0	TS32 TKY08F
FSL5216R	●	MLG	200L 16 14 200 70 8.7 2.0 20 3.0 TS43 TKY15F	2.0	TS43 TKY15F

*DMIN : Min. Cutting Diameter

F234 ● : USA Stock * : Stocked in Japan

LEGEND FOR STOCK STATUS MARK

is shown on the left hand page of each double-page spread.

- To Order : For holder, please specify order number and hand of tool (right/left).
For insert, please specify insert number and grade.

TURNING TOOLS

GROOVING AND CUTTING OFF

CLASSIFICATION (EXTERNAL)..... F002

CLASSIFICATION (INTERNAL)..... F003

STANDARD OF GROOVING AND CUTTING OFF TOOLS

EXTERNAL

FEATURES OF THE GY SERIES..... F004

IDENTIFICATION OF GY SERIES F008

GY SERIES INSERTS F011

GY SERIES REFERENCE DATA F015

GY SERIES F016, F168

GW SERIES F218

INTERNAL

GY SERIES F152

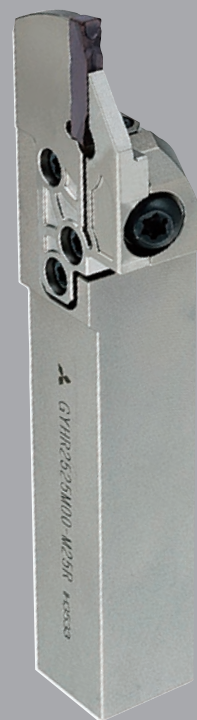
FSL51/52 TYPE F234

S-SL5N TYPE F235

MICRO-MINI TWIN BORING BARS F237

★Arranged by Alphabetical order.

F237	CG
F234	FSL5
F016	GY (Holders)
F011	GY (Inserts)
F226	GW (Blades)
F224	GW (Holder)
F229	GW (Inserts)
F236	MLG (Inserts)
F236	MLT (Inserts)
F235	S-SL5N



F001

CLASSIFICATION

EXTERNAL

Name of Tool Holder	Insert Shape	Features	Cutting Width According to Cutting Mode (inch)					
			Shallow Grooving	Deep Grooving	Cutting Off	Copying	Recessing	Face Grooving
GY Series  F016 F168		Modular type ● Clamp-on type. ● High accuracy and rigidity due to the modular blade. (Tri-lock system) ● Various insert types. Mono block type ● Spring clamp type.	.047" .059" .079" (2.0 mm) .088" .094" .098" (2.5 mm) .108" .118" (3.0 mm) .125" .128" .157" (4.0 mm) .167" .187" .197" (5.0 mm) .206" .236" (6.0 mm) .248" .250" .315" (8.0 mm)			.079" (2.0 mm) .079" (2.0 mm) .098" (2.5 mm) .098" (2.5 mm) .118" (3.0 mm) .118" (3.0 mm) .125" .125" .157" (4.0 mm) .157" (4.0 mm) .187" .187" (5.0 mm) .197" (5.0 mm) .236" (6.0 mm) .236" (6.0 mm) .250" .315" (8.0 mm)	.079" (2.0 mm) .079" (2.0 mm) .098" (2.5 mm) .098" (2.5 mm) .118" (3.0 mm) .118" (3.0 mm) .125" .125" .157" (4.0 mm) .157" (4.0 mm) .187" .187" (5.0 mm) .197" (5.0 mm) .236" (6.0 mm) .236" (6.0 mm) .250" .315" (8.0 mm)	.079" (2.0 mm) .088" .094" .098" (2.5 mm) .108" .118" (3.0 mm) .125" .128" .157" (4.0 mm) .167" .187" .197" (5.0 mm) .206" .236" (6.0 mm) .248" .250"
GW Series  F218		● Spring clamp type. ● Simple insert clamping method. ● The blade is possible to use with both external or through coolant. ● Breaker system offering excellent chip disposal properties. ● Maximum cut off diameter : 4.724" (120 mm).	.079" (2.0 mm) .094" .118" (3.0 mm) .157" (4.0 mm) .197" (5.0 mm)					

INTERNAL

Name of Tool Holder	Insert Shape	Features	Min. Cutting Diameter (inch)	Cutting Width (inch)	Max. Groove Depth (inch)
GY Series    F152		Modular type ● Clamp-on type. ● High accuracy and rigidity due to the modular blade. (Tri-lock system) ● Various insert types. Mono block type ● Spring clamp type.	.984" (25 mm)	.079" (2.0 mm) .088" .094" .098" (2.5 mm) .108" .118" (3.0 mm) .125" .128" .157" (4.0 mm) .167" .187" .197" (5.0 mm) .206" .236" (6.0 mm) .248" .250"	.157" .512"
FSL5/S-SL5 Boring Bars   F234		● Screw-on type. ● Precision class insert. ● Holder is capable of performing both grooving and threading. ● Maximum groove depth .118 inch.	.394"	.047" (1.2 mm) .059" (1.5 mm) .062" .079" (2.0 mm) .094" .118" (3.0 mm) .125" .156" .157" (4.0 mm)	.039" .118"
MICRO-MINI TWIN Boring Bars   F237	—	● Solid carbide type. ● Economical due to single holder with two cutting edges.	.118"	.04" .08"	.04" .08"
MICRO-MINI Boring Bars   E031	—	● Solid carbide type. ● Insert can be ground to suit the application.	.126"	.08" .12"	.04" .08"

F

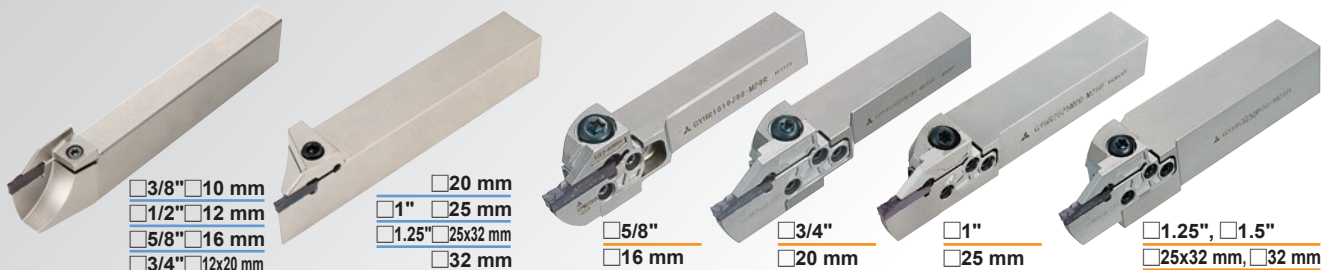
GROOVING / CUTTING OFF

GY SERIES

A wide selection of holders and inserts available for diverse grooving and cutting off applications

External • Face holders

Corresponding blades to a variety of modular holders with different shank sizes

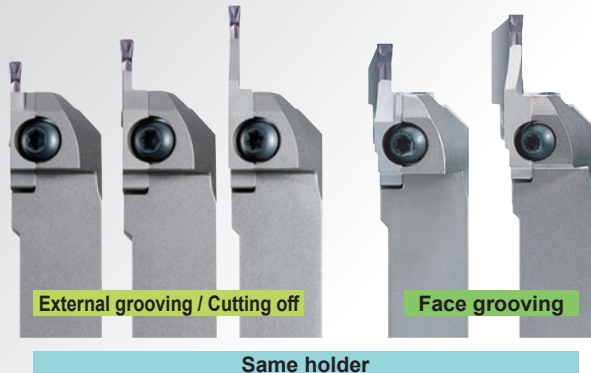


Mono block type

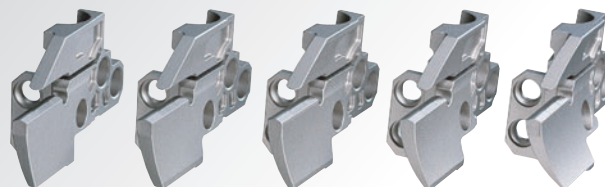
Modular type

F
GROOVING / CUTTING OFF

A wide selection of holders and inserts available for diverse grooving and cutting off applications

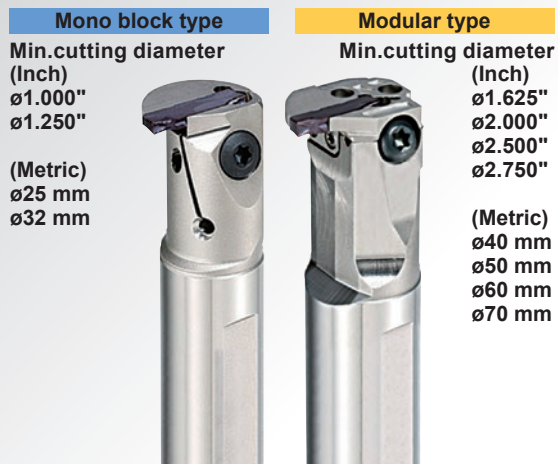


Applicable for various diameters of face grooves by the wide array of modular blades with different grooving diameters

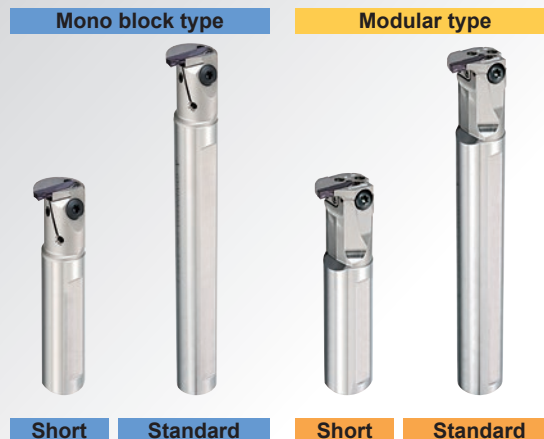


Internal holders

A wide range of holders available from minimum diameter of $\varnothing 25$ mm



Short shank types are standard stocked

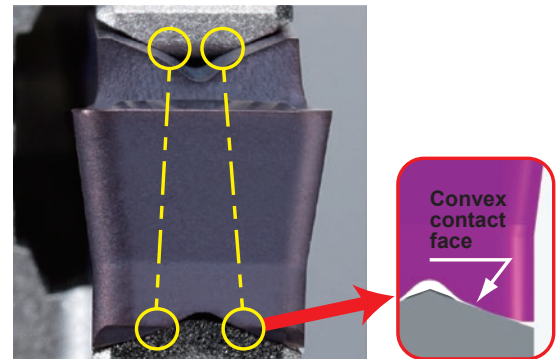
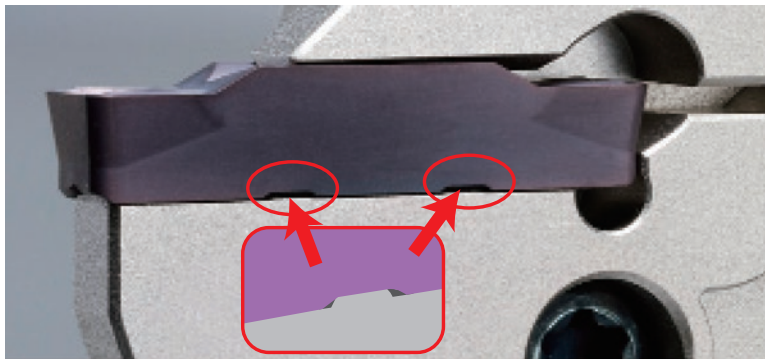


Original insert design leading the way to new grooving and cutting off applications

Highly reliable insert clamping

Safety keys prevent insert movement.

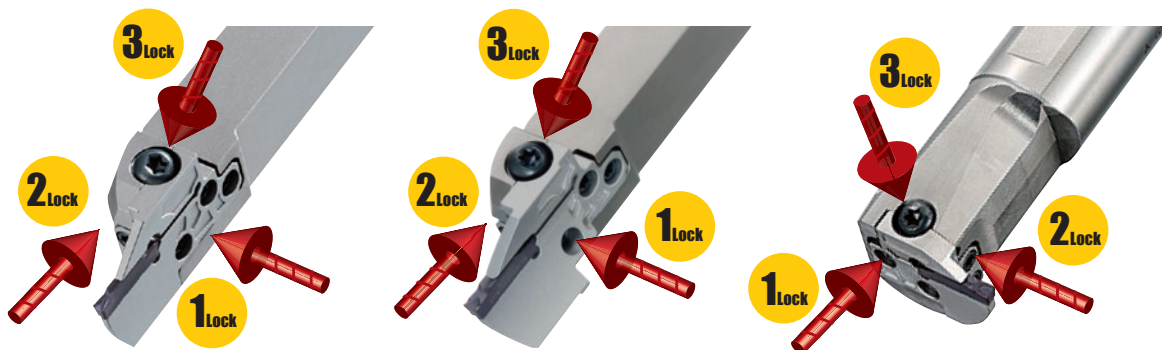
The convex geometry ensures high precision clamping.



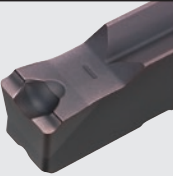
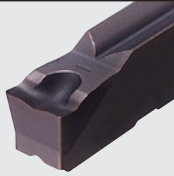
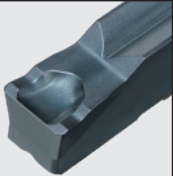
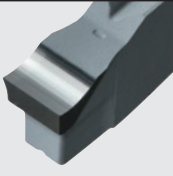
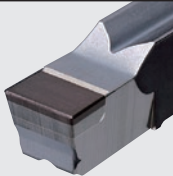
New TRI-LOCK System for increased stability and performance!

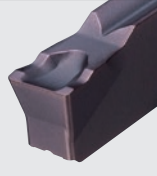
TRI-LOCK System

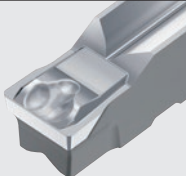
The TRI-LOCK system ensures the blade is securely fixed in 3 directions (side, front and top), giving high rigidity for stable grooving and cutting off performance.



A WIDE SELECTION OF INSERTS BREAKER SYSTEM

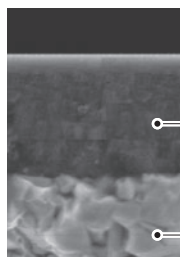
Grooving / Cutting Off				Grooving
				
GUBreaker (For Gummy Steel)	GSBreaker (Low feeds)	GMBreaker (Medium feeds)	GLBreaker (For Aluminum Alloy)	GFGS (CBN)

Cutting Off			
			
R08-GSBreaker (Low feeds)	R15-GSBreaker (Low feeds)	GMBreaker (Medium feeds)	R/L05-GMBreaker (Medium feeds)

For Multifunctional Grooving			Copying/Recessing
			
MFBreaker (G class)	MSBreaker (Low feeds)	MMBreaker (Medium feeds)	BMBreaker

INSERT GRADE

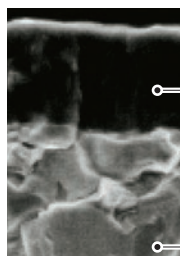
Work Material Machining Condition	P Steel	M Stainless Steel	K Cast Iron	N Aluminum Alloy	S Heat resistant Alloy / Titanium Alloy	H Hardened Steel
Stable ↑ Machining Condition ↓ Unstable	NX2525 MY5015 VP10RT VP20RT	VP10RT VP20RT	MY5015 VP10RT VP20RT	RT9010	NEW MP9015 RT9010 NEW MP9025	BC8110

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

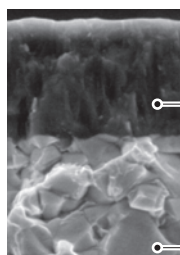
Special Cemented Carbide Substrate

VP20RT (1st Recommendation)

- 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

Carbide substrate (90.5HRA)

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

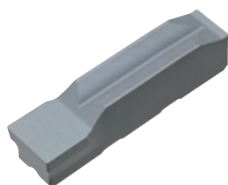
Carbide substrate (92.0HRA)

BLANK INSERTS

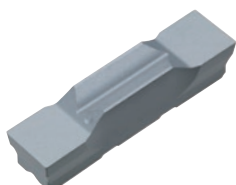
- Blank inserts for custom grinding

RT9010/RT9020 for blank insert

- First recommendation for blank inserts is RT9020 due to the tougher carbide substrate that is suitable for a wider range of applications. RT9010 has a harder substrate than RT9020 and is ideal for longer tool life on stable cutting applications. Both grades are recommended to have a coating applied that is suitable for the required application.

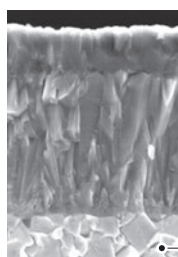


1 Edge Type



2 Edge Type

* Insert blank is not suitable for machining without grinding.

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 iron. Also suitable for high speed continuous cutting of steels.

CVD Coated Carbide

Carbide substrate

RT9010

- RT9010 is an uncoated cemented carbide grade. Suitable for processing non-ferrous metals.

NX2525

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

BC8110

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

GL Breaker for Aluminum Alloys**G Class Breaker**

Improved chip control by narrowing the breaker width.

High Rake Angle

Achieves low cutting resistance.

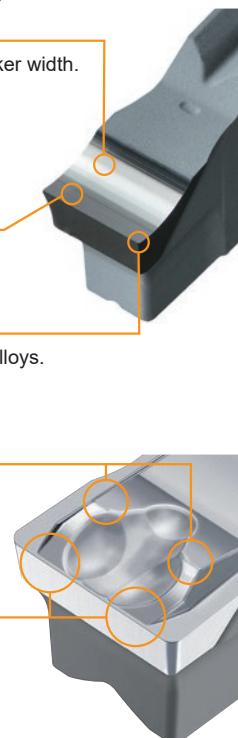
Sharp Edge

Improved welding resistance for aluminium alloys.

MF Breaker (Finishing)

Efficient chip breaking when cross-feed machining.

Chips are controlled when finish machining.



IDENTIFICATION OF GY SERIES

■ INSERT

① **GY** ② **2** ③ **M** ④ **0300** ⑤ **F** ⑥ **030** ⑦ **N** ⑧ **05** - ⑨ **M** ⑩ **F**

① **Series Description**

② **Number of Teeth**

1	1 Edge Type
2	2 Edge Type

③ **Peripheral**

G	Ground
M	Sintered
B	Blank

④ **Cutting Width**

	Inch	Metric
0150	.059"	1.50 mm
0200	.079"	2.00 mm
⋮	⋮	⋮
0800	.315"	8.00 mm

⑤ **Seat Size *1**

	Inch	Metric
B	.047"	1.20 mm
C	.059"	1.50 mm
D	.079" .088"	2.00 mm 2.24 mm
E	.094" .098" .108"	2.39 mm 2.50 mm 2.74 mm
F	.118" .125" .128"	3.00 mm 3.18 mm 3.24 mm
G	.157" .167"	4.00 mm 4.24 mm
H	.187" .197" .206"	4.75 mm 5.00 mm 5.24 mm
J	.236" .248" .250"	6.00 mm 6.31 mm 6.35 mm
K	.315"	8.00 mm

⑥ **Corner Radius**

	Inch	Metric
010	.004"	0.10 mm
015	.006"	0.15 mm
⋮	⋮	⋮
400	.157"	4.00 mm

⑦ **Hand**

N	Neutral
R	Right
L	Left

⑧ **Lead angle (R/L type insert)**

05	5°
08	8°
15	15°

⑨ **Application 1**

G	Grooving/Cutting off
M	Multifunctional
B	Copying (Ball nose)

⑩ **Application 2**

U	For Gummy Steel
F	Finishing
S	Low feeds
M	Medium feeds
L	For Aluminum Alloys

■ CBN INSERT

① **GY** ② **1** ③ **G** ④ **0300** ⑤ **F** ⑥ **020** ⑦ **N** - ⑧ **G** ⑨ **F** ⑩ **GS**

*1 Select a seat size with the same symbol as that of the modular blade and mono block holder.

⑪ **Application 3**

F	Flat Top
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⑫ **Honing Type**

GS	General Purpose
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■ MODULAR BLADE

● EXTERNAL/INTERNAL/RECESSING

① **GY** ② **M25** ③ **R** ④ **A** - ⑤ **F** ⑥ **12** *3

① **Series Description**

② **Modular Blade Size**

M20
M25

③ **Hand**

R	Right
L	Left

④ **Modular Blade Type**

A	Standard Type
B	Reinforced Type
C	External Recessing
D	Face Grooving

⑤ **Seat Size *1**

	Inch	Metric
D	.079" .088"	2.00 mm 2.24 mm
E	.094" .098" .108"	2.39 mm 2.50 mm 2.74 mm
F	.118" .125" .128"	3.00 mm 3.18 mm 3.24 mm
G	.157" .167"	4.00 mm 4.24 mm
H	.187" .197" .206"	4.75 mm 5.00 mm 5.24 mm
J	.236" .248" .250"	6.00 mm 6.31 mm 6.35 mm

⑥ **Max. Groove Depth *2**

	Inch	Metric
005	.197"	0.5 mm
06	.236"	6 mm
⋮	⋮	⋮
25	.984"	25.0 mm

● FACE GROOVING

① **GY** ② **M25** ③ **R** ④ **D** - ⑤ **F** ⑥ **12** - ⑦ **050**

⑦ **Min. Groove Diameter**

	Inch	Metric
035	1.378"	35 mm
040	1.575"	40 mm
⋮	⋮	⋮
250	9.843"	250 mm

*1 Select a seat size with the same symbol as that of the insert.

*2 The maximum groove depth is a value when used for external grooving and changes according to the insert used.

For internal grooving, refer to the maximum groove depth on pages F152 – F167.

*3 GYM20R/LA-○10, GYM20R/LA-○12, GYM25R/LA-○12 and GYM25R/LA-○14 can be used for both external and internal grooving.

EXTERNAL/FACE GROOVING/RECESSING

● MONO BLOCK HOLDER

(Inch) **GY** **P** **R** **US16** **D** **00** - **K** **25**

(Metric) **2525** **M**

① Series Description

② Holder Type	
S	Mono Block Holder for Swiss-type Lathe
P	Offset Mono Block Holder
Q	Zero Offset Mono Block Holder
H	Modular Type Holder

③ Hand of Holder

R	Right
L	Left

④ Holder Size

	Inch		Metric
US06	.375"x.375"	1010	10 mmx10 mm
US08	.500"x.500"	1212	12 mmx12 mm
US10	.625"x.625"	1616	16 mmx16 mm
US12	.750"x.750"	2012	20 mmx20 mm
US16	1.000"x1.000"	2020	20 mmx20 mm
US20	1.250"x1.250"	2525	25 mmx25 mm
US24	1.500"x1.500"	3225	32 mmx25 mm
		3232	32 mmx32 mm

⑤ Holder Length

	Inch		Metric
B	4.5"	J	110 mm
C	5.0"	JX	120 mm
D	6.0"	K	125 mm
E	7.0"	M	150 mm
		P	170 mm

⑥ Angle (degree)

00	0°
50	50°
90	90°

⑦ Seat Size *1

	Inch	Metric
B	.047"	1.20 mm
C	.059"	1.50 mm
D	.079" .088"	2.00 mm 2.24 mm
E	.094" .098" .108"	2.39 mm 2.50 mm 2.74 mm
F	.118" .125" .128"	3.00 mm 3.18 mm 3.24 mm
G	.157" .167"	4.00 mm 4.24 mm
H	.187" .197" .206"	4.75 mm 5.00 mm 5.24 mm
J	.236" .248" .250"	6.00 mm 6.31 mm 6.35 mm
K	.315"	8.00 mm

⑧ Max. Grooving Depth

	Inch	Metric
06	.236"	6 mm
08	.315"	8 mm
⋮	⋮	⋮
25	.984"	25 mm

● MODULAR TYPE HOLDER

(Inch) **GY** **H** **R** **US16** **M** **00** - **M25** **R**

(Metric) **2525**

⑨ Modular Blade Size

M20
M25

⑩ Hand of Modular Blade

R	Right
L	Left

*1 Select a seat size with the same symbol as that of the insert.

INTERNAL

● MONO BLOCK HOLDER

(Inch) **GY** **A** **R** **US16** **K** **90** **A** - **F** **06**

(Metric) **20**

① Series Description

② Holder Type	
A	Mono Block
D	Modular Type Holder

③ Hand of Holder

R	Right
L	Left

④ Shank Size

	Inch		Metric
US12	.750"	20	20 mm
US16	1.000"	25	25 mm
US20	1.250"	32	32 mm
US24	1.500"	40	40 mm
US32	2.000"	50	50 mm

⑤ Holder Length

	Inch	Metric
K	5.0"	125 mm
L	5.5"	140 mm
M	6.0"	150 mm
P	6.75"	170 mm
Q	7.0"	180 mm
R	8.0"	200 mm
S	10.0"	250 mm
T	12.0"	300 mm

⑥ Angle (degree)

90	90°
----	-----

⑦ Neck Length

	Inch	Metric
A	1.250"	30 mm
B	1.500"	40 mm
C	2.000"	50 mm
D	2.500"	60 mm
F	3.250"	80 mm

⑧ Seat Size *1

	Inch	Metric
D	.079" .088"	2.00 mm 2.24 mm
E	.094" .098" .108"	2.39 mm 2.50 mm 2.74 mm
F	.118" .125" .128"	3.00 mm 3.18 mm 3.24 mm
G	.157" .167"	4.00 mm 4.24 mm
H	.187" .197" .206"	4.75 mm 5.00 mm 5.24 mm
J	.236" .248" .250"	6.00 mm 6.31 mm 6.35 mm

⑨ Max. Grooving Depth

	Inch	Metric
06	.236"	6 mm
07	.276"	7 mm

● MODULAR TYPE HOLDER

(Inch) **GY** **D** **R** **US20** **M** **90** **D** - **M25** **L**

(Metric) **40**

⑩ Modular Blade Size

M20
M25

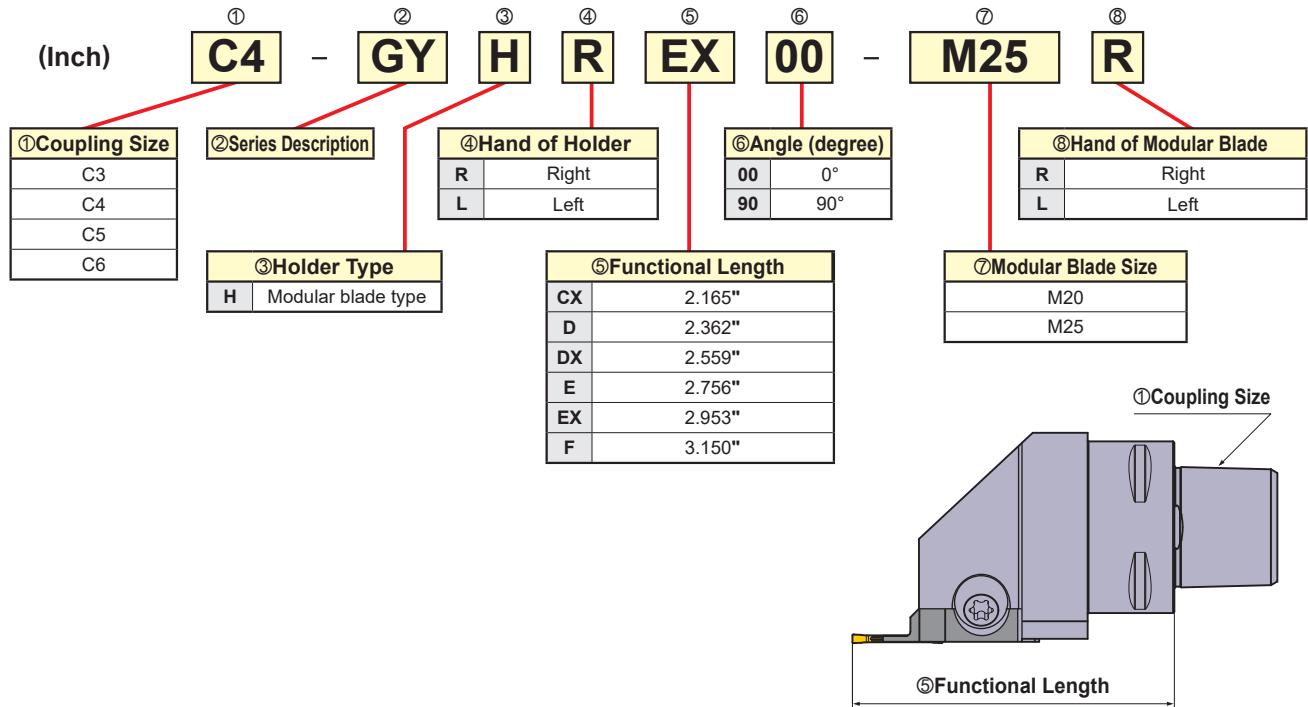
⑪ Hand of Modular Blade

R	Right
L	Left

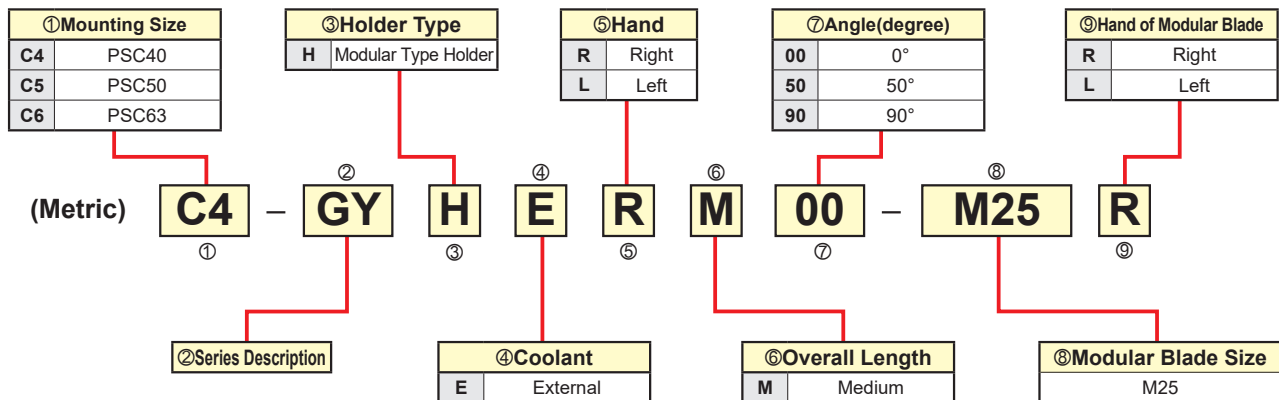
*1 Select a seat size with the same symbol as that of the insert.

IDENTIFICATION OF GY-PSC Holder

EXTERNAL



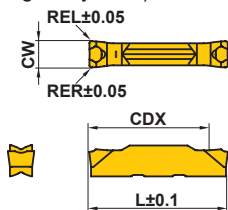
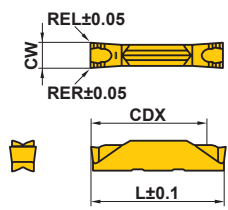
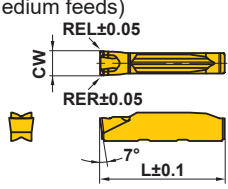
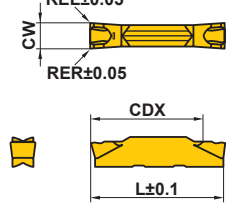
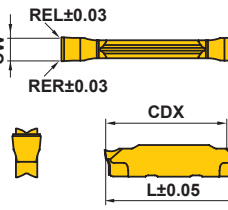
EXTERNAL/FACE GROOVING/RECESSING



GY SERIES INSERTS

INSERTS

(inch)

Applications	Geometry	Order Number	Stock								Seat Size	CW			RER/L	CDX	*2 L	
			Coated				Cermet		Carbide			Cutting Width		Tolerance				
			NEW	NEW								inch	(mm)					
			MP9015	MP9025	VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020								
For Grooving / Cutting Off	GU Breaker (For gummy steel) 	GY2M0200D020N-GU			●	●		●				D	.079	(2.00)	±.0012	.008	.776	.815
		GY2M0239E020N-GU			●	●		●				E	.094	(2.39)	±.0012	.008	.780	.815
		GY2M0250E020N-GU			●	●		●				E	.098	(2.50)	±.0012	.008	.768	.815
		GY2M0300F030N-GU			●	●		●				F	.118	(3.00)	±.0012	.012	.760	.815
		GY2M0318F030N-GU			●	●		●				F	.125	(3.18)	±.0012	.012	.760	.815
		GY2M0400G030N-GU			●	●		●				G	.157	(4.00)	±.0016	.012	.953	1.010
		GY2M0475H040N-GU			●	●		●				H	.187	(4.75)	±.0016	.016	.953	1.010
		GY2M0500H040N-GU			●	●		●				H	.197	(5.00)	±.0016	.016	.953	1.010
		GY2M0600J040N-GU			●	●		●				J	.236	(6.00)	±.0016	.016	.953	1.010
	GY2M0635J040N-GU			●	●		●				J	.250	(6.35)	±.0016	.016	.953	1.010	
	GS Breaker (Low feeds) 	NEW GY2M0120B010N-GS			●	●						B	.047	(1.20)	±.0012	.004	.480	.579
		GY2M0150C010N-GS			●	●		●				C	.059	(1.50)	±.0012	.004	.528	.579
		GY2M0200D020N-GS			●	●		●				D	.079	(2.00)	±.0012	.008	.736	.815
		GY2M0239E020N-GS			●	●		●				E	.094	(2.39)	±.0012	.008	.728	.815
		GY2M0250E020N-GS			●	●		●				E	.098	(2.50)	±.0012	.008	.728	.815
		GY2M0300F020N-GS			●	●		●				F	.118	(3.00)	±.0012	.008	.728	.815
		GY2M0318F020N-GS			●	●		●				F	.125	(3.18)	±.0012	.008	.728	.815
		GY2M0400G020N-GS			●	●		●				G	.157	(4.00)	±.0016	.008	.941	1.010
		GY2M0475H030N-GS			●	●		●				H	.187	(4.75)	±.0016	.012	.941	1.010
		GY2M0500H030N-GS			●	●		●				H	.197	(5.00)	±.0016	.012	.945	1.010
		GY2M0600J030N-GS			●	●		●				J	.236	(6.00)	±.0016	.012	.949	1.010
	GY2M0635J030N-GS			●	●		●				J	.250	(6.35)	±.0016	.012	.949	1.010	
	GY2M0800K030N-GS			●	●						K	.315	(8.00)	±.0016	.012	1.146	1.201	
	GM Breaker (Medium feeds) 	GY1M0200D020N-GM	●	●	●	●	●					D	.079	(2.00)	±.0012	.008	—	.815
		GY1M0250E020N-GM	●	●	●	●	●					E	.098	(2.50)	±.0012	.008	—	.815
		GY1M0300F030N-GM	●	●	●	●	●					F	.118	(3.00)	±.0012	.012	—	.815
		GY1M0400G030N-GM	●	●	●	●	●					G	.157	(4.00)	±.0016	.012	—	1.010
		GY1M0500H040N-GM	●	●	●	●	●					H	.197	(5.00)	±.0016	.016	—	1.010
	GM Breaker (Medium feeds) 	GY2M0150C020N-GM	●	●	●	●	●					C	.059	(1.50)	±.0012	.008	.547	.579
		GY2M0200D020N-GM	●	●	●	●	●					D	.079	(2.00)	±.0012	.008	.764	.815
		GY2M0239E020N-GM	●	●	●	●	●					E	.094	(2.39)	±.0012	.008	.764	.815
		GY2M0250E020N-GM	●	●	●	●	●					E	.098	(2.50)	±.0012	.008	.764	.815
		GY2M0300F030N-GM	●	●	●	●	●					F	.118	(3.00)	±.0012	.012	.764	.815
		GY2M0318F030N-GM	●	●	●	●	●					F	.125	(3.18)	±.0012	.012	.764	.815
		GY2M0400G030N-GM	●	●	●	●	●					G	.157	(4.00)	±.0016	.012	.961	1.010
		GY2M0475H040N-GM	●	●	●	●	●					H	.187	(4.75)	±.0016	.016	.957	1.010
		GY2M0500H040N-GM	●	●	●	●	●					H	.197	(5.00)	±.0016	.016	.957	1.010
		GY2M0600J040N-GM	●	●	●	●	●					J	.236	(6.00)	±.0016	.016	.957	1.010
		GY2M0635J040N-GM	●	●	●	●	●					J	.250	(6.35)	±.0016	.016	.957	1.010
	GY2M0800K050N-GM	●	●	●	●	●					K	.315	(8.00)	±.0016	.020	1.154	1.201	
	GL Breaker (For Aluminum Alloys) 	GY2G0200D005N-GL									●	D	.079	(2.00)	±.0008	.002	.768	.829
		GY2G0250E005N-GL									●	E	.098	(2.50)	±.0008	.002	.752	.829
		GY2G0300F005N-GL									●	F	.118	(3.00)	±.0008	.002	.744	.829

*2 The dimension depends on the breaker. Refer to the F015 "L dimension tolerance conversion table".

● = NEW

● : USA Stock

<10 inserts in one case>

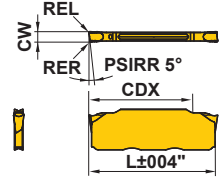
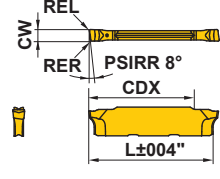
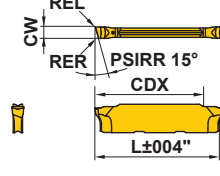
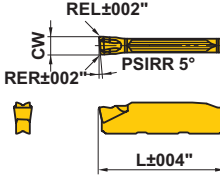
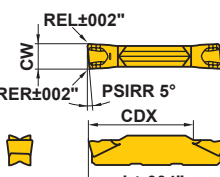
GROOVING / CUTTING OFF

F011

GY SERIES INSERTS

INSERTS

(inch)

Applications	Geometry	Order Number	Stock					Seat Size	CW			Corner R				CDX	*2 L
			Coated						Cutting Width	Tolerance	REL	Tolerance	RER	Tolerance			
			NEW	NEW	VP10RT	VP20RT	MV5015										
			MP9015	MP9025													
For Cutting off	R05-GS Breaker NEW (Low feeds) 	GY2M0120B010R05-GS			●	●		B	.047	(1.20)	±.0012	.004	±.0020	.004	±.002	.481	.579
	R08-GS Breaker NEW (Low feeds) 	GY2G0150C010R08-GS GY2G0200D020R08-GS GY2G0250E020R08-GS GY2G0300F020R08-GS			●	●		C D E F	.059 .079 .098 .118	(1.50) (2.00) (2.50) (3.00)	±.0008 ±.0012 ±.0012 ±.0012	.004 .008 .008 .008	±.0012 ±.0020 ±.0020 ±.0020	.004 .008 .008 .008	— — — —	.519 .742 .750 .733	.600 .840 .845 .848
	R15-GS Breaker NEW (Low feeds) 	GY2G0150C003R15-GS GY2G0150C010R15-GS GY2G0200D003R15-GS GY2G0200D010R15-GS GY2G0250E003R15-GS GY2G0250E020R15-GS GY2G0300F003R15-GS GY2G0300F020R15-GS			●	●		C C D D E E F F	.059 .059 .079 .079 .098 .098 .118 .118	(1.50) (1.50) (2.00) (2.00) (2.50) (2.50) (3.00) (3.00)	±.0008 ±.0008 ±.0012 ±.0012 ±.0012 ±.0012 ±.0012 ±.0012	.0012 .004 .0012 .004 .0012 .008 .0012 .008	+0.0012, -0.0008 ±.0012 +0.0012, -0.0008 ±.0012 +0.0012, -0.0008 ±.0020 +0.0012, -0.0008 ±.0020	.004 .004 .004 .004 .004 .004 .004 .004	— — — — — — — —	.519 .519 .742 .742 .750 .750 .733 .733	.600 .600 .839 .839 .845 .845 .850 .848
	R/L05-GM Breaker  Right hand insert shown.	GY1M0200D020R05-GM GY1M0200D020L05-GM GY1M0300F030R05-GM GY1M0300F030L05-GM			●	●		D D F F	.079 .079 .118 .118	(2.00) (2.00) (3.00) (3.00)	±.0012 ±.0012 ±.0012 ±.0012	.008 .008 .012 .012	±.0020 ±.0020 ±.0020 ±.0020	.008 .008 .012 .012	±.002 ±.002 ±.002 ±.002	— — — —	.819 .819 .821 .821
	R/L05-GM Breaker  Right hand insert shown.	GY2M0200D020R05-GM GY2M0200D020L05-GM GY2M0250E020R05-GM GY2M0250E020L05-GM GY2M0300F030R05-GM GY2M0300F030L05-GM GY2M0400G030R05-GM GY2M0400G030L05-GM GY2M0500H040R05-GM GY2M0500H040L05-GM			●	●		D D E E F F G G H H	.079 .079 .098 .098 .118 .118 .157 .157 .197 .197	(2.00) (2.00) (2.50) (2.50) (3.00) (3.00) (4.00) (4.00) (5.00) (5.00)	±.0012 ±.0012 ±.0012 ±.0012 ±.0012 ±.0012 ±.0016 ±.0016 ±.0016 ±.0016	.008 .008 .008 .008 .012 .012 .012 .012 .016 .016	±.0020 ±.0020 ±.0020 ±.0020 ±.0020 ±.0020 ±.0020 ±.0020 ±.0020 ±.0020	.008 .008 .008 .008 .012 .012 .012 .012 .016 .016	±.002 ±.002 ±.002 ±.002 ±.002 ±.002 ±.002 ±.002 ±.002 ±.002	.768 .768 .768 .768 .768 .768 .965 .965 .965 .965	.819 .819 .820 .820 .821 .821 1.018 1.018 1.022 1.022

*2 The dimension depends on the breaker. Refer to the F015 "L dimension tolerance conversion table".

● = NEW

● : USA Stock

F012

<10 inserts in one case> <CBN inserts are available in 1 piece in one case.>

(inch)

Applications	Geometry	Order Number	Stock									Seat Size	CW			RER/L	CDX	*2 L	LE	
			Coated			Cermet	Carbide	CBN	Cutting Width	Tolerance										
			NEW	NEW																
			MP9015	MP9025	VP10RT						VP20RT		MY5015	NX2525	RT9010					RT9020
For Grooving	Flat Top (For Hardened Steel) 	GY1G0200D020N-GFGS									●	D	.079	(2.00)	±.0012	.008	—	.815	.106	
		GY1G0239E020N-GFGS										●	E	.094	(2.39)	±.0012	.008	—	.815	.106
		GY1G0250E020N-GFGS										●	E	.098	(2.50)	±.0012	.008	—	.815	.106
		GY1G0300F020N-GFGS										●	F	.118	(3.00)	±.0012	.008	—	.815	.106
		GY1G0318F020N-GFGS										●	F	.125	(3.18)	±.0012	.008	—	.815	.106
		GY1G0400G020N-GFGS										●	G	.157	(4.00)	±.0012	.008	—	1.010	.106
		GY1G0475H020N-GFGS										●	H	.187	(4.75)	±.0012	.008	—	1.010	.106
		GY1G0500H020N-GFGS										●	H	.197	(5.00)	±.0012	.008	—	1.010	.106
		GY1G0600J020N-GFGS										●	J	.236	(6.00)	±.0012	.008	—	1.010	.106
		For Multifunctional Grooving	MF Breaker (Finishing) 	GY2G0200D020N-MF			●	●		●		●			D	.079	(2.00)	±.0008	.008	.768
*1 GY2G0224D015N-MF					●	●		●		●			D	.088	(2.24)	±.0008	.006	.780	.829	—
GY2G0239E020N-MF					●	●		●		●			E	.094	(2.39)	±.0008	.008	.756	.829	—
GY2G0250E020N-MF					●	●		●		●			E	.098	(2.50)	±.0008	.008	.764	.829	—
*1 GY2G0274E020N-MF					●	●		●		●			E	.108	(2.74)	±.0008	.008	.776	.829	—
GY2G0300F020N-MF					●	●		●		●			F	.118	(3.00)	±.0008	.008	.768	.829	—
GY2G0300F040N-MF					●	●		●		●			F	.118	(3.00)	±.0008	.016	.760	.829	—
GY2G0318F020N-MF					●	●		●		●			F	.125	(3.18)	±.0008	.008	.768	.829	—
GY2G0318F040N-MF					●	●		●		●			F	.125	(3.18)	±.0008	.016	.760	.829	—
*1 GY2G0324F020N-MF					●	●		●		●			F	.128	(3.24)	±.0008	.008	.768	.829	—
GY2G0400G020N-MF					●	●		●		●			G	.157	(4.00)	±.0008	.008	.980	1.022	—
GY2G0400G040N-MF					●	●		●		●			G	.157	(4.00)	±.0008	.016	.972	1.022	—
GY2G0400G080N-MF					●	●		●		●			G	.157	(4.00)	±.0008	.031	.957	1.022	—
*1 GY2G0424G020N-MF					●	●		●		●			G	.167	(4.24)	±.0008	.008	.980	1.022	—
GY2G0475H020N-MF					●	●		●		●			H	.187	(4.75)	±.0008	.008	.961	1.022	—
GY2G0475H040N-MF					●	●		●		●			H	.187	(4.75)	±.0008	.016	.953	1.022	—
GY2G0475H080N-MF					●	●		●		●			H	.187	(4.75)	±.0008	.031	.937	1.022	—
GY2G0500H020N-MF					●	●		●		●			H	.197	(5.00)	±.0008	.008	.961	1.022	—
GY2G0500H040N-MF					●	●		●		●			H	.197	(5.00)	±.0008	.016	.953	1.022	—
GY2G0500H080N-MF					●	●		●		●			H	.197	(5.00)	±.0008	.031	.937	1.022	—
*1 GY2G0524H020N-MF					●	●		●		●			H	.206	(5.24)	±.0008	.008	.961	1.022	—
GY2G0600J020N-MF					●	●		●		●			J	.236	(6.00)	±.0008	.008	.961	1.022	—
GY2G0600J040N-MF					●	●		●		●			J	.236	(6.00)	±.0008	.016	.953	1.022	—
GY2G0600J080N-MF					●	●		●		●			J	.236	(6.00)	±.0008	.031	.937	1.022	—
*1 GY2G0631J020N-MF					●	●		●		●			J	.248	(6.31)	±.0008	.008	.961	1.022	—
GY2G0635J020N-MF					●	●		●		●			J	.250	(6.35)	±.0008	.008	.961	1.022	—
GY2G0635J040N-MF					●	●		●		●			J	.250	(6.35)	±.0008	.016	.953	1.022	—
GY2G0635J080N-MF					●	●		●		●			J	.250	(6.35)	±.0008	.031	.937	1.022	—
MS Breaker (Low feeds) 	GY2M0200D020N-MS				●	●		●				D	.079	(2.00)	±.0012	.008	.752	.815	—	
	GY2M0250E020N-MS				●	●		●				E	.098	(2.50)	±.0012	.008	.752	.815	—	
	GY2M0300F020N-MS				●	●		●				F	.118	(3.00)	±.0012	.008	.756	.815	—	
	GY2M0300F040N-MS				●	●		●				F	.118	(3.00)	±.0012	.016	.744	.815	—	
	GY2M0400G020N-MS				●	●		●				G	.157	(4.00)	±.0016	.008	.953	1.010	—	
	GY2M0400G040N-MS				●	●		●				G	.157	(4.00)	±.0016	.016	.941	1.010	—	
	GY2M0500H040N-MS				●	●		●				H	.197	(5.00)	±.0016	.016	.941	1.010	—	
	GY2M0500H080N-MS				●	●		●				H	.197	(5.00)	±.0016	.031	.925	1.010	—	
	GY2M0600J040N-MS				●	●		●				J	.236	(6.00)	±.0016	.016	.941	1.010	—	
	GY2M0600J080N-MS				●	●		●				J	.236	(6.00)	±.0016	.031	.925	1.010	—	
	GY2M0800K080N-MS				●	●		●				K	.315	(8.00)	±.0016	.031	1.122	1.201	—	

*1 Groove width corresponding to the circlip.

*2 The dimension depends on the breaker. Refer to the F015 "L dimension tolerance conversion table".

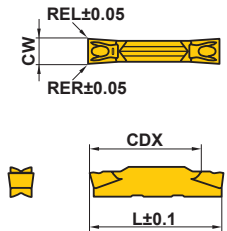
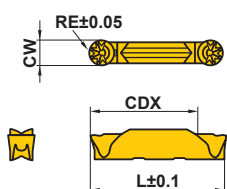
● = NEW

F
GROOVING / CUTTING OFF

GY SERIES INSERTS

INSERTS

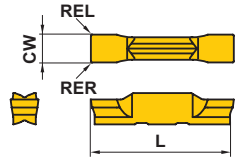
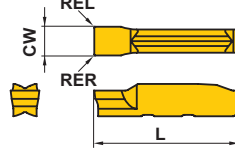
(inch)

Applications	Geometry	Order Number	Stock								Seat Size	CW			RE RER/L	CDX	#2 L		
			Coated				Cermet		Carbide			Cutting Width	Tolerance						
			NEW MP9015	NEW MP9025	VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020				inch				(mm)	
For Multifunctional Grooving	MM Breaker (Medium feeds) 	GY2M0200D020N-MM	●	●	●	●	●	●				D	.079	(2.00)	±.0012	.008	.752	.815	
		GY2M0250E020N-MM	●	●	●	●	●	●	●				E	.098	(2.50)	±.0012	.008	.752	.815
		GY2M0300F020N-MM	●	●	●	●	●	●	●				F	.118	(3.00)	±.0012	.008	.752	.815
		GY2M0300F040N-MM	●	●	●	●	●	●	●				F	.118	(3.00)	±.0012	.016	.744	.815
		GY2M0300F080N-MM	●	●	●	●	●	●	●				F	.118	(3.00)	±.0012	.031	.728	.815
		GY2M0400G020N-MM	●	●	●	●	●	●	●				G	.157	(4.00)	±.0016	.008	.949	1.010
		GY2M0400G040N-MM	●	●	●	●	●	●	●				G	.157	(4.00)	±.0016	.016	.941	1.010
		GY2M0400G080N-MM	●	●	●	●	●	●	●				G	.157	(4.00)	±.0016	.031	.925	1.010
		GY2M0500H040N-MM	●	●	●	●	●	●	●				H	.197	(5.00)	±.0016	.016	.941	1.010
		GY2M0500H080N-MM	●	●	●	●	●	●	●				H	.197	(5.00)	±.0016	.031	.925	1.010
		GY2M0600J040N-MM	●	●	●	●	●	●	●				J	.236	(6.00)	±.0016	.016	.941	1.010
		GY2M0600J080N-MM	●	●	●	●	●	●	●				J	.236	(6.00)	±.0016	.031	.925	1.010
		GY2M0800K080N-MM	●	●	●	●	●	●	●				K	.315	(8.00)	±.0016	.031	1.122	1.201
		GY2M0800K120N-MM	●	●	●	●	●	●	●				K	.315	(8.00)	±.0016	.047	1.106	1.201
For Copying / For Recessing	BM Breaker 	GY2M0200D100N-BM	●	●	●	●	●	●				D	.079	(2.00)	±.0012	.039	.768	.815	
		GY2M0250E125N-BM	●	●	●	●	●	●	●				E	.098	(2.50)	±.0012	.049	.760	.815
		GY2M0300F150N-BM	●	●	●	●	●	●	●				F	.118	(3.00)	±.0012	.059	.748	.823
		GY2M0318F159N-BM	●	●	●	●	●	●	●				F	.125	(3.18)	±.0012	.063	.744	.823
		GY2M0400G200N-BM	●	●	●	●	●	●	●				G	.157	(4.00)	±.0016	.079	.921	1.016
		GY2M0475H238N-BM	●	●	●	●	●	●	●				H	.187	(4.75)	±.0016	.094	.902	1.016
		GY2M0500H250N-BM	●	●	●	●	●	●	●				H	.197	(5.00)	±.0016	.098	.898	1.016
		GY2M0600J300N-BM	●	●	●	●	●	●	●				J	.236	(6.00)	±.0016	.118	.886	1.020
		GY2M0635J318N-BM	●	●	●	●	●	●	●				J	.250	(6.35)	±.0016	.125	.878	1.020
		GY2M0800K400N-BM	●	●	●	●	●	●	●				K	.315	(8.00)	±.0016	.157	1.043	1.213

*2 The dimension depends on the breaker. Refer to the F015 "L dimension tolerance conversion table".

● = NEW

(inch)

Applications	Geometry	Order Number	Stock			Seat Size	CW			RER/L	L
			Cermet		Carbide		Grooving Width		Tolerance		
			NX2525	RT9010							
			inch	(mm)							
*1 Blank	2 Edge Type 	GY2B0220D020N	★	★	★	D	.087	(2.20)	± .0039	.008	.829
		GY2B0250D020N	★	★	★	D	.100	(2.55)	± .0039	.008	.838
		GY2B0270E020N	★	★	★	E	.106	(2.70)	± .0039	.008	.829
		GY2B0300E020N	★	★	★	E	.120	(3.05)	± .0039	.008	.838
		GY2B0340F020N	★	★	★	F	.134	(3.40)	± .0039	.008	.829
		GY2B0360F020N	★	★	★	F	.144	(3.65)	± .0039	.008	.838
		GY2B0420G020N	★	★	★	G	.165	(4.20)	± .0039	.008	1.024
		GY2B0460G020N	★	★	★	G	.183	(4.65)	± .0039	.008	1.031
		GY2B0520H020N	★	★	★	H	.205	(5.20)	± .0039	.008	1.024
		GY2B0560H020N	★	★	★	H	.222	(5.65)	± .0039	.008	1.031
		GY2B0655J020N	★	★	★	J	.258	(6.55)	± .0039	.008	1.025
		GY2B0680J020N	★	★	★	J	.270	(6.85)	± .0039	.008	1.031
		GY2B0880K020N		★	★	K	.348	(8.85)	± .0039	.008	1.216
	1 Edge Type 	GY1B0220D020N	★	★	★	D	.087	(2.20)	± .0039	.008	.830
		GY1B0270E020N	★	★	★	E	.106	(2.70)	± .0039	.008	.831
		GY1B0340F020N	★	★	★	F	.134	(3.40)	± .0039	.008	.827
		GY1B0420G020N	★	★	★	G	.165	(4.20)	± .0039	.008	1.018
		GY1B0520H020N	★	★	★	H	.205	(5.20)	± .0039	.008	1.020
		GY1B0655J020N	★	★	★	J	.258	(6.55)	± .0039	.008	1.020

*1 Insert blank is not suitable for machining without grinding.

REFERENCE DATA

L dimension tolerance conversion table

Cutting Width CW	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
.047", 1.20 mm	.579		0		0						
.059", 1.50 mm	.579		0			.020					
.079", 2.00 mm	.815	0	0	0		.024	.004	0	.014	.008	.014
.088", 2.24 mm	*3 (.815)								.014		
.094", 2.39 mm	.815	0	0					0	.014		
.098", 2.50 mm	.815	0	0	0		.031	.005	0	.014	.008	.014
.108", 2.74 mm	*3 (.815)								.014		
.118", 3.00 mm	.815	0	0	0		.031	.006	0	.014	.008	.014
.125", 3.18 mm	.815	0	0					0	.014	.008	
.128", 3.24 mm	*3 (.815)								.014		
.157", 4.00 mm	1.010	0	0	0			.008	0	.012	.006	
.167", 4.24 mm	*3 (1.010)								.012		
.187", 4.75 mm	1.010	0	0					0	.012	.006	
.197", 5.00 mm	1.010	0	0	0			.012	0	.012	.006	
.206", 5.24 mm	*3 (1.010)								.012		
.236", 6.00 mm	1.010	0	0	0				0	.012	.010	
.248", 6.31 mm	*3 (1.010)								.012		
.250", 6.35 mm	1.010	0	0						.012	.010	
.315", 8.00 mm	1.201		0	0						.012	

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

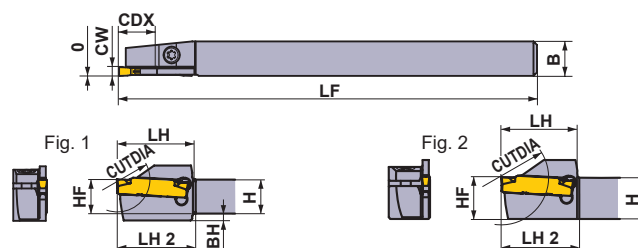
*2 ■ when there is no applicable breaker.

*3 The dimension is the value for approximate cutting width.

F

GROOVING / CUTTING OFF

1-1 00° type holder (Inch)



Right hand tool holder shown.

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

*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F199.

● : USA Stock

SPARE PARTS

Holder Number		
GYSR/LUS06B00-11	CS350990T (Clamp Torque : 22 lbf-in)	TKY10R
GYSR/LUS08B00-13		
GYSR/LUS10B00-18	TS4SBL (Clamp Torque : 31 lbf-in)	TKY15R
GYSR/LUS12B00-17		

Dimensions (inch) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	HBH		Clockwise	Anticlockwise
.375	.375	4.500	.866	.620	.375	.125			
.375	.375	4.500	.866	.620	.375	.125			
.500	.500	4.500	.866	.620	.500	—			
.500	.500	4.500	.866	.620	.500	—			
.625	.625	4.500	1.063	.638	.625	—			
.625	.625	4.500	1.063	.638	.625	—			
.750	.750	4.500	1.102	.638	.750	—			
.750	.750	4.500	1.102	.638	.750	—			
.375	.375	4.500	.866	.899	.375	.125			
.375	.375	4.500	.866	.899	.375	.125			
.500	.500	4.500	.866	.899	.500	—			
.500	.500	4.500	.866	.899	.500	—			
.625	.625	4.500	1.063	.918	.625	—			
.625	.625	4.500	1.063	.918	.625	—			
.750	.750	4.500	1.102	.878	.750	—			
.750	.750	4.500	1.102	.878	.750	—			
.375	.375	4.500	.866	.901	.375	.125			
.375	.375	4.500	.866	.901	.375	.125			
.500	.500	4.500	.866	.901	.500	—			
.500	.500	4.500	.866	.901	.500	—			
.625	.625	4.500	1.063	.920	.625	—			
.625	.625	4.500	1.063	.920	.625	—			
.750	.750	4.500	1.102	.880	.750	—			
.750	.750	4.500	1.102	.880	.750	—			
.625	.625	4.500	1.220	.920	.625	—			
.625	.625	4.500	1.220	.920	.625	—			
.750	.750	4.500	1.220	.880	.750	—			
.750	.750	4.500	1.220	.880	.750	—			
.500	.500	4.500	.866	.903	.500	—			
.500	.500	4.500	.866	.903	.500	—			
.625	.625	4.500	1.063	.925	.625	—			
.625	.625	4.500	1.063	.925	.625	—			
.750	.750	4.500	1.102	.885	.750	—			
.750	.750	4.500	1.102	.885	.750	—			
.625	.625	4.500	1.220	.925	.625	—			
.625	.625	4.500	1.220	.925	.625	—			
.750	.750	4.500	1.220	.885	.750	—			
.750	.750	4.500	1.220	.885	.750	—			
.625	.625	4.500	1.220	.925	.625	—			
.625	.625	4.500	1.220	.925	.625	—			
.750	.750	4.500	1.220	.885	.750	—			
.750	.750	4.500	1.220	.885	.750	—			

Select an Insert

Seat Size	Insert Number
C	GY00150C0000-Breaker
D	GY00200/0224D0000-Breaker
E	GY00239/0250/0274E0000-Breaker
F	GY00300/0318/0324F0000-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
CW		Neutral	Neutral	Neutral	Neutral	Neutral
C	.059", 1.50 mm		●	●		
D	.079", 2.00 mm	●	●	●	●	●
E	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●

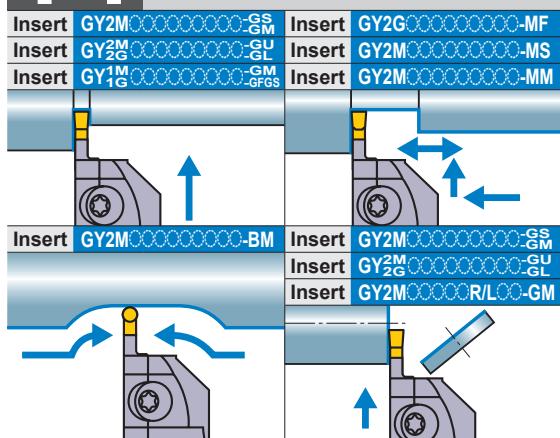
For Cutting off > F012					
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
CW		R	R	R	R/L
C	.059", 1.50 mm		●	●	
D	.079", 2.00 mm		●	●	●
E	.098", 2.50 mm		●	●	●
F	.118", 3.00 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●			
E	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			
F	.118", 3.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

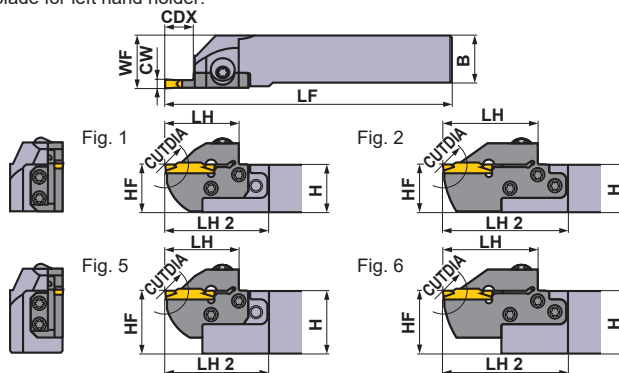
GY SERIES (EXTERNAL)

1-1 00° type holder (Inch)



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
D	.079 .088	.236	.472	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-D06	●	3	
					L	GYHLUS10B00-M20L	●	GYM20LA-D06	●	3	
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-D06	●	1	
					L	GYHLUS12C00-M20L	●	GYM20LA-D06	●	1	
				Modular	R	GYHRUS12C00-M25R	●	GYM25RA-D06	●	3	
					L	GYHLUS12C00-M25L	●	GYM25LA-D06	●	3	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-D06	●	1	
					L	GYHLUS16D00-M25L	●	GYM25LA-D06	●	1	
				Mono Block	R	GYQRUS16D00-D06	●	—	—	7	
					L	GYQLUS16D00-D06	●	—	—	7	
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-D06	●	5	
					L	GYHLUS20D00-M25L	●	GYM25LA-D06	●	5	
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-D06	●	5			
			L	GYHLUS24E00-M25L	●	GYM25LA-D06	●	5			
		.394	.787	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-D10	●	3	
					L	GYHLUS10B00-M20L	●	GYM20LA-D10	●	3	
		Modular	R	GYHRUS12C00-M20R	●	GYM20RA-D10	●	1			
			L	GYHLUS12C00-M20L	●	GYM20LA-D10	●	1			
		.472	.945	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-D12	●	3	
					L	GYHLUS12C00-M25L	●	GYM25LA-D12	●	3	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-D12	●	1	
					L	GYHLUS16D00-M25L	●	GYM25LA-D12	●	1	
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-D12	●	5	
					L	GYHLUS20D00-M25L	●	GYM25LA-D12	●	5	
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-D12	●	5	
					L	GYHLUS24E00-M25L	●	GYM25LA-D12	●	5	
		*4 .709	1.417	Modular	R	GYHRUS10B00-M20R	●	GYM20RB-D18	●	4	
					L	GYHLUS10B00-M20L	●	GYM20LB-D18	●	4	
		Modular	R	GYHRUS12C00-M20R	●	GYM20RB-D18	●	2			
			L	GYHLUS12C00-M20L	●	GYM20LB-D18	●	2			
		*1 .787	*2 1.575	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-D20	●	4	
					L	GYHLUS12C00-M25L	●	GYM25LA-D20	●	4	
				Mono Block	R	GYQRUS16D00-D20	●	—	—	7	
					L	GYQLUS16D00-D20	●	—	—	7	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-D20	●	2	
					L	GYHLUS16D00-M25L	●	GYM25LA-D20	●	2	
Modular	R			GYHRUS20D00-M25R	●	GYM25RA-D20	●	6			
	L			GYHLUS20D00-M25L	●	GYM25LA-D20	●	6			
Modular	R			GYHRUS24E00-M25R	●	GYM25RA-D20	●	6			
	L			GYHLUS24E00-M25L	●	GYM25LA-D20	●	6			

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

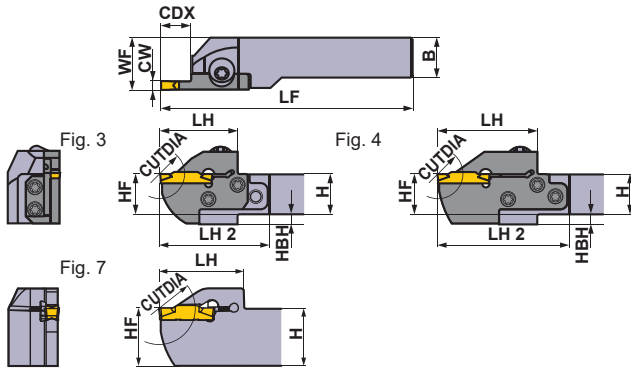
*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH** and **LH 2** values may vary.

*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw	① Wrench *
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○○○-M20R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/LUS○○○○○○○○-M25R/L	—	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Select an Insert

Seat Size	Insert Number
D	GY○○0200/0224D○○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●

For Cutting off > F012				
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)
CW	R	R	R	R/L
D	.079", 2.00 mm	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
CW	Ball nose			
D	.079", 2.00 mm	●	●	●
	.088", 2.24 mm	●		

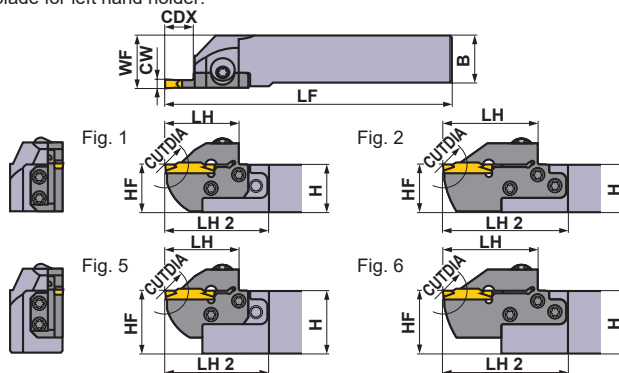
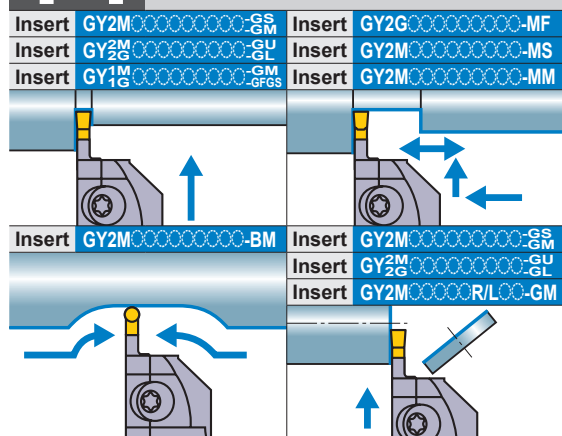
● : Gauge insert shown dimensions

Dimensions (inch) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
.625	.625	4.264	1.102	1.761	.625	.812	.125		
.625	.625	4.264	1.102	1.761	.625	.812	.125		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	6.000	1.417	—	1.000	1.006	—		
1.000	1.000	6.000	1.417	—	1.000	1.006	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
1.000	1.000	6.000	1.614	—	1.000	1.004	—		
1.000	1.000	6.000	1.614	—	1.000	1.004	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

1-1 00° type holder (Inch)

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

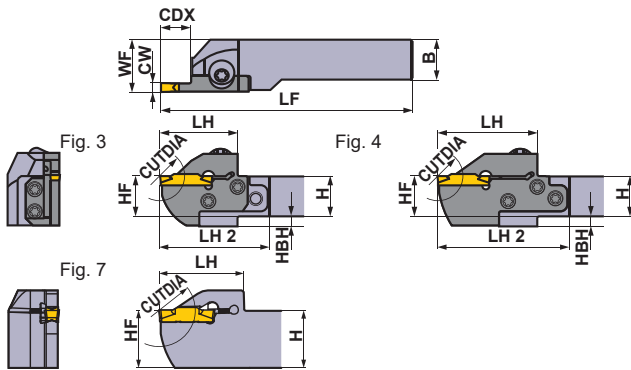


Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
E	.094 .098 .108	.236	.472	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-E06	●	3	
					L	GYHLUS10B00-M20L	●	GYM20LA-E06	●	3	
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-E06	●	1	
					L	GYHLUS12C00-M20L	●	GYM20LA-E06	●	1	
				Modular	R	GYHRUS12C00-M25R	●	GYM25RA-E06	●	3	
					L	GYHLUS12C00-M25L	●	GYM25LA-E06	●	3	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-E06	●	1	
					L	GYHLUS16D00-M25L	●	GYM25LA-E06	●	1	
				Mono Block	R	GYQRUS16D00-E06	●	—	—	7	
					L	GYQLUS16D00-E06	●	—	—	7	
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-E06	●	5	
					L	GYHLUS20D00-M25L	●	GYM25LA-E06	●	5	
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-E06	●	5			
			L	GYHLUS24E00-M25L	●	GYM25LA-E06	●	5			
		.394	.787	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-E10	●	3	
					L	GYHLUS10B00-M20L	●	GYM20LA-E10	●	3	
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-E10	●	1	
					L	GYHLUS12C00-M20L	●	GYM20LA-E10	●	1	
		.472	.945	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-E12	●	3	
					L	GYHLUS12C00-M25L	●	GYM25LA-E12	●	3	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-E12	●	1	
					L	GYHLUS16D00-M25L	●	GYM25LA-E12	●	1	
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-E12	●	5	
					L	GYHLUS20D00-M25L	●	GYM25LA-E12	●	5	
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-E12	●	5	
					L	GYHLUS24E00-M25L	●	GYM25LA-E12	●	5	
		*4 .709	1.417	Modular	R	GYHRUS10B00-M20R	●	GYM20RB-E18	●	4	
					L	GYHLUS10B00-M20L	●	GYM20LB-E18	●	4	
				Modular	R	GYHRUS12C00-M20R	●	GYM20RB-E18	●	2	
					L	GYHLUS12C00-M20L	●	GYM20LB-E18	●	2	
		*1 .787	*2 1.575	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-E20	●	4	
					L	GYHLUS12C00-M25L	●	GYM25LA-E20	●	4	
				Mono Block	R	GYQRUS16D00-E20	●	—	—	7	
					L	GYQLUS16D00-E20	●	—	—	7	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-E20	●	2	
					L	GYHLUS16D00-M25L	●	GYM25LA-E20	●	2	
Modular	R			GYHRUS20D00-M25R	●	GYM25RA-E20	●	6			
	L			GYHLUS20D00-M25L	●	GYM25LA-E20	●	6			
Modular	R			GYHRUS24E00-M25R	●	GYM25RA-E20	●	6			
	L			GYHLUS24E00-M25L	●	GYM25LA-E20	●	6			

*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○○○-M20R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/LUS○○○○○○○○-M25R/L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Select an Insert

Seat Size	Insert Number
E	GY○○0239/0250/0274E○○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
E	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●

For Cutting off > F012				
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)
CW	R	R	R	R/L
E	.098", 2.50 mm	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
CW	Ball nose			
E	.094", 2.39 mm	●	●	●
	.098", 2.50 mm	●	●	●
	.108", 2.74 mm	●		

● : Gauge insert shown dimensions

Dimensions (inch) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
.625	.625	4.264	1.102	1.761	.625	.812	.125		
.625	.625	4.264	1.102	1.761	.625	.812	.125		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	6.000	1.417	—	1.000	1.008	—		
1.000	1.000	6.000	1.417	—	1.000	1.008	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
1.000	1.000	6.000	1.614	—	1.000	1.004	—		
1.000	1.000	6.000	1.614	—	1.000	1.004	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

F

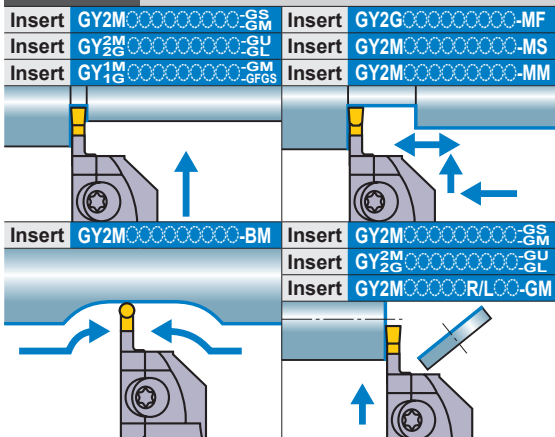
GROOVING / CUTTING OFF

F021

GY SERIES (EXTERNAL)

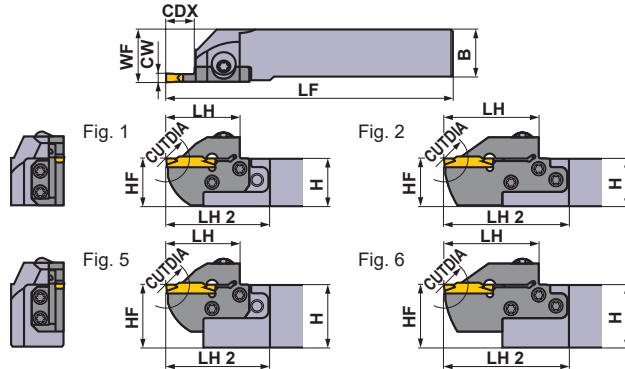
1-1

00° type holder (Inch)



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	F	.236	.472	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-F06	●	3
				Modular	L	GYHLUS10B00-M20L	●	GYM20LA-F06	●	3
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-F06	●	1
				Modular	L	GYHLUS12C00-M20L	●	GYM20LA-F06	●	1
				Modular	R	GYHRUS12C00-M25R	●	GYM25RA-F06	●	3
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-F06	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-F06	●	1
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-F06	●	1
				Mono Block	R	GYQRUS16D00-F06	●	—	—	7
				Mono Block	L	GYQLUS16D00-F06	●	—	—	7
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-F06	●	5
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-F06	●	5
		.394	.787	Modular	R	GYHRUS24E00-M25R	●	GYM25RA-F06	●	5
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-F06	●	5
				Modular	R	GYHRUS10B00-M20R	●	GYM20RA-F10	●	3
				Modular	L	GYHLUS10B00-M20L	●	GYM20LA-F10	●	3
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-F10	●	1
				Modular	L	GYHLUS12C00-M20L	●	GYM20LA-F10	●	1
		.472	.945	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-F12	●	3
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-F12	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-F12	●	1
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-F12	●	1
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-F12	●	5
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-F12	●	5
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-F12	●	5
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-F12	●	5
		.709	1.417	Modular	R	GYHRUS10B00-M20R	●	GYM20RB-F18	●	4
				Modular	L	GYHLUS10B00-M20L	●	GYM20LB-F18	●	4
				Modular	R	GYHRUS12C00-M20R	●	GYM20RB-F18	●	2
				Modular	L	GYHLUS12C00-M20L	●	GYM20LB-F18	●	2
		.787	1.575	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-F20	●	4
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-F20	●	4
				Mono Block	R	GYQRUS16D00-F20	●	—	—	7
				Mono Block	L	GYQLUS16D00-F20	●	—	—	7
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-F20	●	2
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-F20	●	2
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-F20	●	6
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-F20	●	6
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-F20	●	6
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-F20	●	6

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

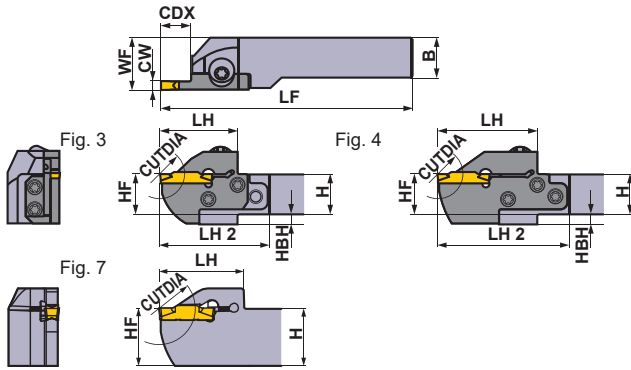
*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench ★
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○○○-M20R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/LUS○○○○○○○○-M25R/L	—	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
CW		Neutral	Neutral	Neutral	Neutral	Neutral
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
CW		R	R	R	R/L
F	.118", 3.00 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					Ball nose
F	.118", 3.00 mm	●	●	●	●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm	●			●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

Dimensions (inch) ★3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
.625	.625	4.264	1.102	1.761	.625	.812	.125		
.625	.625	4.264	1.102	1.761	.625	.812	.125		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	6.000	1.417	—	1.000	1.012	—		
1.000	1.000	6.000	1.417	—	1.000	1.012	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
1.000	1.000	6.000	1.614	—	1.000	1.010	—		
1.000	1.000	6.000	1.614	—	1.000	1.010	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

F

GROOVING / CUTTING OFF

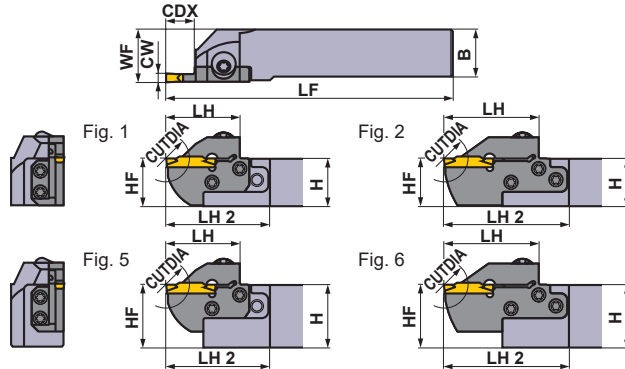
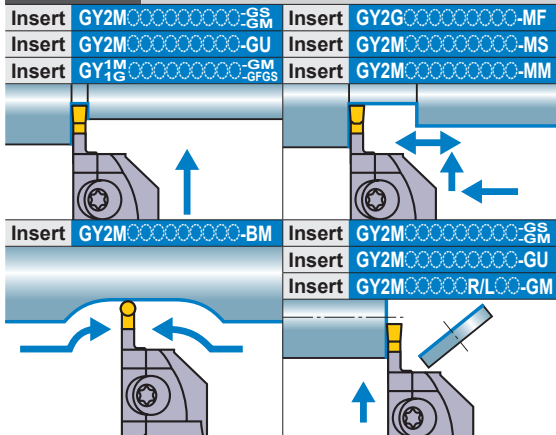
GY SERIES (EXTERNAL)

1-1

00° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
G	.157 .167	.315	.630	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-G08	●	3
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-G08	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-G08	●	1
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-G08	●	1
				Mono Block	R	GYQRUS16D00-G08	●	—	—	7
				Mono Block	L	GYQLUS16D00-G08	●	—	—	7
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-G08	●	5
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-G08	●	5
		.472	.945	Modular	R	GYHRUS24E00-M25R	●	GYM25RA-G08	●	5
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-G08	●	5
				Modular	R	GYHRUS10B00-M20R	●	GYM20RA-G12	●	3
				Modular	L	GYHLUS10B00-M20L	●	GYM20LA-G12	●	3
		.551	1.102	Modular	R	GYHRUS12C00-M20R	●	GYM20RA-G12	●	1
				Modular	L	GYHLUS12C00-M20L	●	GYM20LA-G12	●	1
				Modular	R	GYHRUS12C00-M25R	●	GYM25RA-G14	●	3
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-G14	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-G14	●	1
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-G14	●	1
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-G14	●	5
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-G14	●	5
		.984 ^{*1}	1.969 ^{*2}	Modular	R	GYHRUS24E00-M25R	●	GYM25RA-G14	●	5
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-G14	●	5
				Modular	R	GYHRUS12C00-M25R	●	GYM25RA-G25	●	4
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-G25	●	4
				Mono Block	R	GYQRUS16D00-G25	●	—	—	7
				Mono Block	L	GYQLUS16D00-G25	●	—	—	7
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-G25	●	2
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-G25	●	2
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-G25	●	6
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-G25	●	6
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-G25	●	6
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-G25	●	6

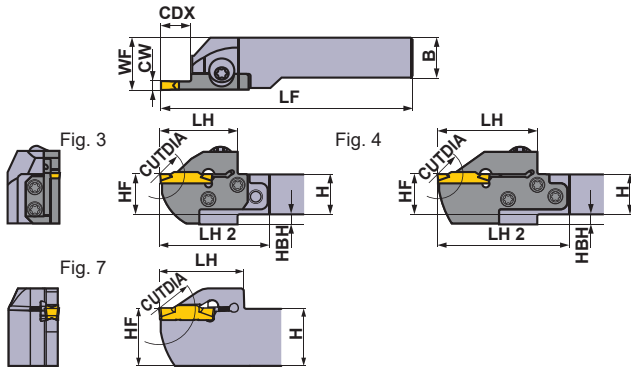
CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

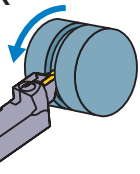
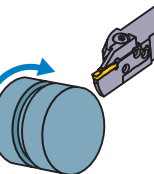
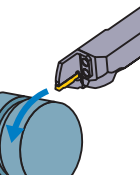
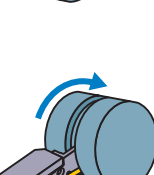
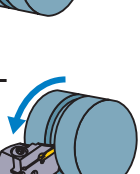
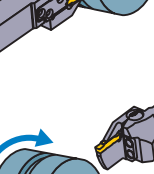
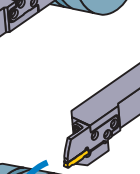
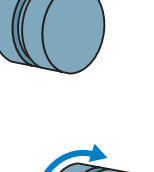
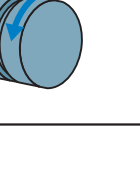
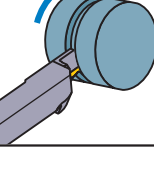
★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench ★
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○○○-M20R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/LUS○○○○○○○○-M25R/L	—	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) *3								Cutting Mode	
	H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
	.750	.750	4.764	1.299	2.139	.750	1.000	.250	R 	
	.750	.750	4.764	1.299	2.139	.750	1.000	.250		
	1.000	1.000	5.764	1.299	2.013	1.000	1.125	—		
	1.000	1.000	5.764	1.299	2.013	1.000	1.125	—		
	1.000	1.000	6.000	1.614	—	1.000	1.014	—		
	1.000	1.000	6.000	1.614	—	1.000	1.014	—		
	1.250	1.250	5.764	1.299	2.021	1.250	1.375	—		
	1.250	1.250	5.764	1.299	2.021	1.250	1.375	—		
	1.500	1.500	6.764	1.299	2.005	1.500	1.625	—		
	1.500	1.500	6.764	1.299	2.005	1.500	1.625	—		
	.625	.625	4.500	1.339	1.997	.625	.812	.125		
	.625	.625	4.500	1.339	1.997	.625	.812	.125		
	.750	.750	5.000	1.339	1.934	.750	.875	—		
	.750	.750	5.000	1.339	1.934	.750	.875	—		
	.750	.750	5.000	1.535	2.375	.750	1.000	.250		
	.750	.750	5.000	1.535	2.375	.750	1.000	.250		
	1.000	1.000	6.000	1.535	2.249	1.000	1.125	—	L 	
	1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
	1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
	1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
	.750	.750	5.433	1.969	2.808	.750	1.000	.250		
	.750	.750	5.433	1.969	2.808	.750	1.000	.250		
	1.000	1.000	6.000	1.811	—	1.000	1.014	—		
	1.000	1.000	6.000	1.811	—	1.000	1.014	—		
	1.000	1.000	6.433	1.969	2.682	1.000	1.125	—		
	1.000	1.000	6.433	1.969	2.682	1.000	1.125	—		
	1.250	1.250	6.433	1.969	2.690	1.250	1.375	—		
	1.250	1.250	6.433	1.969	2.690	1.250	1.375	—		
	1.500	1.500	7.433	1.969	2.674	1.500	1.625	—		
	1.500	1.500	7.433	1.969	2.674	1.500	1.625	—		

Select an Insert

Seat Size	Insert Number
G	GY○○○0400/0424G○○○○○-Breaker

For Grooving/Cutting off > F011—F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Hand
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
CW	Ball nose			
G	.157", 4.00 mm	●	●	●
	RE .008"	●	●	●
	RE .016"	●	●	●
	RE .031"	●	●	●
	.167", 4.24 mm	●	●	●

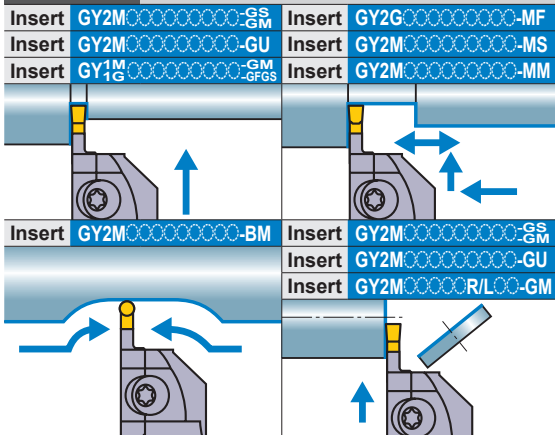
● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

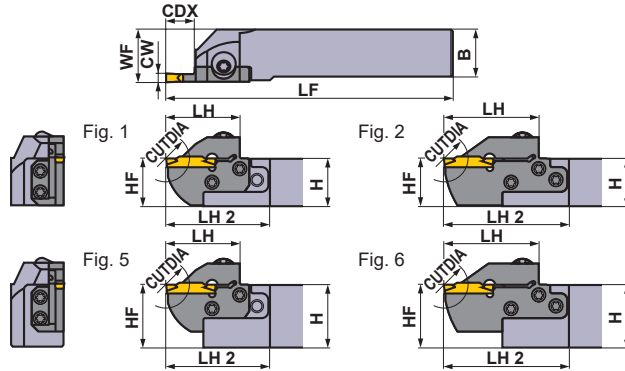
GY SERIES (EXTERNAL)

1-1 00° type holder (Inch)



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	.315	.630	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-H08	●	3
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-H08	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-H08	●	1
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-H08	●	1
				Mono Block	R	GYQRUS16D00-H08	●	—	—	7
				Mono Block	L	GYQLUS16D00-H08	●	—	—	7
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-H08	●	5
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-H08	●	5
		.472	.945	Modular	R	GYHRUS24E00-M25R	●	GYM25RA-H08	●	5
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-H08	●	5
				Modular	R	GYHRUS10B00-M20R	●	GYM20RA-H12	●	3
				Modular	L	GYHLUS10B00-M20L	●	GYM20LA-H12	●	3
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-H12	●	1
				Modular	L	GYHLUS12C00-M20L	●	GYM20LA-H12	●	1
		.551	1.102	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-H14	●	3
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-H14	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-H14	●	1
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-H14	●	1
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-H14	●	5
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-H14	●	5
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-H14	●	5
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-H14	●	5
		.984 ^{*1}	1.969 ^{*2}	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-H25	●	4
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-H25	●	4
				Mono Block	R	GYQRUS16D00-H25	●	—	—	7
				Mono Block	L	GYQLUS16D00-H25	●	—	—	7
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-H25	●	2
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-H25	●	2
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-H25	●	6
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-H25	●	6
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-H25	●	6
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-H25	●	6

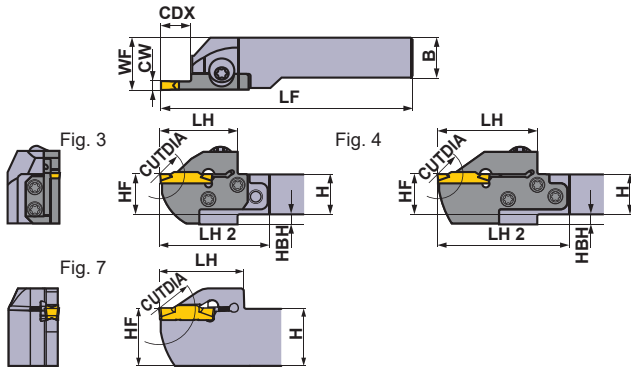
CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench ★
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○○○-M20R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/LUS○○○○○○○○-M25R/L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (inch) ★3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
.750	.750	4.764	1.299	2.139	.750	1.000	.250		
.750	.750	4.764	1.299	2.139	.750	1.000	.250		
1.000	1.000	5.764	1.299	2.013	1.000	1.125	—		
1.000	1.000	5.764	1.299	2.013	1.000	1.125	—		
1.000	1.000	6.000	1.614	—	1.000	1.014	—		
1.000	1.000	6.000	1.614	—	1.000	1.014	—		
1.250	1.250	5.764	1.299	2.021	1.250	1.375	—		
1.250	1.250	5.764	1.299	2.021	1.250	1.375	—		
1.500	1.500	6.764	1.299	2.005	1.500	1.625	—		
1.500	1.500	6.764	1.299	2.005	1.500	1.625	—		
1.500	1.500	6.764	1.299	2.005	1.500	1.625	—		
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
.750	.750	5.433	1.969	2.808	.750	1.000	.250		
.750	.750	5.433	1.969	2.808	.750	1.000	.250		
1.000	1.000	6.000	1.811	—	1.000	1.014	—		
1.000	1.000	6.000	1.811	—	1.000	1.014	—		
1.000	1.000	6.433	1.969	2.682	1.000	1.125	—		
1.000	1.000	6.433	1.969	2.682	1.000	1.125	—		
1.250	1.250	6.433	1.969	2.690	1.250	1.375	—		
1.250	1.250	6.433	1.969	2.690	1.250	1.375	—		
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—		
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—		
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—		

Select an Insert

Seat Size	Insert Number
H	GY○○○0475/0500/0524H○○○○-Breaker

For Grooving/Cutting off > F011-F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Hand
.187", 4.75 mm	●	●	●	●	●
.197", 5.00 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW	Ball nose				
.187", 4.75 mm	RE .008"	●			●
	RE .016"	●			
	RE .031"	●			
.197", 5.00 mm	RE .008"	●			●
	RE .016"	●	●	●	
	RE .031"	●	●	●	
.206", 5.24 mm		●			

● : Gauge insert shown dimensions

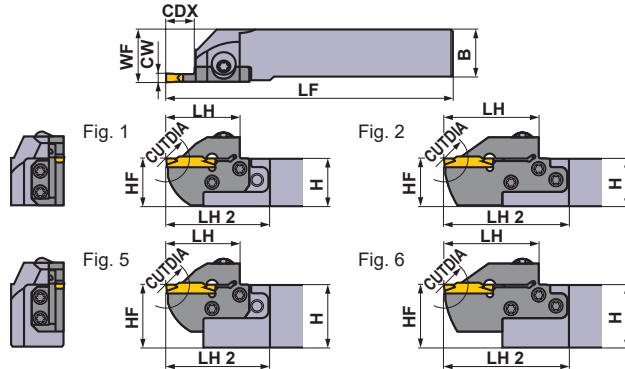
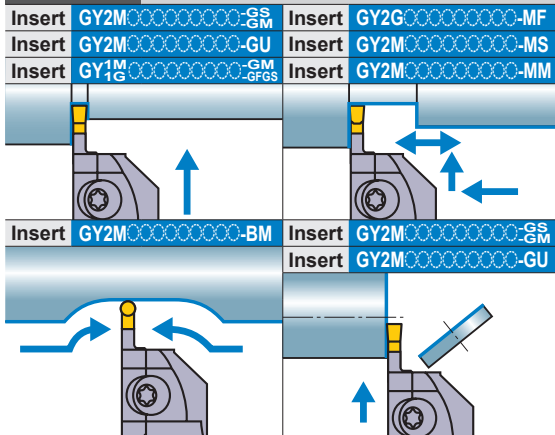
GY SERIES (EXTERNAL)

1-1

00° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

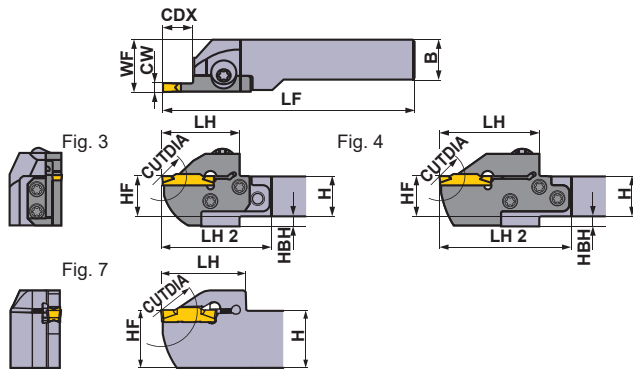
Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
J	.236 .248 .250	.315	.630	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-J08	●	3
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-J08	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-J08	●	1
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-J08	●	1
				Mono Block	R	GYQRUS16D00-J08	●	—	—	7
				Mono Block	L	GYQLUS16D00-J08	●	—	—	7
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-J08	●	5
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-J08	●	5
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-J08	●	5
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-J08	●	5
		.551	1.102	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-J14	●	3
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-J14	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-J14	●	1
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-J14	●	1
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-J14	●	5
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-J14	●	5
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-J14	●	5
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-J14	●	5
				Modular	R	GYHRUS12C00-M25R	●	GYM25RA-J25	●	4
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-J25	●	4
		*1 .984	*2 1.969	Mono Block	R	GYQRUS16D00-J25	●	—	—	7
				Mono Block	L	GYQLUS16D00-J25	●	—	—	7
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-J25	●	2
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-J25	●	2
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-J25	●	6
				Modular	L	GYHLUS20D00-M25L	●	GYM25LA-J25	●	6
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-J25	●	6
				Modular	L	GYHLUS24E00-M25L	●	GYM25LA-J25	●	6

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 F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.



Right hand tool holder shown.

* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw	① Wrench *
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○○○-M25R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (inch) *3									Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH		Clockwise	Anticlockwise
.750	.750	4.764	1.299	2.139	.750	1.000	.250	R		
.750	.750	4.764	1.299	2.139	.750	1.000	.250			
1.000	1.000	5.764	1.299	2.013	1.000	1.125	—			
1.000	1.000	5.764	1.299	2.013	1.000	1.125	—			
1.000	1.000	6.000	1.614	—	1.000	1.014	—			
1.000	1.000	6.000	1.614	—	1.000	1.014	—			
1.250	1.250	5.764	1.299	2.021	1.250	1.375	—	L		
1.250	1.250	5.764	1.299	2.021	1.250	1.375	—			
1.500	1.500	6.764	1.299	2.005	1.500	1.625	—			
1.500	1.500	6.764	1.299	2.005	1.500	1.625	—			
.750	.750	5.000	1.535	2.375	.750	1.000	.250			
.750	.750	5.000	1.535	2.375	.750	1.000	.250			
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—	L		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—			
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—			
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—			
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—			
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—			
.750	.750	5.433	1.969	2.808	.750	1.000	.250	L		
.750	.750	5.433	1.969	2.808	.750	1.000	.250			
1.000	1.000	6.000	1.811	—	1.000	1.014	—			
1.000	1.000	6.000	1.811	—	1.000	1.014	—			
1.000	1.000	6.433	1.969	2.682	1.000	1.125	—			
1.000	1.000	6.433	1.969	2.682	1.000	1.125	—			
1.250	1.250	6.433	1.969	2.690	1.250	1.375	—	L		
1.250	1.250	6.433	1.969	2.690	1.250	1.375	—			
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—			
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—			

Select an Insert

Seat Size	Insert Number
J	GY○○0600/0631/0635J○○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)	05-GM (Cutting off)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Hand
J	.236", 6.00 mm	●	●	●	●	
	.250", 6.35 mm	●	●	●	●	

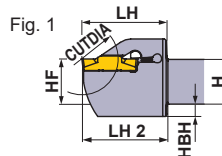
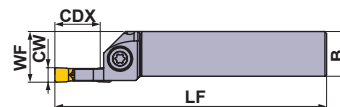
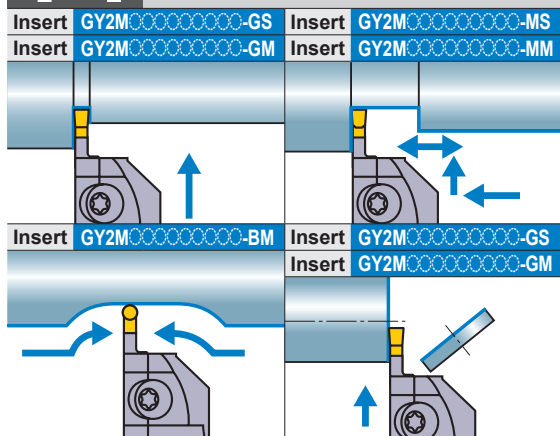
For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW	Ball nose				
J	.236", 6.00 mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.248", 6.31 mm	●			
	.250", 6.35 mm	●			●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			

● : Gauge insert shown dimensions

GY SERIES (EXTERNAL)

1-1

00° type holder (Inch)



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
K	.315	*1 .984	*2 1.968	Mono Block	R	GYPRUS16D00-K25	●	—	—	1
				Mono Block	L	GYPLUS16D00-K25	●	—	—	1
				Mono Block	R	GYPRUS20D00-K25	●	—	—	2
				Mono Block	L	GYPLUS20D00-K25	●	—	—	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 F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.

● : USA Stock

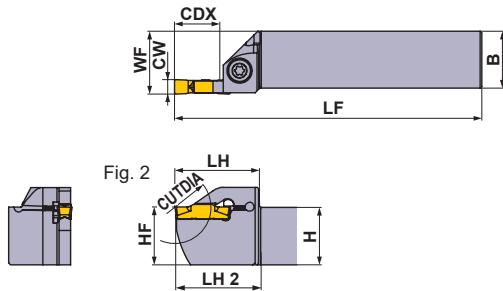
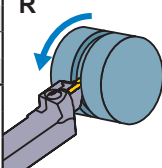
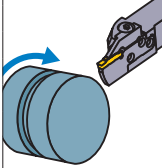
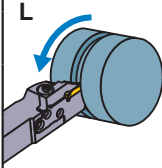
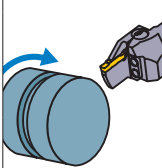


Fig. 2

Right hand tool holder shown.

SPARE PARTS

Holder Number		
GYPR/LUS○○○○00-K25	GY06013M (Clamp Torque : 53 lbf-in)	TKY30R

Dimensions (inch) *3									Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH		Clockwise	Anticlockwise
1.000	1.000	6.000	1.850	1.875	1.000	1.161	.260	R		
1.000	1.000	6.000	1.850	1.875	1.000	1.161	.260			
1.250	1.250	7.000	1.850	2.875	1.250	1.377	—			
1.250	1.250	7.000	1.850	2.875	1.250	1.377	—	L		

Select an Insert

Seat Size	Insert Number
K	GY○○0800K○○○○-Breaker

For Grooving/Cutting off > F011						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)	05-GM (Cutting off)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Hand
K	.315", 8.00 mm		●	●		

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					Ball nose
K	.315", 8.00 mm RE .031" RE .047"		●	●	●

● : Gauge insert shown dimensions

F
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

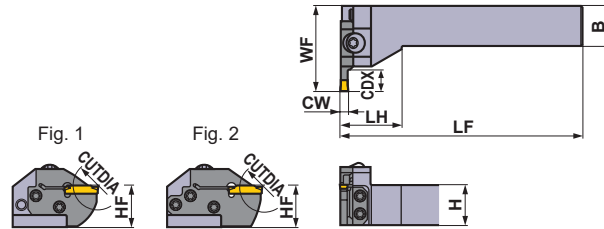
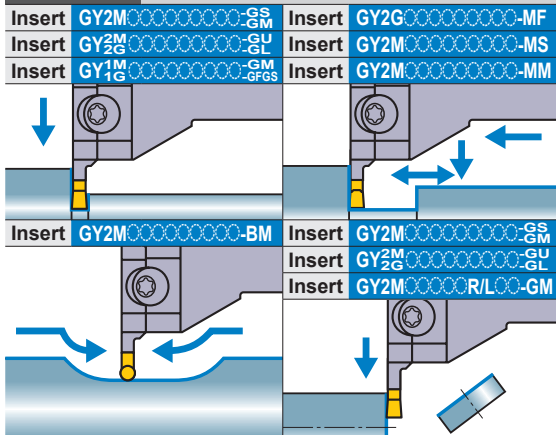
F031

GY SERIES (EXTERNAL)

2-1 90° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	.079 .088	.236	.472	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-D06	●	1
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-D06	●	1
		.394	.787	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-D06	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-D06	●	1
		.472	.945	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-D10	●	1
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-D10	●	1
		.709 *4	1.417	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-D12	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-D12	●	1
		.787 *1	1.575 *2	Modular	R	GYHRUS12C90-M20L	●	GYM20LB-D18	●	2
				Modular	L	GYHLUS12C90-M20R	●	GYM20RB-D18	●	2
E	.094 .098 .108	.236	.472	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-E06	●	1
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-E06	●	1
		.394	.787	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-E06	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-E06	●	1
		.472	.945	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-E10	●	1
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-E10	●	1
		.709 *4	1.417	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-E12	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-E12	●	1
		.787 *1	1.575 *2	Modular	R	GYHRUS12C90-M20L	●	GYM20LB-E18	●	2
				Modular	L	GYHLUS12C90-M20R	●	GYM20RB-E18	●	2
				Modular	R	GYHRUS16D90-M25L	●	GYM25LA-E20	●	2
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-E20	●	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 F011 to F015.

*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 F011 to F015.

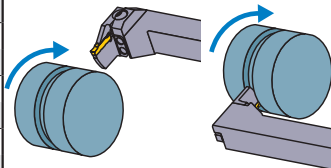
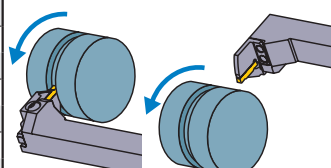
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHRUS12C90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHLUS12C90-M20R			
GYHRUS16D90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) ★3						Cutting Mode
	H	B	LF	LH	HF	WF	
	.750	.750	5.000	1.375	.750	1.545	R 
	.750	.750	5.000	1.375	.750	1.545	
	1.000	1.000	6.000	1.500	1.000	1.779	
	1.000	1.000	6.000	1.500	1.000	1.779	
	.750	.750	5.000	1.375	.750	1.781	
	.750	.750	5.000	1.375	.750	1.781	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	.750	.750	5.000	1.375	.750	2.017	
	.750	.750	5.000	1.375	.750	2.017	
	1.000	1.000	6.000	1.500	1.000	2.330	L 
	1.000	1.000	6.000	1.500	1.000	2.330	
	.750	.750	5.000	1.375	.750	1.545	
	.750	.750	5.000	1.375	.750	1.545	
	1.000	1.000	6.000	1.500	1.000	1.779	
	1.000	1.000	6.000	1.500	1.000	1.779	
	.750	.750	5.000	1.375	.750	1.781	
	.750	.750	5.000	1.375	.750	1.781	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	.750	.750	5.000	1.375	.750	2.017	
	.750	.750	5.000	1.375	.750	2.017	
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	2.330	

Select an Insert

Seat Size	Insert Number
D	GY0000200/0224D0000000-Breaker
E	GY0000239/0250/0274E0000000-Breaker

		For Grooving/Cutting off > F011, F013				
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●
	.094", 2.39 mm	●	●	●	●	●
E	.098", 2.50 mm	●	●	●	●	●

		For Cutting off > F012			
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
		R	R	R	R/L
D	.079", 2.00 mm		●	●	●
E	.098", 2.50 mm		●	●	●

		For Multifunctional Grooving > F013, F014			
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●			
	.094", 2.39 mm	●			
E	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

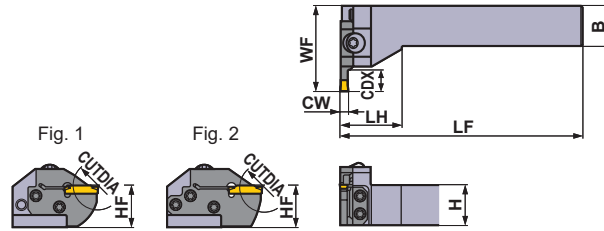
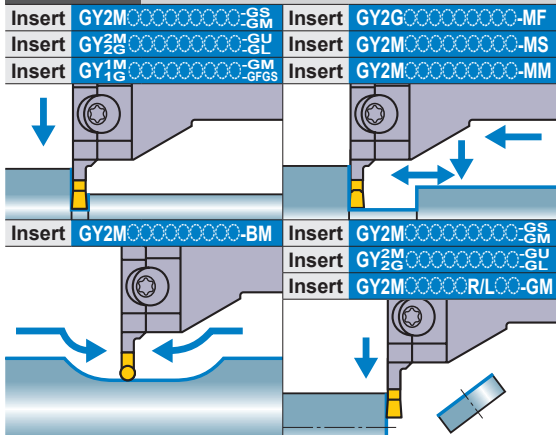
F033

GY SERIES (EXTERNAL)

2-1 90° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	.236	.472	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-F06	●	1
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-F06	●	1
		.394	.787	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-F06	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-F06	●	1
		.472	.945	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-F10	●	1
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-F10	●	1
		.709 *4	1.417	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-F12	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-F12	●	1
		.787 *1	1.575 *2	Modular	R	GYHRUS12C90-M20L	●	GYM20LB-F18	●	2
				Modular	L	GYHLUS12C90-M20R	●	GYM20RB-F18	●	2
G	.157 .167	.315	.630	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-G08	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-G08	●	1
		.472	.945	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-G12	●	1
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-G12	●	1
		.551	1.102	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-G14	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-G14	●	1
		.984 *1	1.969 *2	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-G25	●	2
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-G25	●	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 F011 to F015.

*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 F011 to F015.

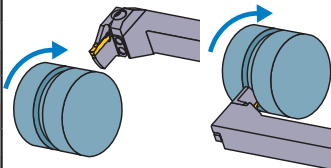
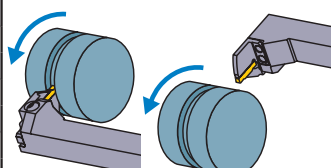
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHRUS12C90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHLUS12C90-M20R			
GYHRUS16D90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) ★3						Cutting Mode
	H	B	LF	LH	HF	WF	
	.750	.750	5.000	1.375	.750	1.545	R 
	.750	.750	5.000	1.375	.750	1.545	
	1.000	1.000	6.000	1.500	1.000	1.779	
	1.000	1.000	6.000	1.500	1.000	1.779	
	.750	.750	5.000	1.375	.750	1.781	
	.750	.750	5.000	1.375	.750	1.781	
	1.000	1.000	6.000	1.500	1.000	2.094	L 
	1.000	1.000	6.000	1.500	1.000	2.094	
	.750	.750	5.000	1.375	.750	2.017	
	.750	.750	5.000	1.375	.750	2.017	
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	1.857	
	1.000	1.000	6.000	1.500	1.000	1.857	
	.750	.750	5.000	1.375	.750	1.781	
	.750	.750	5.000	1.375	.750	1.781	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	

Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○-Breaker
G	GY○○○0400/0424G○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●
G	.157", 4.00 mm	●	●	●	●	●

For Cutting off > F012				
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)
	CW	R	R	R
F	.118", 3.00 mm	●	●	●
G	.157", 4.00 mm	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
	CW	Ball nose	Ball nose	Ball nose
F	.118", 3.00 mm	●	●	●
	RE .008"	●	●	●
	RE .016"	●	●	●
	RE .031"	●	●	●
	.125", 3.18 mm	●	●	●
	RE .008"	●	●	●
G	.128", 3.24 mm	●	●	●
	RE .016"	●	●	●
	.157", 4.00 mm	●	●	●
	RE .008"	●	●	●
	RE .016"	●	●	●
	RE .031"	●	●	●

● : Gauge insert shown dimensions

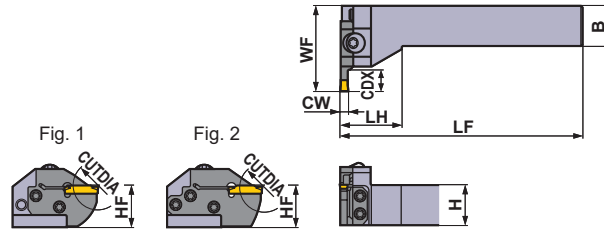
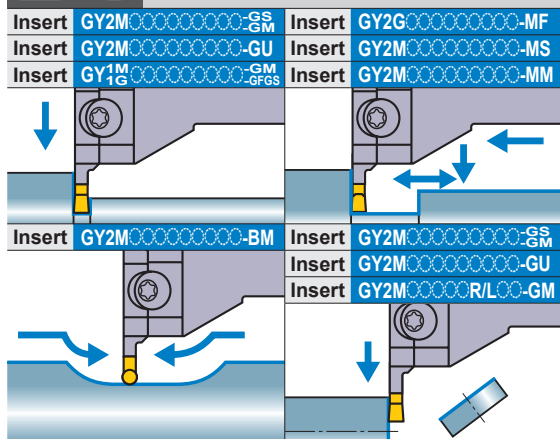
IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL)

2-1 90° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
H	.187 .197 .206	.315	.630	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-H08	●	1	
					L	GYHLUS16D90-M25R	●	GYM25RA-H08	●	1	
		.472	.945	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-H12	●	1	
					L	GYHLUS12C90-M20R	●	GYM20RA-H12	●	1	
		.551	1.102	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-H14	●	1	
					L	GYHLUS16D90-M25R	●	GYM25RA-H14	●	1	
		.984 *1	1.969 *2	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-H25	●	2	
					L	GYHLUS16D90-M25R	●	GYM25RA-H25	●	2	
J	.236 .248 .250	.315	.630	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-J08	●	1	
					L	GYHLUS16D90-M25R	●	GYM25RA-J08	●	1	
		.551	1.102	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-J14	●	1	
					L	GYHLUS16D90-M25R	●	GYM25RA-J14	●	1	
		.984 *1	1.969 *2	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-J25	●	2	
					L	GYHLUS16D90-M25R	●	GYM25RA-J25	●	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 F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

F

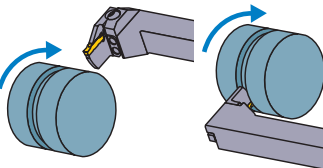
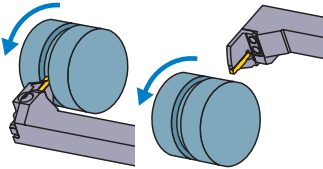
GROOVING / CUTTING OFF

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHRUS12C90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHLUS12C90-M20R			
GYHRUS16D90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) *3						Cutting Mode
	H	B	LF	LH	HF	WF	
	1.000	1.000	6.000	1.500	1.000	1.857	R 
	1.000	1.000	6.000	1.500	1.000	1.857	
	.750	.750	5.000	1.375	.750	1.781	
	.750	.750	5.000	1.375	.750	1.781	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	1.857	L 
	1.000	1.000	6.000	1.500	1.000	1.857	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	

Select an Insert

Seat Size	Insert Number
H	GY○○○0475/0500/0524H○○○-Breaker
J	GY○○○0600/0631/0635J○○○-Breaker

For Grooving/Cutting off > F011~F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)	05-GM (Cutting off)
	CW	Neutral	Neutral	Neutral	Neutral	Hand
H	.187", 4.75 mm	●	●	●	●	●
	.197", 5.00 mm	●	●	●	●	●
J	.236", 6.00 mm	●	●	●	●	●
	.250", 6.35 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
	CW	Finish	Low	Medium
H	.187", 4.75 mm	●		
	RE .008"	●		
	RE .016"	●		
	RE .031"	●		
	.197", 5.00 mm	●		
	RE .008"	●		
	RE .016"	●	●	●
	RE .031"	●	●	●
	.206", 5.24 mm	●		
	.236", 6.00 mm	●		
J	RE .008"	●		
	RE .016"	●	●	●
	RE .031"	●	●	●
	.248", 6.31 mm	●		
	.250", 6.35 mm	●		
	RE .008"	●		
	RE .016"	●		
	RE .031"	●		

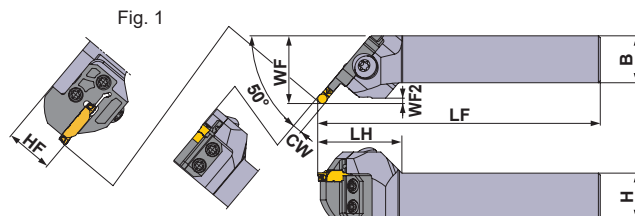
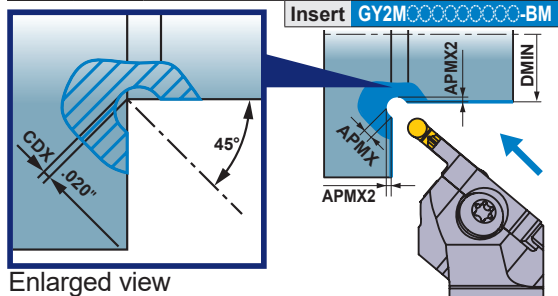
● : Gauge insert shown dimensions

GY SERIES (EXTERNAL RECESSING)

3-1 50° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	DMIN (inch)	APMX (inch)	APMX2 (inch)	Type	Hand (R/L)	Order Number				Fig.
								Holder	Stock	Modular Blade	Stock	
D	.079 .088			.059	.025	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-D005	●	1
						Modular	L	GYHLUS12C50-M20R	●	GYM20RC-D005	●	1
E	.094 .098 .108		1.181	.069	.028	Modular	R	GYHRUS16D50-M25L	●	GYM25LC-D005	●	1
						Modular	L	GYHLUS16D50-M25R	●	GYM25RC-D005	●	1
F	.118 .125 .128		.020	.082	.032	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-E005	●	1
						Modular	L	GYHLUS12C50-M20R	●	GYM20RC-E005	●	1
G	.157 .167			.098	.037	Modular	R	GYHRUS16D50-M25L	●	GYM25LC-E005	●	1
						Modular	L	GYHLUS16D50-M25R	●	GYM25RC-E005	●	1
H	.187 .197 .206			.113	.041	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-F005	●	1
						Modular	L	GYHLUS12C50-M20R	●	GYM20RC-F005	●	1
J	.236 .248 .250			.144	.051	Modular	R	GYHRUS16D50-M25L	●	GYM25LC-F005	●	1
						Modular	L	GYHLUS16D50-M25R	●	GYM25RC-F005	●	1

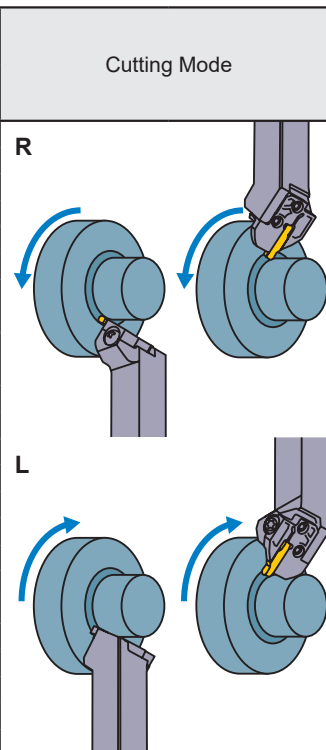
*1 Blades for external and face grooving cannot be used since it interferes with work materials.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, WF and WF2 values may vary.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 4 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C50-M20R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D50-M25R/L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) ★2						
	H	B	LF	LH	HF	WF	WF2
	.750	.750	5.007	1.632	.750	1.232	.076
	.750	.750	5.007	1.632	.750	1.232	.076
	1.000	1.000	6.007	1.819	1.000	1.357	.076
	1.000	1.000	6.007	1.819	1.000	1.357	.076
	.750	.750	5.003	1.628	.750	1.241	.084
	.750	.750	5.003	1.628	.750	1.241	.084
	1.000	1.000	6.003	1.815	1.000	1.366	.084
	1.000	1.000	6.003	1.815	1.000	1.366	.084
	.750	.750	5.000	1.625	.750	1.250	.094
	.750	.750	5.000	1.625	.750	1.250	.094
	1.000	1.000	6.000	1.813	1.000	1.375	.094
	1.000	1.000	6.000	1.813	1.000	1.375	.094
	.750	.750	4.989	1.614	.750	1.265	.109
	.750	.750	4.989	1.614	.750	1.265	.109
	1.000	1.000	5.989	1.802	1.000	1.390	.109
	1.000	1.000	5.989	1.802	1.000	1.390	.109
	.750	.750	4.980	1.605	.750	1.281	.125
	.750	.750	4.980	1.605	.750	1.281	.125
	1.000	1.000	5.980	1.792	1.000	1.406	.125
	1.000	1.000	5.980	1.792	1.000	1.406	.125
	1.000	1.000	5.978	1.791	1.000	1.429	.148
	1.000	1.000	5.978	1.791	1.000	1.429	.148



Select an Insert

Insert Number		
GY2M○○○○○○○○N-BM		
For Multifunctional Grooving > F014		
Seat Size	Breaker	BM (Copying, Recessing)
	CW	Ball nose
D	.079", 2.00 mm	●
E	.098", 2.50 mm	●
F	.118", 3.00 mm	●
	.125", 3.18 mm	●
G	.157", 4.00 mm	●
H	.187", 4.75 mm	●
	.197", 5.00 mm	●
J	.236", 6.00 mm	●
	.250", 6.35 mm	●

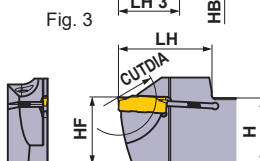
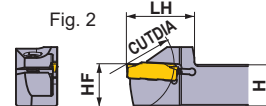
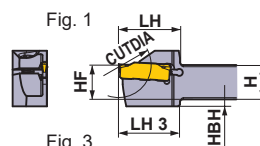
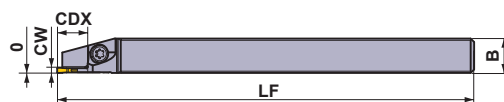
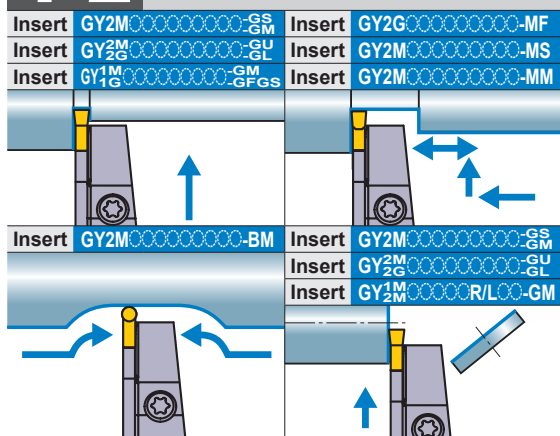
● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

1-2

NEW



Right hand tool holder shown.

Seat Size	CW (mm)	*4 CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number		Fig.	
						Holder	Stock		
B	1.20 .047"	8	16	Mono Block	R	GYSR1010JX00-B08	★	1	
				L	GYSL1010JX00-B08	★	1		
		Mono Block	R	GYSR1212JX00-B08	●	2			
			L	GYSL1212JX00-B08	●	2			
		12	24	Mono Block	R	GYSR1212JX00-B12	●	1	
					L	GYSL1212JX00-B12	●	1	
		13	16	Mono Block	R	GYSR1616JX00-B08	●	2	
					L	GYSL1616JX00-B08	●	2	
26	Mono Block		R	GYSR1616JX00-B13	●	2			
			L	GYSL1616JX00-B13	★	2			
C	1.50	8	16	Mono Block	R	GYSR1010JX00-C08	★	1	
				L	GYSL1010JX00-C08	★	1		
		Mono Block	R	GYSR1212JX00-C08	★	2			
			L	GYSL1212JX00-C08	★	2			
		12	24	Mono Block	R	GYSR1212JX00-C12	★	1	
					L	GYSL1212JX00-C12	★	1	
		13	26	Mono Block	R	GYSR1616JX00-C13	★	2	
					L	GYSL1616JX00-C13	★	2	
Mono Block	R			GYSR2012JX00-C13	★	3			
	L			GYSL2012JX00-C13	★	3			
D	2.00 2.24	10	20	Mono Block	R	GYSR1010JX00-D10	★	1	
					L	GYSL1010JX00-D10	★	1	
		12	24	Mono Block	R	GYSR1212JX00-D12	●	1	
					L	GYSL1212JX00-D12	●	1	
		13	26	Mono Block	R	GYSR1616JX00-D13	●	2	
					L	GYSL1616JX00-D13	●	2	
		16	32	Mono Block	R	GYSR1616JX00-D16	●	2	
					L	GYSL1616JX00-D16	●	2	
		17	34	Mono Block	R	GYSR1915K00-D17	★	3	
					L	GYSL1915K00-D17	★	3	
				Mono Block	R	GYSR2012JX00-D17	●	3	
					L	GYSL2012JX00-D17	★	3	
Mono Block	R			GYSR2020K00-D17	★	2			
	L			GYSL2020K00-D17	★	2			
Mono Block	R	GYSR2525M00-D17	★	2					
	L	GYSL2525M00-D17	★	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 F011 to F015.

*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 F011 to F015.

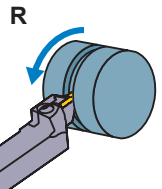
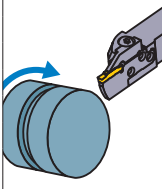
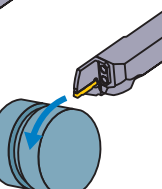
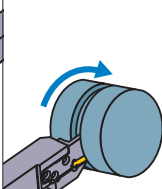
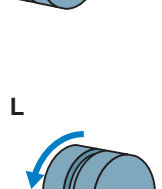
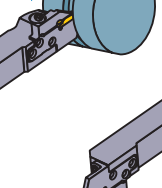
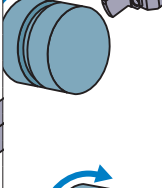
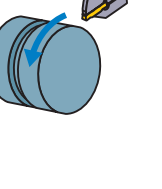
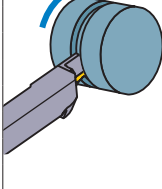
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH** and **LH 3** values may vary.

*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F197.

● : USA Stock ★ : Stocked in Japan

SPARE PARTS

Holder		
	Clamp Screw	Wrench
GYSR/L1010JX00	CS350990T	TKY10R
GYSR/L1212JX00		
GYSR/L1616JX00	TS4SBL	TKY15R
GYSR/L1915K00		
GYSR/L2012JX00	CS350990T	TKY10R
GYSR/L2020K00	HSC05018	TKY40R
GYSR/L2525K00		

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 3	HF	HBH		Clockwise	Anticlockwise
10	10	120	17.5	17.5	10	2			
10	10	120	17.5	17.5	10	2			
12	12	120	19.5	—	12	—			
12	12	120	19.5	—	12	—			
12	12	120	19.5	19.5	12	2			
12	12	120	19.5	19.5	12	2			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
10	10	120	17.5	17.5	10	2			
10	10	120	17.5	17.5	10	2			
12	12	120	19.5	—	12	—			
12	12	120	19.5	—	12	—			
12	12	120	19.5	19.5	12	2			
12	12	120	19.5	19.5	12	2			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
20	12	120	28	—	20	—			
20	12	120	28	—	20	—			
20	12	120	28	—	20	—			
20	12	120	28	—	20	—			
20	20	125	35	—	20	—			
20	20	125	35	—	20	—			
25	25	150	40	—	25	—			
25	25	150	40	—	25	—			

Select an Insert

Seat Size	Insert Number
B	GY○○0120B○○○○—Breaker
C	GY○○0150C○○○○—Breaker
D	GY○○0200/0224D○○○○—Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
B	.047", 1.20 mm		●			
C	.059", 1.50 mm		●	●		
D	.079", 2.00 mm	●	●	●	●	●

For Cutting off > F012				
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)
CW	R	R	R	R
B	.047", 1.20 mm	●		
C	.059", 1.50 mm		●	●
D	.079", 2.00 mm		●	●

For multifunctional grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
CW				Ball shape
D	.079", 2.00 mm	●	●	●
	.088", 2.24 mm	●		

● : Gauge insert shown dimensions

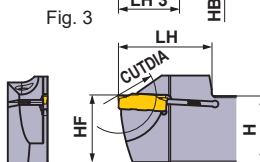
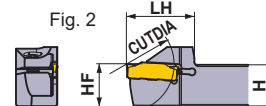
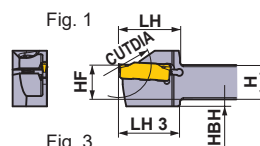
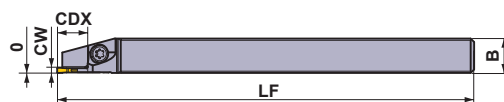
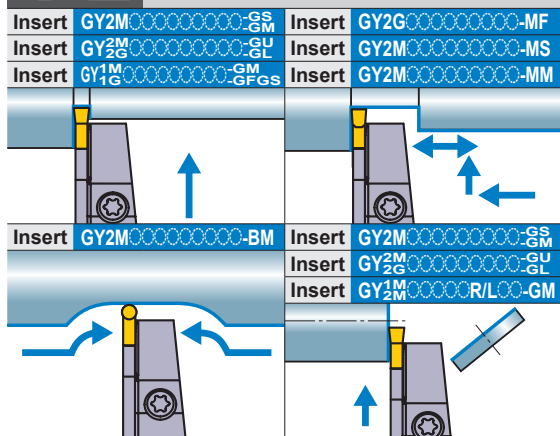
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

F041

1-2

NEW



Right hand tool holder shown.

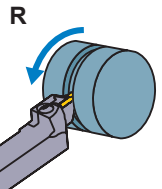
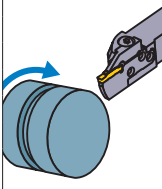
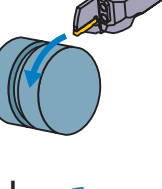
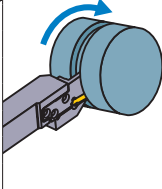
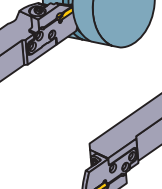
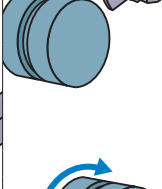
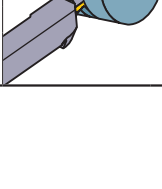
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*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F197.

● : USA Stock ★ : Stocked in Japan

SPARE PARTS

Holder		
	Clamp Screw	Wrench
GYSR/L1010JX00	CS350990T	TKY10R
GYSR/L1212JX00		
GYSR/L1616JX00	TS4SBL	TKY15R
GYSR/L1915K00		
GYSR/L2012JX00	CS350990T	TKY10R
GYSR/L2020K00	HSC05018	TKY40R
GYSR/L2525K00		

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 3	HF	HBH		Clockwise	Anticlockwise
10	10	120	17.5	17.5	10	2			
10	10	120	17.5	17.5	10	2			
12	12	120	19.5	19.5	12	2			
12	12	120	19.5	19.5	12	2			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
16	16	120	28	—	16	—			
16	16	120	28	—	16	—			
19.05	15.875	125	28	—	19.05	—			
19.05	15.875	125	28	—	19.05	—			
20	12	120	28	—	20	—			
20	12	120	28	—	20	—			
20	20	125	35	—	20	—			
20	20	125	35	—	20	—			
25	25	150	40	—	25	—			
25	25	150	40	—	25	—			
12	12	120	19.5	19.5	12	2			
12	12	120	19.5	19.5	12	2			
16	16	120	25	—	16	—			
16	16	120	25	—	16	—			
16	16	120	28	—	16	—			
16	16	120	28	—	16	—			
19.05	15.875	125	28	—	19.05	—			
19.05	15.875	125	28	—	19.05	—			
20	12	120	28	—	20	—			
20	12	120	28	—	20	—			
20	12	120	28	—	20	—			
20	12	120	28	—	20	—			
20	12	120	28	—	20	—			
20	12	120	28	—	20	—			

Select an Insert

Seat Size	Insert Number
E	GY○○○0239/0250/0274E○○○○○-Breaker
F	GY○○○0300/0318/0324F○○○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
E	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●

For Cutting off > F012				
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)
	CW	R	R	R
E	.098", 2.50 mm	●	●	●
F	.118", 3.00 mm	●	●	●

For multifunctional grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
	CW			BM (Copying)
				Ball shape
E	.094", 2.39 mm	●	●	●
	.098", 2.50 mm	●	●	●
	.108", 2.74 mm	●	●	●
F	.118", 3.00 mm	●	●	●
	RE .008", 0.2 mm	●	●	●
	RE .016", 0.4 mm	●	●	●
	RE .031", 0.8 mm	●	●	●
	.125", 3.18 mm	●	●	●
	RE .008", 0.2 mm	●	●	●
	RE .016", 0.4 mm	●	●	●
	.128", 3.24 mm	●	●	●

● : Gauge insert shown dimensions

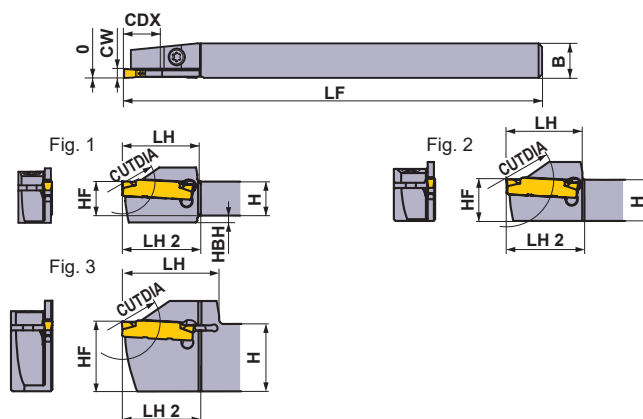
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GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

F043

1-2 00° type holder (Metric)



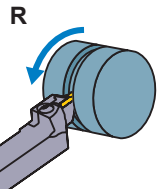
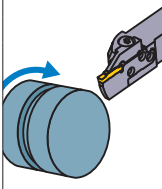
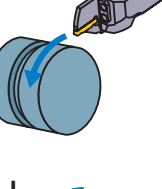
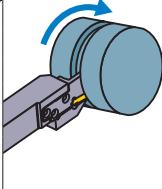
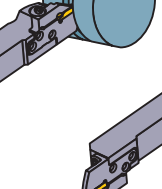
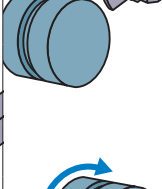
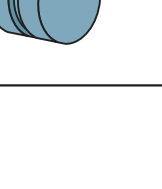
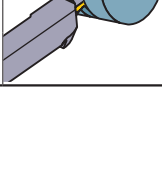
GROOVING / CUTTING OFF

Seat Size	CW (mm)	*4 CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number		Fig.	
						Holder	Stock		
C	1.50	11	22	Mono Block	R	GYSR1010JX00-C11	●	1	
					L	GYSL1010JX00-C11	●	1	
		13	26	Mono Block	R	GYSR1212JX00-C13	●	2	
					L	GYSL1212JX00-C13	●	2	
		17 *1	34 *2	Mono Block	R	GYSR1616JX00-C17	●	2	
					L	GYSL1616JX00-C17	●	2	
		18 *1	36 *2	Mono Block	R	GYSR2012JX00-C18	●	3	
					L	GYSL2012JX00-C18	●	3	
D	2.00 2.24	11	22	Mono Block	R	GYSR1010JX00-D11	●	1	
					L	GYSL1010JX00-D11	●	1	
		13	26	Mono Block	R	GYSR1212JX00-D13	●	2	
					L	GYSL1212JX00-D13	●	2	
		17	34	Mono Block	R	GYSR1616JX00-D17	●	2	
					L	GYSL1616JX00-D17	●	2	
		18	36	Mono Block	R	GYSR2012JX00-D18	●	3	
					L	GYSL2012JX00-D18	●	3	
E	2.39 2.50 2.74	11	22	Mono Block	R	GYSR1010JX00-E11	●	1	
					L	GYSL1010JX00-E11	●	1	
		13	26	Mono Block	R	GYSR1212JX00-E13	●	2	
					L	GYSL1212JX00-E13	●	2	
		17	34	Mono Block	R	GYSR1616JX00-E17	●	2	
					L	GYSL1616JX00-E17	●	2	
		18	36	Mono Block	R	GYSR2012JX00-E18	●	3	
					L	GYSL2012JX00-E18	●	3	
F	3.00 3.18 3.24	11	22	Mono Block	R	GYSR1010JX00-F11	●	1	
					L	GYSL1010JX00-F11	●	1	
		13	26	Mono Block	R	GYSR1212JX00-F13	●	2	
					L	GYSL1212JX00-F13	●	2	
		17	34	Mono Block	R	GYSR1616JX00-F17	●	2	
					L	GYSL1616JX00-F17	●	2	
		18	36	Mono Block	R	GYSR2012JX00-F18	●	3	
					L	GYSL2012JX00-F18	●	3	

*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F011 to F015.
 *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 F011 to F015.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH** and **LH 2** values may vary.
 *4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F199.

SPARE PARTS

Holder Number		
	Clamp Screw	Wrench
GYSR/L1010JX00-11	CS350990T (Clamp Torque : 22 lbf-in)	TKY10R
GYSR/L1212JX00-13		
GYSR/L2012JX00-18		
GYSR/L1616JX00-17	TS4SBL (Clamp Torque : 31 lbf-in)	TKY15R

	Dimensions (mm) *3							Cutting Mode	
	H	B	LF	LH	LH 2	HF	HBH	Clockwise	Anticlockwise
	10	10	120	22	16	10	2		
	10	10	120	22	16	10	2		
	12	12	120	22	16	12	—		
	12	12	120	22	16	12	—		
	16	16	120	27	17	16	—		
	16	16	120	27	17	16	—		
	20	12	120	28	16	20	—		
	20	12	120	28	16	20	—		
	10	10	120	22	23	10	2		
	10	10	120	22	23	10	2		
	12	12	120	22	23	12	—		
	12	12	120	22	23	12	—		
	16	16	120	27	24	16	—		
	16	16	120	27	24	16	—		
	20	12	120	28	23	20	—		
	20	12	120	28	23	20	—		
	10	10	120	22	23	10	2		
	10	10	120	22	23	10	2		
	12	12	120	22	23	12	—		
	12	12	120	22	23	12	—		
	16	16	120	27	24	16	—		
	16	16	120	27	24	16	—		
	20	12	120	28	23	20	—		
	20	12	120	28	23	20	—		

Select an Insert

Seat Size	Insert Number
C	GY00150C0000-Breaker
D	GY00200/0224D0000-Breaker
E	GY00239/0250/0274E0000-Breaker
F	GY00300/0318/0324F0000-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	Neutral	Neutral
C	.059", 1.50 mm		●	●		
D	.079", 2.00 mm	●	●	●	●	●
E	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●

For Cutting off > F012				
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)
		R	R	R
C	.059", 1.50 mm		●	●
D	.079", 2.00 mm		●	●
E	.098", 2.50 mm		●	●
F	.118", 3.00 mm		●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
				BM (Copying, Recessing)
D	.079", 2.00 mm	●	●	●
	.088", 2.24 mm	●		
E	.094", 2.39 mm	●		
	.098", 2.50 mm	●	●	●
	.108", 2.74 mm	●		
F	.118", 3.00 mm			●
	RE 0.2 mm	●	●	●
	RE 0.4 mm	●	●	●
	RE 0.8 mm			●
	.125", 3.18 mm			●
	RE 0.2 mm	●		
	RE 0.4 mm	●		
	.128", 3.24 mm	●		

● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194

INSTRUCTION MANUAL > F201

F045

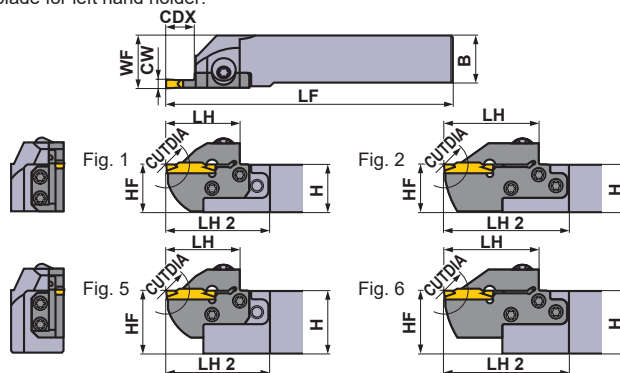
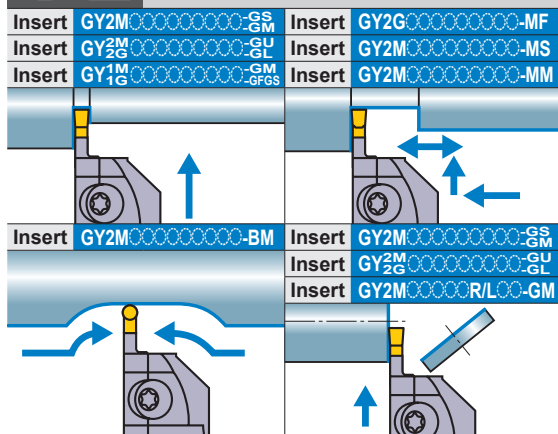
GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)

1-2 00° type holder (Metric)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
D	2.00 2.24	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-D06	●	3	
					L	GYHL1616J00-M20L	●	GYM20LA-D06	●	3	
				Mono Block	R	GYQR2020K00-D06	★	—	—	7	
					L	GYQL2020K00-D06	★	—	—	7	
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-D06	●	1	
					L	GYHL2020K00-M20L	●	GYM20LA-D06	●	1	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-D06	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-D06	●	3	
				Mono Block	R	GYQR2525M00-D06	★	—	—	7	
					L	GYQL2525M00-D06	★	—	—	7	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-D06	●	1	
					L	GYHL2525M00-M25L	●	GYM25LA-D06	●	1	
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-D06	●	5			
			L	GYHL3225P00-M25L	★	GYM25LA-D06	●	5			
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-D06	●	5			
			L	GYHL3232P00-M25L	★	GYM25LA-D06	●	5			
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-D10	●	3	
					L	GYHL1616J00-M20L	●	GYM20LA-D10	●	3	
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-D10	●	1	
					L	GYHL2020K00-M20L	●	GYM20LA-D10	●	1	
		12	24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-D12	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-D12	●	3	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-D12	●	1	
					L	GYHL2525M00-M25L	●	GYM25LA-D12	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-D12	●	5	
					L	GYHL3225P00-M25L	★	GYM25LA-D12	●	5	
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-D12	●	5			
			L	GYHL3232P00-M25L	★	GYM25LA-D12	●	5			
		18 *4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-D18	●	4	
					L	GYHL1616J00-M20L	●	GYM20LB-D18	●	4	
				Mono Block	R	GYQR2020K00-D18	★	—	—	7	
					L	GYQL2020K00-D18	★	—	—	7	
		Modular	R	GYHR2020K00-M20R	●	GYM20RB-D18	●	2			
			L	GYHL2020K00-M20L	●	GYM20LB-D18	●	2			
		20 *1	40 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RA-D20	●	4	
					L	GYHL2020K00-M25L	●	GYM25LA-D20	●	4	
Mono Block	R			GYQR2525M00-D20	★	—	—	7			
	L			GYQL2525M00-D20	★	—	—	7			
Modular	R			GYHR2525M00-M25R	●	GYM25RA-D20	●	2			
	L			GYHL2525M00-M25L	●	GYM25LA-D20	●	2			
Modular	R			GYHR3225P00-M25R	★	GYM25RA-D20	●	6			
	L			GYHL3225P00-M25L	★	GYM25LA-D20	●	6			
Modular	R	GYHR3232P00-M25R	★	GYM25RA-D20	●	6					
	L	GYHL3232P00-M25L	★	GYM25LA-D20	●	6					

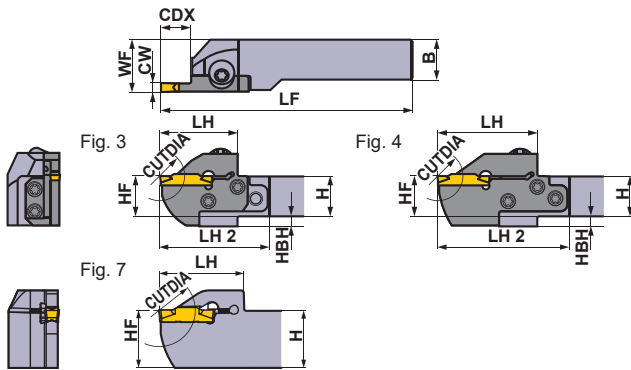
CW = Cutting Width **CDX** = Max. Groove Depth **CUTDIA** = Max. Cut Off Diameter

*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F011 to F015.

*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F014 to F015.
*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 F011 to F015.
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH** and **LH 2** values may vary.

*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench ★
GYQR/L○○○○○○○○○○○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L○○○○○○○○○○○○○○○○○○○○-M20R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/L○○○○○○○○○○○○○○○○○○○○-M25R/L	—	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Select an Insert

Seat Size	Insert Number
D	GY○○○0200/0224D○○○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●

For Cutting off > F012				
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)
CW	R	R	R	R/L
D	.079", 2.00 mm	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
CW	Ball nose			
D	.079", 2.00 mm	●	●	●
	.088", 2.24 mm	●		

● : Gauge insert shown dimensions

Dimensions (mm) ★3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
16	16	104	28	44	16	20	4		
16	16	104	28	44	16	20	4		
20	20	125	36	—	20	20.15	—		
20	20	125	36	—	20	20.15	—		
20	20	119	28	43	20	23	—		
20	20	119	28	43	20	23	—		
20	20	117	31	52	20	26	5		
20	20	117	31	52	20	26	5		
25	25	150	36	—	25	25.15	—		
25	25	150	36	—	25	25.15	—		
25	25	142	31	49	25	28	—		
25	25	142	31	49	25	28	—		
32	25	162	31	49	32	28	—		
32	25	162	31	49	32	28	—		
32	32	162	31	49	32	35	—		
32	32	162	31	49	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
16	16	116	40	56	16	20	4		
16	16	116	40	56	16	20	4		
20	20	125	39	—	20	20.10	—		
20	20	125	39	—	20	20.10	—		
20	20	131	40	55	20	23	—		
20	20	131	40	55	20	23	—		
20	20	131	45	66	20	26	5		
20	20	131	45	66	20	26	5		
25	25	150	41	—	25	25.10	—		
25	25	150	41	—	25	25.10	—		
25	25	156	45	63	25	28	—		
25	25	156	45	63	25	28	—		
32	25	176	45	63	32	28	—		
32	25	176	45	63	32	28	—		
32	32	176	45	63	32	35	—		
32	32	176	45	63	32	35	—		
32	32	176	45	63	32	35	—		

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

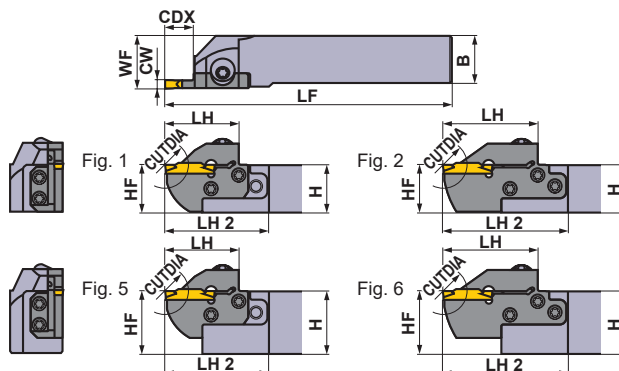
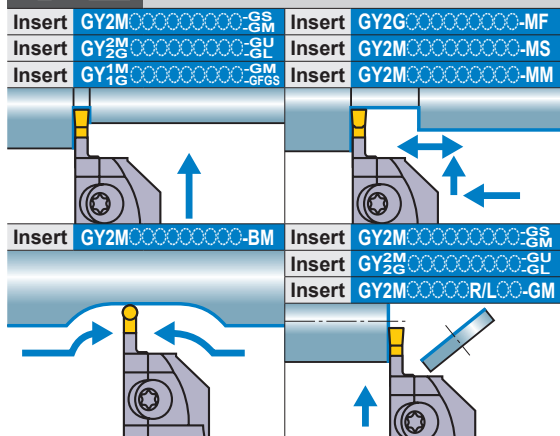
F

GROOVING / CUTTING OFF

F047

1-2 00° type holder (Metric)

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



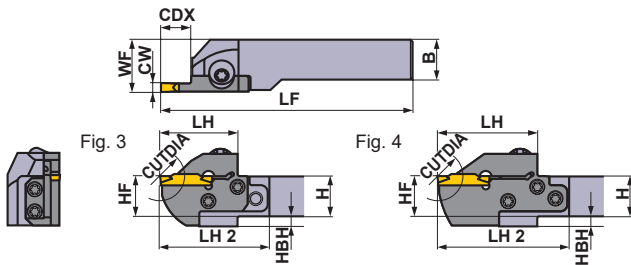
Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
E	2.39 2.50 2.74	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-E06	●	3	
					L	GYHL1616J00-M20L	●	GYM20LA-E06	●	3	
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-E06	●	1	
					L	GYHL2020K00-M20L	●	GYM20LA-E06	●	1	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-E06	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-E06	●	3	
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-E06	●	1			
			L	GYHL2525M00-M25L	●	GYM25LA-E06	●	1			
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-E06	●	5			
			L	GYHL3225P00-M25L	★	GYM25LA-E06	●	5			
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-E06	●	5			
			L	GYHL3232P00-M25L	★	GYM25LA-E06	●	5			
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-E10	●	3	
					L	GYHL1616J00-M20L	●	GYM20LA-E10	●	3	
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-E10	●	1	
					L	GYHL2020K00-M20L	●	GYM20LA-E10	●	1	
		12	24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-E12	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-E12	●	3	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-E12	●	1	
					L	GYHL2525M00-M25L	●	GYM25LA-E12	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-E12	●	5	
					L	GYHL3225P00-M25L	★	GYM25LA-E12	●	5	
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-E12	●	5			
			L	GYHL3232P00-M25L	★	GYM25LA-E12	●	5			
18 *4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-E18	●	4			
			L	GYHL1616J00-M20L	●	GYM20LB-E18	●	4			
		Modular	R	GYHR2020K00-M20R	●	GYM20RB-E18	●	2			
			L	GYHL2020K00-M20L	●	GYM20LB-E18	●	2			
20 *1	40 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RA-E20	●	4			
			L	GYHL2020K00-M25L	●	GYM25LA-E20	●	4			
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-E20	●	2			
			L	GYHL2525M00-M25L	●	GYM25LA-E20	●	2			
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-E20	●	6			
			L	GYHL3225P00-M25L	★	GYM25LA-E20	●	6			
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-E20	●	6			
			L	GYHL3232P00-M25L	★	GYM25LA-E20	●	6			

*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F011 to F015.
 *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 F011 to F015.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH** and **LH 2** values may vary.
 *4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock ★ : Stocked in Japan

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench ★
GYQR/L	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (mm) ★3									Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH		Clockwise	Anticlockwise
16	16	104	28	44	16	20	4			
16	16	104	28	44	16	20	4			
20	20	119	28	43	20	23	—			
20	20	119	28	43	20	23	—			
20	20	117	31	52	20	26	5			
20	20	117	31	52	20	26	5			
25	25	142	31	49	25	28	—			
25	25	142	31	49	25	28	—			
32	25	162	31	49	32	28	—			
32	25	162	31	49	32	28	—			
32	32	162	31	49	32	35	—			
32	32	162	31	49	32	35	—			
16	16	110	34	50	16	20	4			
16	16	110	34	50	16	20	4			
20	20	125	34	49	20	23	—			
20	20	125	34	49	20	23	—			
20	20	125	39	60	20	26	5			
20	20	125	39	60	20	26	5			
25	25	150	39	57	25	28	—			
25	25	150	39	57	25	28	—			
32	25	170	39	57	32	28	—			
32	25	170	39	57	32	28	—			
32	32	170	39	57	32	35	—			
32	32	170	39	57	32	35	—			
16	16	116	40	56	16	20	4			
16	16	116	40	56	16	20	4			
20	20	131	40	55	20	23	—			
20	20	131	40	55	20	23	—			
20	20	131	45	66	20	26	5			
20	20	131	45	66	20	26	5			
25	25	156	45	63	25	28	—			
25	25	156	45	63	25	28	—			
32	25	176	45	63	32	28	—			
32	25	176	45	63	32	28	—			
32	32	176	45	63	32	35	—			
32	32	176	45	63	32	35	—			

Select an Insert

Seat Size	Insert Number
E	GY000239/0250/0274E0000-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
E	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●

For Cutting off > F012				
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)
CW	R	R	R	R/L
E	.098", 2.50 mm	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
CW	Ball nose	●	●	●
E	.094", 2.39 mm	●	●	●
	.098", 2.50 mm	●	●	●
	.108", 2.74 mm	●	●	●

● : Gauge insert shown dimensions

F

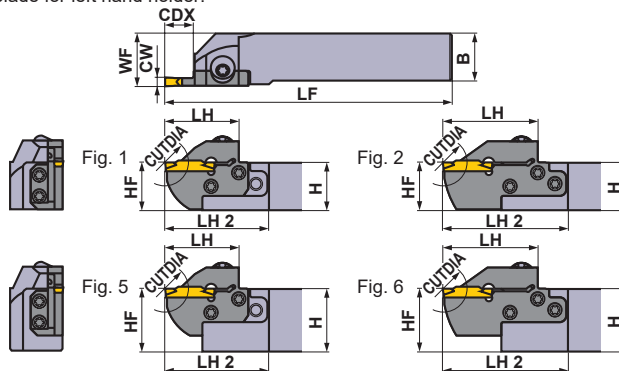
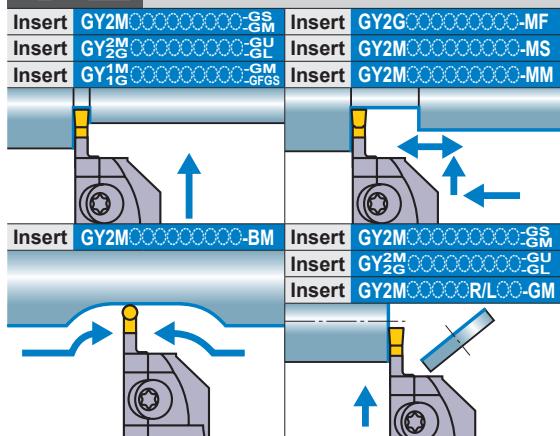
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

F049

1-2 00° type holder (Metric)

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

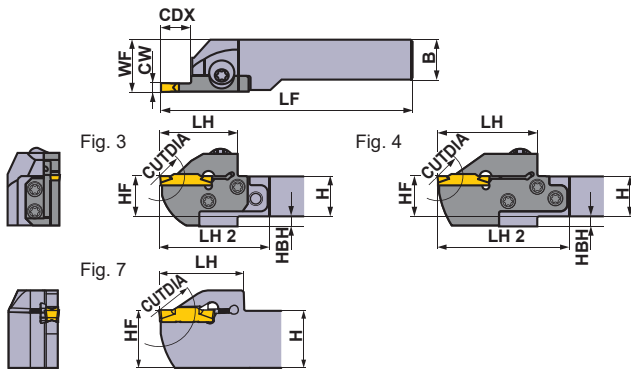


Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
F	3.00 3.18 3.24	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-F06	●	3	
					L	GYHL1616J00-M20L	●	GYM20LA-F06	●	3	
				Mono Block	R	GYQR2020K00-F06	★	—	—	7	
					L	GYQL2020K00-F06	★	—	—	7	
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-F06	●	1	
					L	GYHL2020K00-M20L	●	GYM20LA-F06	●	1	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-F06	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-F06	●	3	
		Mono Block	R	GYQR2525M00-F06	★	—	—	7			
			L	GYQL2525M00-F06	★	—	—	7			
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-F06	●	1			
			L	GYHL2525M00-M25L	●	GYM25LA-F06	●	1			
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-F06	●	5			
			L	GYHL3225P00-M25L	★	GYM25LA-F06	●	5			
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-F06	●	5			
			L	GYHL3232P00-M25L	★	GYM25LA-F06	●	5			
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-F10	●	3	
					L	GYHL1616J00-M20L	●	GYM20LA-F10	●	3	
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-F10	●	1	
					L	GYHL2020K00-M20L	●	GYM20LA-F10	●	1	
		12	24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-F12	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-F12	●	3	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-F12	●	1	
					L	GYHL2525M00-M25L	●	GYM25LA-F12	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-F12	●	5	
					L	GYHL3225P00-M25L	★	GYM25LA-F12	●	5	
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-F12	●	5			
			L	GYHL3232P00-M25L	★	GYM25LA-F12	●	5			
		18 *4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-F18	●	4	
					L	GYHL1616J00-M20L	●	GYM20LB-F18	●	4	
				Mono Block	R	GYQR2020K00-F18	★	—	—	7	
		L	GYQL2020K00-F18		★	—	—	7			
		20 *1	40 *2	Modular	R	GYHR2020K00-M20R	●	GYM20RB-F18	●	2	
					L	GYHL2020K00-M20L	●	GYM20LB-F18	●	2	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-F20	●	4	
					L	GYHL2020K00-M25L	●	GYM25LA-F20	●	4	
Mono Block	R			GYQR2525M00-F20	★	—	—	7			
	L			GYQL2525M00-F20	★	—	—	7			
Modular	R			GYHR2525M00-M25R	●	GYM25RA-F20	●	2			
	L			GYHL2525M00-M25L	●	GYM25LA-F20	●	2			
Modular	R			GYHR3225P00-M25R	★	GYM25RA-F20	●	6			
	L			GYHL3225P00-M25L	★	GYM25LA-F20	●	6			
Modular	R	GYHR3232P00-M25R	★	GYM25RA-F20	●	6					
	L	GYHL3232P00-M25L	★	GYM25LA-F20	●	6					

*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/L	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Select an Insert

Seat Size	Insert Number
F	GY000300/0318/0324F0000-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
F	.118", 3.00 mm .125", 3.18 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
CW	R	R	R	R	R/L
F	.118", 3.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW	Ball nose				
F	.118", 3.00 mm RE 0.2 mm RE 0.4 mm RE 0.8 mm .125", 3.18 mm RE 0.2 mm RE 0.4 mm .128", 3.24 mm	●	●	●	●

● : Gauge insert shown dimensions

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
16	16	104	28	44	16	20	4		
16	16	104	28	44	16	20	4		
20	20	125	36	—	20	20.30	—		
20	20	125	36	—	20	20.30	—		
20	20	119	28	43	20	23	—		
20	20	119	28	43	20	23	—		
20	20	117	31	52	20	26	5		
20	20	117	31	52	20	26	5		
25	25	150	36	—	25	25.30	—		
25	25	150	36	—	25	25.30	—		
25	25	142	31	49	25	28	—		
25	25	142	31	49	25	28	—		
32	25	162	31	49	32	28	—		
32	25	162	31	49	32	28	—		
32	32	162	31	49	32	35	—		
32	32	162	31	49	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
16	16	116	40	56	16	20	4		
16	16	116	40	56	16	20	4		
20	20	125	39	—	20	20.25	—		
20	20	125	39	—	20	20.25	—		
20	20	131	40	55	20	23	—		
20	20	131	40	55	20	23	—		
20	20	131	45	66	20	26	5		
20	20	131	45	66	20	26	5		
25	25	150	41	—	25	25.25	—		
25	25	150	41	—	25	25.25	—		
25	25	156	45	63	25	28	—		
25	25	156	45	63	25	28	—		
32	25	176	45	63	32	28	—		
32	25	176	45	63	32	28	—		
32	32	176	45	63	32	35	—		
32	32	176	45	63	32	35	—		
32	32	176	45	63	32	35	—		

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

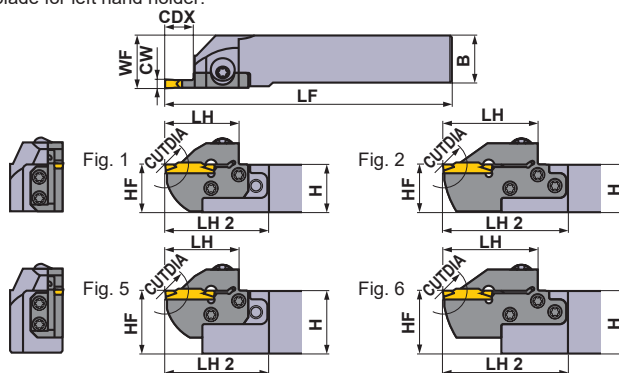
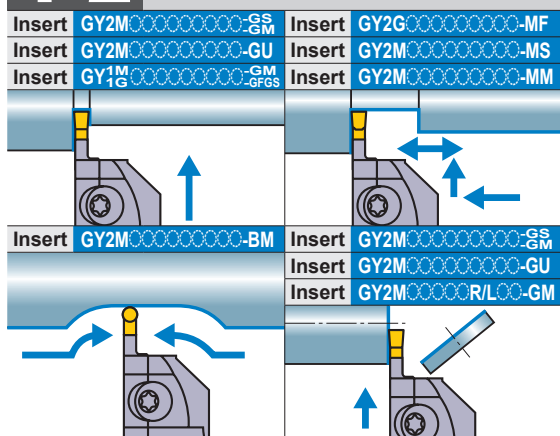
F

GROOVING / CUTTING OFF

F051

1-2 00° type holder (Metric)

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

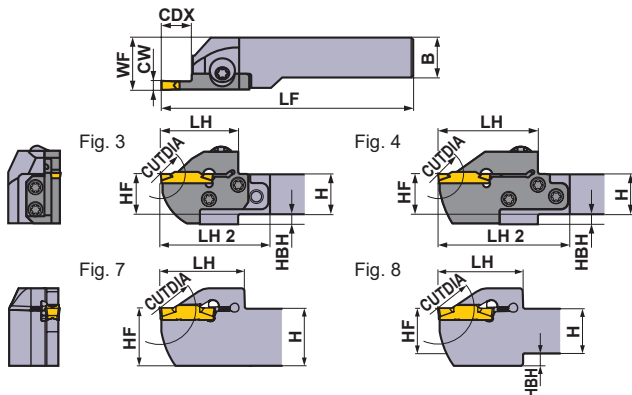


Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
G	4.00 4.24	8	16	Mono Block	R	GYQR2020K00-G08	★	—	—	7	
					L	GYQL2020K00-G08	★	—	—	7	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-G08	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-G08	●	3	
				Mono Block	R	GYQR2525M00-G08	★	—	—	7	
					L	GYQL2525M00-G08	★	—	—	7	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-G08	●	1	
					L	GYHL2525M00-M25L	●	GYM25LA-G08	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-G08	●	5	
					L	GYHL3225P00-M25L	★	GYM25LA-G08	●	5	
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-G08	●	5	
					L	GYHL3232P00-M25L	★	GYM25LA-G08	●	5	
		12	24	Modular	R	GYHR1616J00-M20R	●	GYM20RA-G12	●	3	
					L	GYHL1616J00-M20L	●	GYM20LA-G12	●	3	
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-G12	●	1	
					L	GYHL2020K00-M20L	●	GYM20LA-G12	●	1	
		14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-G14	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-G14	●	3	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-G14	●	1	
					L	GYHL2525M00-M25L	●	GYM25LA-G14	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-G14	●	5	
					L	GYHL3225P00-M25L	★	GYM25LA-G14	●	5	
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-G14	●	5	
					L	GYHL3232P00-M25L	★	GYM25LA-G14	●	5	
		25 *1	50 *2	Mono Block	R	GYQR2020K00-G25	★	—	—	8	
					L	GYQL2020K00-G25	★	—	—	8	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-G25	●	4	
					L	GYHL2020K00-M25L	●	GYM25LA-G25	●	4	
Mono Block	R			GYQR2525M00-G25	★	—	—	7			
	L			GYQL2525M00-G25	★	—	—	7			
Modular	R			GYHR2525M00-M25R	●	GYM25RA-G25	●	2			
	L			GYHL2525M00-M25L	●	GYM25LA-G25	●	2			
Modular	R			GYHR3225P00-M25R	★	GYM25RA-G25	●	6			
	L			GYHL3225P00-M25L	★	GYM25LA-G25	●	6			
Modular	R			GYHR3232P00-M25R	★	GYM25RA-G25	●	6			
	L			GYHL3232P00-M25L	★	GYM25LA-G25	●	6			

*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F011 to F015.
 *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 F011 to F015.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench ★
GYQR/L	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Select an Insert

Seat Size	Insert Number
G	GY000400/0424G-Breaker

For Grooving/Cutting off > F011-F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Hand
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
CW	Ball nose			
G	.157", 4.00 mm	●	●	●
	RE 0.2 mm	●	●	●
	RE 0.4 mm	●	●	●
	RE 0.8 mm	●	●	●
	.167", 4.24 mm	●	●	●

● : Gauge insert shown dimensions

Dimensions (mm) ★3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—	R	
20	20	125	41	—	20	20.35	—		
20	20	119	33	54	20	26	5		
20	20	119	33	54	20	26	5		
25	25	150	41	—	25	25.35	—		
25	25	150	41	—	25	25.35	—		
25	25	144	33	51	25	28	—		
25	25	144	33	51	25	28	—		
32	25	164	33	51	32	28	—		
32	25	164	33	51	32	28	—		
32	32	164	33	51	32	35	—	L	
32	32	164	33	51	32	35	—		
32	32	164	33	51	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	125	46	—	20	20.35	4	L	
20	20	125	46	—	20	20.35	4		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	150	46	—	25	25.35	—		
25	25	150	46	—	25	25.35	—		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		

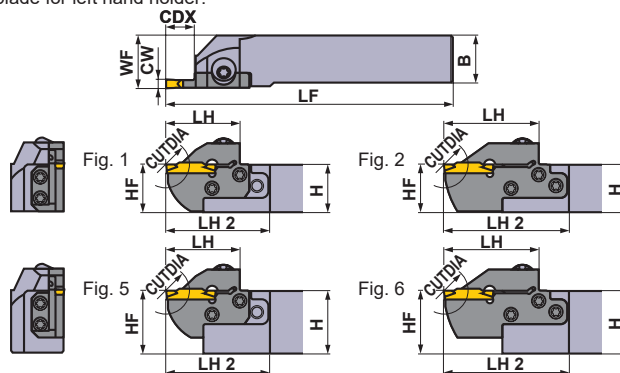
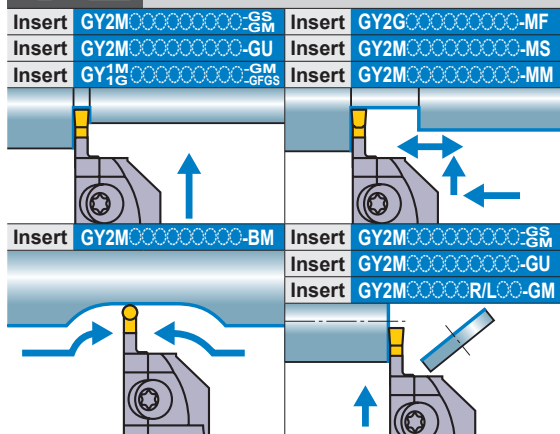
IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL)

1-2 00° type holder (Metric)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
H	4.75 5.00 5.24	8	16	Mono Block	R	GYQR2020K00-H08	★	—	—	7	
					L	GYQL2020K00-H08	★	—	—	7	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-H08	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-H08	●	3	
				Mono Block	R	GYQR2525M00-H08	★	—	—	7	
					L	GYQL2525M00-H08	★	—	—	7	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-H08	●	1	
					L	GYHL2525M00-M25L	●	GYM25LA-H08	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-H08	●	5	
					L	GYHL3225P00-M25L	★	GYM25LA-H08	●	5	
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-H08	●	5	
					L	GYHL3232P00-M25L	★	GYM25LA-H08	●	5	
		12	24	Modular	R	GYHR1616J00-M20R	●	GYM20RA-H12	●	3	
					L	GYHL1616J00-M20L	●	GYM20LA-H12	●	3	
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-H12	●	1	
					L	GYHL2020K00-M20L	●	GYM20LA-H12	●	1	
		14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-H14	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-H14	●	3	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-H14	●	1	
					L	GYHL2525M00-M25L	●	GYM25LA-H14	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-H14	●	5	
					L	GYHL3225P00-M25L	★	GYM25LA-H14	●	5	
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-H14	●	5	
					L	GYHL3232P00-M25L	★	GYM25LA-H14	●	5	
		25 *1	50 *2	Mono Block	R	GYQR2020K00-H25	★	—	—	8	
					L	GYQL2020K00-H25	★	—	—	8	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-H25	●	4	
					L	GYHL2020K00-M25L	●	GYM25LA-H25	●	4	
				Mono Block	R	GYQR2525M00-H25	★	—	—	7	
					L	GYQL2525M00-H25	★	—	—	7	
Modular	R			GYHR2525M00-M25R	●	GYM25RA-H25	●	2			
	L			GYHL2525M00-M25L	●	GYM25LA-H25	●	2			
Modular	R			GYHR3225P00-M25R	★	GYM25RA-H25	●	6			
	L			GYHL3225P00-M25L	★	GYM25LA-H25	●	6			
Modular	R			GYHR3232P00-M25R	★	GYM25RA-H25	●	6			
	L			GYHL3232P00-M25L	★	GYM25LA-H25	●	6			

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

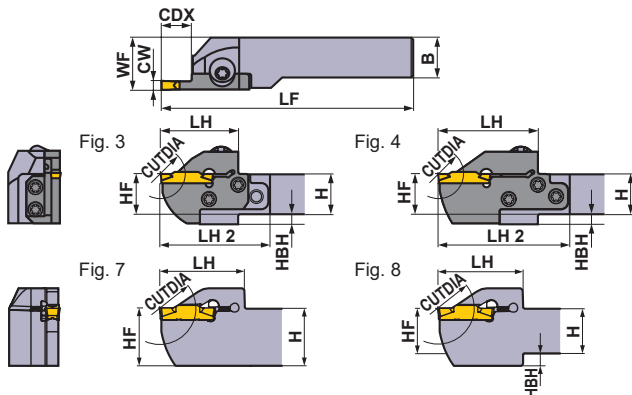
*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.

● : USA Stock ★ : Stocked in Japan

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench ★
GYQR/L	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (mm) ★3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—		
20	20	125	41	—	20	20.35	—		
20	20	119	33	54	20	26	5		
20	20	119	33	54	20	26	5		
25	25	150	41	—	25	25.35	—		
25	25	150	41	—	25	25.35	—		
25	25	144	33	51	25	28	—		
25	25	144	33	51	25	28	—		
32	25	164	33	51	32	28	—		
32	25	164	33	51	32	28	—		
32	32	164	33	51	32	35	—		
32	32	164	33	51	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	125	46	—	20	20.35	4		
20	20	125	46	—	20	20.35	4		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	150	46	—	25	25.35	—		
25	25	150	46	—	25	25.35	—		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		

Select an Insert

Seat Size	Insert Number
H	GY000475/0500/0524H0000-Breaker

For Grooving/Cutting off > F011-F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Hand
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
CW	Ball nose			
H	.187", 4.75 mm	●		
	RE 0.2 mm	●		
	RE 0.4 mm	●		
	RE 0.8 mm	●		
	.197", 5.00 mm	●		
	RE 0.2 mm	●		
	RE 0.4 mm	●		
	RE 0.8 mm	●		
	.206", 5.24 mm	●		

● : Gauge insert shown dimensions

F

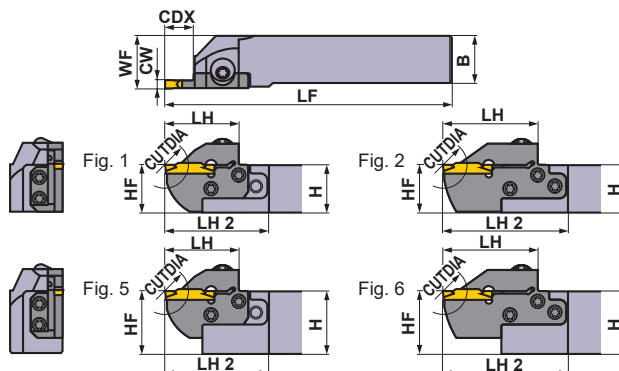
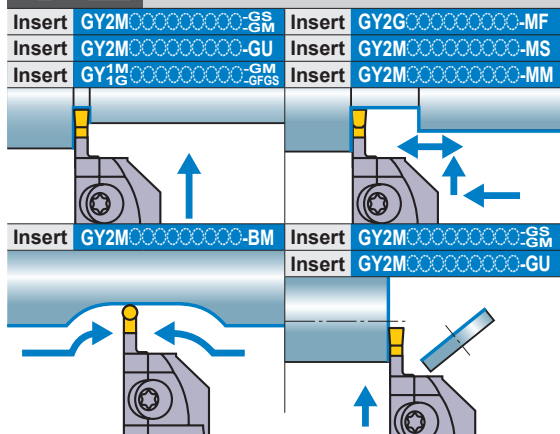
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

F055

1-2 00° type holder (Metric)

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

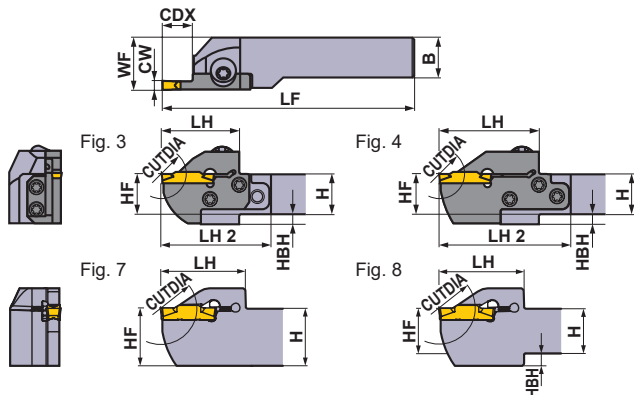


Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
J	6.00 6.31 6.35	8	16	Mono Block	R	GYQR2020K00-J08	★	—	—	7	
					L	GYQL2020K00-J08	★	—	—	7	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-J08	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-J08	●	3	
				Mono Block	R	GYQR2525M00-J08	★	—	—	7	
					L	GYQL2525M00-J08	★	—	—	7	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-J08	●	1	
					L	GYHL2525M00-M25L	●	GYM25LA-J08	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-J08	●	5	
					L	GYHL3225P00-M25L	★	GYM25LA-J08	●	5	
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-J08	●	5	
					L	GYHL3232P00-M25L	★	GYM25LA-J08	●	5	
		14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-J14	●	3	
					L	GYHL2020K00-M25L	●	GYM25LA-J14	●	3	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-J14	●	1	
					L	GYHL2525M00-M25L	●	GYM25LA-J14	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-J14	●	5	
					L	GYHL3225P00-M25L	★	GYM25LA-J14	●	5	
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-J14	●	5	
					L	GYHL3232P00-M25L	★	GYM25LA-J14	●	5	
		25 *1	50 *2	Mono Block	R	GYQR2020K00-J25	★	—	—	8	
					L	GYQL2020K00-J25	★	—	—	8	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-J25	●	4	
					L	GYHL2020K00-M25L	●	GYM25LA-J25	●	4	
Mono Block	R			GYQR2525M00-J25	★	—	—	7			
	L			GYQL2525M00-J25	★	—	—	7			
Modular	R			GYHR2525M00-M25R	●	GYM25RA-J25	●	2			
	L			GYHL2525M00-M25L	●	GYM25LA-J25	●	2			
Modular	R			GYHR3225P00-M25R	★	GYM25RA-J25	●	6			
	L			GYHL3225P00-M25L	★	GYM25LA-J25	●	6			
Modular	R			GYHR3232P00-M25R	★	GYM25RA-J25	●	6			
	L			GYHL3232P00-M25L	★	GYM25LA-J25	●	6			

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.

● : USA Stock ★ : Stocked in Japan



Right hand tool holder shown.

* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw	① Wrench *
GYQR/L	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—		
20	20	125	41	—	20	20.35	—		
20	20	119	33	54	20	26	5		
20	20	119	33	54	20	26	5		
25	25	150	41	—	25	25.35	—		
25	25	150	41	—	25	25.35	—		
25	25	144	33	51	25	28	—		
25	25	144	33	51	25	28	—		
32	25	164	33	51	32	28	—		
32	25	164	33	51	32	28	—		
32	32	164	33	51	32	35	—		
32	32	164	33	51	32	35	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	125	46	—	20	20.35	4		
20	20	125	46	—	20	20.35	4		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	150	46	—	25	25.35	—		
25	25	150	46	—	25	25.35	—		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		

Select an Insert

Seat Size	Insert Number
J	GY000600/0631/0635J0000-Breaker

For Grooving/Cutting off > F011—F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Hand
J	.236", 6.00 mm	●	●	●	●
	.250", 6.35 mm	●	●	●	●

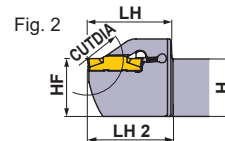
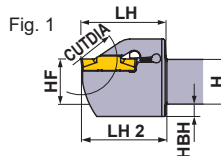
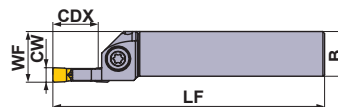
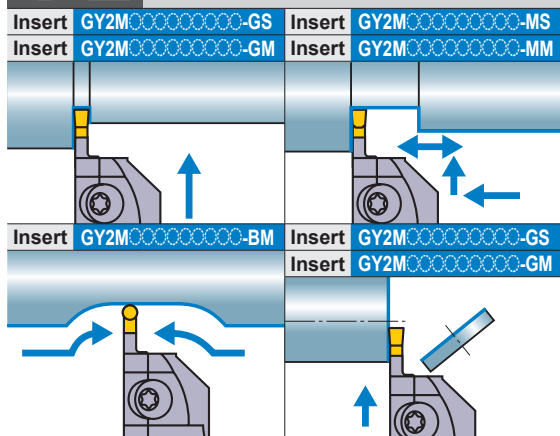
For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW	Ball nose				
J	.236", 6.00 mm	●			●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.248", 6.31 mm	●			●
	.250", 6.35 mm	●			●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)

1-2 00° type holder (Metric)


Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
K	8.00	25 *1	50 *2	Mono Block	R	GYPR2525M00-K25	●	—	—	1	
				Mono Block	L	GYPL2525M00-K25	●	—	—	1	
				Mono Block	R	GYPR3225P00-K25	●	—	—	2	
				Mono Block	L	GYPL3225P00-K25	●	—	—	2	
				Mono Block	R	GYPR3232P00-K25	●	—	—	3	
				Mono Block	L	GYPL3232P00-K25	●	—	—	3	

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 F011 to F015.

 *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 F011 to F015.

 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH**, **LH 2** and **WF** values may vary.

● : USA Stock

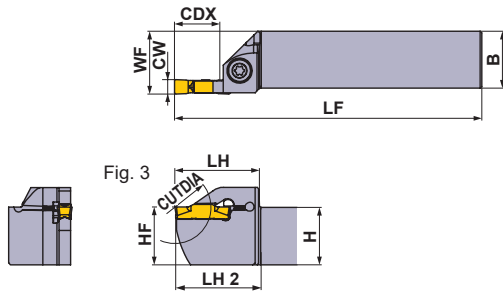
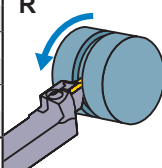
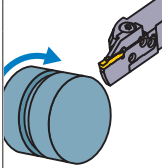
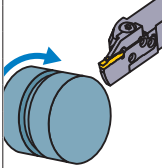
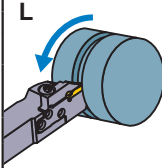
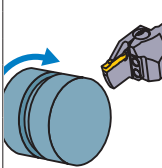
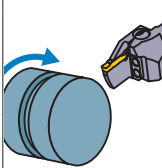


Fig. 3

Right hand tool holder shown.

SPARE PARTS

Holder Number		
GYPR/L00000000-K25	GY06013M (Clamp Torque : 53 lbf-in)	TKY30R

Dimensions (mm) *3									Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH		Clockwise	Anticlockwise
25	25	150	47	48	25	28	7			
25	25	150	47	48	25	28	7			
32	25	170	47	48	32	28	—			
32	25	170	47	48	32	28	—			
32	32	170	47	48	32	35	—			
32	32	170	47	48	32	35	—			

Select an Insert

Seat Size	Insert Number
K	GY000800K0000-Breaker

For Grooving/Cutting off > F011						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)	05-GM (Cutting off)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Hand
K	.315", 8.00 mm		●	●		

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					Ball nose
K	.315", 8.00 mm		●	●	●
	RE 0.8 mm				
	RE 1.2 mm				

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

2-2 90° type holder (Metric)

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

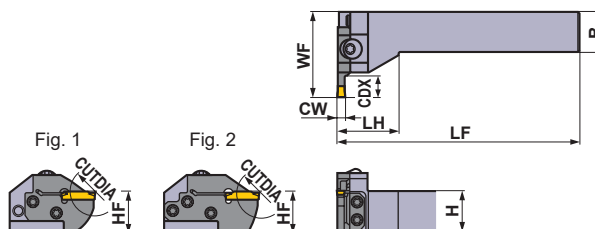
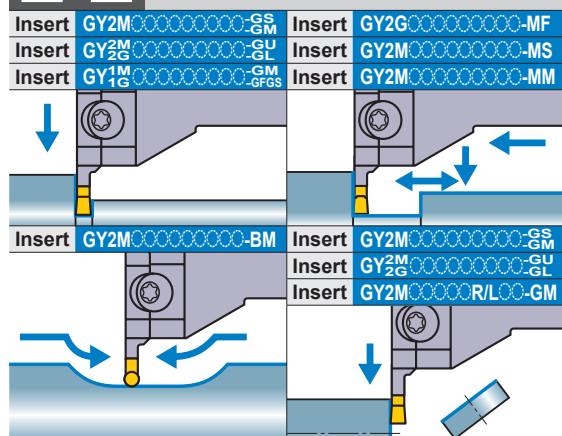


Fig. 1

Fig. 2

Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	6	12	Modular	R	GYHR2020K90-M20L	●	GYM20LA-D06	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-D06	●	1
				Modular	R	GYHR2525M90-M25L	●	GYM25LA-D06	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-D06	●	1
		10	20	Modular	R	GYHR2020K90-M20L	●	GYM20LA-D10	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-D10	●	1
		12	24	Modular	R	GYHR2525M90-M25L	●	GYM25LA-D12	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-D12	●	1
		18 *4	36	Modular	R	GYHR2020K90-M20L	●	GYM20LB-D18	●	2
					L	GYHL2020K90-M20R	●	GYM20RB-D18	●	2
		20 *1	40 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-D20	●	2
					L	GYHL2525M90-M25R	●	GYM25RA-D20	●	2
E	2.39 2.50 2.74	6	12	Modular	R	GYHR2020K90-M20L	●	GYM20LA-E06	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-E06	●	1
				Modular	R	GYHR2525M90-M25L	●	GYM25LA-E06	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-E06	●	1
		10	20	Modular	R	GYHR2020K90-M20L	●	GYM20LA-E10	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-E10	●	1
		12	24	Modular	R	GYHR2525M90-M25L	●	GYM25LA-E12	●	1
					L	GYHL2525M90-M25R	●	GYM25RA-E12	●	1
		18 *4	36	Modular	R	GYHR2020K90-M20L	●	GYM20LB-E18	●	2
					L	GYHL2020K90-M20R	●	GYM20RB-E18	●	2
		20 *1	40 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-E20	●	2
					L	GYHL2525M90-M25R	●	GYM25RA-E20	●	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 F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH** and **LH 2** values may vary.

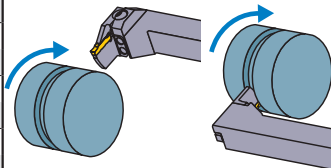
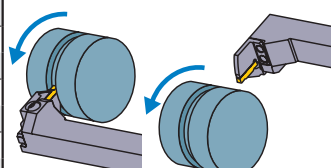
*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR2020K90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHL2020K90-M20R			
GYHR2525M90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★3						Cutting Mode
	H	B	LF	LH	HF	WF	
	20	20	125	35	20	39	R 
	20	20	125	35	20	39	
	25	25	150	38	25	45	
	25	25	150	38	25	45	
	20	20	125	35	20	45	
	20	20	125	35	20	45	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	20	20	125	35	20	51	
	20	20	125	35	20	51	
	25	25	150	38	25	59	L 
	25	25	150	38	25	59	
	20	20	125	35	20	39	
	20	20	125	35	20	39	
	25	25	150	38	25	45	
	25	25	150	38	25	45	
	20	20	125	35	20	45	
	20	20	125	35	20	45	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	20	20	125	35	20	51	
	20	20	125	35	20	51	
	25	25	150	38	25	59	
	25	25	150	38	25	59	

Select an Insert

Seat Size	Insert Number
D	GY○○○0200/0224D○○○○○-Breaker
E	GY○○○0239/0250/0274E○○○○○-Breaker

		For Grooving/Cutting off > F011, F013				
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●
E	.094", 2.39 mm	●	●	●	●	●

		For Cutting off > F012			
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
		R	R	R	R/L
D	.079", 2.00 mm		●	●	●
E	.098", 2.50 mm		●	●	●

		For Multifunctional Grooving > F013, F014			
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●			
	.094", 2.39 mm	●			
E	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

F061

2-2 90° type holder (Metric)

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

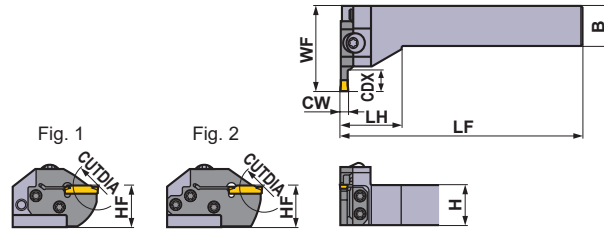


Fig. 2

Right hand tool holder shown.

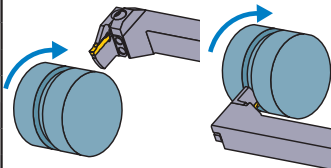
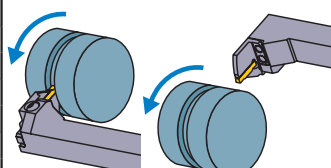
GROOVING / CUTTING OFF

*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHR2020K90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHL2020K90-M20R			
GYHR2525M90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) *3						Cutting Mode
	H	B	LF	LH	HF	WF	
	20	20	125	35	20	39	R 
	20	20	125	35	20	39	
	25	25	150	38	25	45	
	25	25	150	38	25	45	
	20	20	125	35	20	45	
	20	20	125	35	20	45	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	20	20	125	35	20	51	
	20	20	125	35	20	51	
	25	25	150	38	25	59	L 
	25	25	150	38	25	59	
	25	25	150	38	25	47	
	25	25	150	38	25	47	
	20	20	125	35	20	45	
	20	20	125	35	20	45	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	

Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○-Breaker
G	GY○○○0400/0424G○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●
G	.157", 4.00 mm	●	●	●	●	●

For Cutting off > F012				
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)
	CW	R	R	R
F	.118", 3.00 mm	●	●	●
G	.157", 4.00 mm	●	●	●

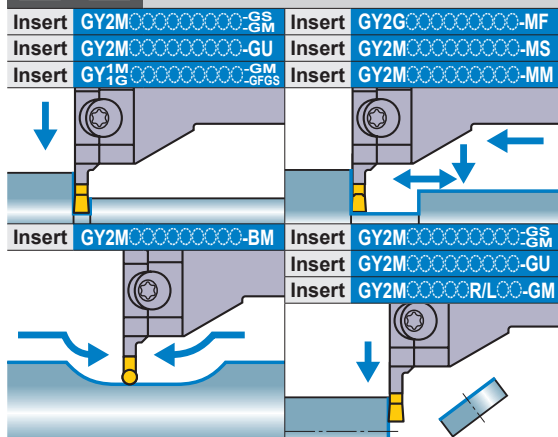
For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
	CW	Ball nose	Ball nose	Ball nose
F	.118", 3.00 mm	●	●	●
	RE 0.2 mm	●	●	●
	RE 0.4 mm	●	●	●
	RE 0.8 mm	●	●	●
	.125", 3.18 mm	●	●	●
	RE 0.2 mm	●	●	●
G	RE 0.4 mm	●	●	●
	RE 0.8 mm	●	●	●
	.128", 3.24 mm	●	●	●
	RE 0.2 mm	●	●	●
	RE 0.4 mm	●	●	●
	RE 0.8 mm	●	●	●

● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

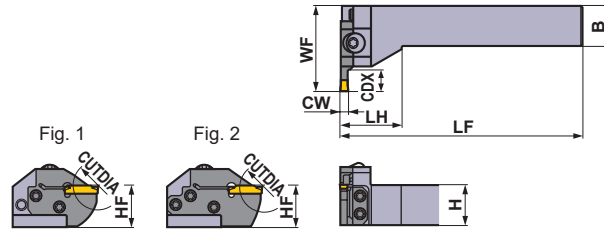
GY SERIES (EXTERNAL)

2-2 90° type holder (Metric)



Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
H	4.75 5.00 5.24	8	16	Modular	R	GYHR2525M90-M25L	●	GYM25LA-H08	●	1	
					L	GYHL2525M90-M25R	●	GYM25RA-H08	●	1	
		12	24	Modular	R	GYHR2020K90-M20L	●	GYM20LA-H12	●	1	
					L	GYHL2020K90-M20R	●	GYM20RA-H12	●	1	
		14	28	Modular	R	GYHR2525M90-M25L	●	GYM25LA-H14	●	1	
					L	GYHL2525M90-M25R	●	GYM25RA-H14	●	1	
J	6.00 6.31 6.35	25 *1	50 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-H25	●	2	
					L	GYHL2525M90-M25R	●	GYM25RA-H25	●	2	
		8	16	Modular	R	GYHR2525M90-M25L	●	GYM25LA-J08	●	1	
					L	GYHL2525M90-M25R	●	GYM25RA-J08	●	1	
		14	28	Modular	R	GYHR2525M90-M25L	●	GYM25LA-J14	●	1	
					L	GYHL2525M90-M25R	●	GYM25RA-J14	●	1	
		25 *1	50 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-J25	●	2	
					L	GYHL2525M90-M25R	●	GYM25RA-J25	●	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 F011 to F015.

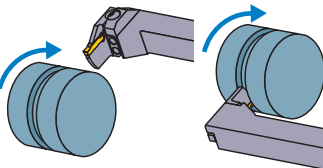
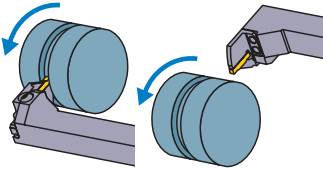
*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHR2020K90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHL2020K90-M20R			
GYHR2525M90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) *3						Cutting Mode
	H	B	LF	LH	HF	WF	
	25	25	150	38	25	47	R 
	25	25	150	38	25	47	
	20	20	125	35	20	45	
	20	20	125	35	20	45	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	47	L 
	25	25	150	38	25	47	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	

Select an Insert

Seat Size	Insert Number
H	GY000475/0500/0524H0000-Breaker
J	GY000600/0631/0635J0000-Breaker

		For Grooving/Cutting off > F011-F013				
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)	05-GM (Cutting off)
		Neutral	Neutral	Neutral	Neutral	Hand
H	.187", 4.75 mm	●	●	●	●	●
	.197", 5.00 mm	●	●	●	●	●
J	.236", 6.00 mm	●	●	●	●	●
	.250", 6.35 mm	●	●	●	●	●

		For Multifunctional Grooving > F013, F014			
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
		Finish	Low	Medium	Ball nose
H	.187", 4.75 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			
	.197", 5.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.206", 5.24 mm	●			
	.236", 6.00 mm				●
J	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.248", 6.31 mm	●			
	.250", 6.35 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			

● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

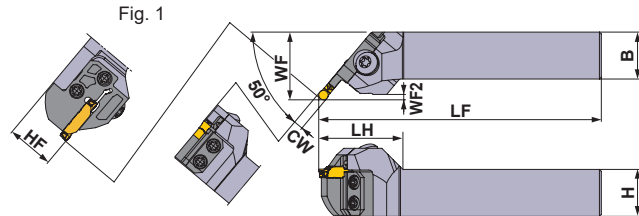
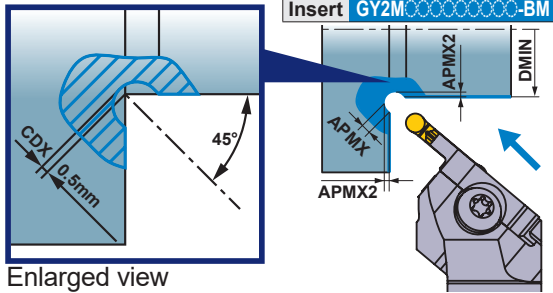
GY SERIES (EXTERNAL RECESSING)

3-2

50° type holder (Metric)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	DMIN (mm)	APMX (mm)	APMX2 (mm)	Type	Hand (R/L)	Order Number				Fig.	
								Holder	Stock	Modular Blade	Stock		
D	2.00	0.5	30	1.5	0.646	Modular	R	GYHR2020K50-M20L	●	GYM20LC-D005	●	1	
							L	GYHL2020K50-M20R	●	GYM20RC-D005	●	1	
				Modular	R	GYHR2525M50-M25L	●	GYM25LC-D005	●	1			
					L	GYHL2525M50-M25R	●	GYM25RC-D005	●	1			
E	2.50			1.75	0.72	Modular	R	GYHR2020K50-M20L	●	GYM20LC-E005	●	1	
							L	GYHL2020K50-M20R	●	GYM20RC-E005	●	1	
				Modular	R	GYHR2525M50-M25L	●	GYM25LC-E005	●	1			
					L	GYHL2525M50-M25R	●	GYM25RC-E005	●	1			
F	3.00 3.18		2	0.793	Modular	R	GYHR2020K50-M20L	●	GYM20LC-F005	●	1		
						L	GYHL2020K50-M20R	●	GYM20RC-F005	●	1		
			Modular	R	GYHR2525M50-M25L	●	GYM25LC-F005	●	1				
				L	GYHL2525M50-M25R	●	GYM25RC-F005	●	1				
G	4.00		2.5	0.939	Modular	R	GYHR2020K50-M20L	●	GYM20LC-G005	●	1		
						L	GYHL2020K50-M20R	●	GYM20RC-G005	●	1		
			Modular	R	GYHR2525M50-M25L	●	GYM25LC-G005	●	1				
				L	GYHL2525M50-M25R	●	GYM25RC-G005	●	1				
H	4.75 5.00		2.88	1.049	Modular	R	GYHR2020K50-M20L	●	GYM20LC-H005	●	1		
						L	GYHL2020K50-M20R	●	GYM20RC-H005	●	1		
			Modular	R	GYHR2525M50-M25L	●	GYM25LC-H005	●	1				
				L	GYHL2525M50-M25R	●	GYM25RC-H005	●	1				
J	6.00 6.35		3.5	1.232	Modular	R	GYHR2525M50-M25L	●	GYM25LC-J005	●	1		
						L	GYHL2525M50-M25R	●	GYM25RC-J005	●	1		

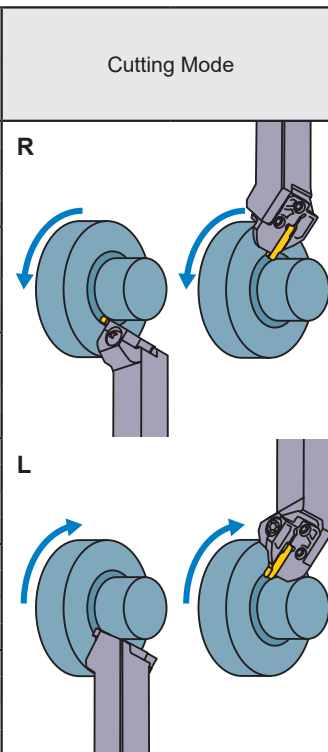
*1 Blades for external and face grooving cannot be used since it interferes with work materials.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, WF and WF2 values may vary.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 4 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K50-M20R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY25D
GYHR/L2525M50-M25R/L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) ★2						
	H	B	LF	LH	HF	WF	WF2
	20	20	125	40	20	32	1.6
	20	20	125	40	20	32	1.6
	25	25	150	45	25	35	1.6
	25	25	150	45	25	35	1.6
	20	20	125	40	20	32	1.8
	20	20	125	40	20	32	1.8
	25	25	150	45	25	35	1.8
	25	25	150	45	25	35	1.8
	20	20	125	40	20	32	2.0
	20	20	125	40	20	32	2.0
	25	25	150	45	25	35	2.0
	25	25	150	45	25	35	2.0
	20	20	125	40	20	32	2.4
	20	20	125	40	20	32	2.4
	25	25	150	45	25	35	2.4
	25	25	150	45	25	35	2.4
	20	20	125	40	20	33	2.8
	20	20	125	40	20	33	2.8
	25	25	150	45	25	36	2.8
	25	25	150	45	25	36	2.8
	25	25	150	44	25	36	3.4
	25	25	150	44	25	36	3.4



Select an Insert

Insert Number		
GY2M○○○○○○○○N-BM		
For Multifunctional Grooving > F014		
Seat Size	Breaker	BM (Copying, Recessing)
	CW	Ball nose
D	.079", 2.00 mm	●
E	.098", 2.50 mm	●
F	.118", 3.00 mm	●
	.125", 3.18 mm	●
G	.157", 4.00 mm	●
H	.187", 4.75 mm	●
	.197", 5.00 mm	●
J	.236", 6.00 mm	●
	.250", 6.35 mm	●

● : Gauge insert shown dimensions

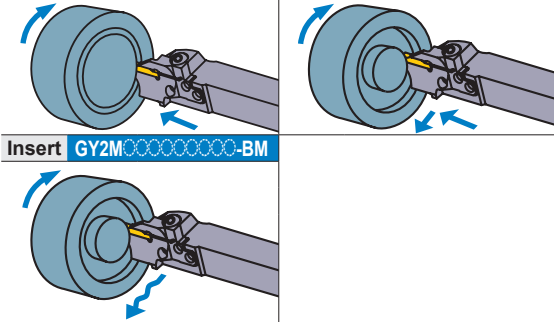
F

GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1M	GM-GFGS	Insert	GY2M	MM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

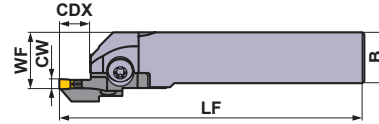


Fig. 1

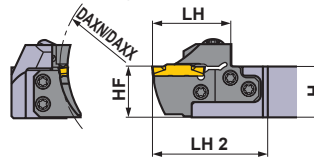
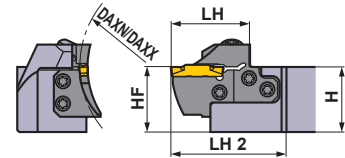


Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	.079 .088	1.575	1.969	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-040	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-040	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-040	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-040	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-040	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-040	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-040	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-040	●	2
		1.969	2.362	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-050	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-050	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-050	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-050	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-050	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-050	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-050	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-050	●	2
		2.362	2.953	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-060	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-060	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-060	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-060	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-060	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-060	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-060	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-060	●	2
		2.953	3.937	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-075	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-075	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-075	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-075	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-075	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-075	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-075	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-075	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

F

GROOVING / CUTTING OFF

● : USA Stock

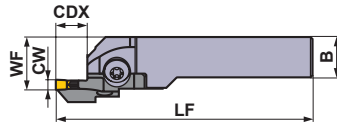
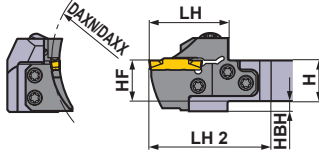


Fig. 3



Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

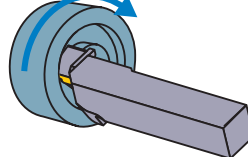
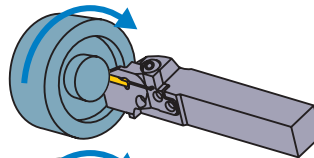
SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

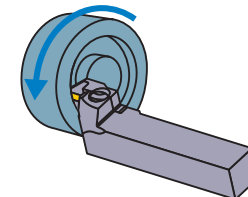
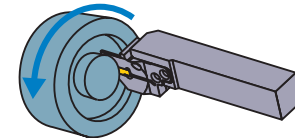
Dimensions (inch) ★1							
H	B	LF	LH	LH 2	HF	WF	HBH
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—

Cutting Mode

R



L



Select an Insert

Seat Size	Insert Number
D	GY0000200/0224D0000000-Breaker

For Grooving/Cutting off > F011, F013				
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)
CW				
D	.079", 2.00 mm	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
CW				
D	.079", 2.00 mm	●	●	●
	.088", 2.24 mm	●	●	●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

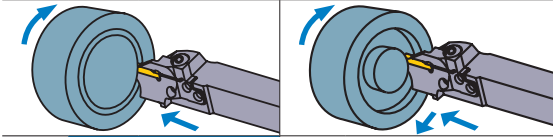
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CUTTING CONDITIONS	> F206
INSTRUCTION MANUAL	> F208

F069

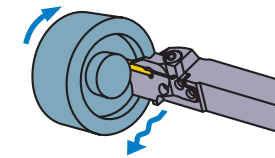
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1M	GM-GFGS	Insert	GY2M	MM



Insert GY2M-BM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

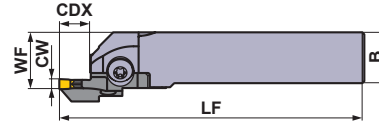


Fig. 1

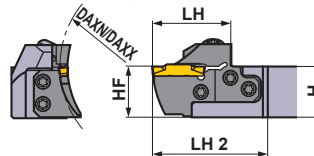
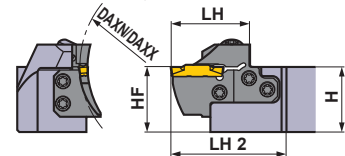


Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	.079 .088	3.937	5.906	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-100	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-100	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-100	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-100	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-100	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-100	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-100	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-100	●	2
		5.315	7.874	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-135	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-135	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-135	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-135	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-135	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-135	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-135	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-135	●	2
		7.087	9.843	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-180	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-180	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-180	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-180	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-180	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-180	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-180	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-180	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

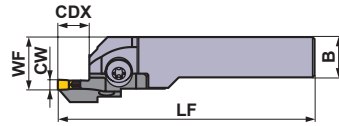
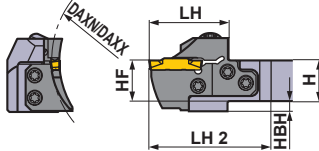


Fig. 3



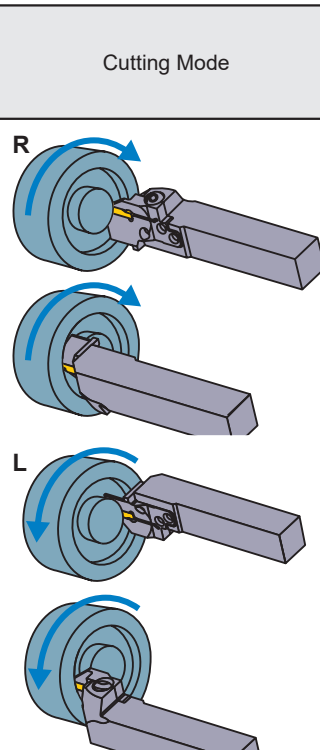
Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	 5 pcs.	 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Dimensions (inch) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	R
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	L
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	L
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	L
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	L
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	



Select an Insert

Seat Size	Insert Number
D	GY0000200/0224D0000000-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW					
D	.079", 2.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

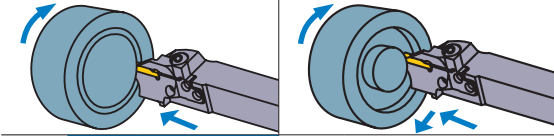
IDENTIFICATION	> F008, F009
CUTTING CONDITIONS	> F206
INSTRUCTION MANUAL	> F208

F071

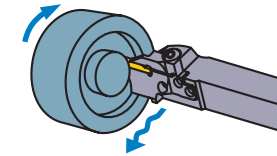
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1M	GM	Insert	GY2M	MM
	1G	GFGS			



Insert GY2M



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

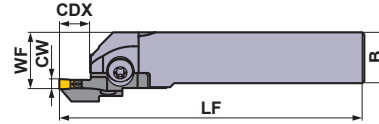


Fig. 1

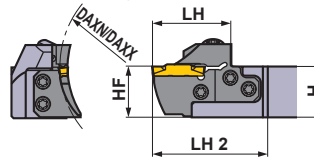
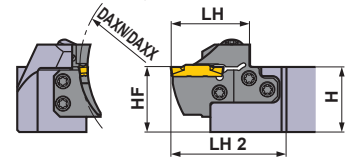


Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
E	.094 .098 .108	1.575	1.969	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-040	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-040	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-040	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-040	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-040	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-040	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-040	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-040	●	2
		1.969	2.362	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-050	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-050	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-050	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-050	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-050	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-050	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-050	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-050	●	2
		2.362	2.953	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-060	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-060	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-060	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-060	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-060	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-060	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-060	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-060	●	2
		2.953	3.937	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-075	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-075	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-075	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-075	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-075	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-075	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-075	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-075	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

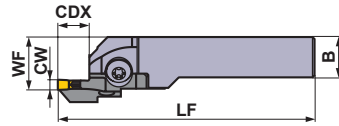
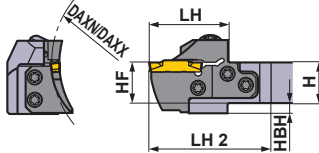


Fig. 3



Right hand tool holder shown.

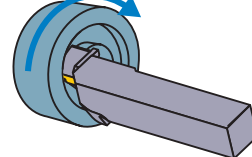
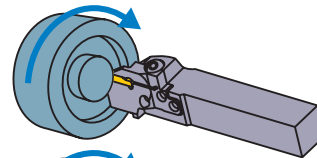
SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

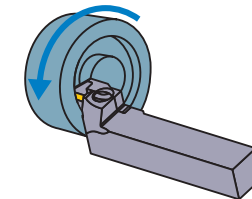
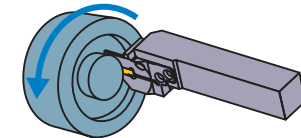
Dimensions (inch) ★1							
H	B	LF	LH	LH 2	HF	WF	HBH
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—

Cutting Mode

R



L



Select an Insert

Seat Size	Insert Number
E	GY000239/0250/0274E00000-Breaker

For Grooving/Cutting off > F011, F013				
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)
CW				GFGS (Hardened steel)
E	.094", 2.39 mm	●	●	●
	.098", 2.50 mm	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
CW				BM (Copying, Recessing)
E	.094", 2.39 mm	●		●
	.098", 2.50 mm	●	●	●
	.108", 2.74 mm	●		●

● : Gauge insert shown dimensions

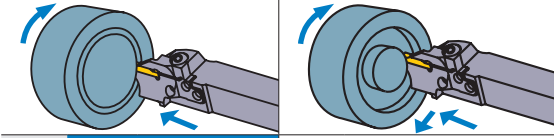
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GROOVING / CUTTING OFF

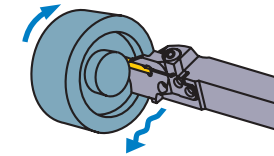
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GM-GFS	Insert	GY2M	MM



Insert GY2M-BM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

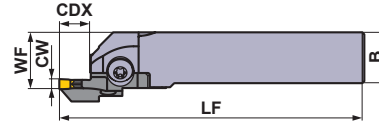


Fig. 1

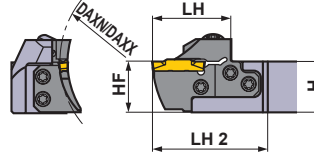
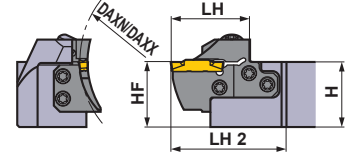


Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
E	.094 .098 .108	3.937	5.906	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-100	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-100	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-100	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-100	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-100	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-100	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-100	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-100	●	2
		5.315	7.874	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-135	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-135	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-135	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-135	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-135	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-135	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-135	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-135	●	2
		7.087	9.843	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-180	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-180	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-180	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-180	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-180	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-180	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-180	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-180	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

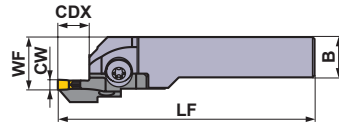
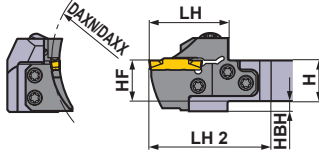


Fig. 3



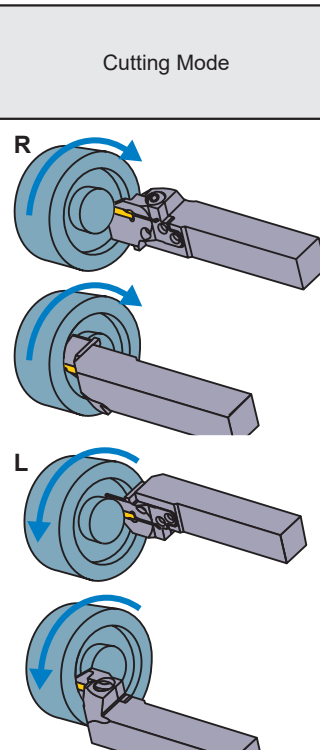
Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Dimensions (inch) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	R
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	L
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	L
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	L
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	



Select an Insert

Seat Size	Insert Number
E	GY000239/0250/0274E00000-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
E	CW				
	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
E	CW				Ball nose
	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

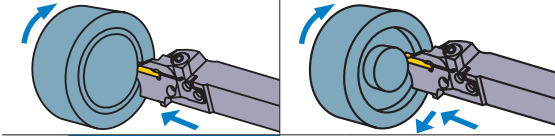
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GROOVING / CUTTING OFF

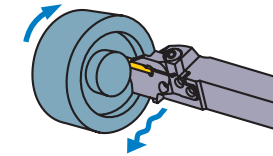
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1M	GM-GFGS	Insert	GY2M	MM



Insert GY2M



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

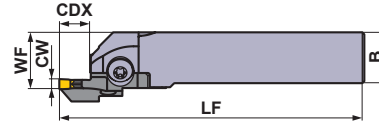


Fig. 1

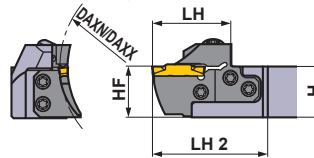
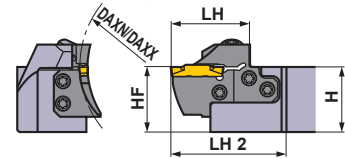


Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	1.378	1.575	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-035	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-035	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-035	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-035	●	1
		1.575	1.969	.472	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-035	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-035	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-035	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-035	●	2
					Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-040	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-040	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-040	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-040	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-040	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-040	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-040	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-040	●	2
		1.969	2.362	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-050	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-050	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-050	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-050	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-050	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-050	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-050	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-050	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

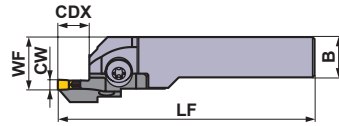
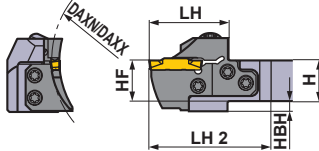


Fig. 3

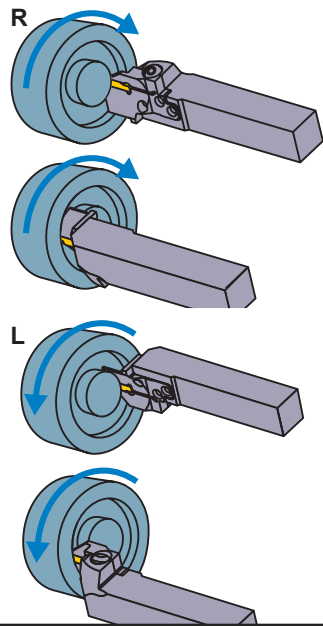
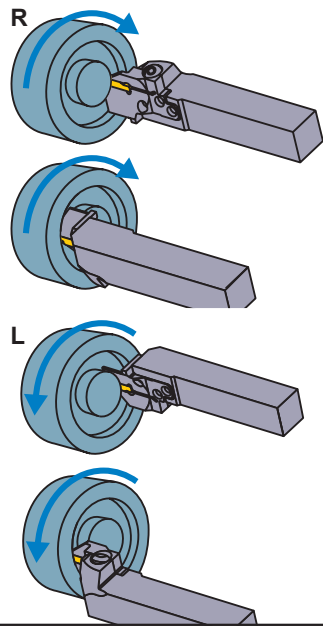
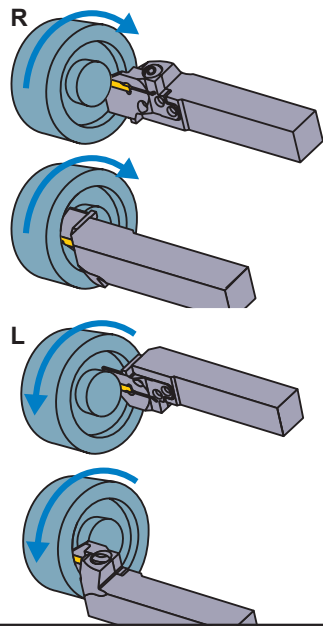
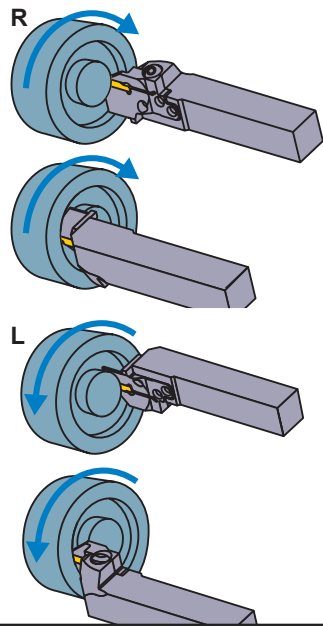


Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Dimensions (inch) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	

Cutting Mode

Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	CW				
	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
F	CW				Ball nose
	.118", 3.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	.128", 3.24 mm	●	●	●	●

● : Gauge insert shown dimensions

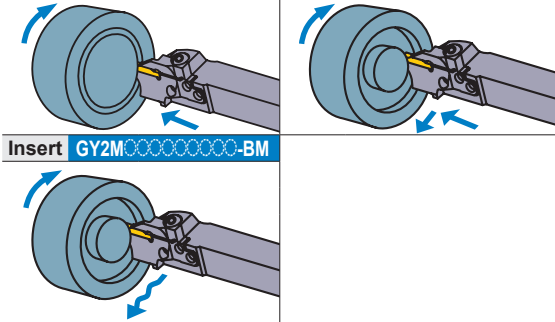
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GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

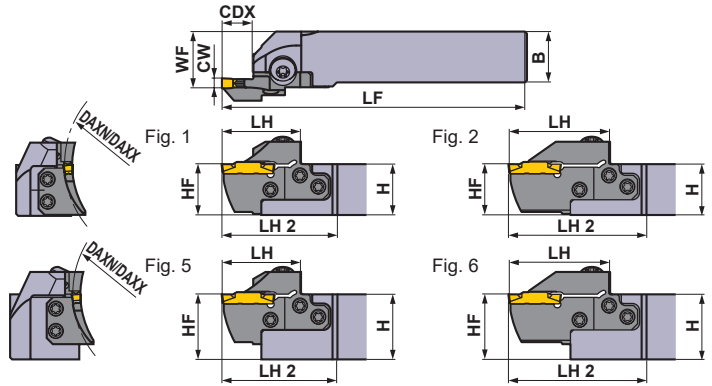
4-1 00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GM-GFGS	Insert	GY2M	MM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

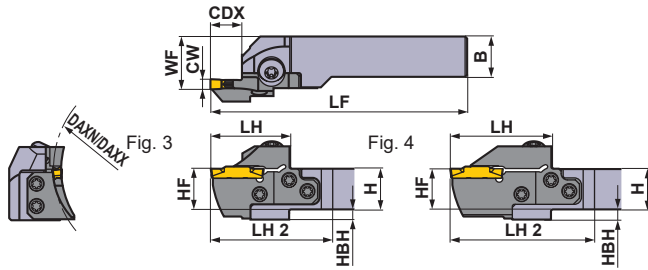
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	2.362	2.953	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-060	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-060	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-060	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-060	●	1
				.787*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-060	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-060	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-060	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-060	●	5
				.787*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-060	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-060	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-060	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-060	●	2
				.472	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-060	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-060	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-060	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-060	●	6
		2.953	3.937	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-075	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-075	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-075	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-075	●	1
				.787*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-075	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-075	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-075	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-075	●	5
				.787*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-075	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-075	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-075	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-075	●	2
				.787*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-075	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-075	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-075	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-075	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock



★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1								
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	

Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	CW				
	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
F	CW				Ball nose
	.118", 3.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	.128", 3.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

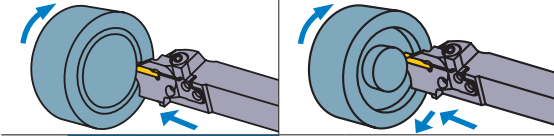
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GY SERIES (FACE GROOVING)

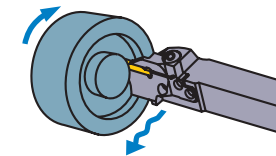
4-1

00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GM-GFGS	Insert	GY2M	MM

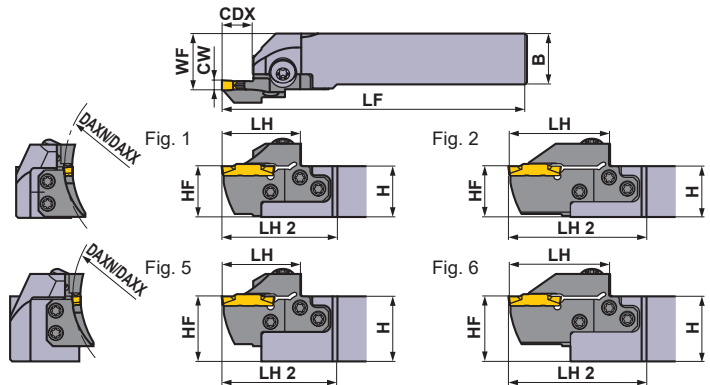


Insert GY2M



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

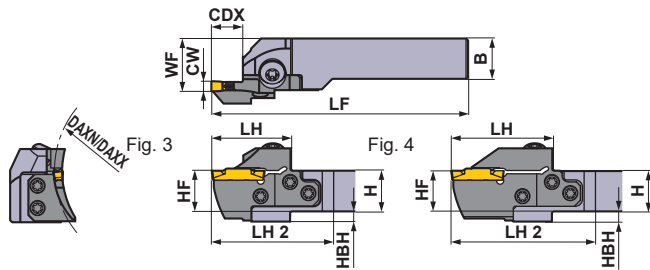
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	3.937	5.906	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-100	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-100	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-100	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-100	●	1
				.787*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-100	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-100	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-100	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-100	●	5
				.787*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-100	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-100	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-100	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-100	●	2
				.472	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-100	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-100	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-100	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-100	●	6
		5.315	7.874	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-135	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-135	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-135	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-135	●	1
				.787*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-135	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-135	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-135	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-135	●	5
				.787*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-135	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-135	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-135	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-135	●	2
				.787*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-135	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-135	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-135	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-135	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock



★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench ★
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	

Cutting Mode

Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing) Ball nose
F	.118", 3.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	.128", 3.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

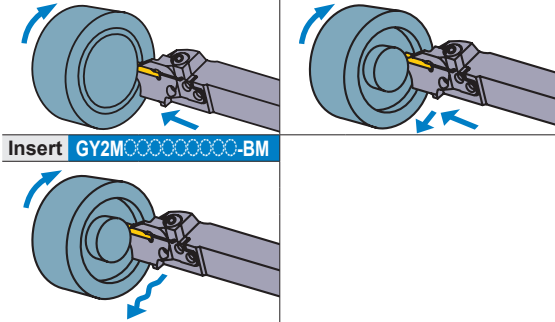
F081

GY SERIES (FACE GROOVING)

4-1

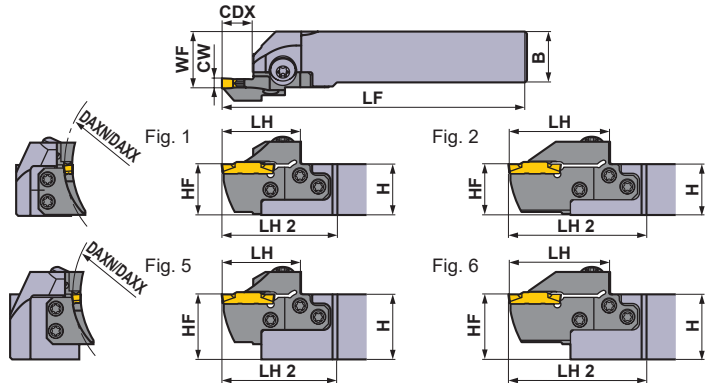
00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GM-GFGS	Insert	GY2M	MM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

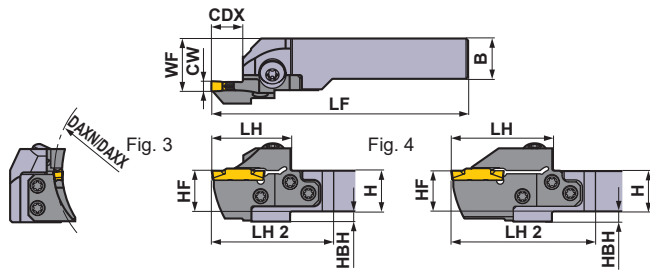
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	7.087	9.843	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-180	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-180	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-180	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-180	●	1
				.472	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-180	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-180	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-180	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-180	●	5
				.787*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-180	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-180	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-180	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-180	●	2
				.472	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-180	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-180	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-180	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-180	●	6
		8.858	39.331	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-225	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-225	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-225	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-225	●	1
				.787*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-225	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-225	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-225	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-225	●	5
				.787*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-225	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-225	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-225	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-225	●	2
				.787*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-225	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-225	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-225	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-225	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock



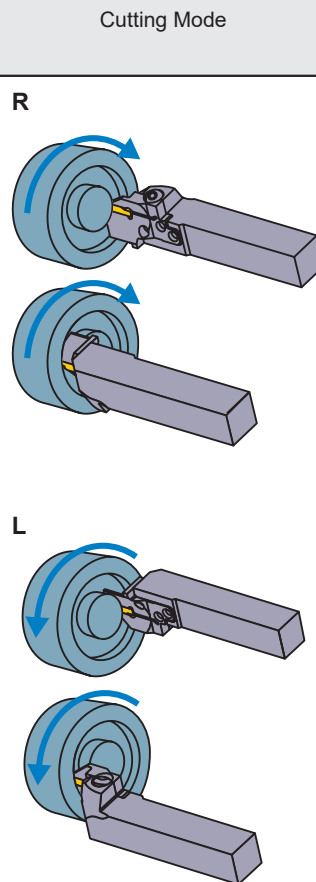
★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	R
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	L
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	L
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	L
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.236	1.772	.477	.750	1.000	.250	L
.750	.750	5.236	1.772	.477	.750	1.000	.250	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	L
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	



Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	CW				
	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
F	CW				Ball nose
	.118", 3.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	.128", 3.24 mm	●	●	●	●

● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

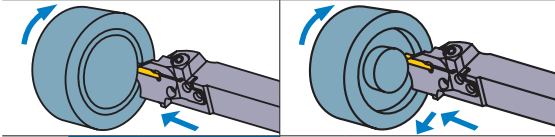
GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

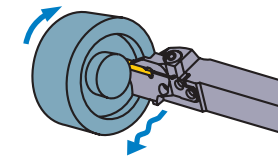
4-1

00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GM-GFGS	Insert	GY2M	MM

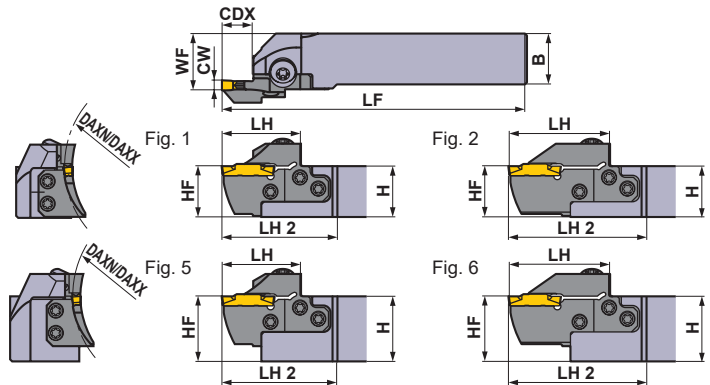


Insert GY2M-BM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

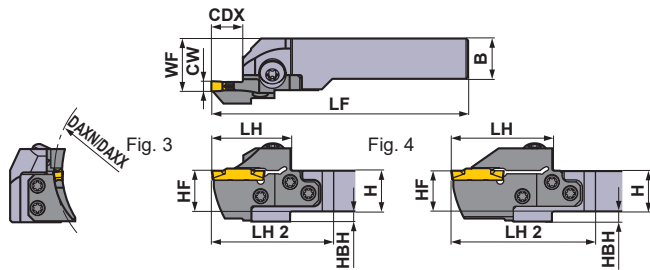
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	.157 .167	1.575	1.969	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-040	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-040	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-040	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-040	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-040	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-040	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-040	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-040	●	5
		1.969	2.362	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-050	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-050	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-050	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-050	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-050	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-050	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-050	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-050	●	5
		2.362	3.346	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-060	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-060	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-060	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-060	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-060	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-060	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-060	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-060	●	5
		2.362	3.346	.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G25-060	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G25-060	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G25-060	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G25-060	●	2
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G25-060	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G25-060	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G25-060	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G25-060	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock



★ Wrench : ① : Clamp Screw, ② : Blade Screw

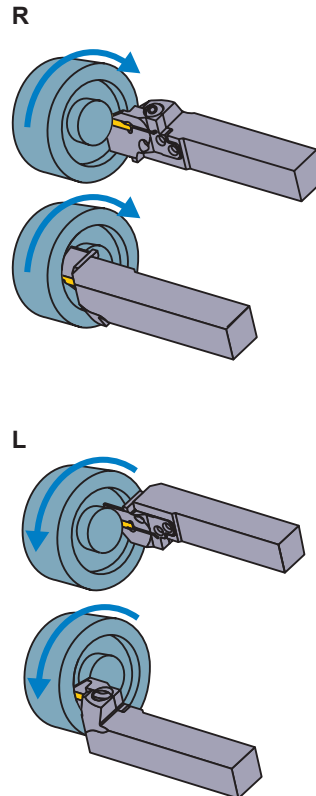
SPARE PARTS

Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench ★
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) ★1							
H	B	LF	LH	LH 2	HF	WF	HBH
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—

Cutting Mode



Select an Insert

Seat Size	Insert Number
G	GY○○○0400/0424G○○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW					
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					Ball nose
G	.157", 4.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.167", 4.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

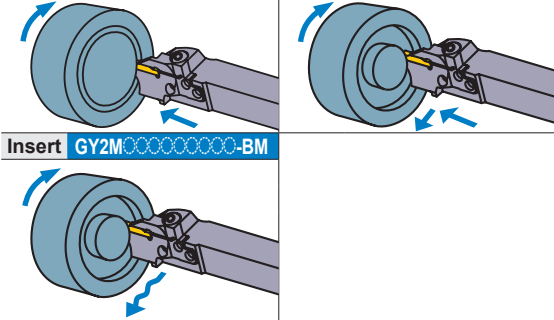
IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

F085

GY SERIES (FACE GROOVING)

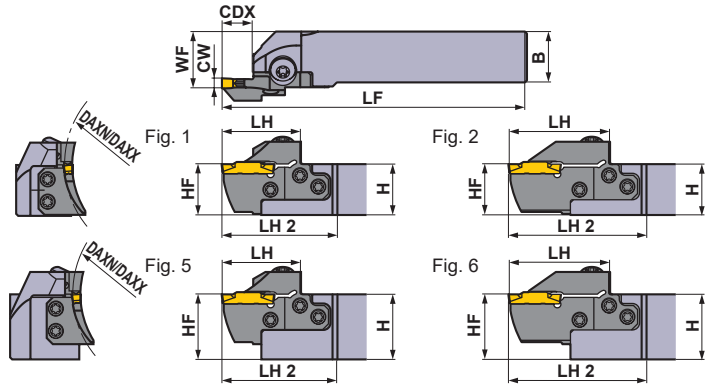
4-1 00° type holder (Inch)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



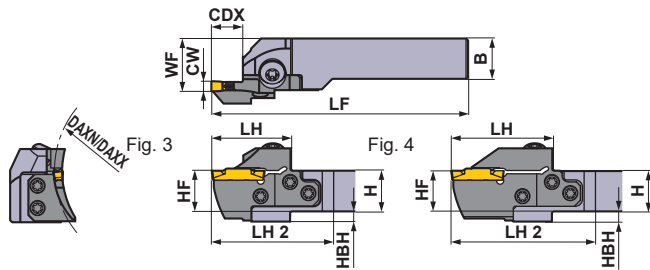
Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	.157 .167	3.346	4.921	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-085	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-085	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-085	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-085	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-085	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-085	●	5
				.984*2	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-085	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-085	●	5
					Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G25-085	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G25-085	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G25-085	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G25-085	●	2
				.551	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G25-085	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G25-085	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G25-085	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G25-085	●	6
				4.921	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-125	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-125	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-125	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-125	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-125	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-125	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-125	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-125	●	5
				.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G25-125	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G25-125	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G25-125	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G25-125	●	2
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G25-125	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G25-125	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G25-125	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G25-125	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.



★ Wrench : ① : Clamp Screw, ② : Blade Screw

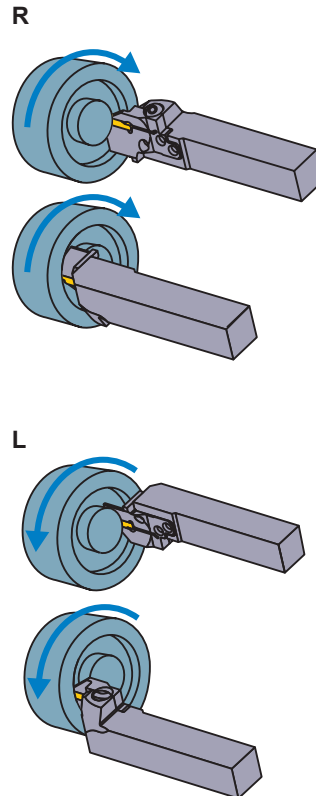
SPARE PARTS

Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench ★
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) ★1							
H	B	LF	LH	LH 2	HF	WF	HBH
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—

Cutting Mode



Select an Insert

Seat Size	Insert Number
G	GY○○○0400/0424G○○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW					
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					Ball nose
G	.157", 4.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.167", 4.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

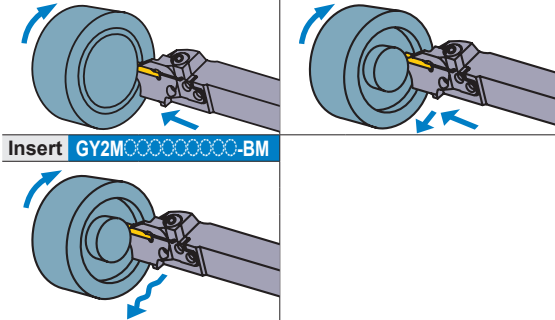
F087

GY SERIES (FACE GROOVING)

4-1

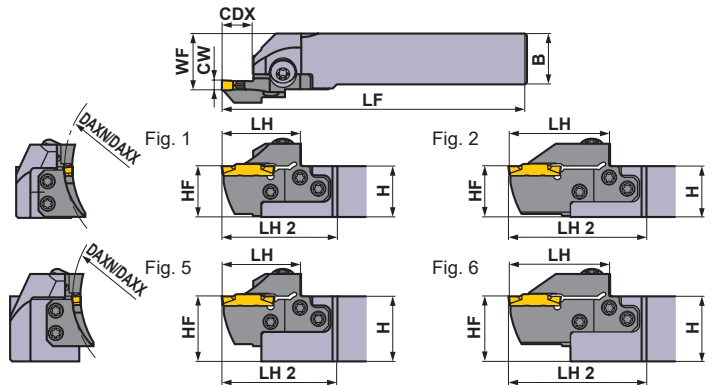
00° type holder (Inch)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

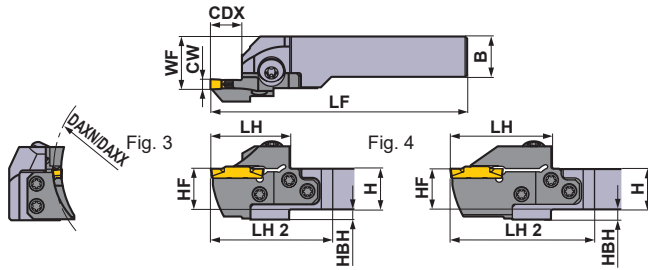
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	.157 .167	7.087	11.024	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-180	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-180	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-180	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-180	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-180	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-180	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-180	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-180	●	5
				.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G25-180	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G25-180	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G25-180	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G25-180	●	2
				.551	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G25-180	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G25-180	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G25-180	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G25-180	●	6
					Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-250	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-250	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-250	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-250	●	1
				.984*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G25-250	●	4
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G25-250	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G25-250	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G25-250	●	2
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G25-250	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G25-250	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G25-250	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G25-250	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock



★ Wrench : ① : Clamp Screw, ② : Blade Screw

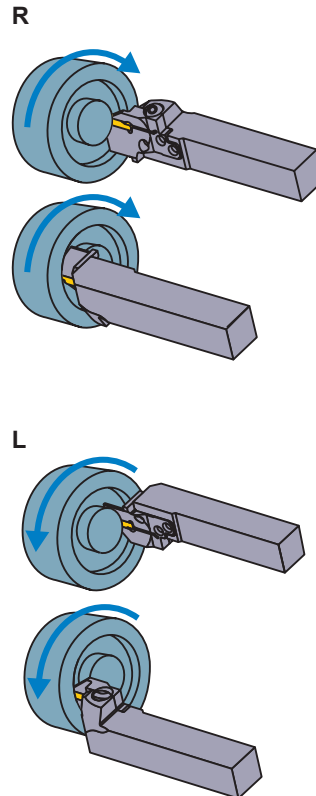
SPARE PARTS

Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench ★
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) ★1							
H	B	LF	LH	LH 2	HF	WF	HBH
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—

Cutting Mode



Select an Insert

Seat Size	Insert Number
G	GY○○0400/0424G○○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
G	CW .157", 4.00 mm	●	●	●	●

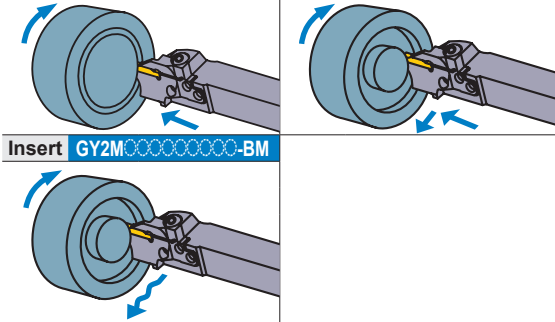
For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
G	CW .157", 4.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.167", 4.24 mm	●	●	●	●

● : Gauge insert shown dimensions

GY SERIES (FACE GROOVING)

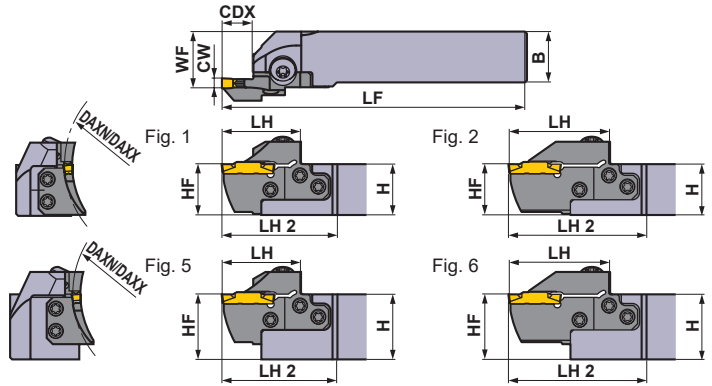
4-1 00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GM-GFGS	Insert	GY2M	MM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



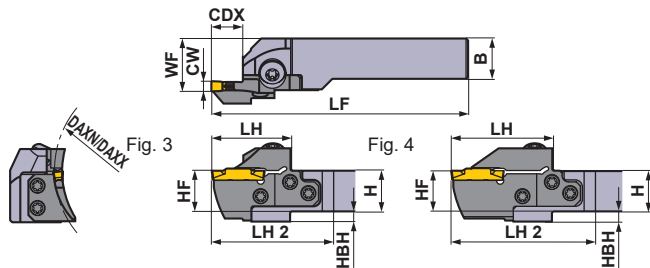
Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	1.969	2.362	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-050	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H14-050	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-050	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H14-050	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-050	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H14-050	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-050	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H14-050	●	5
		2.362	3.346	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-060	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H14-060	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-060	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H14-060	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-060	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H14-060	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-060	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H14-060	●	5
		.984*2			Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-060	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H25-060	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H25-060	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H25-060	●	2
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H25-060	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H25-060	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H25-060	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H25-060	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.



★ Wrench : ① : Clamp Screw, ② : Blade Screw

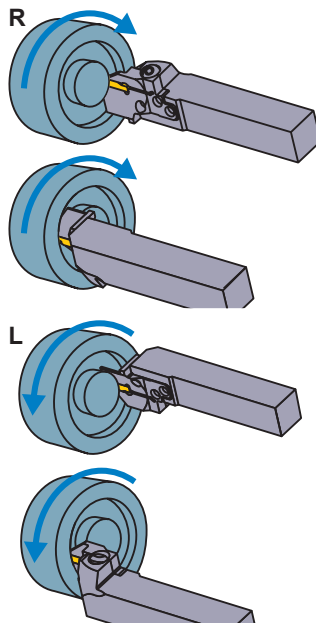
SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

	Dimensions (inch) ★1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	.750	.750	5.433	1.969	.674	.750	1.000	.250
	.750	.750	5.433	1.969	.674	.750	1.000	.250
	1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
	1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
	1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
	1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
	1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
	1.500	1.500	7.433	1.969	2.674	1.500	1.625	—

Cutting Mode



Select an Insert

Seat Size	Insert Number
H	GY○○0475/0500/0524H○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
H	.187", 4.75 mm	●			●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00 mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

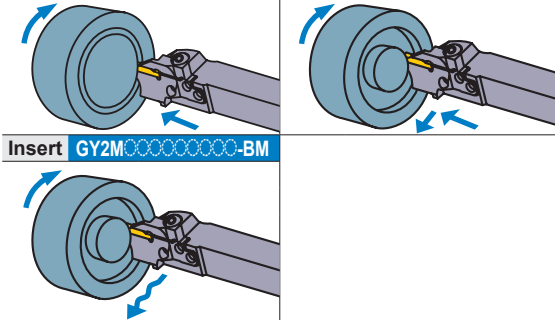
F091

GY SERIES (FACE GROOVING)

4-1

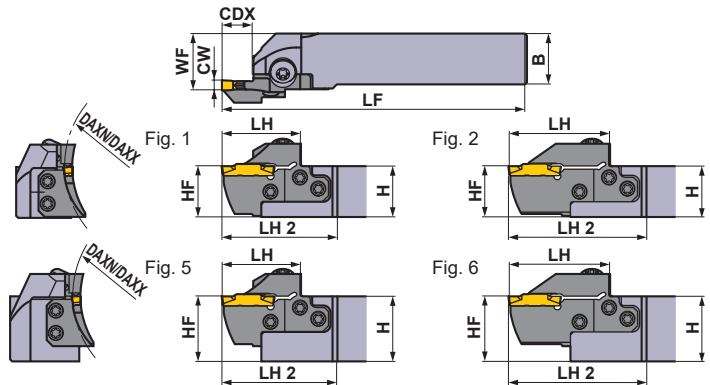
00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GM-GFS	Insert	GY2M	MM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

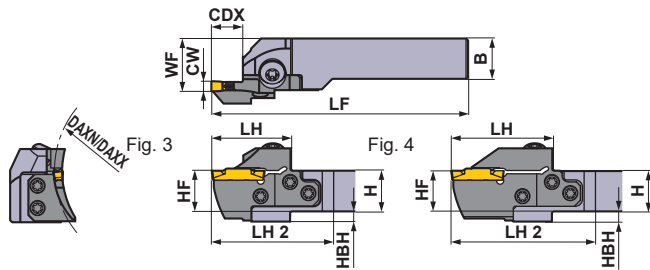
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	3.346	4.921	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-085	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H14-085	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-085	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H14-085	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-085	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H14-085	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-085	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H14-085	●	5
				.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-085	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H25-085	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H25-085	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H25-085	●	2
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H25-085	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H25-085	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H25-085	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H25-085	●	6
		4.921	7.874	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-125	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H14-125	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-125	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H14-125	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-125	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H14-125	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-125	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H14-125	●	5
				.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-125	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H25-125	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H25-125	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H25-125	●	2
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H25-125	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H25-125	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H25-125	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H25-125	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock



★ Wrench : ① : Clamp Screw, ② : Blade Screw

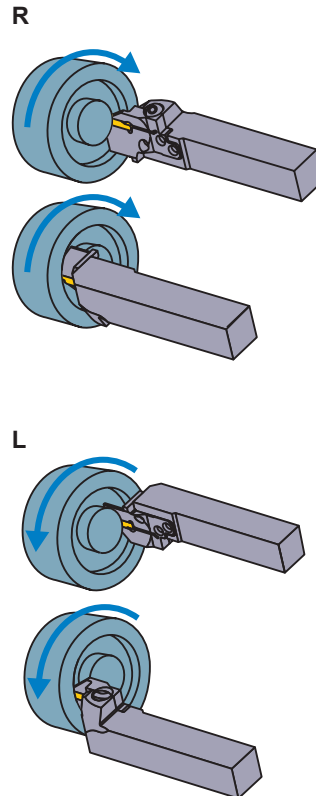
SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

	Dimensions (inch) ★1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	.750	.750	5.433	1.969	.674	.750	1.000	.250
	.750	.750	5.433	1.969	.674	.750	1.000	.250
	1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
	1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
	1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
	1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
	1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
	1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	.750	.750	5.433	1.969	.674	.750	1.000	.250
	.750	.750	5.433	1.969	.674	.750	1.000	.250
	1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
	1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
	1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
	1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
	1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
	1.500	1.500	7.433	1.969	2.674	1.500	1.625	—

Cutting Mode



Select an Insert

Seat Size	Insert Number
H	GY○○○0475/0500/0524H○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	CW				
	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
H	CW				Ball nose
	.187", 4.75 mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00 mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

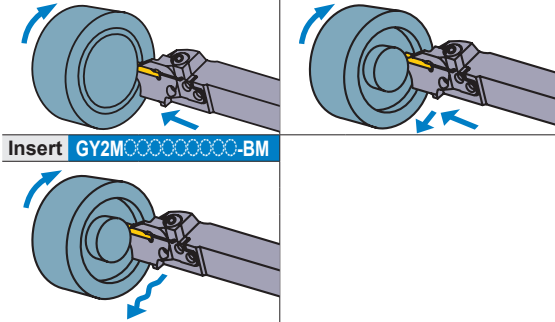
F093

GY SERIES (FACE GROOVING)

4-1

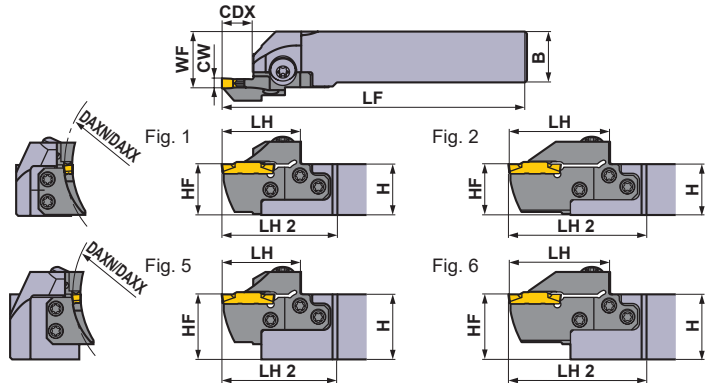
00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GM} _{GFGS}	Insert	GY2M ^{MM}



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

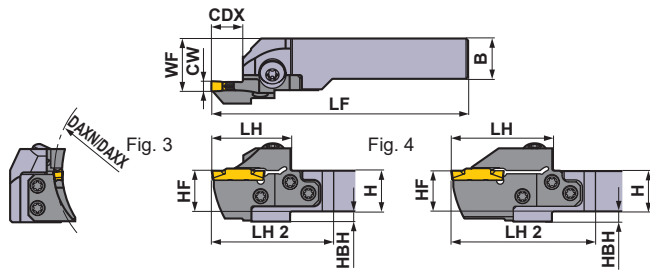
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	7.087	11.024	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-180	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H14-180	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-180	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H14-180	●	1
				.984*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-180	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H14-180	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-180	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H14-180	●	5
				.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-180	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H25-180	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H25-180	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H25-180	●	2
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H25-180	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H25-180	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H25-180	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H25-180	●	6
		9.843	39.331	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-250	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H14-250	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-250	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H14-250	●	1
				.984*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H25-250	●	4
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H25-250	●	4
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H25-250	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H25-250	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock



★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	

Cutting Mode

Select an Insert

Seat Size	Insert Number
H	GY○○○0475/0500/0524H○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	CW				
	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
H	CW				Ball nose
	.187", 4.75 mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00 mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

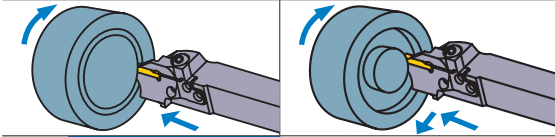
F095

GY SERIES (FACE GROOVING)

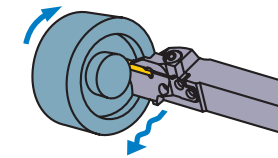
4-1

00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GFGS	Insert	GY2M	MM

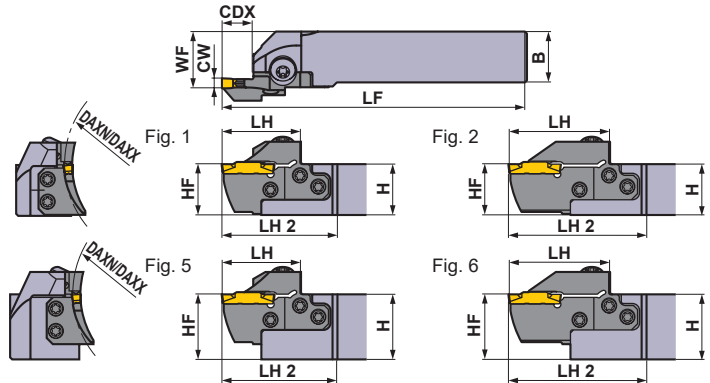


Insert GY2M



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

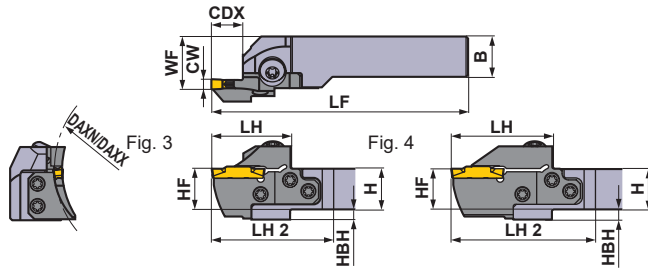
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	.236 .248 .250	1.969	2.756	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-050	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J14-050	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J14-050	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J14-050	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J14-050	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J14-050	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J14-050	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J14-050	●	5
		2.756	4.331	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-070	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J14-070	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J14-070	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J14-070	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J14-070	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J14-070	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J14-070	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J14-070	●	5
		4.331	7.874	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J25-070	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J25-070	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J25-070	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J25-070	●	2
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J25-070	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J25-070	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J25-070	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J25-070	●	6
		4.331	7.874	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-110	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J14-110	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J14-110	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J14-110	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J14-110	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J14-110	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J14-110	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J14-110	●	5
		4.331	7.874	.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J25-110	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J25-110	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J25-110	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J25-110	●	2
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J25-110	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J25-110	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J25-110	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J25-110	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock



★ Wrench : ① : Clamp Screw, ② : Blade Screw

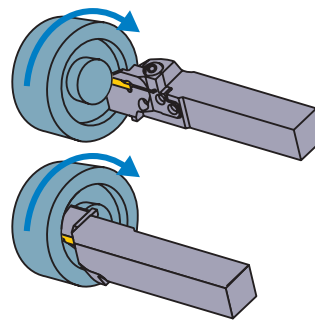
SPARE PARTS

Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench ★
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

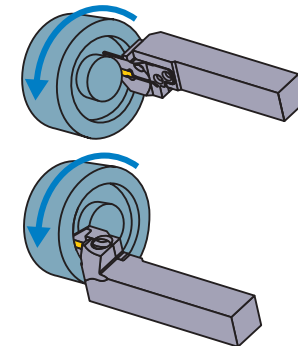
Right hand tool holder shown.

Dimensions (inch) ★1							
H	B	LF	LH	LH 2	HF	WF	HBH
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—

R



L



Select an Insert

Seat Size	Insert Number
J	GY○○0600/0631/0635J○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
J	.236", 6.00 mm	●	●	●	●
	.250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing) Ball nose
J	.236", 6.00 mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.248", 6.31 mm	●			
	.250", 6.35 mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

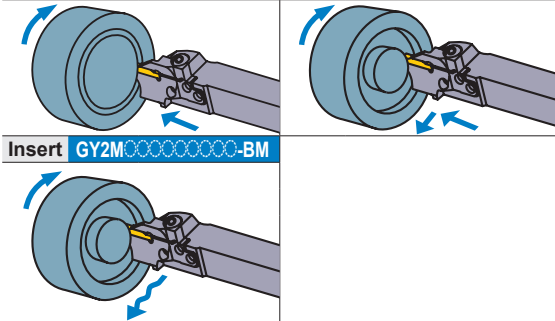
F097

GY SERIES (FACE GROOVING)

4-1

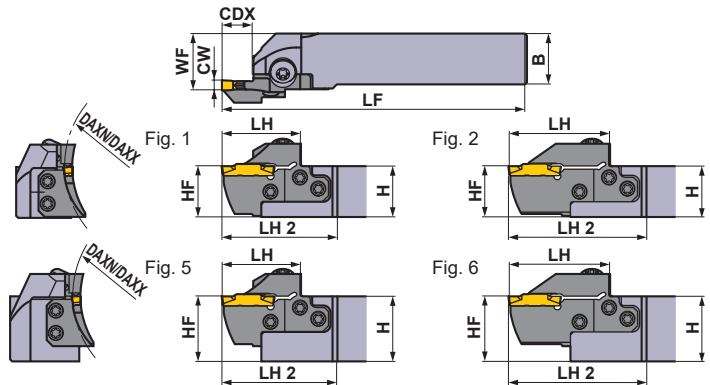
00° type holder (Inch)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GFGS	Insert	GY2M	MM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

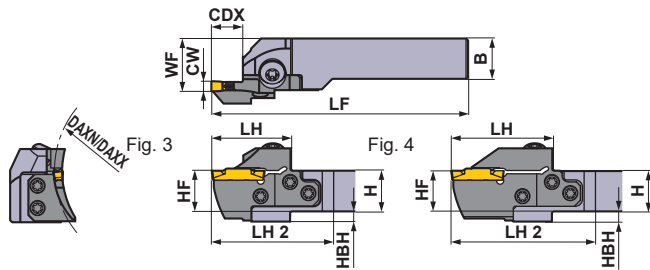
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	.236 .248 .250	6.693	11.024	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-170	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J14-170	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J14-170	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J14-170	●	1
				.984*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J14-170	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J14-170	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J14-170	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J14-170	●	5
		9.843	39.331	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J25-170	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J25-170	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J25-170	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J25-170	●	2
				.984*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J25-170	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J25-170	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J25-170	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J25-170	●	6
				.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-250	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J14-250	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J14-250	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J14-250	●	1
				.984*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J14-250	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J14-250	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J14-250	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J14-250	●	5
				.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J25-250	●	4
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J25-250	●	4
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J25-250	●	2
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J25-250	●	2
				.984*2	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J25-250	●	6
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J25-250	●	6
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J25-250	●	6
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J25-250	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock



Right hand tool holder shown.

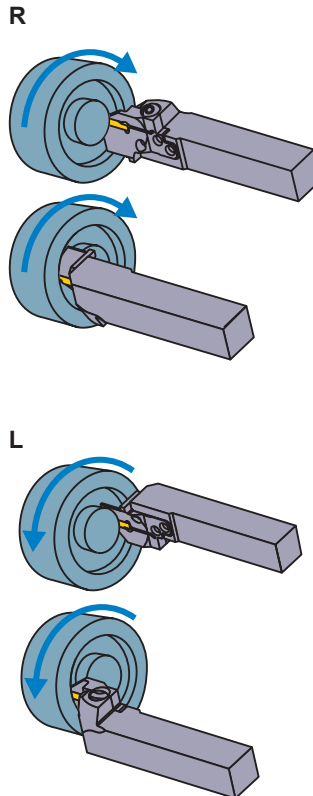
★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Dimensions (inch) ★1							
H	B	LF	LH	LH 2	HF	WF	HBH
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—

Cutting Mode



Select an Insert

Seat Size	Insert Number
J	GY○○0600/0631/0635J○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
J	.236", 6.00 mm	●	●	●	●
	.250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
J	.236", 6.00 mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.248", 6.31 mm	●			
	.250", 6.35 mm	●			●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

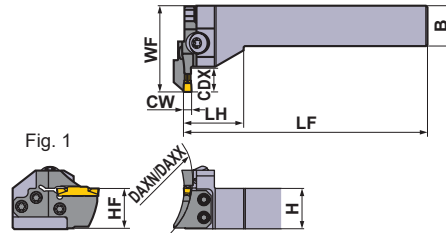
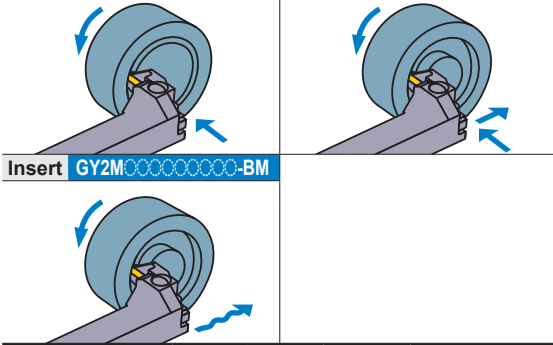
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

Insert	GY2M	GS _{GM}	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GFS	Insert	GY2M	MM

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	.079 .088	1.575	1.969	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-040	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-040	●	1
		1.969	2.362	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-050	●	1
		2.362	2.953	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-060	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-060	●	1
		2.953	3.937	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-075	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-075	●	1
E	.094 .098 .108	3.937	5.906	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-100	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-100	●	1
		5.315	7.874	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-135	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-135	●	1
		7.087	9.843	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-180	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-180	●	1
		1.575	1.969	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-040	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-040	●	1
		1.969	2.362	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-050	●	1
		2.362	2.953	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-060	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-060	●	1
		2.953	3.937	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-075	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-075	●	1
		3.937	5.906	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-100	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-100	●	1
		5.315	7.874	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-135	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-135	●	1
		7.087	9.843	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-180	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-180	●	1

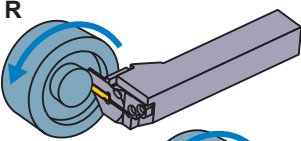
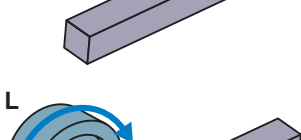
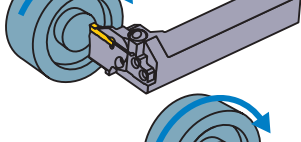
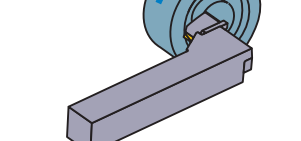
CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHRUS16D90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) ★1						Cutting Mode
	H	B	LF	LH	HF	WF	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	

Select an Insert

Seat Size	Insert Number
D	GY0000200/0224D00000-Breaker
E	GY0000239/0250/0274E00000-Breaker

		> F011, F013			
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
	CW				
D	.079", 2.00 mm	●	●	●	●
E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●

		> F013, F014			
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
	CW				Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●
E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●	●	●	●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

F101

GY SERIES (FACE GROOVING)

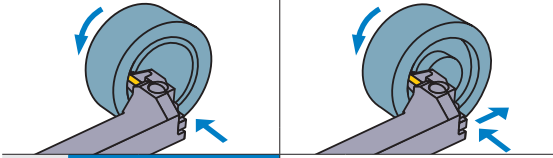
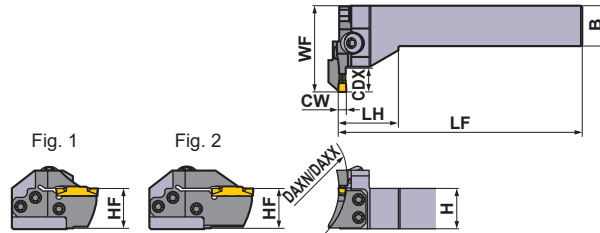
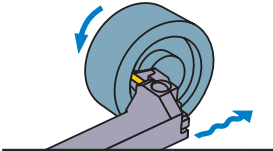
5-1

90° type holder (inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1M ^{GM} _{GFS}	Insert	GY2M ^{MM}

Insert GY2M^{BM}

Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	1.378	1.575	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-035	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-035	●	1
		1.575	1.969	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-040	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-040	●	1
		1.969	2.362	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-050	●	1
		2.362	2.953	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-060	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-060	●	1
				.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-060	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-F20-060	●	2
		2.953	3.937	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-075	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-075	●	1
				.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-075	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-F20-075	●	2
		3.937	5.906	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-100	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-100	●	1
				.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-100	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-F20-100	●	2
		5.315	7.874	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-135	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-135	●	1
				.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-135	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-F20-135	●	2
		7.087	9.843	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-180	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-180	●	1
				.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-180	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-F20-180	●	2
		8.858	39.331	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-225	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-225	●	1
				.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-225	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-F20-225	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

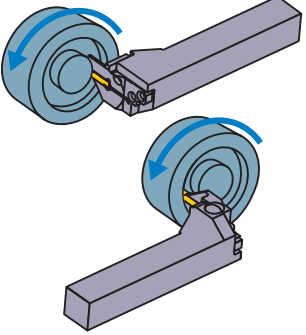
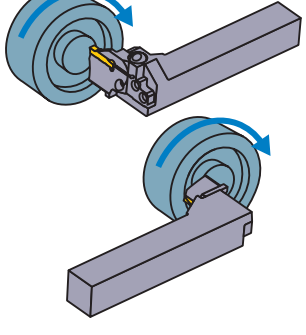
*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHRUS16D90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) ★1						Cutting Mode
	H	B	LF	LH	HF	WF	
	1.000	1.000	6.000	1.500	1.000	2.094	R 
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.330	L 
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.330	

Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	CW				
	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
F	CW				Ball nose
	.118", 3.00 mm	●	●	●	●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"		●	●	
	.125", 3.18 mm	●			●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

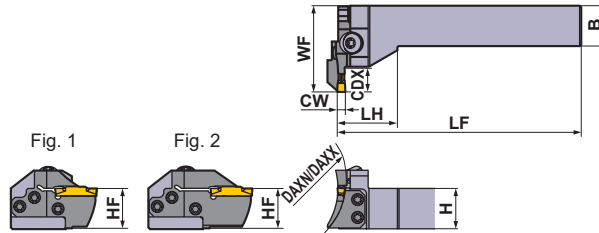
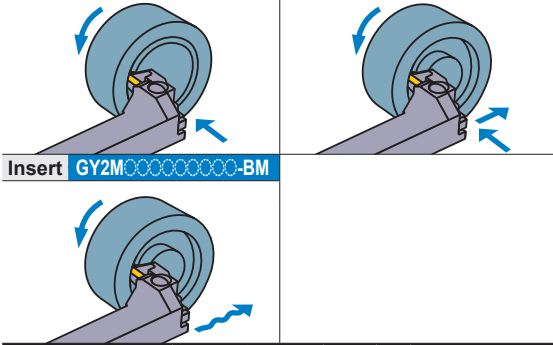
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GM	Insert	GY2M	MM
		GFGS			

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	.157 .167	1.575	1.969	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-040	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-040	●	1
		1.969	2.362	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-050	●	1
		2.362	3.346	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-060	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-060	●	1
				.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G25-060	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-G25-060	●	2
		3.346	4.921	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-085	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-085	●	1
				.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G25-085	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-G25-085	●	2
		4.921	7.874	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-125	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-125	●	1
				.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G25-125	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-G25-125	●	2
		7.087	11.024	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-180	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-180	●	1
				.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G25-180	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-G25-180	●	2
		9.843	39.331	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-250	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-250	●	1
				.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G25-250	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-G25-250	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

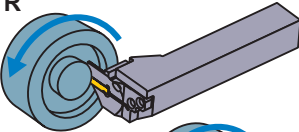
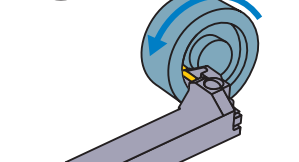
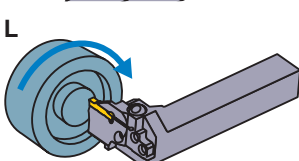
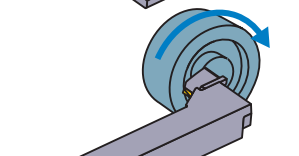
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHRUS16D90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) ★1						Cutting Mode
	H	B	LF	LH	HF	WF	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	

Select an Insert

Seat Size	Insert Number
G	GY○○○0400/0424G○○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW					
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					Ball nose
G	.157", 4.00 mm	●	●	●	●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.167", 4.24 mm	●	●	●	

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

GY SERIES (FACE GROOVING)

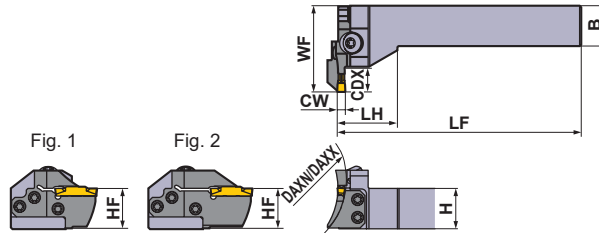
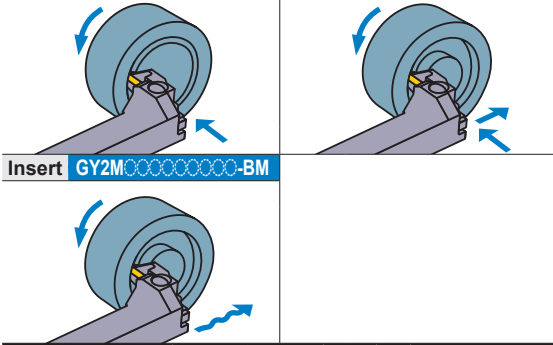
5-1

90° type holder (inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GM	Insert	GY2M	MM



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	1.969	2.362	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-050	●	1
		2.362	3.346	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-060	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-060	●	1
		3.346	4.921	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H25-060	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-H25-060	●	2
				.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-085	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-085	●	1
		4.921	7.874	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H25-085	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-H25-085	●	2
				.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-125	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-125	●	1
		7.087	11.024	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H25-125	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-H25-125	●	2
				.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-180	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-180	●	1
		9.843	39.331	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H25-180	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-H25-180	●	2
				.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-250	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-250	●	1
				.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H25-250	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-H25-250	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

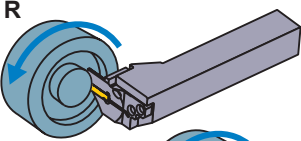
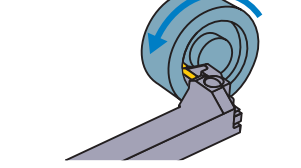
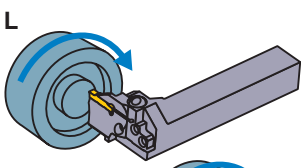
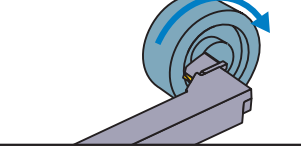
*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHRUS16D90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) ★1						Cutting Mode
	H	B	LF	LH	HF	WF	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	

Select an Insert

Seat Size	Insert Number
H	GY○○○0475/0500/0524H○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	CW				
	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Reversing)
H	CW				Ball nose
	.187", 4.75 mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00 mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

GY SERIES (FACE GROOVING)

5-1

90° type holder (inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

Insert GY2M-SS-GM

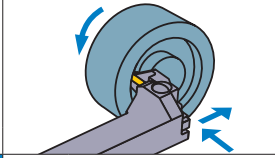
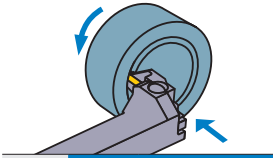
Insert GY2G-MF

Insert GY2M-GU

Insert GY2M-MS

Insert GY1G-GFGS

Insert GY2M-MM



Insert GY2M-BM

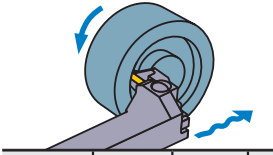


Fig. 1

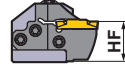
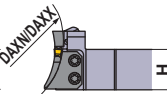
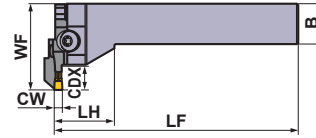
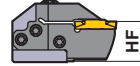


Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	.236 .248 .250	1.969	2.756	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-J14-050	●	1
		2.756	4.331	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-070	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-J14-070	●	1
				.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J25-070	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-J25-070	●	2
		4.331	7.874	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-110	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-J14-110	●	1
				.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J25-110	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-J25-110	●	2
		6.693	11.024	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-170	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-J14-170	●	1
				.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J25-170	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-J25-170	●	2
		9.843	39.331	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-250	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-J14-250	●	1
				.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J25-250	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-J25-250	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

F

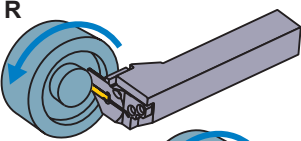
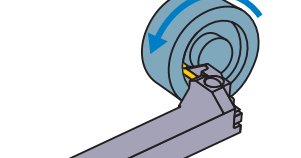
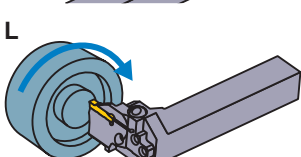
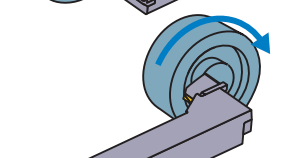
GROOVING / CUTTING OFF

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHRUS16D90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) ★1						Cutting Mode
	H	B	LF	LH	HF	WF	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	

Select an Insert

Seat Size	Insert Number
J	GY○○○0600/0631/0635J○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
J	.236", 6.00 mm	●	●	●	●
	.250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing) Ball nose
J	.236", 6.00 mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.248", 6.31 mm	●			
	.250", 6.35 mm	●			●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			

● : Gauge insert shown dimensions

F

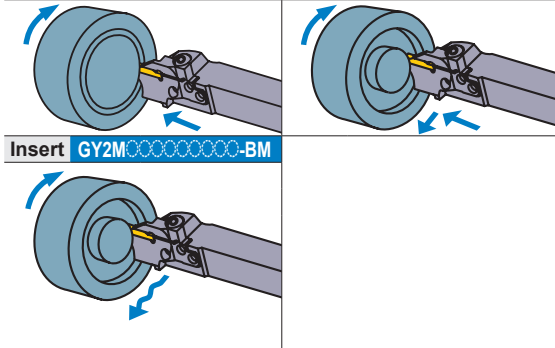
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2S	GL	Insert	GY2M	MS
Insert	GY1M	GM	Insert	GY2M	MM
		GFGS			



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

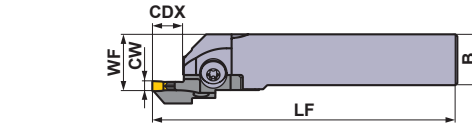


Fig. 1

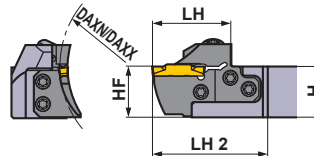
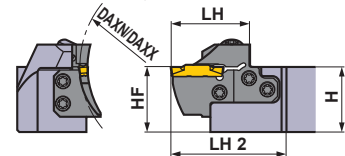


Fig. 2



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-040	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-040	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-040	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-040	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-040	●	2
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-D12-040	●	2
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-040	●	2
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-D12-040	●	2
		50	60	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-050	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-050	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-050	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-050	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-D12-050	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-050	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-D12-050	●	2
		60	75	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-060	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-060	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-060	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-060	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-060	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-D12-060	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-060	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-D12-060	●	2
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-075	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-075	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-075	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-075	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-075	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-D12-075	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-075	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-D12-075	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

● : USA Stock ★ : Stocked in Japan

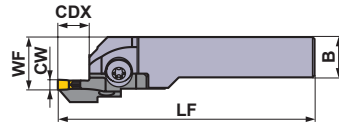
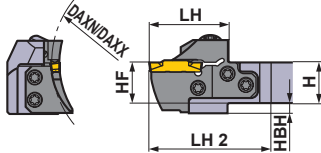


Fig. 3



Right hand tool holder shown.

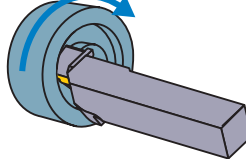
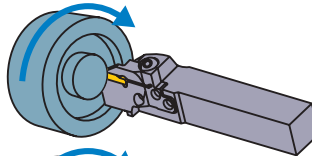
★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

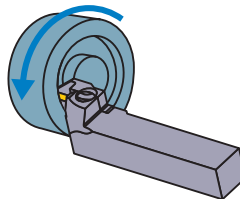
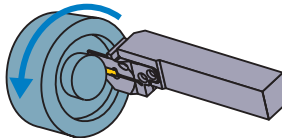
Holder Number		 5 pcs.	 ① ②
GYHR/L2020K00-M25R/L	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	R
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	L
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	L
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	L
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	

R



L



Select an Insert

Seat Size	Insert Number
D	GY000200/0224D000000-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW					
D	.079", 2.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

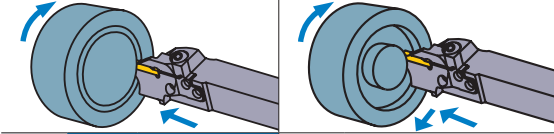
GROOVING / CUTTING OFF

IDENTIFICATION	> F008, F009
CUTTING CONDITIONS	> F206
INSTRUCTION MANUAL	> F208

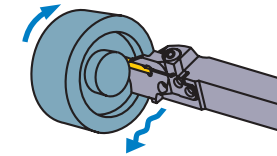
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2G	GL	Insert	GY2M	MS
Insert	GY1G	GFGS	Insert	GY2M	MM



Insert GY2M-BM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

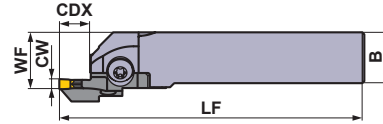


Fig. 1

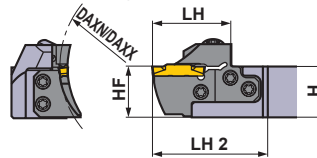
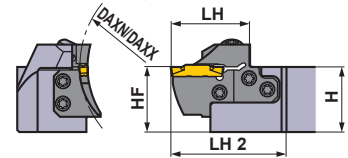


Fig. 2



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-100	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-100	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-100	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-100	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-100	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-D12-100	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-100	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-D12-100	●	2
		135	200	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-135	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-135	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-135	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-135	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-135	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-D12-135	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-135	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-D12-135	●	2
		180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-180	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-180	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-180	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-180	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-D12-180	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-180	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-D12-180	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★ 1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

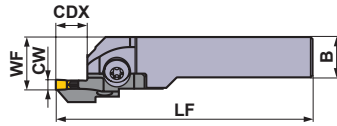
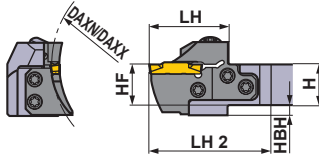


Fig. 3



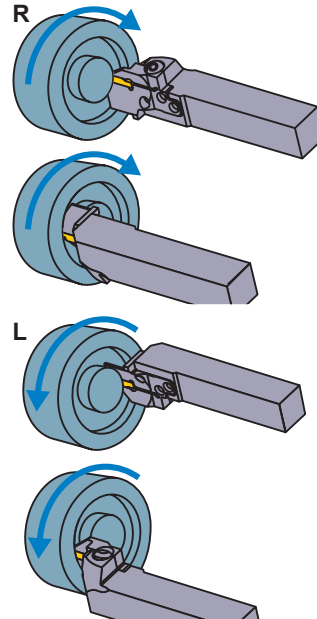
Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	R
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	R
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	R
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	L
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	L
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	L
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	L
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	L
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	L
32	32	170	39	57	32	35	—	



Select an Insert

Seat Size	Insert Number
D	GY000200/0224D000000-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
D	.079", 2.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

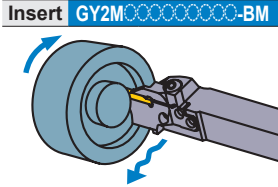
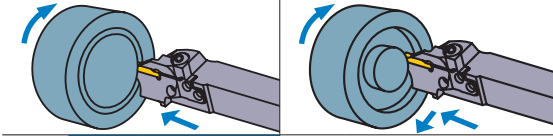
GROOVING / CUTTING OFF

IDENTIFICATION	> F008, F009
CUTTING CONDITIONS	> F206
INSTRUCTION MANUAL	> F208

GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2S	GU	Insert	GY2M	MS
Insert	GY1G	GM	Insert	GY2M	MM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

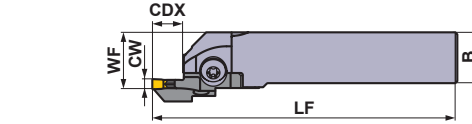


Fig. 1

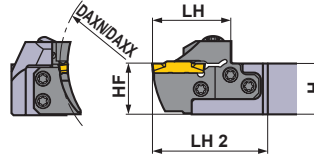
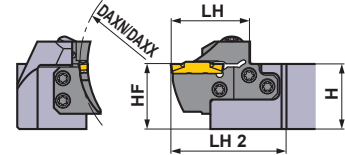


Fig. 2



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-040	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-040	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-040	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-040	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-E12-040	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-E12-040	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-E12-040	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-E12-040	●	2
		50	60	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-050	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-050	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-050	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-E12-050	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-E12-050	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-E12-050	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-E12-050	●	2
		60	75	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-060	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-060	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-060	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-060	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-E12-060	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-E12-060	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-E12-060	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-E12-060	●	2
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-075	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-075	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-075	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-075	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-E12-075	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-E12-075	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-E12-075	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-E12-075	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

● : USA Stock ★ : Stocked in Japan

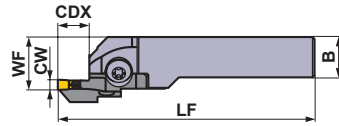
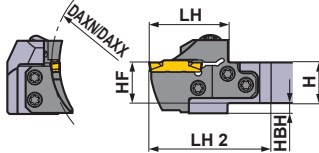


Fig. 3



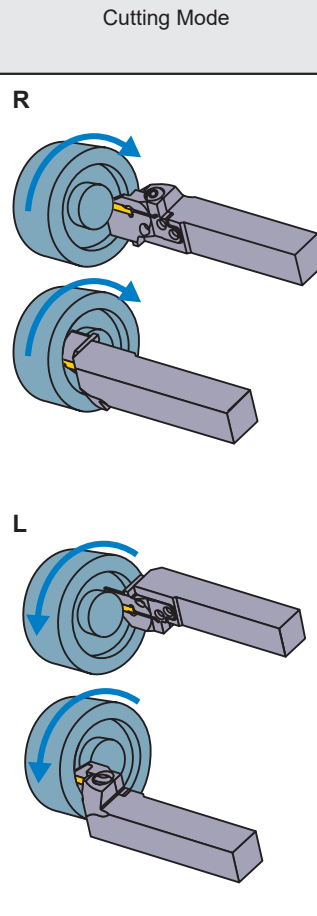
Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) ★1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—



Select an Insert

Seat Size	Insert Number
E	GY000239/0250/0274E000000-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW					
E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					
E	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

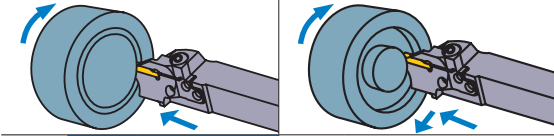
F

GROOVING / CUTTING OFF

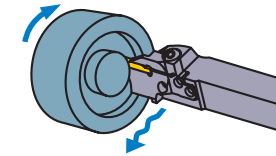
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1M	GM-GFGS	Insert	GY2M	MM



Insert GY2M



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

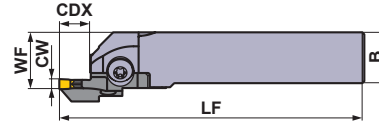


Fig. 1

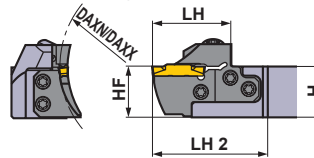
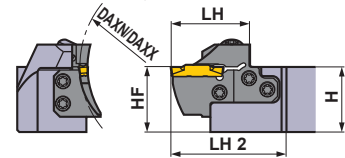


Fig. 2



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-100	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-100	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-100	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-100	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-E12-100	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-E12-100	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-E12-100	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-E12-100	●	2
		135	200	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-135	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-135	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-135	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-135	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-E12-135	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-E12-135	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-E12-135	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-E12-135	●	2
		180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-180	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-180	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-180	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-E12-180	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-E12-180	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-E12-180	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-E12-180	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★ 1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

F

GROOVING / CUTTING OFF

● : USA Stock ★ : Stocked in Japan

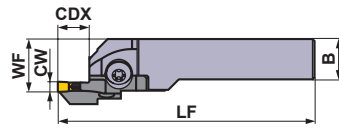
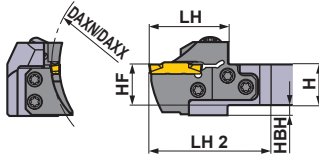


Fig. 3



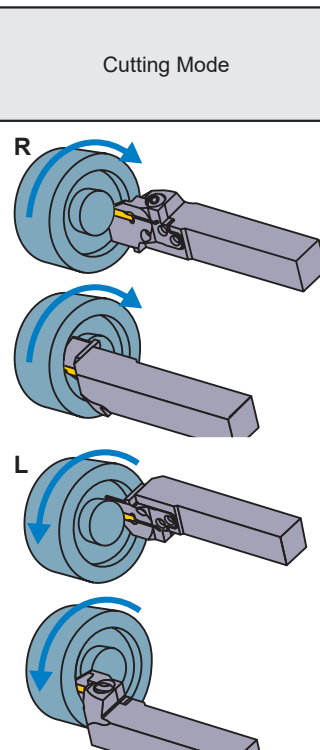
Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	R
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	R
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	R
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	L
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	L
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	L
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	L
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	L
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	L
32	32	170	39	57	32	35	—	



Select an Insert

Seat Size	Insert Number
E	GY000239/0250/0274E00000-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
E	CW				
	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
E	CW				Ball nose
	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

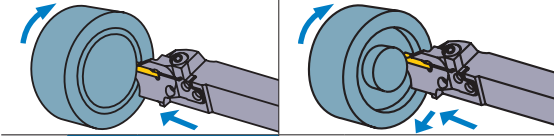
F

GROOVING / CUTTING OFF

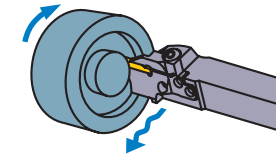
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M	GS _{GM}	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1M	GM _{GFS}	Insert	GY2M	MM



Insert GY2M



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

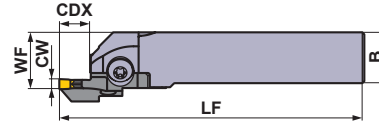


Fig. 1

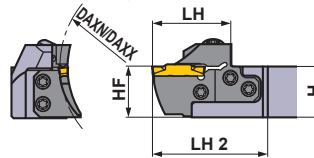
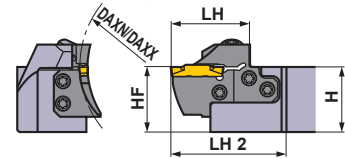


Fig. 2



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	35	40	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-035	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-035	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-035	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-035	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-035	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-035	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-035	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-035	●	2
		40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-040	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-040	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-040	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-040	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-040	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-040	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-040	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-040	●	2
		50	60	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-050	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-050	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-050	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-050	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-050	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-050	●	2
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-050	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★ 1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

F

GROOVING / CUTTING OFF

● : USA Stock ★ : Stocked in Japan

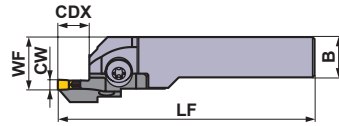
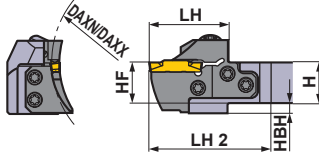


Fig. 3



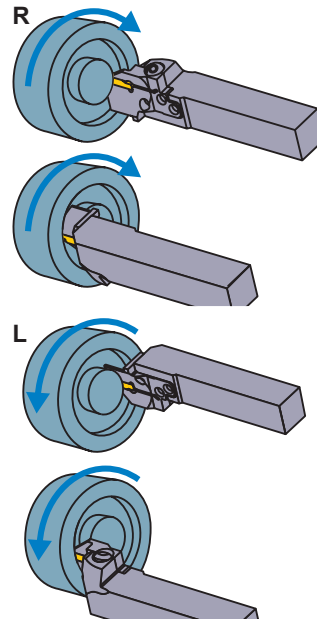
Right hand tool holder shown.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	R
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	R
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	R
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	L
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	L
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	L
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	L
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	L
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	L
32	32	170	39	57	32	35	—	



Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	CW				
	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
F	CW				Ball nose
	.118", 3.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	RE 0.8 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	.128", 3.24 mm	●	●	●	●

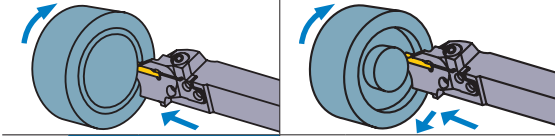
● : Gauge insert shown dimensions

F GROOVING / CUTTING OFF

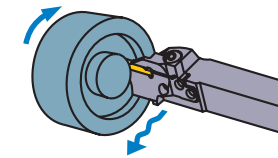
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}

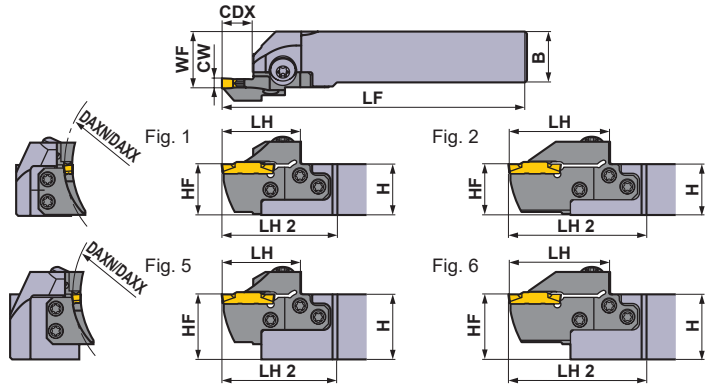


Insert GY2M^{BM}



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

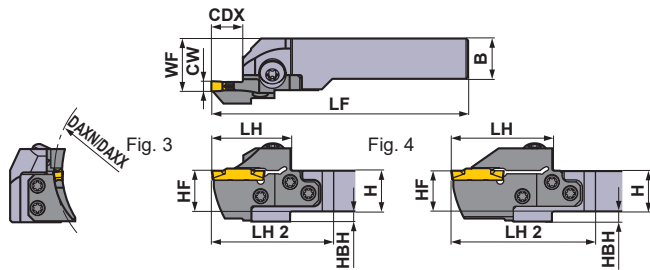
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	60	75	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-060	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-060	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-060	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-060	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-060	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-060	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-060	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-060	●	5
				20 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-060	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-060	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-060	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-060	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-060	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-060	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-060	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-060	●	6
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-075	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-075	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-075	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-075	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-075	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-075	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-075	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-075	●	5
				20 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-075	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-075	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-075	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-075	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-075	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-075	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-075	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-075	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan



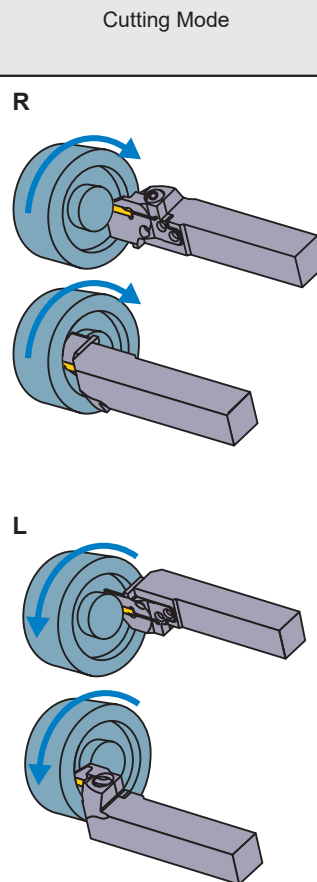
★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench ★
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	131	45	66	20	26	5
	20	20	131	45	66	20	26	5
	25	25	156	45	63	25	28	—
	25	25	156	45	63	25	28	—
	32	25	176	45	63	32	28	—
	32	25	176	45	63	32	28	—
	32	32	176	45	63	32	35	—
	32	32	176	45	63	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	131	45	66	20	26	5
	20	20	131	45	66	20	26	5
	25	25	156	45	63	25	28	—
	25	25	156	45	63	25	28	—
	32	25	176	45	63	32	28	—
	32	25	176	45	63	32	28	—
	32	32	176	45	63	32	35	—
	32	32	176	45	63	32	35	—



Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing) Ball nose
F	.118", 3.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	RE 0.8 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	.128", 3.24 mm	●	●	●	●

● : Gauge insert shown dimensions

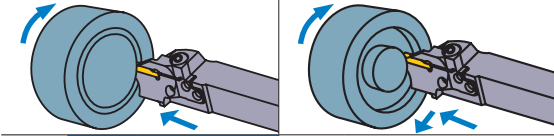
F

GROOVING / CUTTING OFF

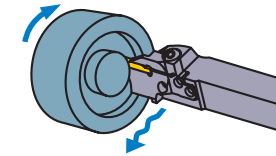
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}

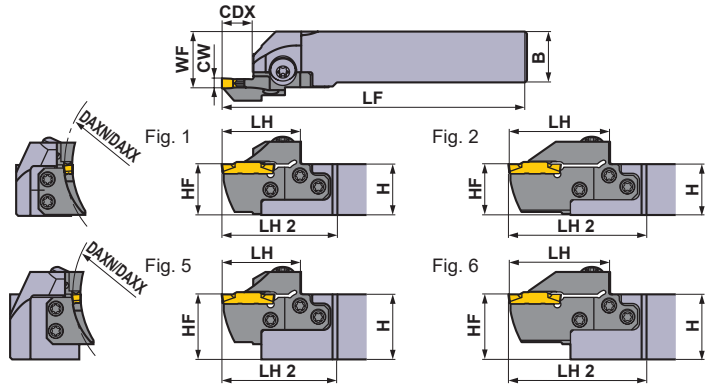


Insert GY2M^{BM}



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

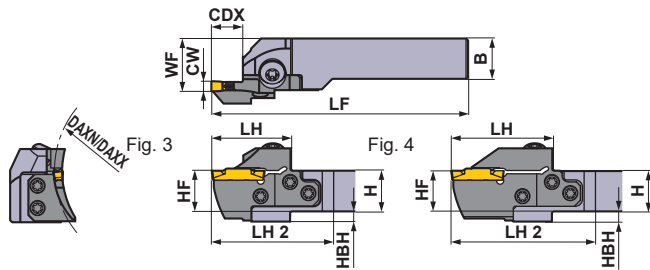
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-100	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-100	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-100	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-100	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-100	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-100	●	5
				20 *2	Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-100	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-100	●	5
					Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-100	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-100	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-100	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-100	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-100	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-100	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-100	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-100	●	6
		135	200	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-135	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-135	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-135	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-135	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-135	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-135	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-135	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-135	●	5
				20 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-135	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-135	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-135	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-135	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-135	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-135	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-135	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-135	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan



★ Wrench : ① : Clamp Screw, ② : Blade Screw

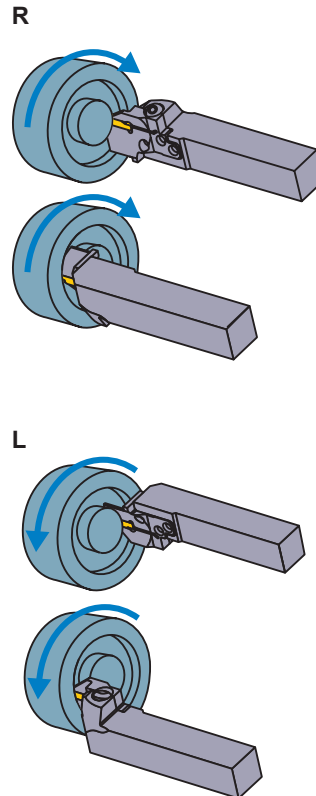
SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	131	45	66	20	26	5
	20	20	131	45	66	20	26	5
	25	25	156	45	63	25	28	—
	25	25	156	45	63	25	28	—
	32	25	176	45	63	32	28	—
	32	25	176	45	63	32	28	—
	32	32	176	45	63	32	35	—
	32	32	176	45	63	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	131	45	66	20	26	5
	20	20	131	45	66	20	26	5
	25	25	156	45	63	25	28	—
	25	25	156	45	63	25	28	—
	32	25	176	45	63	32	28	—
	32	25	176	45	63	32	28	—
	32	32	176	45	63	32	35	—
	32	32	176	45	63	32	35	—

Cutting Mode



Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	CW				
	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
F	CW				Ball nose
	.118", 3.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	RE 0.8 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	.128", 3.24 mm	●	●	●	●

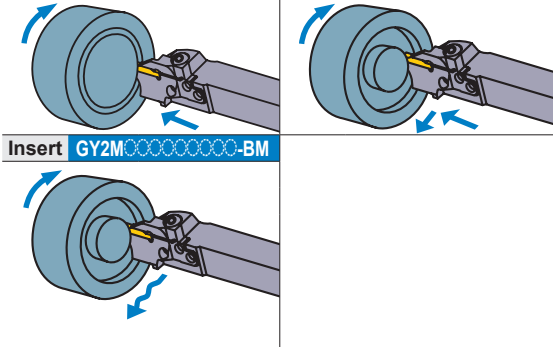
● : Gauge insert shown dimensions

F
GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

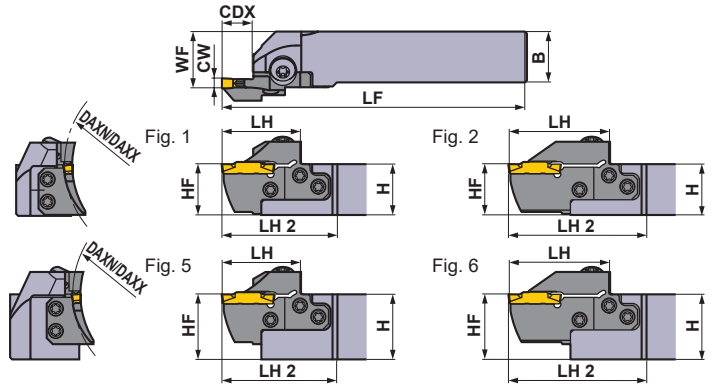
4-2 00° type holder (Metric)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GM-GFGS	Insert	GY2M	MM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



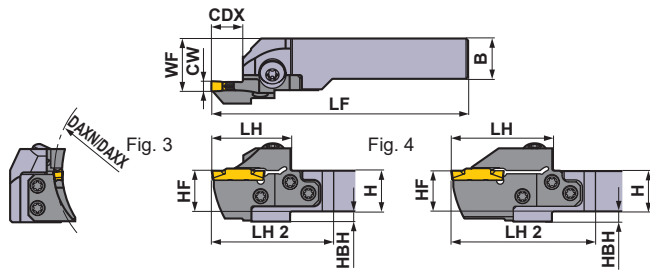
Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-180	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-180	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-180	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-180	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-180	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-180	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-180	●	5
				20 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-180	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-180	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-180	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-180	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-180	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-180	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-180	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-180	●	6
		225	999	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-225	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-225	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-225	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-225	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-225	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-225	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-225	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-225	●	5
				20 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-225	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-225	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-225	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-225	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-225	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-225	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-225	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-225	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.



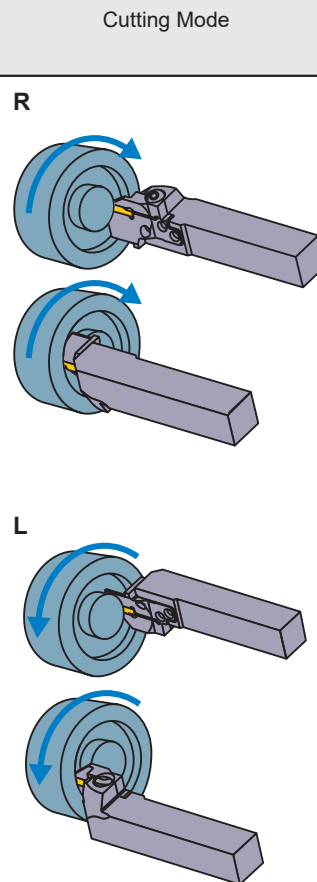
★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	131	45	66	20	26	5
	20	20	131	45	66	20	26	5
	25	25	156	45	63	25	28	—
	25	25	156	45	63	25	28	—
	32	25	176	45	63	32	28	—
	32	25	176	45	63	32	28	—
	32	32	176	45	63	32	35	—
	32	32	176	45	63	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	131	45	66	20	26	5
	20	20	131	45	66	20	26	5
	25	25	156	45	63	25	28	—
	25	25	156	45	63	25	28	—
	32	25	176	45	63	32	28	—
	32	25	176	45	63	32	28	—
	32	32	176	45	63	32	35	—
	32	32	176	45	63	32	35	—



Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	CW				
	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

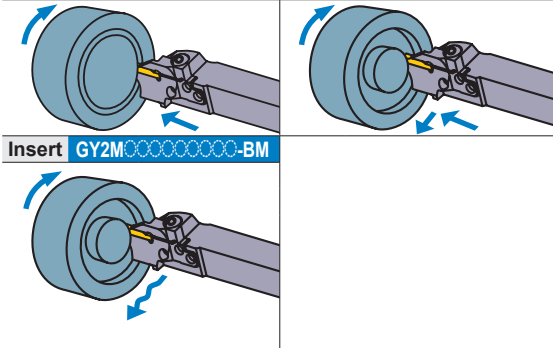
For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
F	CW				Ball nose
	.118", 3.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	RE 0.8 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	.128", 3.24 mm	●	●	●	●

● : Gauge insert shown dimensions

GY SERIES (FACE GROOVING)

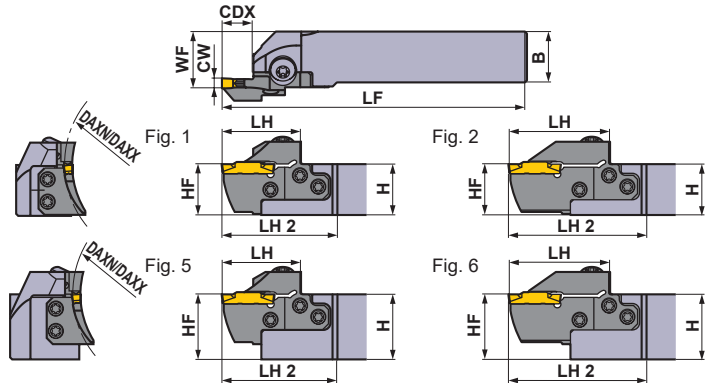
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1M ^{GM}	Insert	GY2M ^{MM}



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

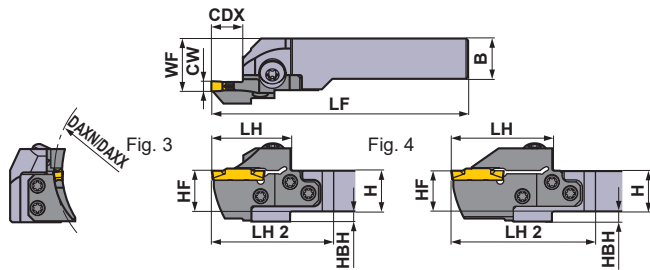
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	40	50	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-040	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-040	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-040	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-040	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-040	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-G14-040	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-040	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-G14-040	●	5
		50	60	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-050	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-050	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-050	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-050	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-G14-050	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-050	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-G14-050	●	5
		60	85	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-060	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-060	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-060	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-060	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-060	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-G14-060	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-060	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-G14-060	●	5
		25 *2			Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-060	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G25-060	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-060	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G25-060	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-060	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-G25-060	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-060	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-G25-060	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan



★ Wrench : ① : Clamp Screw, ② : Blade Screw

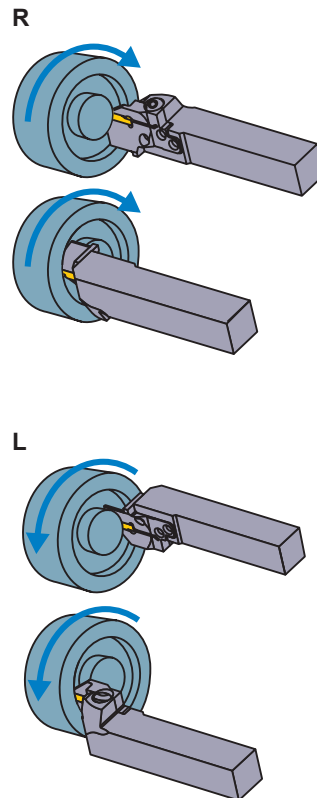
SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) ★1							
H	B	LF	LH	LH 2	HF	WF	HBH
20	20	125	39	60	20	26	5
20	20	125	39	60	20	26	5
25	25	150	39	57	25	28	—
25	25	150	39	57	25	28	—
32	25	170	39	57	32	28	—
32	25	170	39	57	32	28	—
32	32	170	39	57	32	35	—
32	32	170	39	57	32	35	—
20	20	125	39	60	20	26	5
20	20	125	39	60	20	26	5
25	25	150	39	57	25	28	—
25	25	150	39	57	25	28	—
32	25	170	39	57	32	28	—
32	25	170	39	57	32	28	—
32	32	170	39	57	32	35	—
32	32	170	39	57	32	35	—
20	20	125	39	60	20	26	5
20	20	125	39	60	20	26	5
25	25	150	39	57	25	28	—
25	25	150	39	57	25	28	—
32	25	170	39	57	32	28	—
32	25	170	39	57	32	28	—
32	32	170	39	57	32	35	—
32	32	170	39	57	32	35	—
20	20	136	50	71	20	26	5
20	20	136	50	71	20	26	5
25	25	161	50	68	25	28	—
25	25	161	50	68	25	28	—
32	25	181	50	68	32	28	—
32	25	181	50	68	32	28	—
32	32	181	50	68	32	35	—
32	32	181	50	68	32	35	—

Cutting Mode



Select an Insert

Seat Size	Insert Number
G	GY○○○0400/0424G○○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
G	CW .157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
G	CW .157", 4.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	RE 0.8 mm	●	●	●	●
	.167", 4.24 mm	●	●	●	●

● : Gauge insert shown dimensions

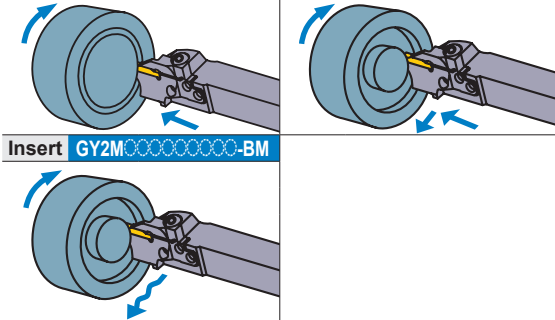
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

GY SERIES (FACE GROOVING)

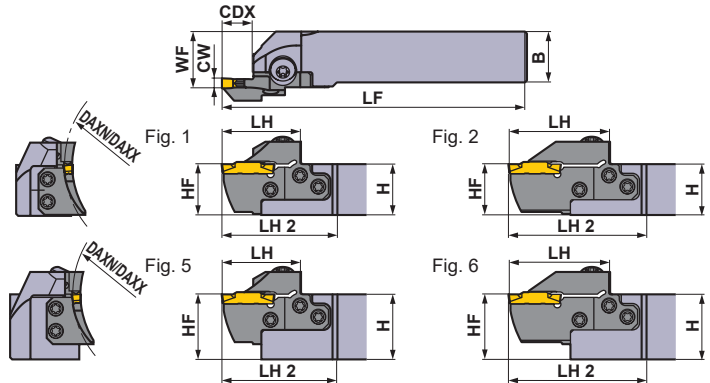
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GM}	Insert	GY2M ^{MM}



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



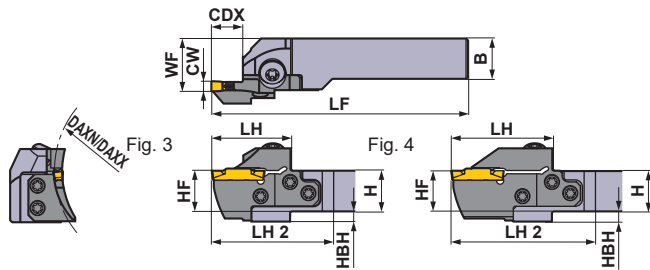
Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.	
							Holder	Stock	Modular Blade	Stock		
G	4.00 4.24	85	125	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-085	●	3	
						L	GYHL2020K00-M25L	●	GYM25LD-G14-085	●	3	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-085	●	1	
						L	GYHL2525M00-M25L	●	GYM25LD-G14-085	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-085	●	5		
					L	GYHL3225P00-M25L	★	GYM25LD-G14-085	●	5		
				Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-085	●	5		
					L	GYHL3232P00-M25L	★	GYM25LD-G14-085	●	5		
		25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-085	●	4			
				L	GYHL2020K00-M25L	●	GYM25LD-G25-085	●	4			
			Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-085	●	2			
				L	GYHL2525M00-M25L	●	GYM25LD-G25-085	●	2			
		Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-085	●	6				
			L	GYHL3225P00-M25L	★	GYM25LD-G25-085	●	6				
		Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-085	●	6				
			L	GYHL3232P00-M25L	★	GYM25LD-G25-085	●	6				
		125	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-125	●	3	
						L	GYHL2020K00-M25L	●	GYM25LD-G14-125	●	3	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-125	●	1	
						L	GYHL2525M00-M25L	●	GYM25LD-G14-125	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-125	●	5		
					L	GYHL3225P00-M25L	★	GYM25LD-G14-125	●	5		
				Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-125	●	5		
					L	GYHL3232P00-M25L	★	GYM25LD-G14-125	●	5		
	25 *2			Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-125	●	4		
					L	GYHL2020K00-M25L	●	GYM25LD-G25-125	●	4		
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-125	●	2		
					L	GYHL2525M00-M25L	●	GYM25LD-G25-125	●	2		
				Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-125	●	6		
					L	GYHL3225P00-M25L	★	GYM25LD-G25-125	●	6		
				Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-125	●	6		
					L	GYHL3232P00-M25L	★	GYM25LD-G25-125	●	6		

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.



★ Wrench : ① : Clamp Screw, ② : Blade Screw

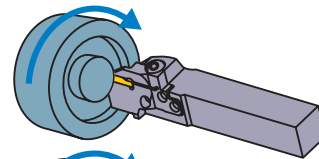
SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

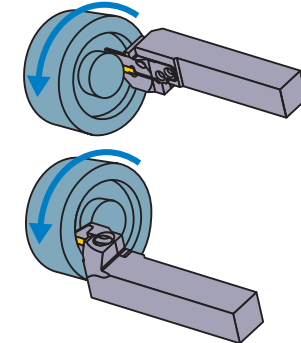
Right hand tool holder shown.

Dimensions (mm) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	

R



L



Select an Insert

Seat Size	Insert Number
G	GY○○○0400/0424G○○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
G	.157", 4.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	RE 0.8 mm	●	●	●	●
	.167", 4.24 mm	●	●	●	●

● : Gauge insert shown dimensions

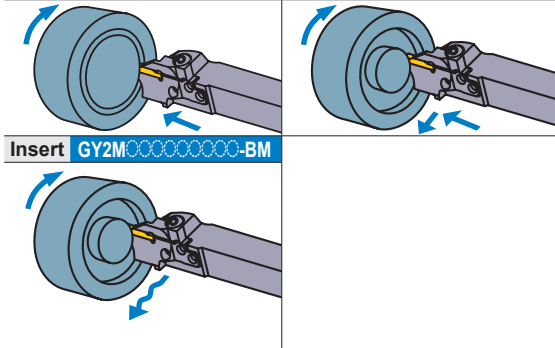
F

GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

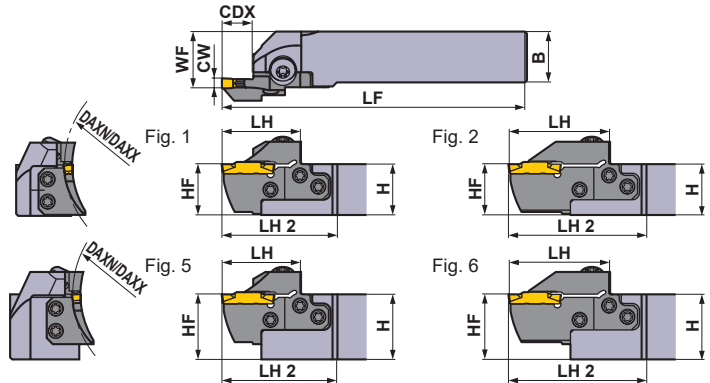
4-2 00° type holder (Metric)

Insert	GY2M	GS-GM	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GM-GFGS	Insert	GY2M	MM



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

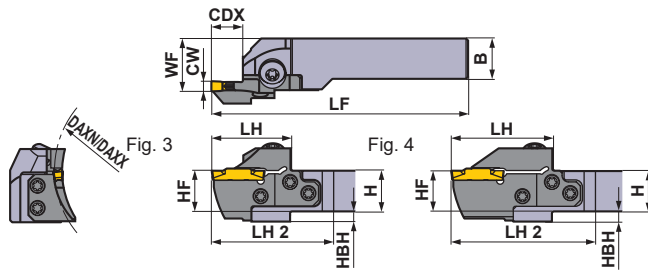
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	180	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-180	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-180	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-180	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-180	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-G14-180	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-180	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-G14-180	●	5
				25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-180	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G25-180	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-180	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G25-180	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-180	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-G25-180	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-180	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-G25-180	●	6
		250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-250	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-250	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-250	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-250	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-250	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-G14-250	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-250	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-G14-250	●	5
				25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-250	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G25-250	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-250	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G25-250	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-250	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-G25-250	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-250	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-G25-250	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan



★ Wrench : ① : Clamp Screw, ② : Blade Screw

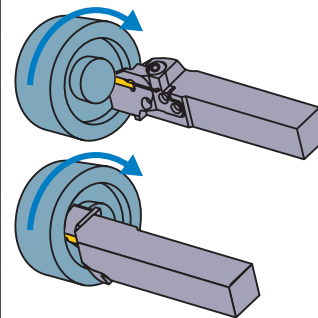
SPARE PARTS

Holder Number	5 pcs.	① ②	Wrench *
GYHR/L2020K00-M25R/L	Clamp Screw	Blade Screw	
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

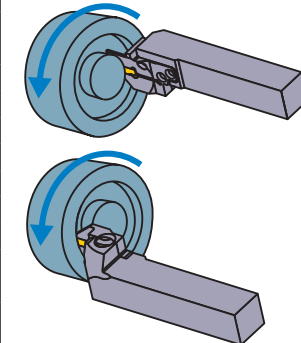
Right hand tool holder shown.

Dimensions (mm) *1								
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	

R



L



Select an Insert

Seat Size	Insert Number
G	GY○○0400/0424G○○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
G	CW .157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
G	CW .157", 4.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	RE 0.8 mm	●	●	●	●
	.167", 4.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

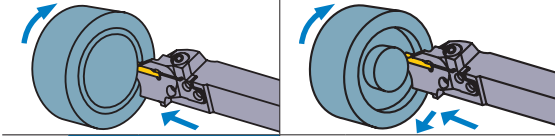
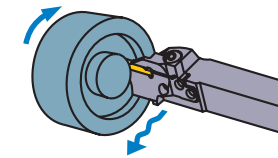
GROOVING / CUTTING OFF

IDENTIFICATION	> F008, F009
CUTTING CONDITIONS	> F206
INSTRUCTION MANUAL	> F208

GY SERIES (FACE GROOVING)

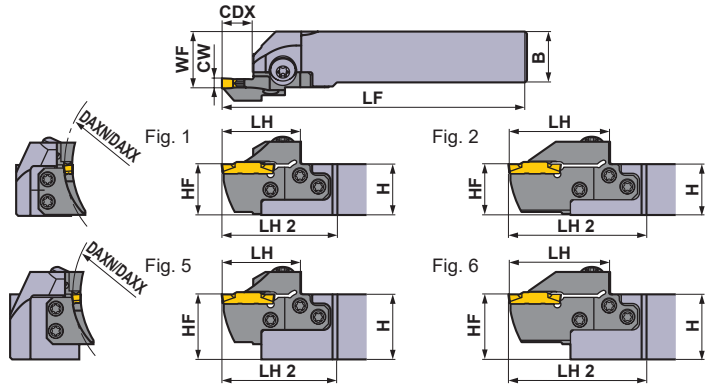
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1M ^{GFGS}	Insert	GY2M ^{MM}

Insert GY2M^{BM}

Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



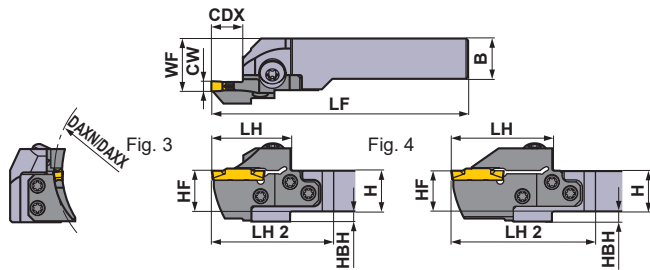
Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	50	60	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-050	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-050	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-050	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-H14-050	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-H14-050	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-H14-050	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-H14-050	●	5
		60	85	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-060	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-060	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-060	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-060	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-H14-060	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-H14-060	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-H14-060	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-H14-060	●	5
				25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-060	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-060	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-060	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-060	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-H25-060	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-H25-060	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-H25-060	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-H25-060	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.



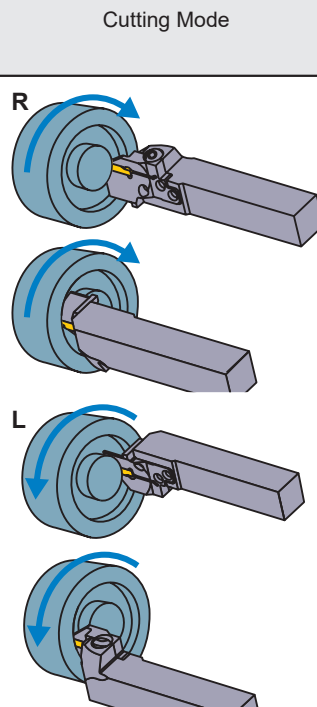
★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—



Select an Insert

Seat Size	Insert Number
H	GY○○○0475/0500/0524H○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	CW				
	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

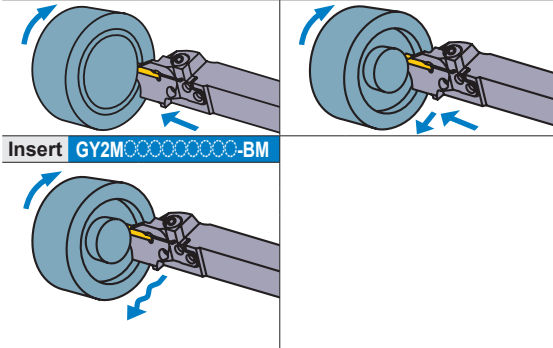
For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
H	CW				Ball nose
	.187", 4.75 mm	●			●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			
	.197", 5.00 mm	●			●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

GY SERIES (FACE GROOVING)

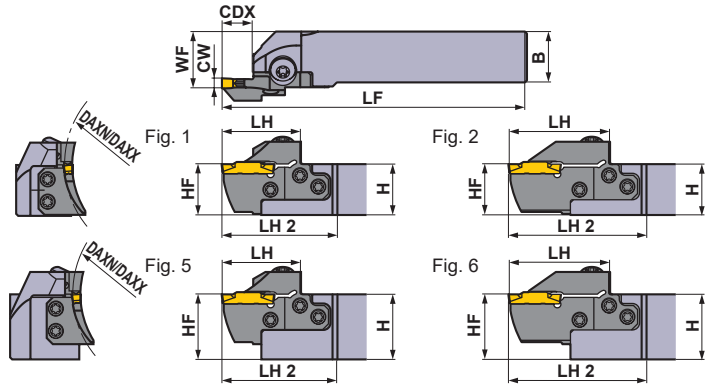
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

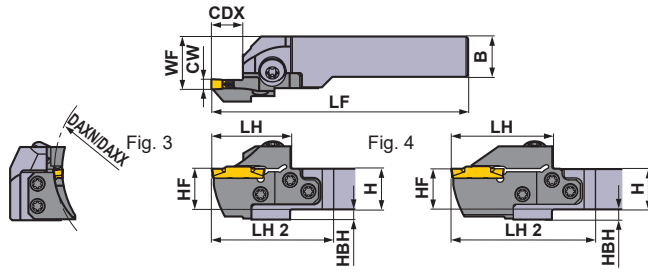
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F H	4.75 5.00 5.24	85	125	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-085	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-085	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-085	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-085	●	1
				25 *2	Modular	R	GYHR3225P00-M25R	★	GYM25RD-H14-085	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-H14-085	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-H14-085	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-H14-085	●	5
				25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-085	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-085	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-085	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-085	●	2
				14	Modular	R	GYHR3225P00-M25R	★	GYM25RD-H25-085	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-H25-085	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-H25-085	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-H25-085	●	6
		125	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-125	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-125	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-125	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-125	●	1
				25 *2	Modular	R	GYHR3225P00-M25R	★	GYM25RD-H14-125	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-H14-125	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-H14-125	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-H14-125	●	5
				25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-125	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-125	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-125	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-125	●	2
				25 *2	Modular	R	GYHR3225P00-M25R	★	GYM25RD-H25-125	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-H25-125	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-H25-125	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-H25-125	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan



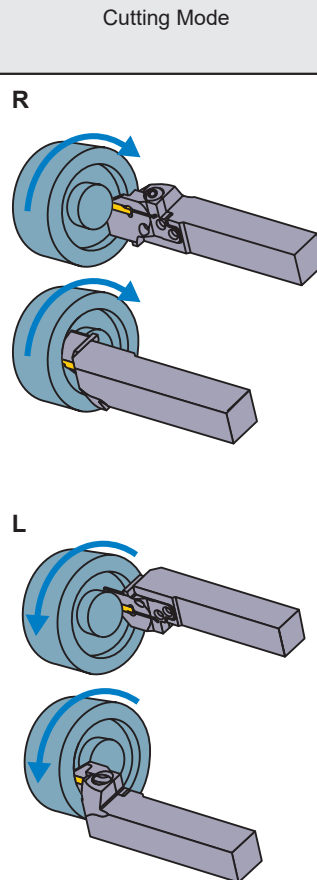
★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—



Select an Insert

Seat Size	Insert Number
H	GY○○○0475/0500/0524H○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	CW				
	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

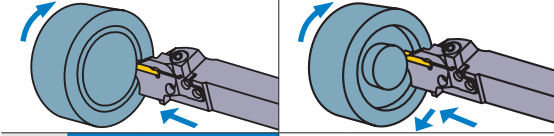
For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
H	CW				Ball nose
	.187", 4.75 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			
	.197", 5.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

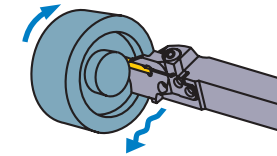
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}

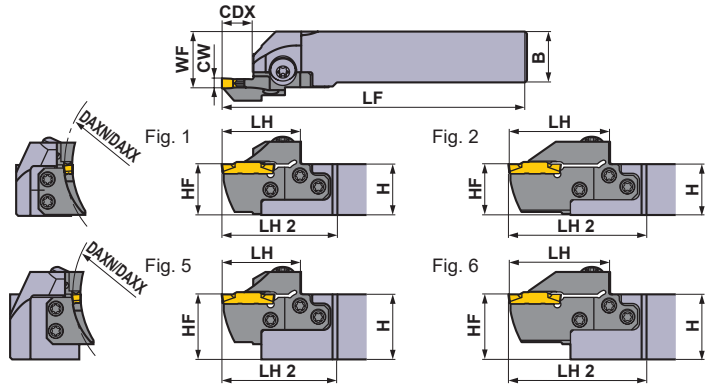


Insert GY2M^{BM}



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

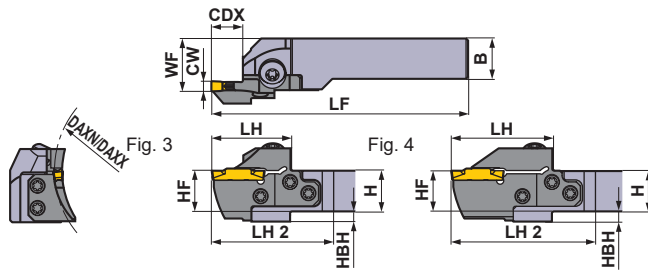
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	H	4.75 5.00 5.24	180	280	14	Modular R	GYHR2020K00-M25R	●	GYM25RD-H14-180	●	3
						Modular L	GYHL2020K00-M25L	●	GYM25LD-H14-180	●	3
						Modular R	GYHR2525M00-M25R	●	GYM25RD-H14-180	●	1
						Modular L	GYHL2525M00-M25L	●	GYM25LD-H14-180	●	1
					25 *2	Modular R	GYHR3225P00-M25R	★	GYM25RD-H14-180	●	5
						Modular L	GYHL3225P00-M25L	★	GYM25LD-H14-180	●	5
						Modular R	GYHR3232P00-M25R	★	GYM25RD-H14-180	●	5
						Modular L	GYHL3232P00-M25L	★	GYM25LD-H14-180	●	5
					25 *2	Modular R	GYHR2020K00-M25R	●	GYM25RD-H25-180	●	4
						Modular L	GYHL2020K00-M25L	●	GYM25LD-H25-180	●	4
						Modular R	GYHR2525M00-M25R	●	GYM25RD-H25-180	●	2
						Modular L	GYHL2525M00-M25L	●	GYM25LD-H25-180	●	2
					14	Modular R	GYHR3225P00-M25R	★	GYM25RD-H25-180	●	6
						Modular L	GYHL3225P00-M25L	★	GYM25LD-H25-180	●	6
						Modular R	GYHR3232P00-M25R	★	GYM25RD-H25-180	●	6
						Modular L	GYHL3232P00-M25L	★	GYM25LD-H25-180	●	6
			250	999	14	Modular R	GYHR2020K00-M25R	●	GYM25RD-H14-250	●	3
						Modular L	GYHL2020K00-M25L	●	GYM25LD-H14-250	●	3
						Modular R	GYHR2525M00-M25R	●	GYM25RD-H14-250	●	1
						Modular L	GYHL2525M00-M25L	●	GYM25LD-H14-250	●	1
					25 *2	Modular R	GYHR3225P00-M25R	★	GYM25RD-H14-250	●	5
						Modular L	GYHL3225P00-M25L	★	GYM25LD-H14-250	●	5
						Modular R	GYHR3232P00-M25R	★	GYM25RD-H14-250	●	5
						Modular L	GYHL3232P00-M25L	★	GYM25LD-H14-250	●	5
					25 *2	Modular R	GYHR2020K00-M25R	●	GYM25RD-H25-250	●	4
						Modular L	GYHL2020K00-M25L	●	GYM25LD-H25-250	●	4
						Modular R	GYHR2525M00-M25R	●	GYM25RD-H25-250	●	2
						Modular L	GYHL2525M00-M25L	●	GYM25LD-H25-250	●	2
					14	Modular R	GYHR3225P00-M25R	★	GYM25RD-H25-250	●	6
						Modular L	GYHL3225P00-M25L	★	GYM25LD-H25-250	●	6
						Modular R	GYHR3232P00-M25R	★	GYM25RD-H25-250	●	6
						Modular L	GYHL3232P00-M25L	★	GYM25LD-H25-250	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan



★ Wrench : ① : Clamp Screw, ② : Blade Screw

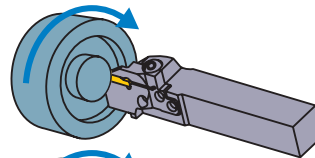
SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

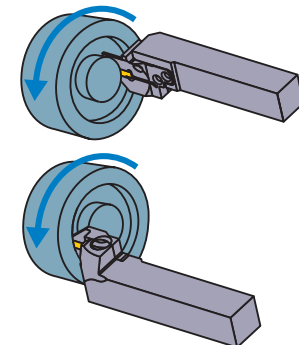
Right hand tool holder shown.

	Dimensions (mm) ★1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—

R



L



Select an Insert

Seat Size	Insert Number
H	GY○○○0475/0500/0524H○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	CW				
	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
H	CW				Ball nose
	.187", 4.75 mm	●			●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			
	.197", 5.00 mm	●			●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

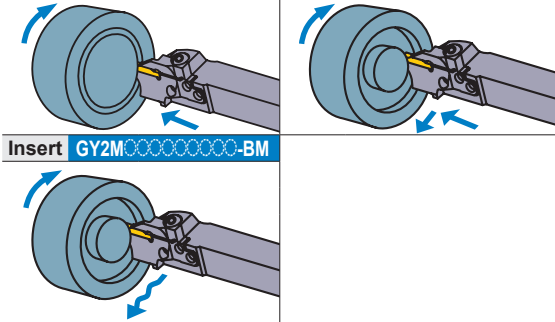
F

GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

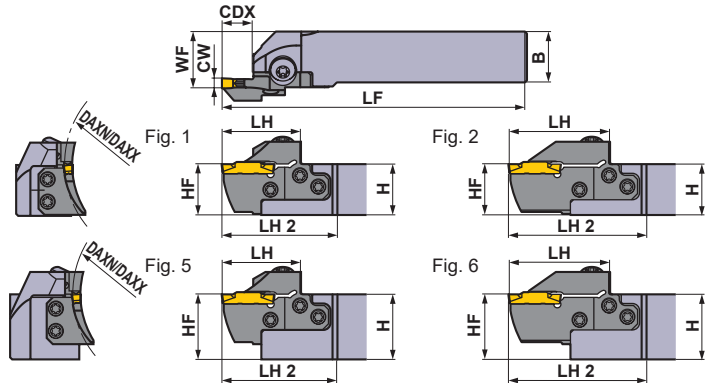
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

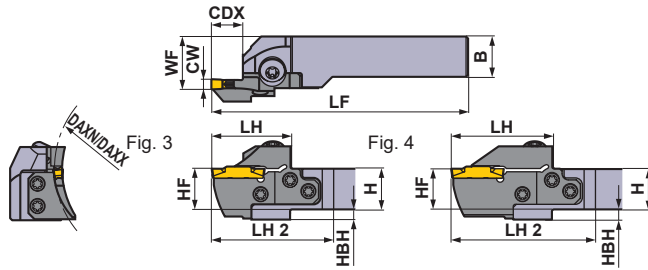
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	6.00 6.31 6.35	50	70	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-050	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-050	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-050	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-J14-050	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-J14-050	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-J14-050	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-J14-050	●	5
		70	110	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-070	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-070	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-070	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-070	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-J14-070	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-J14-070	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-J14-070	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-J14-070	●	5
		110	200	25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-070	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-070	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-070	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-070	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-J25-070	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-J25-070	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-J25-070	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-J25-070	●	6
		110	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-110	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-110	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-110	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-110	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-J14-110	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-J14-110	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-J14-110	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-J14-110	●	5
		110	200	25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-110	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-110	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-110	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-110	●	2
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-J25-110	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-J25-110	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-J25-110	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-J25-110	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan



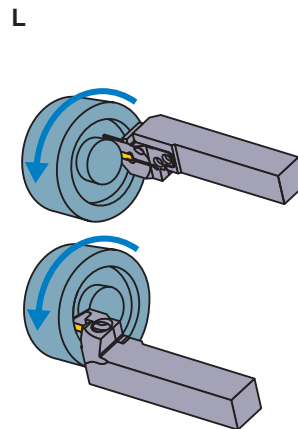
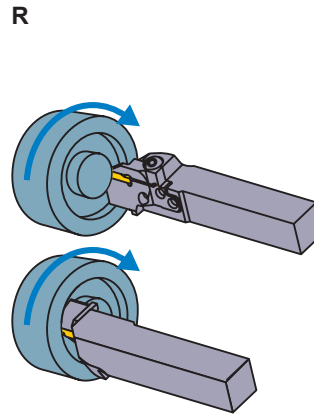
★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench ★
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	R
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	R
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	L
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	R
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	



Select an Insert

Seat Size	Insert Number
J	GY○○0600/0631/0635J○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
J	236", 6.00 mm	●	●	●	●
	250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
J	236", 6.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	248", 6.31 mm	●			
	250", 6.35 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			

● : Gauge insert shown dimensions

F

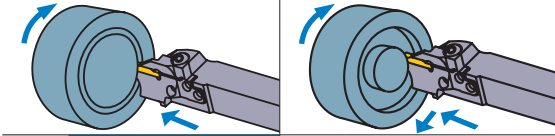
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

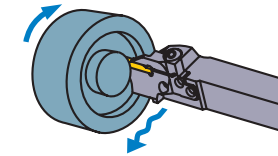
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{SS} _{GM}	Insert	GY2G ^{SS} _{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}

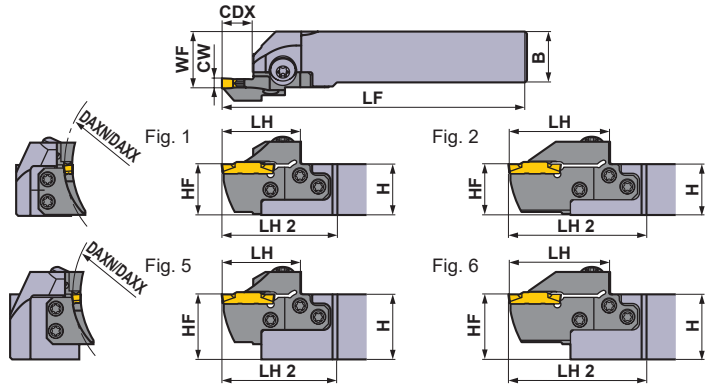


Insert GY2M^{BM}



Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

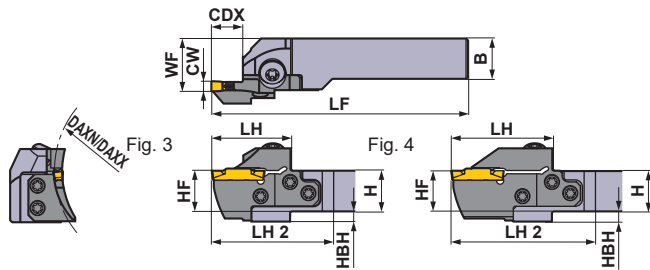
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	6.00 6.31 6.35	170	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-170	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-170	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-170	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-170	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-J14-170	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-J14-170	●	5
				25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-170	●	5
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-170	●	5
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-170	●	4
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-170	●	4
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-J25-170	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-J25-170	●	2
				14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-170	●	6
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-170	●	6
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-170	●	6
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-170	●	6
		250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-250	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-250	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-250	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-250	●	1
				25 *2	Modular	R	GYHR3225P00-M25R	★	GYM25RD-J14-250	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-J14-250	●	5
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-J14-250	●	5
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-J14-250	●	5
				25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-250	●	4
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-250	●	4
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-250	●	2
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-250	●	2
				25 *2	Modular	R	GYHR3225P00-M25R	★	GYM25RD-J25-250	●	6
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-J25-250	●	6
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-J25-250	●	6
					Modular	L	GYHL3232P00-M25L	★	GYM25LD-J25-250	●	6

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan



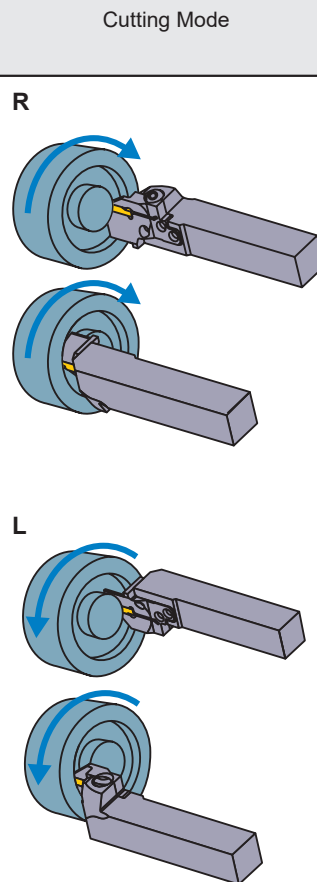
★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number	5 pcs.	5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—



Select an Insert

Seat Size	Insert Number
J	GY○○0600/0631/0635J○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
J	236", 6.00 mm	●	●	●	●
	250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
J	236", 6.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	248", 6.31 mm	●			
	250", 6.35 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			

● : Gauge insert shown dimensions

GY SERIES (FACE GROOVING)

5-2

90° type holder (Metric)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1M ^{GM}	Insert	GY2M ^{MM}

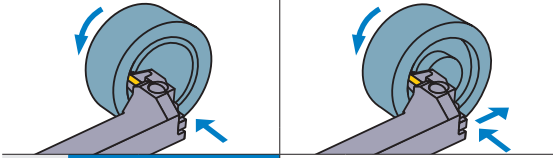
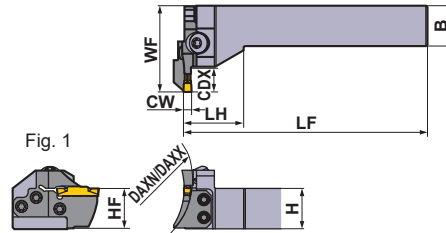
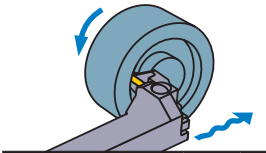
Insert GY2M^{BM}

Fig. 1

Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	40	50	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-D12-040 GYM25RD-D12-040	● ●	1 1
		50	60	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-D12-050 GYM25RD-D12-050	● ●	1 1
		60	75	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-D12-060 GYM25RD-D12-060	● ●	1 1
		75	100	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-D12-075 GYM25RD-D12-075	● ●	1 1
		100	150	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-D12-100 GYM25RD-D12-100	● ●	1 1
		135	200	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-D12-135 GYM25RD-D12-135	● ●	1 1
		180	250	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-D12-180 GYM25RD-D12-180	● ●	1 1
		40	50	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-E12-040 GYM25RD-E12-040	● ●	1 1
		50	60	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-E12-050 GYM25RD-E12-050	● ●	1 1
		60	75	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-E12-060 GYM25RD-E12-060	● ●	1 1
		75	100	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-E12-075 GYM25RD-E12-075	● ●	1 1
		100	150	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-E12-100 GYM25RD-E12-100	● ●	1 1
		135	200	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-E12-135 GYM25RD-E12-135	● ●	1 1
		180	250	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LD-E12-180 GYM25RD-E12-180	● ●	1 1

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

F

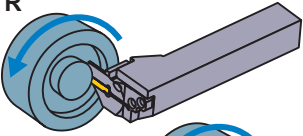
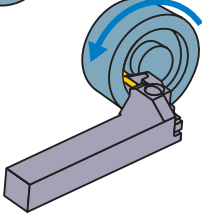
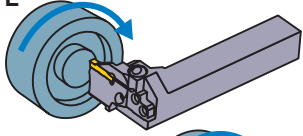
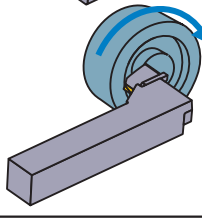
GROOVING / CUTTING OFF

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR2525M90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★1						Cutting Mode
	H	B	LF	LH	HF	WF	
	25	25	150	38	25	53	R 
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	L 
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	

Select an Insert

Seat Size	Insert Number
D	GY○○○0200/0224D○○○-Breaker
E	GY○○○0239/0250/0274E○○○-Breaker

		➤ F011, F013			
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
	CW				
D	.079", 2.00 mm	●	●	●	●
E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●

		➤ F013, F014			
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
	CW				Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●
E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●	●	●	●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION ➤ F008, F009
CUTTING CONDITIONS ➤ F206
INSTRUCTION MANUAL ➤ F208

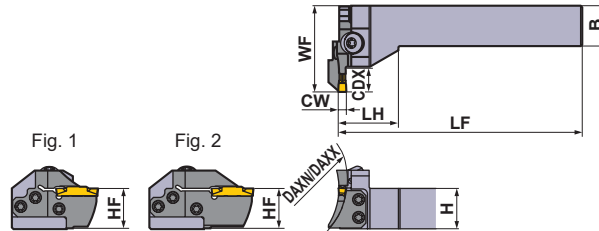
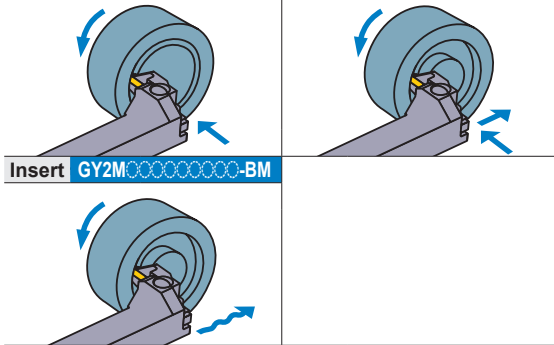
GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1M ^{GM}	Insert	GY2M ^{MM}

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	35	40	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-035	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-035	●	1
		40	50	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-040	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-040	●	1
		50	60	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-050	●	1
		60	75	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-060	●	1
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-060	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-060	●	2
		75	100	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-075	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-075	●	1
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-075	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-075	●	2
		100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-100	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-100	●	1
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-100	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-100	●	2
		135	200	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-135	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-135	●	1
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-135	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-135	●	2
		180	250	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-180	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-180	●	1
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-180	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-180	●	2
		225	999	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-225	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-225	●	1
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-225	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-225	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

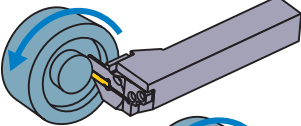
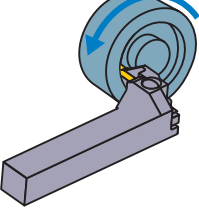
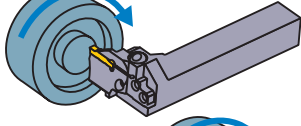
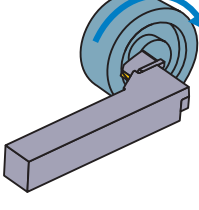
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR2525M90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★1						Cutting Mode
	H	B	LF	LH	HF	WF	
	25	25	150	38	25	53	R 
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	53	L 
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	59	

Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
F	.118", 3.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	RE 0.8 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	.128", 3.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

GY SERIES (FACE GROOVING)

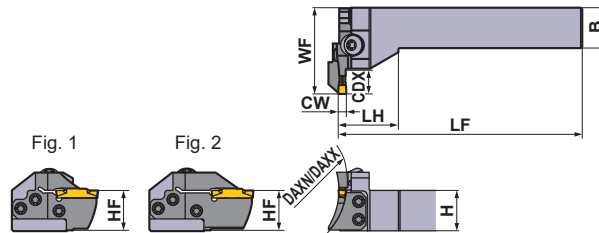
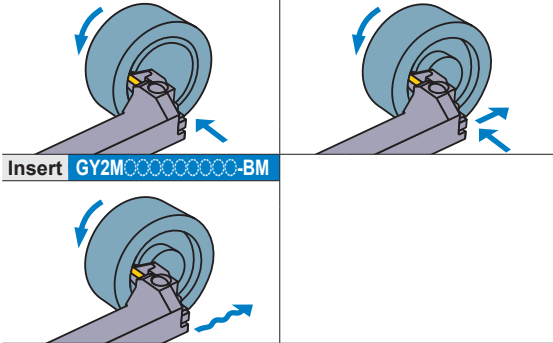
5-2

90° type holder (Metric)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1M ^{GM}	Insert	GY2M ^{MM}



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	40	50	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-040	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-040	●	1
		50	60	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-050	●	1
		60	85	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-060	●	1
		85	125	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-060	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-060	●	2
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-085	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-085	●	1
		125	200	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-085	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-085	●	2
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-125	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-125	●	1
		180	280	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-125	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-125	●	2
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-180	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-180	●	1
		250	999	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-180	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-180	●	2
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-250	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-250	●	1
		250	999	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-250	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-250	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

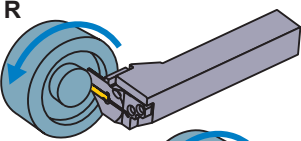
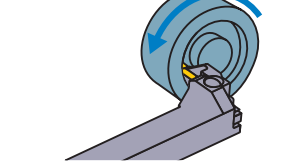
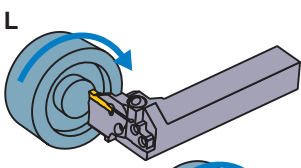
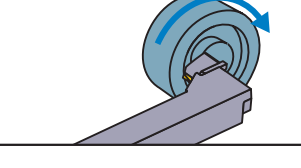
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR2525M90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★1						Cutting Mode
	H	B	LF	LH	HF	WF	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
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	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	

Select an Insert

Seat Size	Insert Number
G	GY○○○0400/0424G○○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW					
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					Ball nose
G	.157", 4.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.167", 4.24 mm	●	●	●	

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION	> F008, F009
CUTTING CONDITIONS	> F206
INSTRUCTION MANUAL	> F208

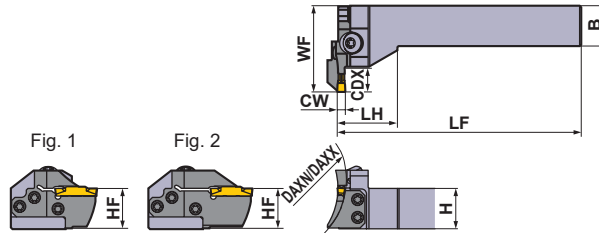
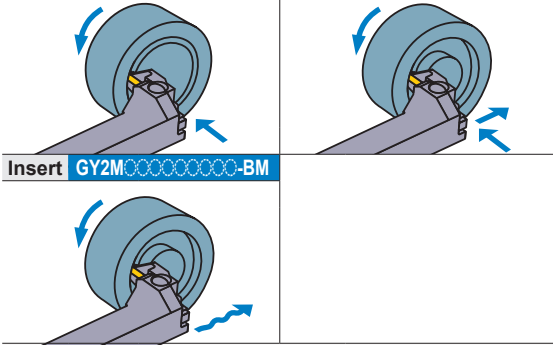
GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1M ^{GM}	Insert	GY2M ^{MM}

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	50	60	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-050	●	1
		60	85	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-060	●	1
		85	125	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-060	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-H25-060	●	2
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-085	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-085	●	1
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-085	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-H25-085	●	2
		125	200	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-125	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-125	●	1
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-125	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-H25-125	●	2
		180	280	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-180	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-180	●	1
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-180	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-H25-180	●	2
		250	999	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-250	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-H14-250	●	1
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-250	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-H25-250	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

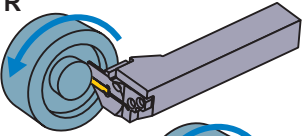
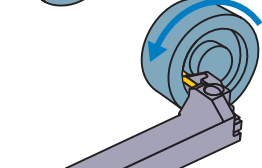
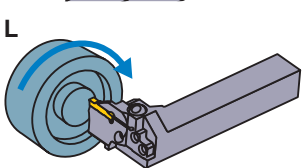
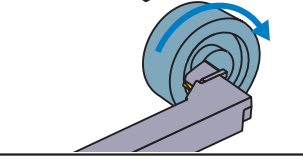
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR2525M90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★1						Cutting Mode
	H	B	LF	LH	HF	WF	
	25	25	150	38	25	53	R 
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	

Select an Insert

Seat Size	Insert Number
H	GY○○○0475/0500/0524H○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW					
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					Ball nose
H	.187", 4.75 mm	●			●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			
	.197", 5.00 mm	●			●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

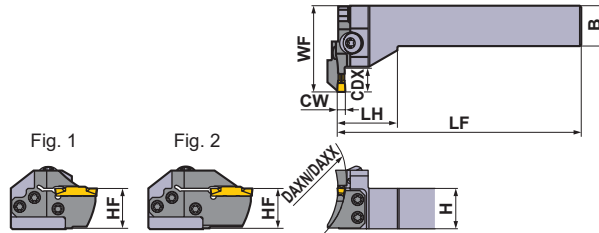
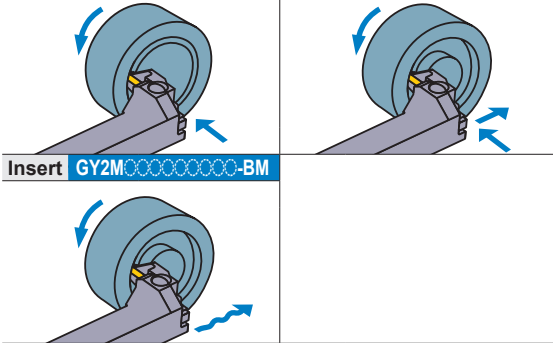
GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GFGS	Insert	GY2M	MM

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	6.00 6.31 6.35	50	70	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-050	●	1
		70	110	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-070	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-070	●	1
		110	200	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-070	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-J25-070	●	2
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-110	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-110	●	1
		170	280	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-110	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-J25-110	●	2
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-170	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-170	●	1
		250	999	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-170	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-J25-170	●	2
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-250	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-250	●	1
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-250	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-J25-250	●	2

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

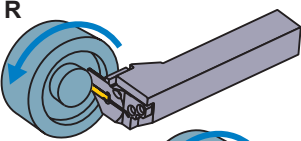
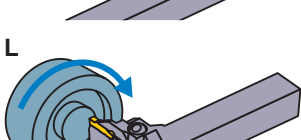
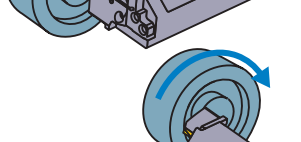
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR2525M90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★1						Cutting Mode
	H	B	LF	LH	HF	WF	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	

Select an Insert

Seat Size	Insert Number
J	GY○○0600/0631/0635J○○○○-Breaker

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
J	236", 6.00 mm	●	●	●	●
	250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
J	236", 6.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	248", 6.31 mm	●			
	250", 6.35 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

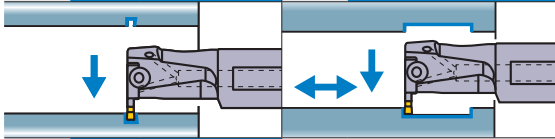
IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

GY SERIES (INTERNAL GROOVING)

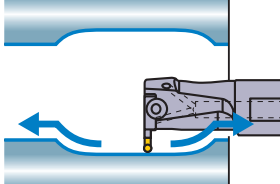
6-1

90° type holder (Inch)

Insert	GY2M	GS _{GM}	Insert	GY2G	MF
Insert	GY2G	GU _{GL}	Insert	GY2M	MS
Insert	GY1G	GM _{GFGS}	Insert	GY2M	MM



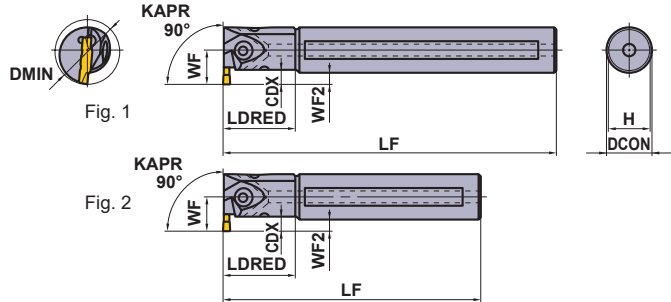
Insert GY2M



Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

● Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	*3 DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
D	.079 .088	.236	1.000	Mono Block	R	GYARUS12K90A-D06	●	—	—	2	
					L	GYALUS12K90A-D06	●	—	—	2	
				Mono Block	R	GYARUS12Q90A-D06	●	—	—	1	
					L	GYALUS12Q90A-D06	●	—	—	1	
			1.250	Mono Block	R	GYARUS16K90B-D06	●	—	—	2	
					L	GYALUS16K90B-D06	●	—	—	2	
				Mono Block	R	GYARUS16R90B-D06	●	—	—	1	
					L	GYALUS16R90B-D06	●	—	—	1	
		.157— .374 *1	1.625	Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-D10	●	4	
				L	GYDLUS20L90C-M20R	●	GYM20RA-D10	●	4		
			Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-D10	●	3		
				L	GYDLUS20S90C-M20R	●	GYM20RA-D10	●	3		
		.217— .374 *1	2.000	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-D10	●	4	
				L	GYDLUS24M90D-M20R	●	GYM20RA-D10	●	4		
			Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-D10	●	3		
				L	GYDLUS24T90D-M20R	●	GYM20RA-D10	●	3		
		.276— .453 *1	2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-D12	●	4	
					L	GYDLUS24M90D-M25R	●	GYM25RA-D12	●	4	
				Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-D12	●	3	
					L	GYDLUS24T90D-M25R	●	GYM25RA-D12	●	3	
			2.750	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-D12	●	4	
					L	GYDLUS32P90F-M25R	●	GYM25RA-D12	●	4	
				Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-D12	●	3	
					L	GYDLUS32T90F-M25R	●	GYM25RA-D12	●	3	

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

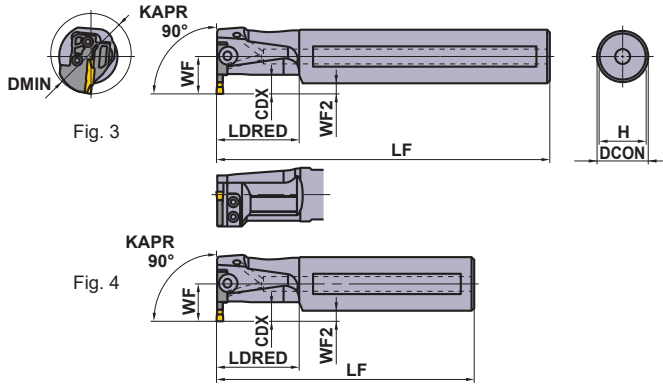
*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw

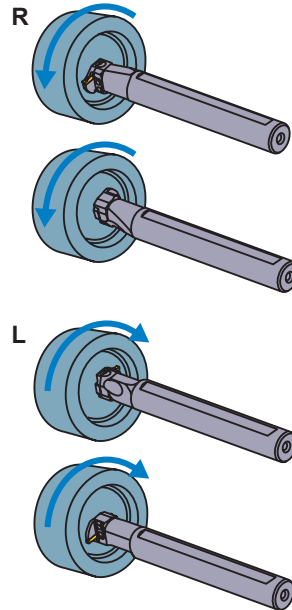


Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/LUS12○90A-○06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/LUS16○90B-○06	—	—	—
GYDR/LUS20○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS24○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) ★2					
	DCON	LF	LDRED	WF	WF2	H
	.750	5.000	1.250	.605	.230	.671
	.750	5.000	1.250	.605	.230	.671
	.750	7.000	1.250	.605	.230	.671
	.750	7.000	1.250	.605	.230	.671
	1.000	5.000	1.500	.730	.230	.921
	1.000	5.000	1.500	.730	.230	.921
	1.000	8.000	1.500	.730	.230	.921
	1.000	8.000	1.500	.730	.230	.921
	1.250	5.500	2.000	.875	.250	1.171
	1.250	5.500	2.000	.875	.250	1.171
	1.250	10.000	2.000	.875	.250	1.171
	1.250	10.000	2.000	.875	.250	1.171
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882



Select an Insert

Seat Size	Insert Number
D	GY○0200/0224D○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
D	.079", 2.00 mm	●	●	●	●	●

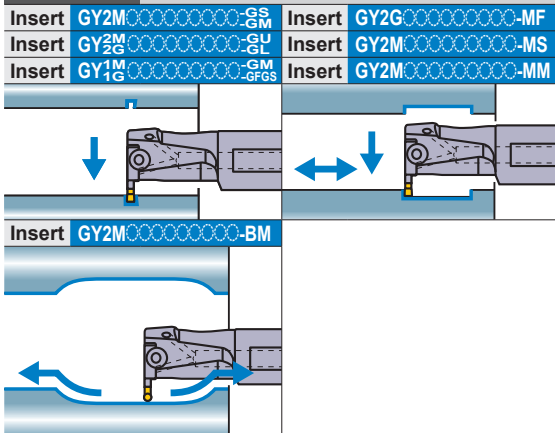
For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F
GROOVING / CUTTING OFF

GY SERIES (INTERNAL GROOVING)

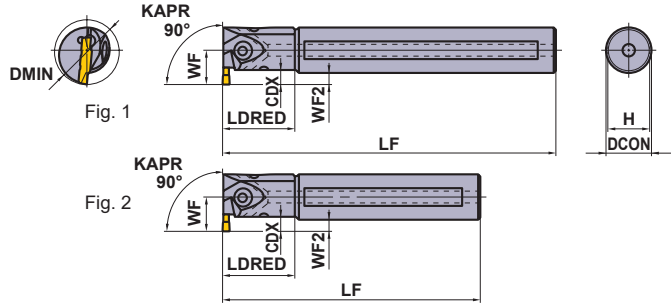
6-1 90° type holder (Inch)



Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

● Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
E	.094 .098 .108	.236	1.000	Mono Block	R	GYARUS12K90A-E06	●	—	—	2
				Mono Block	L	GYALUS12K90A-E06	●	—	—	2
			1.250	Mono Block	R	GYARUS12Q90A-E06	●	—	—	1
				Mono Block	L	GYALUS12Q90A-E06	●	—	—	1
		.157— .374 *1	1.625	Mono Block	R	GYARUS16K90B-E06	●	—	—	2
				Mono Block	L	GYALUS16K90B-E06	●	—	—	2
			2.000	Mono Block	R	GYARUS16R90B-E06	●	—	—	1
				Mono Block	L	GYALUS16R90B-E06	●	—	—	1
		.217— .374 *1	2.500	Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-E10	●	4
				Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-E10	●	4
			2.750	Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-E10	●	3
				Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-E10	●	3
		.276— .453 *1	2.500	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-E10	●	4
				Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-E10	●	4
			2.500	Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-E10	●	3
				Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-E10	●	3
			2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-E12	●	4
				Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-E12	●	4
			2.750	Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-E12	●	3
				Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-E12	●	3
		.276— .453 *1	2.500	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-E12	●	4
				Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-E12	●	4
			2.750	Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-E12	●	3
				Modular	L	GYDLUS32T90F-M25R	●	GYM25RA-E12	●	3

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

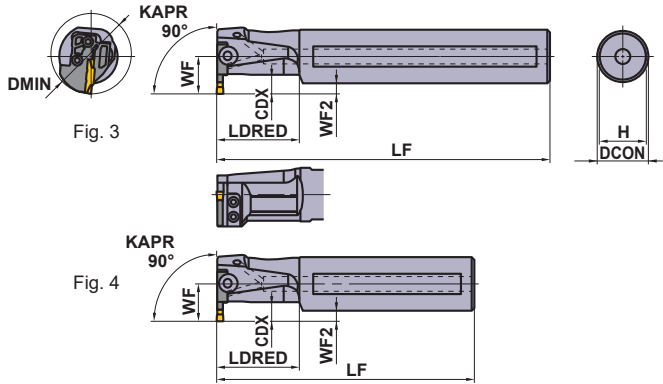
*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw

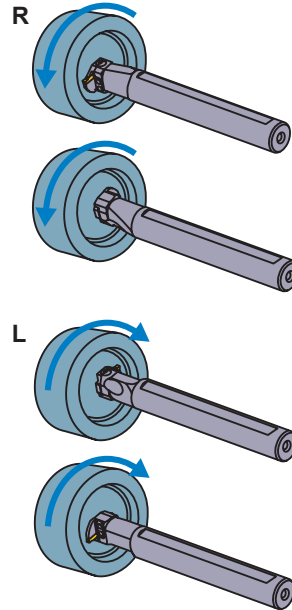


Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/LUS12○90A-○06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/LUS16○90B-○06			
GYDR/LUS20○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24○90D-M20L/R			
GYDR/LUS24○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32○90F-M25L/R			

	Dimensions (inch) *2					
	DCON	LF	LDRED	WF	WF2	H
	.750	5.000	1.250	.605	.230	.671
	.750	5.000	1.250	.605	.230	.671
	.750	7.000	1.250	.605	.230	.671
	.750	7.000	1.250	.605	.230	.671
	1.000	5.000	1.500	.730	.230	.921
	1.000	5.000	1.500	.730	.230	.921
	1.000	8.000	1.500	.730	.230	.921
	1.000	8.000	1.500	.730	.230	.921
	1.250	5.500	2.000	.875	.250	1.171
	1.250	5.500	2.000	.875	.250	1.171
	1.250	10.000	2.000	.875	.250	1.171
	1.250	10.000	2.000	.875	.250	1.171
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882



Select an Insert

Seat Size	Insert Number
E	GY○○○0239/0250/0274E○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker CW	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
E	.094", 2.39 mm .098", 2.50 mm	● ●	● ●	● ●	● ●	● ●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
E	.094", 2.39 mm .098", 2.50 mm .108", 2.74 mm	● ● ●	● ● ●	● ● ●	● ● ●

● : Gauge insert shown dimensions

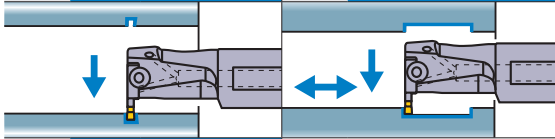
F
GROOVING / CUTTING OFF

GY SERIES (INTERNAL GROOVING)

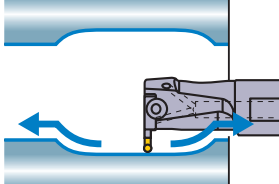
6-1

90° type holder (Inch)

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2G	GU	Insert	GY2M	MS
Insert	GY1G	GFGS	Insert	GY2M	MM



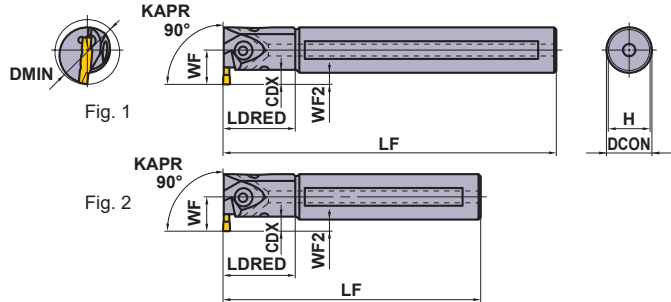
Insert GY2M



Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

● Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	.236	1.000	Mono Block	R	GYARUS12K90A-F06	●	—	—	2
				Mono Block	L	GYALUS12K90A-F06	●	—	—	2
			1.250	Mono Block	R	GYARUS12Q90A-F06	●	—	—	1
				Mono Block	L	GYALUS12Q90A-F06	●	—	—	1
		.157— .374 *1	1.625	Mono Block	R	GYARUS16K90B-F06	●	—	—	2
				Mono Block	L	GYALUS16K90B-F06	●	—	—	2
			2.000	Mono Block	R	GYARUS16R90B-F06	●	—	—	1
				Mono Block	L	GYALUS16R90B-F06	●	—	—	1
		.217— .374 *1	2.500	Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-F10	●	4
				Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-F10	●	4
			2.750	Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-F10	●	3
				Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-F10	●	3
			2.000	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-F10	●	4
				Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-F10	●	4
			2.500	Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-F10	●	3
				Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-F10	●	3
		.276— .453 *1	2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-F12	●	4
				Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-F12	●	4
			2.750	Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-F12	●	3
				Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-F12	●	3
			2.000	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-F12	●	4
				Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-F12	●	4
			2.500	Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-F12	●	3
				Modular	L	GYDLUS32T90F-M25R	●	GYM25RA-F12	●	3
G	.157 .167	.276	1.250	Mono Block	R	GYARUS16K90B-G07	●	—	—	2
				Mono Block	L	GYALUS16K90B-G07	●	—	—	2
			1.625	Mono Block	R	GYARUS16R90B-G07	●	—	—	1
				Mono Block	L	GYALUS16R90B-G07	●	—	—	1
		.197 - .453 *1	2.000	Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-G12	●	4
				Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-G12	●	4
			2.500	Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-G12	●	3
				Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-G12	●	3
		.236 - .453 *1	2.000	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-G12	●	4
				Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-G12	●	4
			2.500	Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-G12	●	3
				Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-G12	●	3
		.295 - .512 *1	2.750	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-G14	●	4
				Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-G14	●	4
			2.500	Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-G14	●	3
				Modular	L	GYDLUS32T90F-M25R	●	GYM25RA-G14	●	3
		.315 - .512 *1	2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-G14	●	4
				Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-G14	●	4
			2.500	Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-G14	●	3
				Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-G14	●	3

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

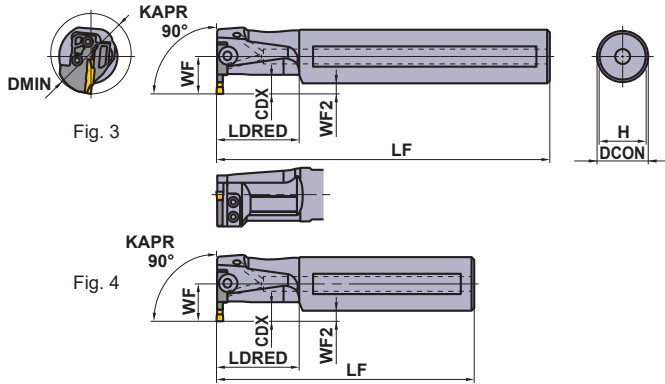
*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw



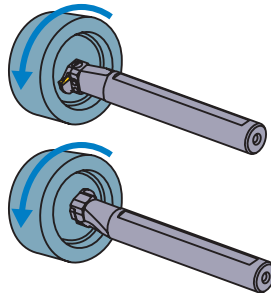
Right hand tool holder shown.

SPARE PARTS

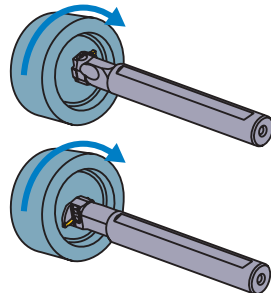
Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/LUS12○90A-F06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/LUS16○90B-○○○	—	—	—
GYDR/LUS20○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS24○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) *2					
	DCON	LF	LDRED	WF	WF2	H
	.750	5.000	1.250	.605	.230	.671
	.750	5.000	1.250	.605	.230	.671
	.750	7.000	1.250	.605	.230	.671
	.750	7.000	1.250	.605	.230	.671
	1.000	5.000	1.500	.730	.230	.921
	1.000	5.000	1.500	.730	.230	.921
	1.000	8.000	1.500	.730	.230	.921
	1.000	8.000	1.500	.730	.230	.921
	1.250	5.500	2.000	.875	.250	1.171
	1.250	5.500	2.000	.875	.250	1.171
	1.250	10.000	2.000	.875	.250	1.171
	1.250	10.000	2.000	.875	.250	1.171
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882
	1.000	5.000	1.500	.730	.230	.921
	1.000	5.000	1.500	.730	.230	.921
	1.000	8.000	1.500	.730	.230	.921
	1.000	8.000	1.500	.730	.230	.921
	1.250	5.500	2.000	.875	.250	1.171
	1.250	5.500	2.000	.875	.250	1.171
	1.250	10.000	2.000	.875	.250	1.171
	1.250	10.000	2.000	.875	.250	1.171
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382

R



L



Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○-Breaker
G	GY○○○0400/0424G○○○-Breaker

		For Grooving/Cutting off > F011, F013				
Seat Size	Breaker CW	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●
G	.157", 4.00 mm	●	●	●	●	●

		For Multifunctional Grooving > F013, F014			
Seat Size	Breaker CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
F	.118", 3.00 mm				Ball nose
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm				●
	RE .008"	●			
G	.128", 3.24 mm	●			
	RE .016"	●	●	●	
	.157", 4.00 mm	●			●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●		●	

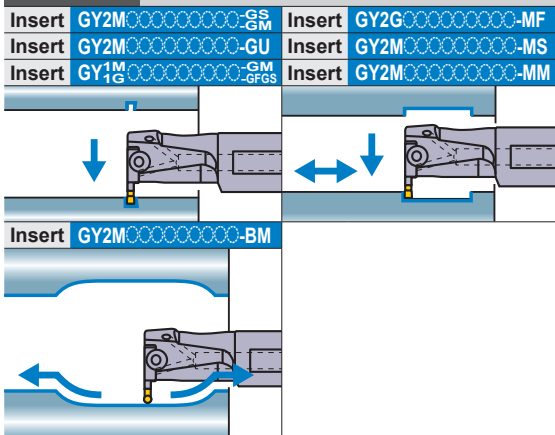
● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F213
INSTRUCTION MANUAL > F215

GROOVING / CUTTING OFF

GY SERIES (INTERNAL GROOVING)

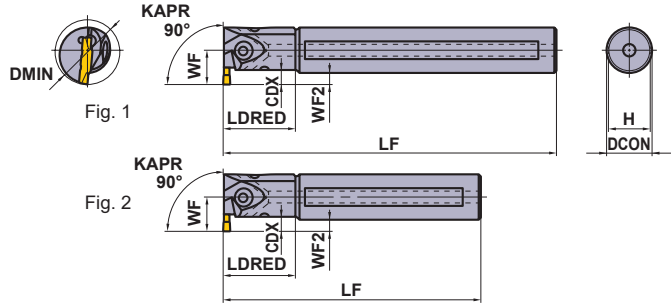
6-1 90° type holder (Inch)



Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

● Mono block type (Air / coolant through)



Right hand tool holder shown.

GROOVING / CUTTING OFF

F

Seat Size	CW (inch)	CDX (inch) *3	DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	.276	1.250	Mono Block	R	GYARUS16K90B-H07	●	—	—	2
				Mono Block	L	GYALUS16K90B-H07	●	—	—	2
		.197 - .453 *1	1.625	Mono Block	R	GYARUS16R90B-H07	●	—	—	1
				Mono Block	L	GYALUS16R90B-H07	●	—	—	1
				Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-H12	●	4
				Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-H12	●	4
				Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-H12	●	3
				Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-H12	●	3
		.236 - .453 *1	2.000	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-H12	●	4
				Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-H12	●	4
				Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-H12	●	3
				Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-H12	●	3
		.295 - .512 *1	2.750	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-H14	●	4
				Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-H14	●	4
				Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-H14	●	3
				Modular	L	GYDLUS32T90F-M25R	●	GYM25RA-H14	●	3
J	.236 .248 .250	.295 - .512 *1	2.750	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-H14	●	4
				Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-H14	●	4
				Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-J14	●	4
				Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-J14	●	4
		.315 - .512 *1	2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-H14	●	3
				Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-H14	●	3
				Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-H14	●	3
				Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-H14	●	3

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

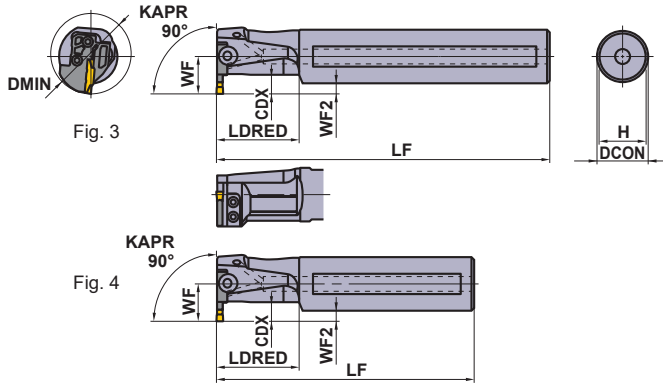
*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw



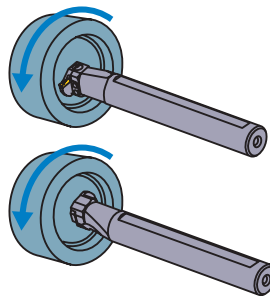
Right hand tool holder shown.

SPARE PARTS

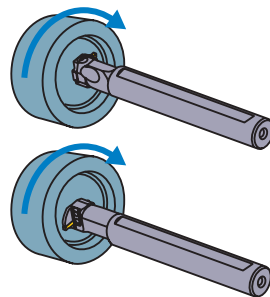
Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/LUS16○90B○07	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYDR/LUS20○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) *2					
	DCON	LF	LDRED	WF	WF2	H
	1.000	5.000	1.500	.730	.230	.921
	1.000	5.000	1.500	.730	.230	.921
	1.000	8.000	1.500	.730	.230	.921
	1.000	8.000	1.500	.730	.230	.921
	1.250	5.500	2.000	.875	.250	1.171
	1.250	5.500	2.000	.875	.250	1.171
	1.250	10.000	2.000	.875	.250	1.171
	1.250	10.000	2.000	.875	.250	1.171
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	6.750	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882
	2.000	12.000	3.250	1.250	.250	1.882
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	6.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382
	1.500	12.000	2.500	1.125	.375	1.382

R



L



Select an Insert

Seat Size	Insert Number
H	GY○0475/0500/0524H○-Breaker
J	GY○0600/0631/0635J○-Breaker

		> F011, F013				
Seat Size	CW	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	.187", 4.75 mm	●	●	●	●	●
	.197", 5.00 mm	●	●	●	●	●
	.236", 6.00 mm	●	●	●	●	●
J	.250", 6.35 mm	●	●	●	●	●

		> F013, F014				
Seat Size	CW	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing) Ball nose
H	.187", 4.75 mm	●	●	●	●	●
	RE .008"	●	●	●	●	●
	RE .016"	●	●	●	●	●
	RE .031"	●	●	●	●	●
	.197", 5.00 mm	●	●	●	●	●
	RE .008"	●	●	●	●	●
J	.206", 5.24 mm	●	●	●	●	●
	RE .008"	●	●	●	●	●
	RE .016"	●	●	●	●	●
	RE .031"	●	●	●	●	●
	.248", 6.31 mm	●	●	●	●	●
	RE .008"	●	●	●	●	●
J	.250", 6.35 mm	●	●	●	●	●
	RE .016"	●	●	●	●	●
	RE .031"	●	●	●	●	●

● : Gauge insert shown dimensions

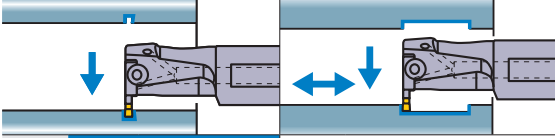
F

GROOVING / CUTTING OFF

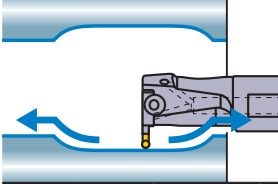
GY SERIES (INTERNAL GROOVING)

6-2 90° type holder (Metric)

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2G	GU	Insert	GY2M	MS
Insert	GY1G	GM	Insert	GY2M	MM



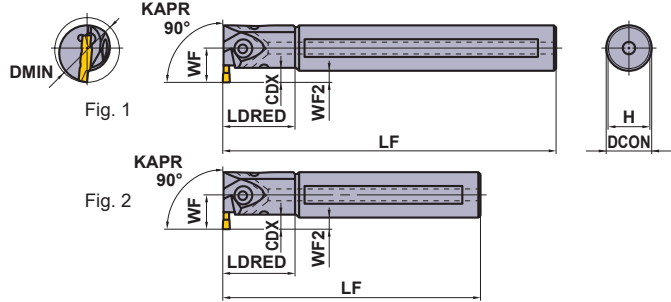
Insert GY2M



Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

● Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	6	25	Mono Block	R	GYAR20K90A-D06	●	—	—	2
				Mono Block	L	GYAL20K90A-D06	●	—	—	2
			32	Mono Block	R	GYAR20Q90A-D06	●	—	—	1
				Mono Block	L	GYAL20Q90A-D06	●	—	—	1
				Mono Block	R	GYAR25K90B-D06	●	—	—	2
				Mono Block	L	GYAL25K90B-D06	●	—	—	2
			40	Mono Block	R	GYAR25R90B-D06	●	—	—	1
				Mono Block	L	GYAL25R90B-D06	●	—	—	1
		4—9.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-D10	●	4
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-D10	●	4
			50	Modular	R	GYDR32S90C-M20L	●	GYM20LA-D10	●	3
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-D10	●	3
		5.5—9.5 *1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-D10	●	4
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-D10	●	4
			60	Modular	R	GYDR40T90D-M20L	●	GYM20LA-D10	●	3
				Modular	L	GYDL40T90D-M20R	●	GYM20RA-D10	●	3
			70	Modular	R	GYDR40M90D-M25L	●	GYM25LA-D12	●	4
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-D12	●	4
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-D12	●	3
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-D12	●	3
		7—11.5 *1	60	Modular	R	GYDR50P90F-M25L	●	GYM25LA-D12	●	4
				Modular	L	GYDL50P90F-M25R	●	GYM25RA-D12	●	4
			70	Modular	R	GYDR50T90F-M25L	●	GYM25LA-D12	●	3
				Modular	L	GYDL50T90F-M25R	●	GYM25RA-D12	●	3

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

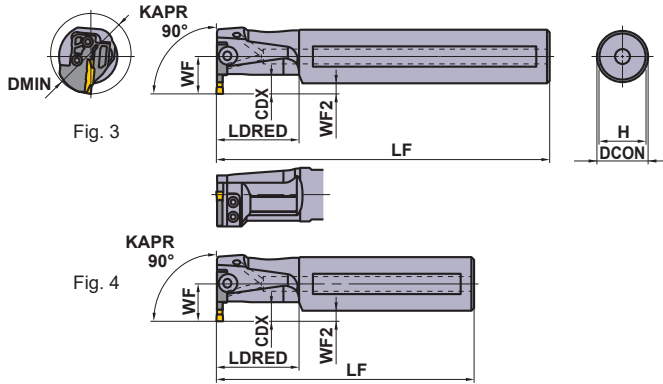
*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/L20-90A-006	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/L25-90B-006	—	—	—
GYDR/L32-90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40-90D-M20L/R	—	—	—
GYDR/L40-90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L50-90F-M25L/R	—	—	—

	Dimensions (mm) *2						Cutting Mode
	DCON	LF	LDRED	WF	WF2	H	
	20	125	30	14.5	4.5	18	R
	20	125	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	25	125	40	19.0	6.5	23	
	25	125	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	
	32	140	50	22.0	6.0	30	
	32	140	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	40	150	60	28.0	8.0	37	L
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	50	170	80	34.0	9.0	47	
	50	170	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	

Select an Insert

Seat Size	Insert Number
D	GY-0200/0224D-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
D	.079", 2.00 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

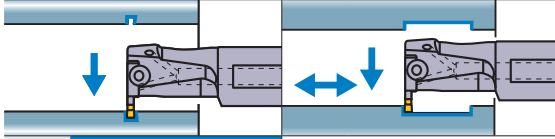
GROOVING / CUTTING OFF

IDENTIFICATION	> F008, F009
CUTTING CONDITIONS	> F213
INSTRUCTION MANUAL	> F215

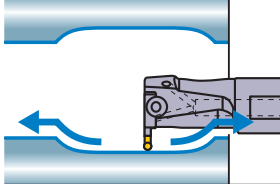
GY SERIES (INTERNAL GROOVING)

6-2 90° type holder (Metric)

Insert	GY2M	GS _{GM}	Insert	GY2G	MF
Insert	GY2G	GU _{GL}	Insert	GY2M	MS
Insert	GY1G	GM _{GFS}	Insert	GY2M	MM



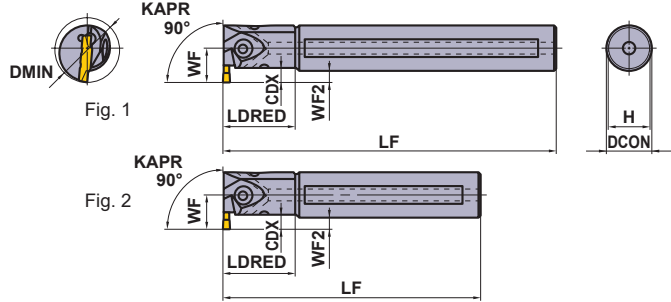
Insert GY2M



Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

● Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm) *3	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	6	25	Mono Block	R	GYAR20K90A-E06	●	—	—	2
				Mono Block	L	GYAL20K90A-E06	●	—	—	2
			32	Mono Block	R	GYAR20Q90A-E06	●	—	—	1
				Mono Block	L	GYAL20Q90A-E06	●	—	—	1
				Mono Block	R	GYAR25K90B-E06	●	—	—	2
				Mono Block	L	GYAL25K90B-E06	●	—	—	2
		4—9.5 *1	40	Mono Block	R	GYAR25R90B-E06	●	—	—	1
				Mono Block	L	GYAL25R90B-E06	●	—	—	1
				Modular	R	GYDR32L90C-M20L	●	GYM20LA-E10	●	4
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-E10	●	4
		5.5—9.5 *1	50	Modular	R	GYDR32S90C-M20L	●	GYM20LA-E10	●	3
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-E10	●	3
				Modular	R	GYDR40M90D-M20L	●	GYM20LA-E10	●	4
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-E10	●	4
			60	Modular	R	GYDR40T90D-M20L	●	GYM20LA-E10	●	3
				Modular	L	GYDL40T90D-M20R	●	GYM20RA-E10	●	3
		7—11.5 *1	70	Modular	R	GYDR40M90D-M25L	●	GYM25LA-E12	●	4
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-E12	●	4
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-E12	●	3
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-E12	●	3
			70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-E12	●	4
				Modular	L	GYDL50P90F-M25R	●	GYM25RA-E12	●	4
			70	Modular	R	GYDR50T90F-M25L	●	GYM25LA-E12	●	3
				Modular	L	GYDL50T90F-M25R	●	GYM25RA-E12	●	3

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

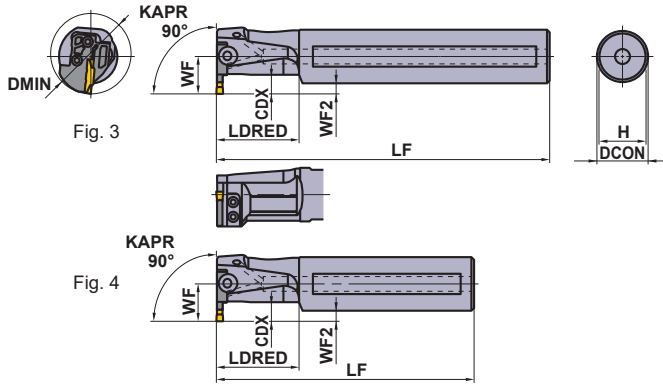
*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/L20-90A-006	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/L25-90B-006	—	—	—
GYDR/L32-90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40-90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L40-90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L50-90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *2						Cutting Mode
	DCON	LF	LDRED	WF	WF2	H	
	20	125	30	14.5	4.5	18	R
	20	125	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	25	125	40	19.0	6.5	23	
	25	125	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	L
	25	200	40	19.0	6.5	23	
	32	140	50	22.0	6.0	30	
	32	140	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	40	150	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	50	170	80	34.0	9.0	47	
	50	170	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	

Select an Insert

Seat Size	Insert Number
E	GY-0239/0250/0274E-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
E	CW					
	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
E	CW				
	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●	●	●	●

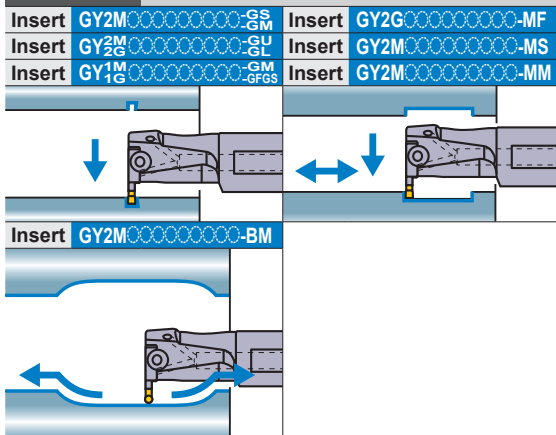
● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

GY SERIES (INTERNAL GROOVING)

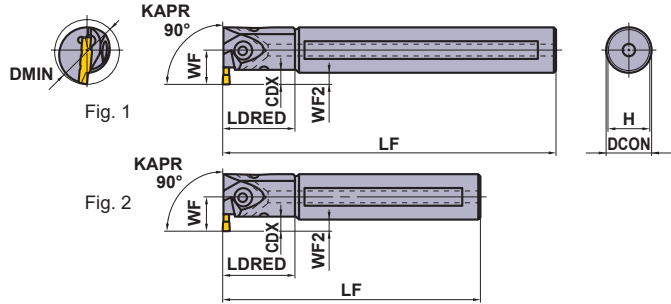
6-2 90° type holder (Metric)



Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

● Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	6	25	Mono Block	R	GYAR20K90A-F06	●	—	—	2
				Mono Block	L	GYAL20K90A-F06	●	—	—	2
			32	Mono Block	R	GYAR20Q90A-F06	●	—	—	1
				Mono Block	L	GYAL20Q90A-F06	●	—	—	1
		4—9.5 *1	40	Mono Block	R	GYAR25K90B-F06	●	—	—	2
				Mono Block	L	GYAL25K90B-F06	●	—	—	2
			50	Mono Block	R	GYAR25R90B-F06	●	—	—	1
				Mono Block	L	GYAL25R90B-F06	●	—	—	1
		5.5—9.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-F10	●	4
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-F10	●	4
			50	Modular	R	GYDR32S90C-M20L	●	GYM20LA-F10	●	3
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-F10	●	3
			60	Modular	R	GYDR40M90D-M20L	●	GYM20LA-F10	●	4
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-F10	●	4
			70	Modular	R	GYDR40T90D-M20L	●	GYM20LA-F10	●	3
				Modular	L	GYDL40T90D-M20R	●	GYM20RA-F10	●	3
		7—11.5 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-F12	●	4
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-F12	●	4
			70	Modular	R	GYDR40T90D-M25L	●	GYM25LA-F12	●	3
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-F12	●	3
G	4.00 4.24	7	32	Mono Block	R	GYAR25K90B-G07	●	—	—	2
				Mono Block	L	GYAL25K90B-G07	●	—	—	2
			40	Mono Block	R	GYAR25R90B-G07	●	—	—	1
				Mono Block	L	GYAL25R90B-G07	●	—	—	1
		4.5—11.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-G12	●	4
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-G12	●	4
			50	Modular	R	GYDR32S90C-M20L	●	GYM20LA-G12	●	3
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-G12	●	3
		6—11.5 *1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-G12	●	4
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-G12	●	4
			60	Modular	R	GYDR40T90D-M20L	●	GYM20LA-G12	●	3
				Modular	L	GYDL40T90D-M20R	●	GYM20RA-G12	●	3
		7.5—13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-G14	●	4
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-G14	●	4
			70	Modular	R	GYDR40T90D-M25L	●	GYM25LA-G14	●	3
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-G14	●	3

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

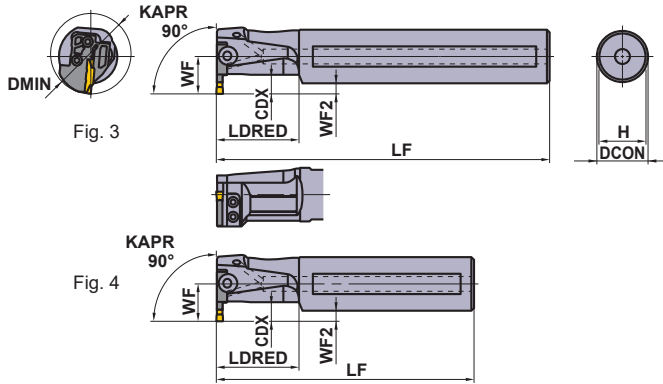
*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw



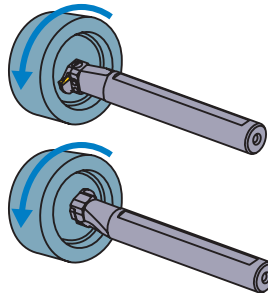
Right hand tool holder shown.

SPARE PARTS

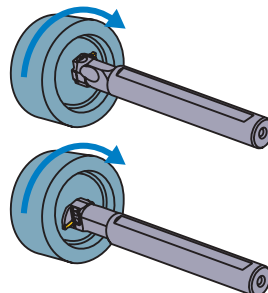
Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/L20○90A-F06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/L25○90B-○○○	—	—	—
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L40○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L50○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *2					
	DCON	LF	LDRED	WF	WF2	H
	20	125	30	14.5	4.5	18
	20	125	30	14.5	4.5	18
	20	180	30	14.5	4.5	18
	20	180	30	14.5	4.5	18
	25	125	40	19.0	6.5	23
	25	125	40	19.0	6.5	23
	25	200	40	19.0	6.5	23
	25	200	40	19.0	6.5	23
	32	140	50	22.0	6.0	30
	32	140	50	22.0	6.0	30
	32	250	50	22.0	6.0	30
	32	250	50	22.0	6.0	30
	40	150	60	28.0	8.0	37
	40	150	60	28.0	8.0	37
	40	300	60	28.0	8.0	37
	40	300	60	28.0	8.0	37
	40	150	60	28.0	8.0	37
	40	150	60	28.0	8.0	37
	40	300	60	28.0	8.0	37
	40	300	60	28.0	8.0	37
	50	170	80	34.0	9.0	47
	50	170	80	34.0	9.0	47
	50	300	80	34.0	9.0	47
	50	300	80	34.0	9.0	47
	25	125	40	19.0	6.5	23
	25	125	40	19.0	6.5	23
	25	200	40	19.0	6.5	23
	25	200	40	19.0	6.5	23
	32	140	50	22.0	6.0	30
	32	140	50	22.0	6.0	30
	32	250	50	22.0	6.0	30
	32	250	50	22.0	6.0	30
	40	150	60	28.0	8.0	37
	40	150	60	28.0	8.0	37
	40	300	60	28.0	8.0	37
	40	300	60	28.0	8.0	37
	40	150	60	28.0	8.0	37
	40	150	60	28.0	8.0	37
	40	300	60	28.0	8.0	37
	40	300	60	28.0	8.0	37
	50	170	80	34.0	9.0	47
	50	170	80	34.0	9.0	47
	50	300	80	34.0	9.0	47
	50	300	80	34.0	9.0	47

R



L



Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○-Breaker
G	GY○○○0400/0424G○○○-Breaker

		F011, F013				
Seat Size	Breaker CW	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●
G	.157", 4.00 mm	●	●	●	●	●

		F013, F014			
Seat Size	Breaker CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
F	.118", 3.00 mm				Ball nose
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm			●	
	.125", 3.18 mm				●
	RE 0.2 mm	●	●	●	
G	.128", 3.24 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.157", 4.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	

● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F213
INSTRUCTION MANUAL > F215

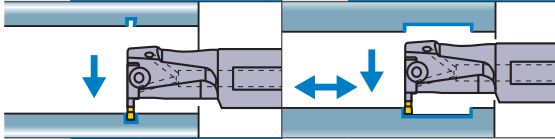
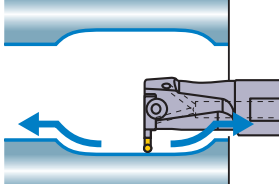
GROOVING / CUTTING OFF

GY SERIES (INTERNAL GROOVING)

6-2

90° type holder (Metric)

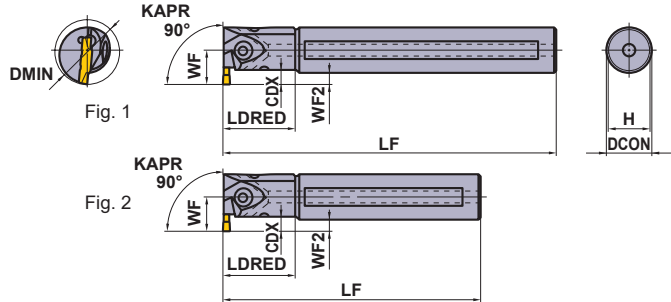
Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM}	Insert	GY2M ^{MM}

Insert GY2M^{BM}

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

● Mono block type (Air / coolant through)



Right hand tool holder shown.

GROOVING / CUTTING OFF

F

Seat Size	CW (mm)	CDX (mm)	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	7	32	Mono Block	R	GYAR25K90B-H07	●	—	—	2
				Mono Block	L	GYAL25K90B-H07	●	—	—	2
			40	Mono Block	R	GYAR25R90B-H07	●	—	—	1
				Mono Block	L	GYAL25R90B-H07	●	—	—	1
		4.5—11.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-H12	●	4
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-H12	●	4
			50	Modular	R	GYDR32S90C-M20L	●	GYM20LA-H12	●	3
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-H12	●	3
		6—11.5 *1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-H12	●	4
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-H12	●	4
			60	Modular	R	GYDR40T90D-M20L	●	GYM20LA-H12	●	3
				Modular	L	GYDL40T90D-M20R	●	GYM20RA-H12	●	3
		7.5—13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-H14	●	4
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-H14	●	4
			70	Modular	R	GYDR40T90D-M25L	●	GYM25LA-H14	●	3
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-H14	●	3
J	6.00 6.31 6.35	7.5—13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-J14	●	4
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-J14	●	4
			70	Modular	R	GYDR40T90D-M25L	●	GYM25LA-J14	●	3
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-J14	●	3
			60	Modular	R	GYDR50P90F-M25L	●	GYM25LA-J14	●	4
				Modular	L	GYDL50P90F-M25R	●	GYM25RA-J14	●	4
			70	Modular	R	GYDR50T90F-M25L	●	GYM25LA-J14	●	3
				Modular	L	GYDL50T90F-M25R	●	GYM25RA-J14	●	3

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

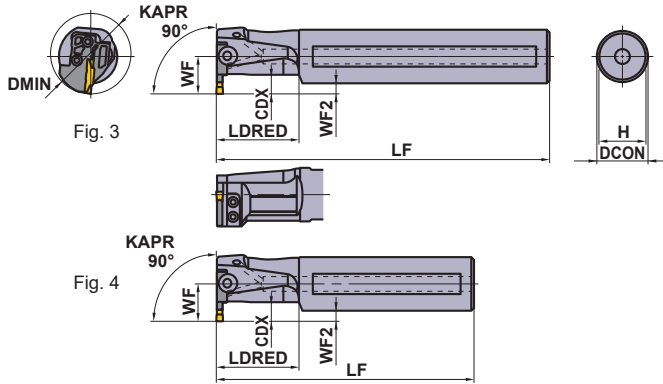
*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw



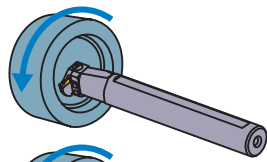
Right hand tool holder shown.

SPARE PARTS

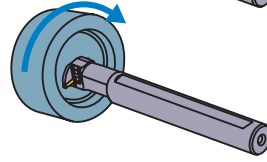
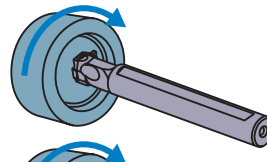
Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/L25○90B-○07	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L40○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L50○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *2						Cutting Mode
	DCON	LF	LDRED	WF	WF2	H	
	25	125	40	19	6.5	23	R
	25	125	40	19	6.5	23	
	25	200	40	19	6.5	23	
	25	200	40	19	6.5	23	
	32	140	50	22	6.0	30	
	32	140	50	22	6.0	30	
	32	250	50	22	6.0	30	
	32	250	50	22	6.0	30	
	40	150	60	28	8.0	37	
	40	150	60	28	8.0	37	
	40	300	60	28	8.0	37	L
	40	300	60	28	8.0	37	
	40	150	60	28	8.0	37	
	40	150	60	28	8.0	37	
	40	300	60	28	8.0	37	
	40	300	60	28	8.0	37	
	40	150	60	28	8.0	37	
	40	150	60	28	8.0	37	
	40	300	60	28	8.0	37	
	40	300	60	28	8.0	37	
	50	170	80	34	9.0	47	F
	50	170	80	34	9.0	47	
	50	300	80	34	9.0	47	
	50	300	80	34	9.0	47	
	40	150	60	28	8.0	37	
	40	150	60	28	8.0	37	
	40	300	60	28	8.0	37	
	40	300	60	28	8.0	37	
	50	170	80	34	9.0	47	
	50	170	80	34	9.0	47	
	50	300	80	34	9.0	47	F
	50	300	80	34	9.0	47	
	50	300	80	34	9.0	47	
	50	300	80	34	9.0	47	

R



L



Select an Insert

Seat Size	Insert Number
H	GY○0475/0500/0524H○-Breaker
J	GY○0600/0631/0635J○-Breaker

For Grooving/Cutting off		> F011, F013			
Seat Size	Breaker CW	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●
J	.236", 6.00 mm	●	●	●	●
	.250", 6.35 mm	●	●	●	●

For Multifunctional Grooving		> F013, F014				
Seat Size	Breaker CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)	Ball nose
H	.187", 4.75 mm	●				●
	RE 0.2 mm	●				
	RE 0.4 mm	●				
	RE 0.8 mm	●				
	.197", 5.00 mm	●				●
	RE 0.2 mm	●				
J	RE 0.4 mm	●	●	●		
	RE 0.8 mm	●	●	●		
	.206", 5.24 mm	●				
	.236", 6.00 mm	●				●
	RE 0.2 mm	●				
	RE 0.4 mm	●				
J	RE 0.8 mm	●				
	.248", 6.31 mm	●				
	.250", 6.35 mm	●				●
	RE 0.2 mm	●				
J	RE 0.4 mm	●				
	RE 0.8 mm	●				

● : Gauge insert shown dimensions

GY SERIES (EXTERNAL GROOVING PSC TYPE)

7-1

00° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

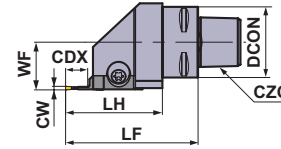
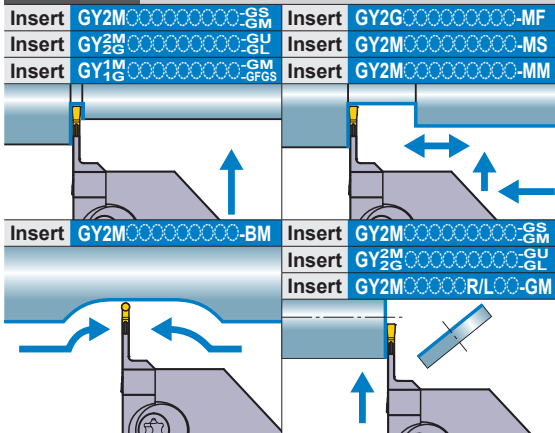


Fig. 1

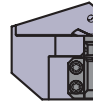
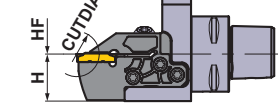
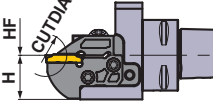


Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
D	.079 .088	.236	.472	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-D06	●	1	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-D06	●	1	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-D06	●	1	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-D06	●	1	
		.394	.787	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-D06	●	1	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-D06	●	1	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-D06	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-D06	●	1	
		.472	.945	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-D10	●	1	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-D10	●	1	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-D12	●	1	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-D12	●	1	
		.709 ^{*4}	1.417	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-D12	●	1	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-D12	●	1	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-D12	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-D12	●	1	
		.787 ^{*1}	1.575 ^{*2}	Modular	R	C3-GYHRDX00-M20R	●	GYM20RB-D18	●	2	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LB-D18	●	2	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-D20	●	2	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-D20	●	2	
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-D20	●	2	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-D20	●	2	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-D20	●	2	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-D20	●	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 F011 to F015.

*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 F011 to F015.

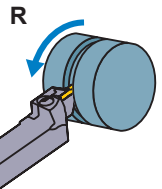
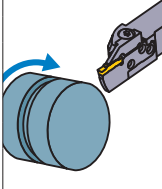
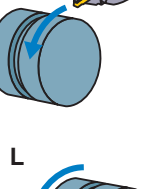
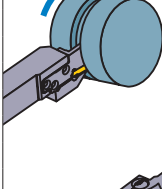
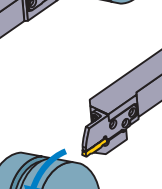
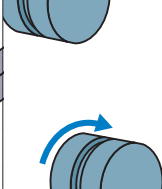
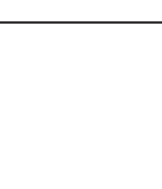
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) ★3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.260	2.323	1.724	.866	0	.787		
	1.260	2.323	1.724	.866	0	.787		
	1.575	2.638	1.843	1.063	0	.984		
	1.575	2.638	1.843	1.063	0	.984		
	1.969	2.638	1.843	1.378	0	1.063		
	1.969	2.638	1.843	1.378	0	1.063		
	2.480	2.835	1.961	1.772	0	1.378		
	2.480	2.835	1.961	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.260	2.795	2.197	.866	0	.787		
	1.260	2.795	2.197	.866	0	.787		
	1.575	3.189	2.394	1.063	0	.984		
	1.575	3.189	2.394	1.063	0	.984		
	1.969	3.189	2.394	1.378	0	1.063		
	1.969	3.189	2.394	1.378	0	1.063		
	2.480	3.386	2.512	1.772	0	1.378		
	2.480	3.386	2.512	1.772	0	1.378		

Select an Insert

Seat Size	Insert Number
D	GY○○0200/0224D○○○-Breaker

For Grooving/Cutting off ➤ F011, F013						
Seat Size	Breaker CW	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●

For Cutting off					> F012
Seat Size	Breaker CW	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
		R	R	R	R/L
D	.079", 2.00 mm		●	●	●

For Multifunctional Grooving					> F013, F014
Seat Size	Breaker CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088" 2.24 mm	●			

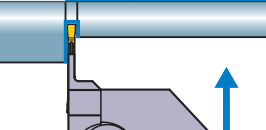
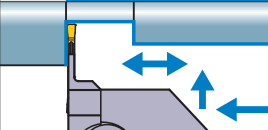
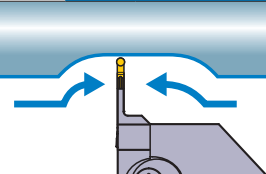
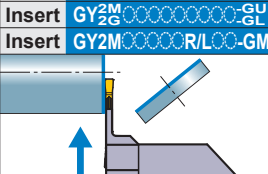
● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

7-1

Note 1) For modular blades and holders, please order separately.

Insert GY2M  GS GM Insert GY2^M_{2G}  GU GL Insert GY1^M_{1G}  GM GFGS 	Insert GY2G  MF Insert GY2M  MS Insert GY2M  MM 
Insert GY2M  BM 	Insert GY2M  GS GM Insert GY2^M_{2G}  GU GL Insert GY2M  R/L GM GM 

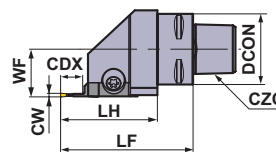


Fig. 1

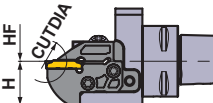
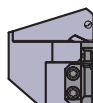
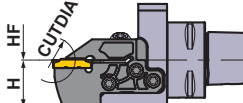


Fig. 2



Right hand tool holder shown.

[illegible]

*1 The maximum groove depth (**CDX**) varies according to the insert used. Please refer to the maximum groove depth (**CDX**) of inserts on pages F011 to F015.

*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 F011 to F015.

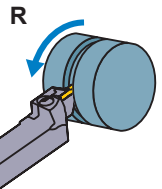
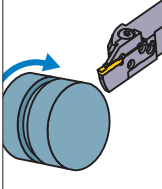
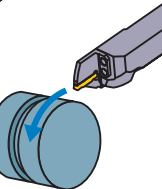
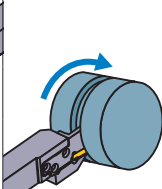
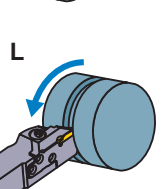
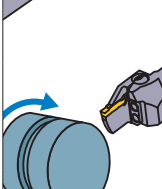
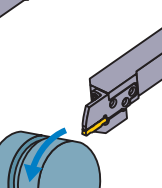
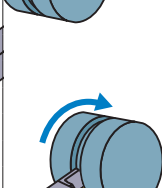
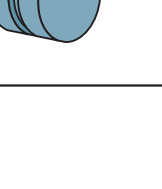
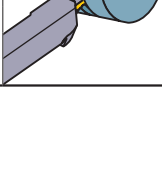
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH** and **LH 2** values may vary.

*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
C3-GYHR/LDX00-M20R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) ★3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.260	2.323	1.724	.866	0	.787		
	1.260	2.323	1.724	.866	0	.787		
	1.575	2.638	1.843	1.063	0	.984		
	1.575	2.638	1.843	1.063	0	.984		
	1.969	2.638	1.843	1.378	0	1.063		
	1.969	2.638	1.843	1.378	0	1.063		
	2.480	2.835	1.961	1.772	0	1.378		
	2.480	2.835	1.961	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.260	2.795	2.197	.866	0	.787		
	1.260	2.795	2.197	.866	0	.787		
	1.575	3.189	2.394	1.063	0	.984		
	1.575	3.189	2.394	1.063	0	.984		
	1.969	3.189	2.394	1.378	0	1.063		
	1.969	3.189	2.394	1.378	0	1.063		
	2.480	3.386	2.512	1.772	0	1.378		
	2.480	3.386	2.512	1.772	0	1.378		

Select an Insert

Seat Size	Insert Number
E	GY○○○0239/0250/0274E○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
E	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
CW	R	R	R	R	R/L
E	.098", 2.50 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW	Ball nose				
E	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

GY SERIES (EXTERNAL GROOVING PSC TYPE)

7-1

00° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

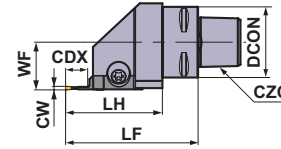
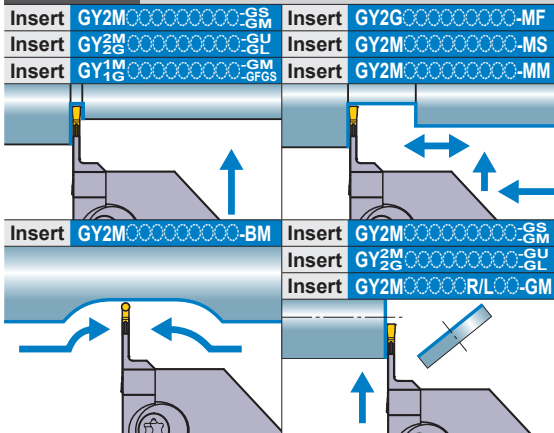


Fig. 1

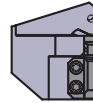
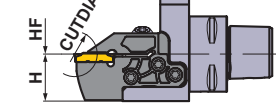


Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
F	.118 .125 .128	.236	.472	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-F06	●	1	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-F06	●	1	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-F06	●	1	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-F06	●	1	
		.394	.787	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-F06	●	1	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-F06	●	1	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-F06	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-F06	●	1	
		.472	.945	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-F10	●	1	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-F10	●	1	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-F12	●	1	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-F12	●	1	
		.709 ^{*4}	1.417	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-F12	●	1	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-F12	●	1	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-F12	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-F12	●	1	
		.787 ^{*1}	1.575 ^{*2}	Modular	R	C3-GYHRDX00-M20R	●	GYM20RB-F18	●	2	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LB-F18	●	2	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-F20	●	2	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-F20	●	2	
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-F20	●	2	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-F20	●	2	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-F20	●	2	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-F20	●	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 F011 to F015.

*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 F011 to F015.

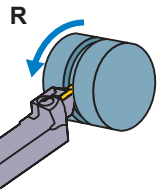
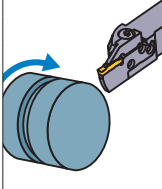
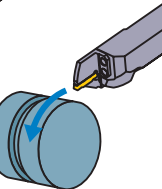
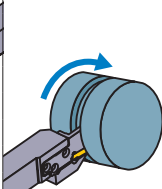
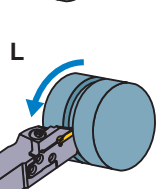
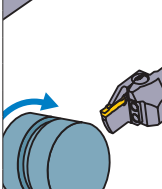
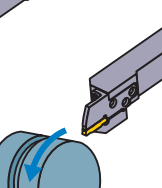
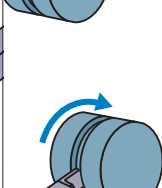
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) ★3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.260	2.323	1.724	.866	0	.787		
	1.260	2.323	1.724	.866	0	.787		
	1.575	2.638	1.843	1.063	0	.984		
	1.575	2.638	1.843	1.063	0	.984		
	1.969	2.638	1.843	1.378	0	1.063		
	1.969	2.638	1.843	1.378	0	1.063		
	2.480	2.835	1.961	1.772	0	1.378		
	2.480	2.835	1.961	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.260	2.795	2.197	.866	0	.787		
	1.260	2.795	2.197	.866	0	.787		
	1.575	3.189	2.394	1.063	0	.984		
	1.575	3.189	2.394	1.063	0	.984		
	1.969	3.189	2.394	1.378	0	1.063		
	1.969	3.189	2.394	1.378	0	1.063		
	2.480	3.386	2.512	1.772	0	1.378		
	2.480	3.386	2.512	1.772	0	1.378		

Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
	CW	R	R	R	R/L
F	.118", 3.00 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
	CW				Ball nose
F	.118", 3.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F010
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

F173

GY SERIES (EXTERNAL GROOVING PSC TYPE)

7-1

00° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

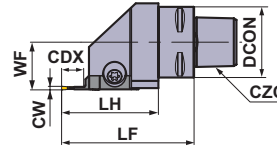
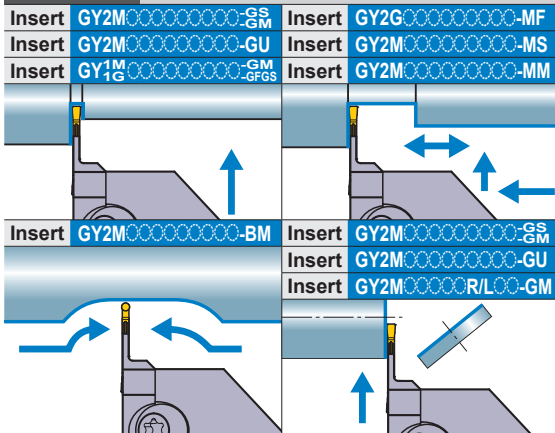


Fig. 1

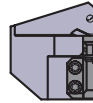
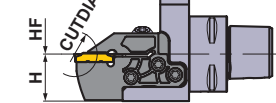


Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
G	.157 .167	.315	.630	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-G08	●	1	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-G08	●	1	
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-G08	●	1	C5
		.472	.945	Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-G08	●	1	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-G08	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-G08	●	1	
		.551	1.102	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-G12	●	1	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-G12	●	1	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-G14	●	1	C4
		.984*1	1.969*2	Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-G14	●	1	
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-G14	●	1	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-G14	●	1	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-G14	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-G14	●	1	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-G25	●	2	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-G25	●	2	
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-G25	●	2	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-G25	●	2	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-G25	●	2	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-G25	●	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 F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

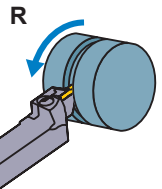
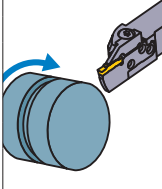
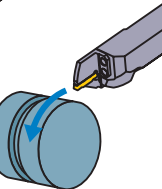
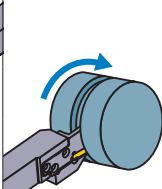
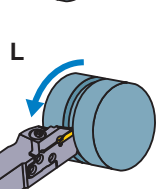
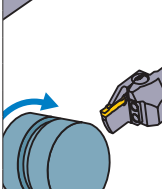
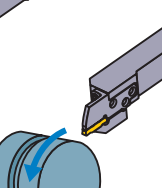
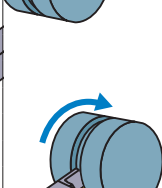
*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L		GY06013M (Clamp Torque : 53 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) ★3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.575	2.717	1.921	1.063	0	.984		
	1.575	2.717	1.921	1.063	0	.984		
	1.969	2.717	1.921	1.378	0	1.063		
	1.969	2.717	1.921	1.378	0	1.063		
	2.480	2.913	2.039	1.772	0	1.378		
	2.480	2.913	2.039	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.575	3.386	2.591	1.063	0	.984		
	1.575	3.386	2.591	1.063	0	.984		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	2.480	3.583	2.709	1.772	0	1.378		
	2.480	3.583	2.709	1.772	0	1.378		

Select an Insert

Seat Size	Insert Number
G	GY○○0400/0424G○○○○○-Breaker

For Grooving/Cutting off > F011-F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS 05-GM (Hardened steel) (Cutting off)
	CW	Neutral	Neutral	Neutral	Hand
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
	CW			BM (Copying, Recessing)
G	.157", 4.00 mm	●	●	●
	RE .008"	●	●	●
	RE .016"	●	●	●
	RE .031"	●	●	●
	.167", 4.24 mm	●		

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F010
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

F175

GY SERIES (EXTERNAL GROOVING PSC TYPE)

7-1

00° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

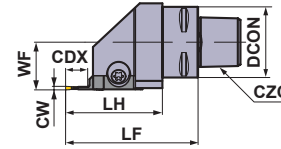
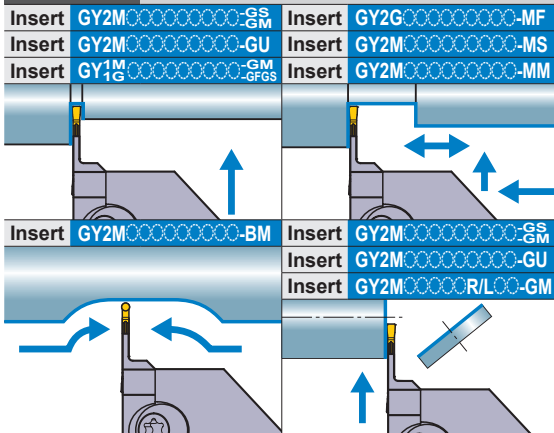
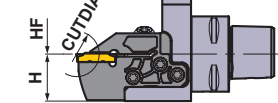
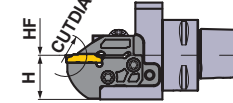
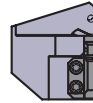


Fig. 1

Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
H	.187 .197 .206	.315	.630	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-H08	●	1	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-H08	●	1	
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-H08	●	1	C5
		.472	.945	Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-H08	●	1	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-H08	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-H08	●	1	
		.551	1.102	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-H12	●	1	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-H12	●	1	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-H14	●	1	C4
		.984*1	1.969*2	Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-H14	●	1	
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-H14	●	1	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-H14	●	1	
J	.236 .248 .250	.315	.630	Modular	R	C6-GYHRF00-M25R	●	GYM25RA-H14	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-H14	●	1	
		.551	1.102	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-H25	●	2	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-H25	●	2	
		.984*1	1.969*2	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-H25	●	2	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-H25	●	2	
		.236	.630	Modular	R	C6-GYHRF00-M25R	●	GYM25RA-H25	●	2	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-H25	●	2	
		.248	1.102	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-J08	●	1	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-J08	●	1	
		.250	1.102	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-J08	●	1	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-J08	●	1	
		.315	.630	Modular	R	C6-GYHRF00-M25R	●	GYM25RA-J08	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-J08	●	1	
		.551	1.102	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-J14	●	1	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-J14	●	1	
		.984*1	1.969*2	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-J14	●	1	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-J14	●	1	
		.236	.630	Modular	R	C6-GYHRF00-M25R	●	GYM25RA-J14	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-J14	●	1	
		.248	1.102	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-J25	●	2	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-J25	●	2	
		.250	1.102	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-J25	●	2	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-J25	●	2	
		.984*1	1.969*2	Modular	R	C6-GYHRF00-M25R	●	GYM25RA-J25	●	2	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-J25	●	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 F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

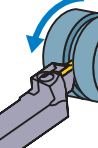
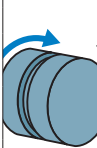
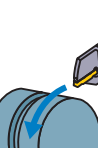
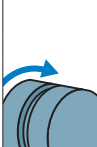
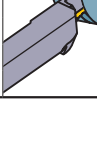
*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LDX00-M20R/L	 GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.575	2.717	1.921	1.063	0	.984		
	1.575	2.717	1.921	1.063	0	.984		
	1.969	2.717	1.921	1.378	0	1.063		
	1.969	2.717	1.921	1.378	0	1.063		
	2.480	2.913	2.039	1.772	0	1.378		
	2.480	2.913	2.039	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.575	3.386	2.591	1.063	0	.984		
	1.575	3.386	2.591	1.063	0	.984		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	2.480	3.583	2.709	1.772	0	1.378		
	2.480	3.583	2.709	1.772	0	1.378		
	1.575	2.717	1.921	1.063	0	.984		
	1.575	2.717	1.921	1.063	0	.984		
	1.969	2.717	1.921	1.378	0	1.063		
	1.969	2.717	1.921	1.378	0	1.063		
	2.480	2.913	2.039	1.772	0	1.378		
	2.480	2.913	2.039	1.772	0	1.378		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.575	3.386	2.591	1.063	0	.984		
	1.575	3.386	2.591	1.063	0	.984		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	2.480	3.583	2.709	1.772	0	1.378		
	2.480	3.583	2.709	1.772	0	1.378		

Select an Insert

Seat Size	Insert Number
H	GY000475/0500/0524H0000-Breaker
J	GY000600/0631/0635J0000-Breaker

For Grooving/Cutting off > F011-F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)	05-GM (Cutting off)
		Neutral	Neutral	Neutral	Neutral	Hand
H	.187", 4.75 mm	●	●	●	●	●
	.197", 5.00 mm	●	●	●	●	●
J	.236", 6.00 mm	●	●	●	●	●
	.250", 6.35 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
					Ball nose
H	.187", 4.75 mm	●			●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00 mm	●			●
	RE .008"	●			
J	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24 mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●			
J	.248", 6.31 mm	●			●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.250", 6.35 mm	●			●
	RE .008"	●			

● : Gauge insert shown dimensions

GROOVING / CUTTING OFF

IDENTIFICATION > F010
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

8-1 90° type holder (Inch)

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

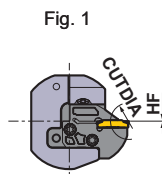
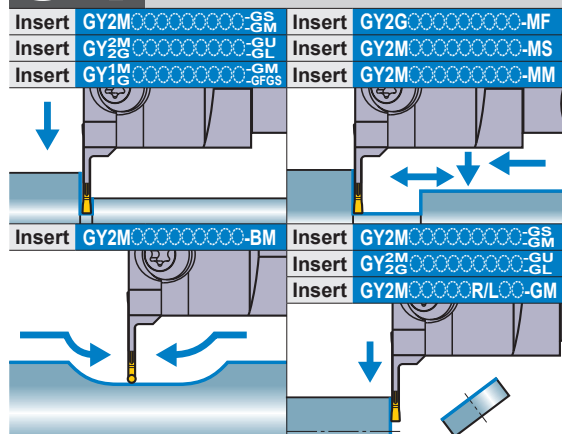
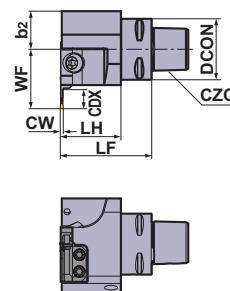
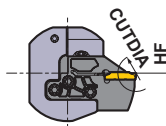


Fig. 2



Right hand tool holder shown.

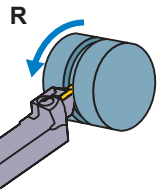
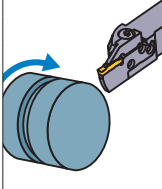
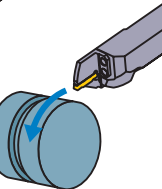
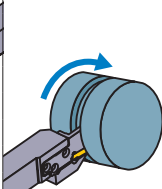
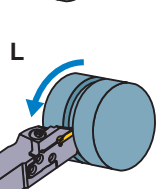
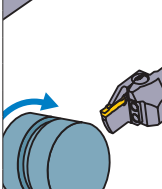
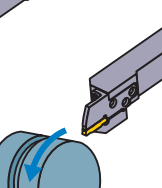
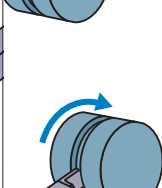
[illegible]

*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
C3-GYHR/LCX90-M20L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) ★3						Cutting Mode	
	DCON	LF	LH	WF	HF	b ₂	Clockwise	Anticlockwise
	1.260	2.165	1.567	1.024	0	.787		
	1.260	2.165	1.567	1.024	0	.787		
	1.575	2.362	1.567	1.220	0	.984		
	1.575	2.362	1.567	1.220	0	.984		
	1.969	2.362	1.567	1.299	0	1.024		
	1.969	2.362	1.567	1.299	0	1.024		
	2.480	2.756	1.882	1.575	0	1.319		
	2.480	2.756	1.882	1.575	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.260	2.165	1.567	1.496	0	.787		
	1.260	2.165	1.567	1.496	0	.787		
	1.575	2.362	1.567	1.772	0	.984		
	1.575	2.362	1.567	1.772	0	.984		
	1.969	2.362	1.567	1.850	0	1.024		
	1.969	2.362	1.567	1.850	0	1.024		
	2.480	2.756	1.882	2.126	0	1.319		
	2.480	2.756	1.882	2.126	0	1.319		

Select an Insert

Seat Size	Insert Number
D	GY○○0200/0224D○○○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●

For Cutting off > F012				
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)
		R	R	R
D	.079", 2.00 mm	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
				BM (Copying, Recessing)
D	.079", 2.00 mm	●	●	●
	.088", 2.24 mm	●		

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

GY SERIES (EXTERNAL GROOVING PSC TYPE)

8-1

90° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

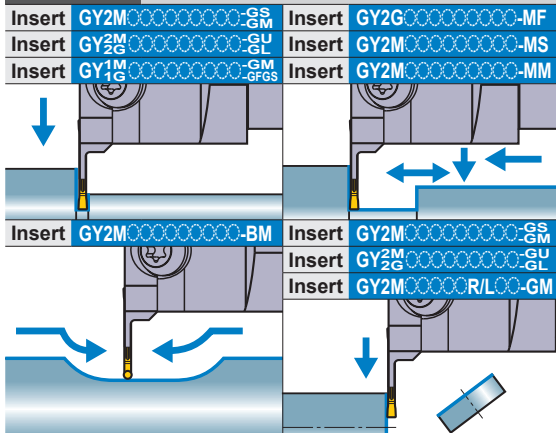
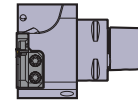
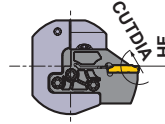
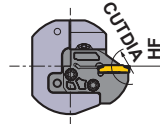
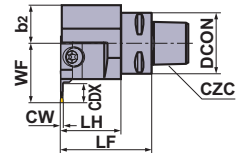


Fig. 1

Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
E	.094 .098 .108	.236	.472	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-E06	●	1	C3
				Modular	L	C3-GYHLCX90-M20R	●	GYM20RA-E06	●	1	
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-E06	●	1	C4
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-E06	●	1	
		.394	.787	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-E06	●	1	C5
				Modular	L	C5-GYHLD90-M25R	●	GYM25RA-E06	●	1	
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-E06	●	1	C6
				Modular	L	C6-GYHLE90-M25R	●	GYM25RA-E06	●	1	
		.472	.945	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-E10	●	1	C3
				Modular	L	C3-GYHLCX90-M20R	●	GYM20RA-E10	●	1	
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-E12	●	1	C4
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-E12	●	1	
		.709*4	1.417	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-E12	●	1	C5
				Modular	L	C5-GYHLD90-M25R	●	GYM25RA-E12	●	1	
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-E12	●	1	C6
				Modular	L	C6-GYHLE90-M25R	●	GYM25RA-E12	●	1	
		.787*1	1.575*2	Modular	R	C3-GYHRCX90-M20L	●	GYM20LB-E18	●	2	C3
				Modular	L	C3-GYHLCX90-M20R	●	GYM20RB-E18	●	2	
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-E20	●	2	C4
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-E20	●	2	
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-E20	●	2	C5
				Modular	L	C5-GYHLD90-M25R	●	GYM25RA-E20	●	2	
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-E20	●	2	C6
				Modular	L	C6-GYHLE90-M25R	●	GYM25RA-E20	●	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 F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

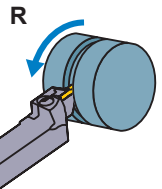
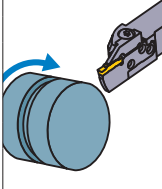
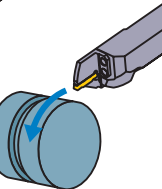
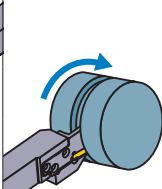
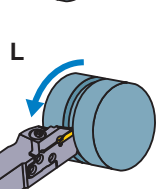
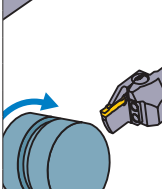
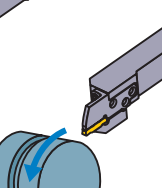
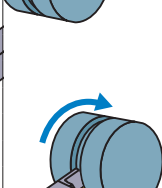
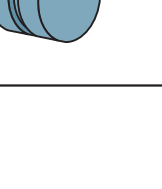
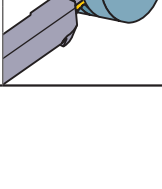
*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
C3-GYHR/LCX90-M20L/R	Clamp Screw	Blade Screw	Wrench ★
C4-GYHR/LD90-M25L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C5-GYHR/LD90-M25L/R		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) ★3						Cutting Mode	
	DCON	LF	LH	WF	HF	b ₂	Clockwise	Anticlockwise
	1.260	2.165	1.567	1.024	0	.787		
	1.260	2.165	1.567	1.024	0	.787		
	1.575	2.362	1.567	1.220	0	.984		
	1.575	2.362	1.567	1.220	0	.984		
	1.969	2.362	1.567	1.299	0	1.024		
	1.969	2.362	1.567	1.299	0	1.024		
	2.480	2.756	1.882	1.575	0	1.319		
	2.480	2.756	1.882	1.575	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.260	2.165	1.567	1.496	0	.787		
	1.260	2.165	1.567	1.496	0	.787		
	1.575	2.362	1.567	1.772	0	.984		
	1.575	2.362	1.567	1.772	0	.984		
	1.969	2.362	1.567	1.850	0	1.024		
	1.969	2.362	1.567	1.850	0	1.024		
	2.480	2.756	1.882	2.126	0	1.319		
	2.480	2.756	1.882	2.126	0	1.319		

Select an Insert

Seat Size	Insert Number
E	GY○○○0239/0250/0274E○○○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
E	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●

For Cutting off > F012				
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)
CW	R	R	R	R/L
E	.098", 2.50 mm	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
CW	Ball nose			
E	.094", 2.39 mm	●	●	●
	.098", 2.50 mm	●	●	●
	.108", 2.74 mm	●	●	●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

8-1 90° type holder (Inch)

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

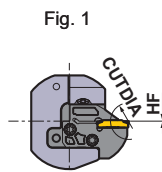
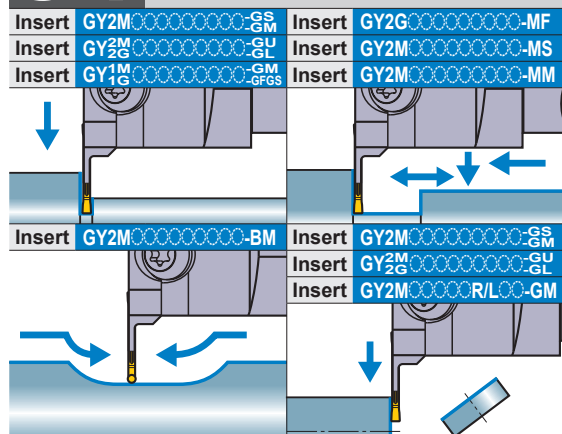
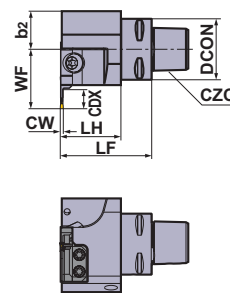
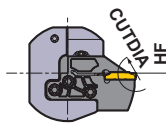


Fig. 2



Right hand tool holder shown.

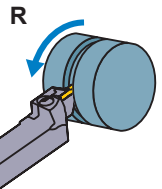
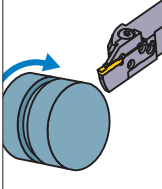
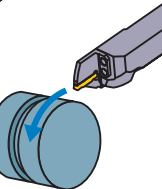
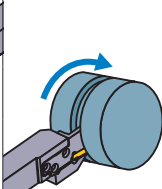
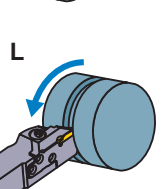
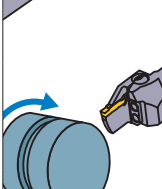
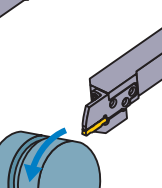
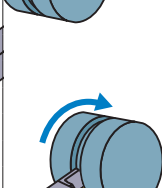
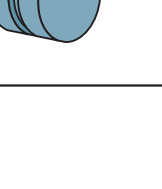
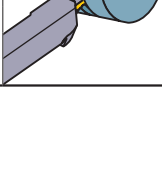
[illegible]

*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
C3-GYHR/LCX90-M20L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) ★3						Cutting Mode	
	DCON	LF	LH	WF	HF	b ₂	Clockwise	Anticlockwise
	1.260	2.165	1.567	1.024	0	.787		
	1.260	2.165	1.567	1.024	0	.787		
	1.575	2.362	1.567	1.220	0	.984		
	1.575	2.362	1.567	1.220	0	.984		
	1.969	2.362	1.567	1.299	0	1.024		
	1.969	2.362	1.567	1.299	0	1.024		
	2.480	2.756	1.882	1.575	0	1.319		
	2.480	2.756	1.882	1.575	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.260	2.165	1.567	1.496	0	.787		
	1.260	2.165	1.567	1.496	0	.787		
	1.575	2.362	1.567	1.772	0	.984		
	1.575	2.362	1.567	1.772	0	.984		
	1.969	2.362	1.567	1.850	0	1.024		
	1.969	2.362	1.567	1.850	0	1.024		
	2.480	2.756	1.882	2.126	0	1.319		
	2.480	2.756	1.882	2.126	0	1.319		

Select an Insert

Seat Size	Insert Number
F	GY○○○0300/0318/0324F○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
	CW	R	R	R	R/L
F	.118", 3.00 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
	CW				Ball nose
F	.118", 3.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F010
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL GROOVING PSC TYPE)

8-1

90° type holder (Inch)

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

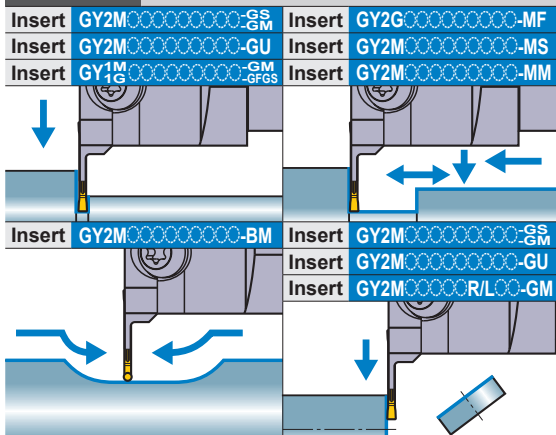
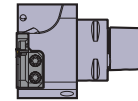
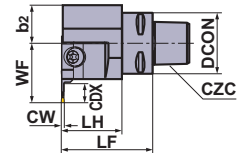
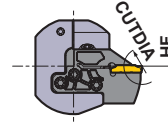
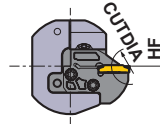


Fig. 1

Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
G	.157 .167	.315	.630	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-G08	●	1	C4
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-G08	●	1	
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-G08	●	1	C5
				Modular	L	C5-GYHLD90-M25R	●	GYM25RA-G08	●	1	
		.472	.945	Modular	R	C6-GYHRE90-M25L	●	GYM25LA-G08	●	1	C6
				Modular	L	C6-GYHLE90-M25R	●	GYM25RA-G08	●	1	
		.551	1.102	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-G12	●	1	C3
				Modular	L	C3-GYHLCX90-M20R	●	GYM20RA-G12	●	1	
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-G14	●	1	C4
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-G14	●	1	
		.984*1	1.969*2	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-G14	●	1	C5
				Modular	L	C5-GYHLD90-M25R	●	GYM25RA-G14	●	1	
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-G14	●	1	C6
				Modular	L	C6-GYHLE90-M25R	●	GYM25RA-G14	●	1	
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-G25	●	2	C4
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-G25	●	2	
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-G25	●	2	C5
				Modular	L	C5-GYHLD90-M25R	●	GYM25RA-G25	●	2	
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-G25	●	2	C6
				Modular	L	C6-GYHLE90-M25R	●	GYM25RA-G25	●	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 F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

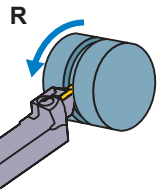
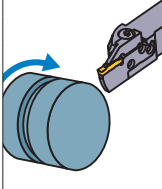
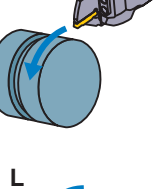
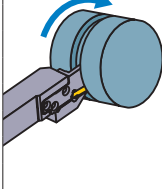
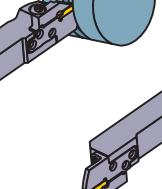
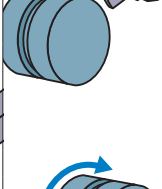
*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
C3-GYHR/LCX90-M20L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) ★3						Cutting Mode	
	DCON	LF	LH	WF	HF	b ₂	Clockwise	Anticlockwise
	1.575	2.362	1.567	1.299	0	.984		
	1.575	2.362	1.567	1.299	0	.984		
	1.969	2.362	1.567	1.378	0	1.024		
	1.969	2.362	1.567	1.378	0	1.024		
	2.480	2.756	1.882	1.654	0	1.319		
	2.480	2.756	1.882	1.654	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.575	2.362	1.567	1.969	0	.984		
	1.575	2.362	1.567	1.969	0	.984		
	1.969	2.362	1.567	2.047	0	1.024		
	1.969	2.362	1.567	2.047	0	1.024		
	2.480	2.756	1.882	2.323	0	1.319		
	2.480	2.756	1.882	2.323	0	1.319		

Select an Insert

Seat Size	Insert Number
G	GY○○○0400/0424G○○○○○-Breaker

For Grooving/Cutting off > F011-F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS 05-GM (Hardened steel) (Cutting off)
	CW	Neutral	Neutral	Neutral	Hand
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)
	CW			BM (Copying, Recessing) Ball nose
G	.157", 4.00 mm	●	●	●
	RE .008"	●	●	●
	RE .016"	●	●	●
	RE .031"	●	●	●
	.167", 4.24 mm	●		

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

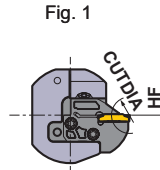
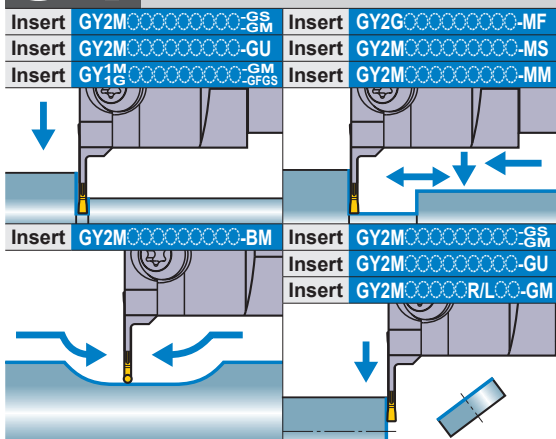


Fig. 1

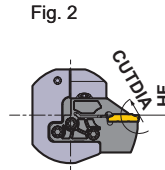
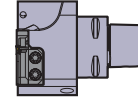
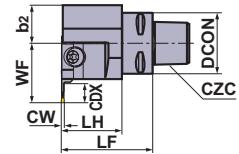


Fig. 2



Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC	
						Holder	Stock	Modular Blade	Stock			
H	.187 .197 .206	.315	.630	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-H08	●	1	C4	
				L	C4-GYHLD90-M25R	●	GYM25RA-H08	●	1			
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-H08	●	1	C5	
		L	C5-GYHLD90-M25R	●	GYM25RA-H08	●	1					
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-H08	●	1	C6			
		L	C6-GYHLE90-M25R	●	GYM25RA-H08	●	1					
		.472	.945	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-H12	●	1	C3	
				L	C3-GYHLCX90-M20R	●	GYM20RA-H12	●	1			
		.551	1.102	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-H14	●	1	C4	
				L	C4-GYHLD90-M25R	●	GYM25RA-H14	●	1			
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-H14	●	1	C5	
				L	C5-GYHLD90-M25R	●	GYM25RA-H14	●	1			
	Modular			R	C6-GYHRE90-M25L	●	GYM25LA-H14	●	1	C6		
	L			C6-GYHLE90-M25R	●	GYM25RA-H14	●	1				
	.984*1	1.969*2	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-H25	●	2	C4		
			L	C4-GYHLD90-M25R	●	GYM25RA-H25	●	2				
Modular			R	C5-GYHRD90-M25L	●	GYM25LA-H25	●	2	C5			
L			C5-GYHLD90-M25R	●	GYM25RA-H25	●	2					
Modular			R	C6-GYHRE90-M25L	●	GYM25LA-H25	●	2	C6			
L			C6-GYHLE90-M25R	●	GYM25RA-H25	●	2					
J	.236 .248 .250	.315	.630	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-J08	●	1	C4	
				L	C4-GYHLD90-M25R	●	GYM25RA-J08	●	1			
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-J08	●	1	C5	
		L	C5-GYHLD90-M25R	●	GYM25RA-J08	●	1					
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-J08	●	1	C6			
		L	C6-GYHLE90-M25R	●	GYM25RA-J08	●	1					
		.551	1.102	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-J14	●	1	C4	
				L	C4-GYHLD90-M25R	●	GYM25RA-J14	●	1			
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-J14	●	1	C5	
				L	C5-GYHLD90-M25R	●	GYM25RA-J14	●	1			
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-J14	●	1	C6	
				L	C6-GYHLE90-M25R	●	GYM25RA-J14	●	1			
	.984*1	1.969*2	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-J25	●	2	C4		
			L	C4-GYHLD90-M25R	●	GYM25RA-J25	●	2				
			Modular	R	C5-GYHRD90-M25L	●	GYM25LA-J25	●	2	C5		
			L	C5-GYHLD90-M25R	●	GYM25RA-J25	●	2				
Modular			R	C6-GYHRE90-M25L	●	GYM25LA-J25	●	2	C6			
L			C6-GYHLE90-M25R	●	GYM25RA-J25	●	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 F011 to F015.

*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 F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **LF**, **LH** and **LH 2** values may vary.

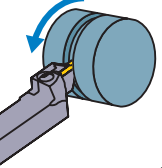
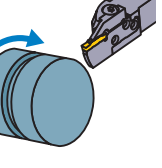
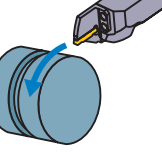
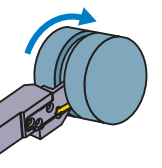
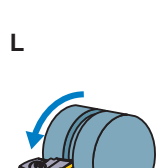
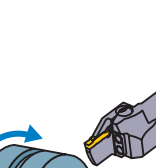
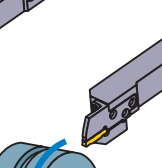
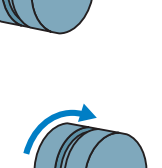
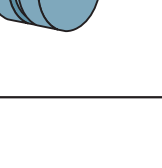
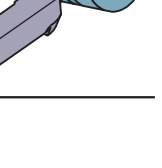
*4 The maximum groove depth (**CDX**) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LCX90-M20L/R		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	b ₂	Clockwise	Anticlockwise
	1.575	2.362	1.567	1.299	0	.984		
	1.575	2.362	1.567	1.299	0	.984		
	1.969	2.362	1.567	1.378	0	1.024		
	1.969	2.362	1.567	1.378	0	1.024		
	2.480	2.756	1.882	1.654	0	1.319		
	2.480	2.756	1.882	1.654	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.575	2.362	1.567	1.969	0	.984		
	1.575	2.362	1.567	1.969	0	.984		
	1.969	2.362	1.567	2.047	0	1.024		
	1.969	2.362	1.567	2.047	0	1.024		
	2.480	2.756	1.882	2.323	0	1.319		
	2.480	2.756	1.882	2.323	0	1.319		
	1.575	2.362	1.567	1.299	0	.984		
	1.575	2.362	1.567	1.299	0	.984		
	1.969	2.362	1.567	1.378	0	1.024		
	1.969	2.362	1.567	1.378	0	1.024		
	2.480	2.756	1.882	1.654	0	1.319		
	2.480	2.756	1.882	1.654	0	1.319		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.575	2.362	1.567	1.969	0	.984		
	1.575	2.362	1.567	1.969	0	.984		
	1.969	2.362	1.567	2.047	0	1.024		
	1.969	2.362	1.567	2.047	0	1.024		
	2.480	2.756	1.882	2.323	0	1.319		
	2.480	2.756	1.882	2.323	0	1.319		

Select an Insert

Seat Size	Insert Number
H	GY○○○0475/0500/0524H○○○-Breaker
J	GY○○○0600/0631/0635J○○○-Breaker

For Grooving/Cutting off > F011-F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)	05-GM (Cutting off)
	CW	Neutral	Neutral	Neutral	Neutral	Hand
H	.187", 4.75 mm	●	●	●	●	●
	.197", 5.00 mm	●	●	●	●	●
J	.236", 6.00 mm	●	●	●	●	●
	.250", 6.35 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
	CW				Ball nose
	.187", 4.75 mm	●			●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
H	.197", 5.00 mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24 mm	●			
	.236", 6.00 mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
J	.248", 6.31 mm	●			●
	.250", 6.35 mm	●			●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			

● : Gauge insert shown dimensions

GROOVING / CUTTING OFF

F

IDENTIFICATION > F010
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL / FACE GROOVING PSC TYPE)

7-2

00° type holder (Metric)

NEW

Note 1) For modular blades and holders, please order separately.

Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.

P

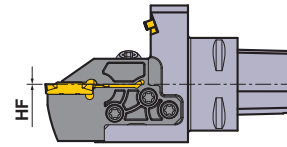
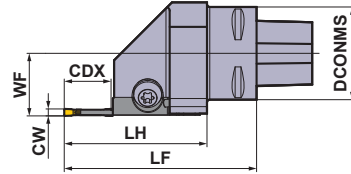
M

K

N

S

H



Right hand tool holder shown.

(mm)

Order Number	Stock	Hand (R/L)	Coolant	Mounting Size	DCONMS	CW
C4-GYHERM00-M25R	●	R	External	PSC40	40	2.0—6.35
C4-GYHELM00-M25L	●	L	External	PSC40	40	2.0—6.35
C5-GYHERM00-M25R	●	R	External	PSC50	50	2.0—6.35
C5-GYHELM00-M25L	●	L	External	PSC50	50	2.0—6.35
C6-GYHERM00-M25R	●	R	External	PSC63	63	2.0—6.35
C6-GYHELM00-M25L	●	L	External	PSC63	63	2.0—6.35

GROOVING / CUTTING OFF

F

Set Dimensions with Modular Blades

Holder Type	Modular Blade Type	Standard CW	CDX	WF	HF	LF	LH
C4-GYHER/LM00-M25R/L	GYM25R/L○-D06	2.0	6	27.0	0	69	47.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-D12	2.0	12	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-D20	2.0	20	27.0	0	83	61.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-E06	2.5	6	27.0	0	69	47.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-E12	2.5	12	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-E20	2.5	20	27.0	0	83	61.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-F06	3.0	6	27.0	0	69	47.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-F12	3.0	12	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-F20	3.0	20	27.0	0	83	61.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-G08	4.0	8	27.0	0	71	49.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-G14	4.0	14	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-G25	4.0	25	27.0	0	88	66.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-H08	5.0	8	27.0	0	71	49.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-H14	5.0	14	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-H25	5.0	25	27.0	0	88	66.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-J08	6.0	8	27.0	0	71	49.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-J14	6.0	14	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○-J25	6.0	25	27.0	0	88	66.6

*Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter. Example) GYM25RD-D12-040

The "○" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining.

Note 1) The indicated dimensions are values for standard inserts (GM breakers). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from "TOOL NEWS B255A-G GYGW Inserts".

● : USA Stock

(mm)

Holder Type	Modular Blade Type	Standard CW	CDX	WF	HF	LF	LH
C5-GYHER/LM00-M25R/L	GYM25R/L-○-D06	2.0	6	35.0	0	69	47.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-D12	2.0	12	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-D20	2.0	20	35.0	0	83	61.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-E06	2.5	6	35.0	0	69	47.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-E12	2.5	12	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-E20	2.5	20	35.0	0	83	61.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-F06	3.0	6	35.0	0	69	47.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-F12	3.0	12	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-F20	3.0	20	35.0	0	83	61.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-G08	4.0	8	35.0	0	71	49.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-G14	4.0	14	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-G25	4.0	25	35.0	0	88	66.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-H08	5.0	8	35.0	0	71	49.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-H14	5.0	14	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-H25	5.0	25	35.0	0	88	66.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-J08	6.0	8	35.0	0	71	49.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-J14	6.0	14	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L-○-J25	6.0	25	35.0	0	88	66.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-D06	2.0	6	45.0	0	71	47.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-D12	2.0	12	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-D20	2.0	20	45.0	0	85	61.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-E06	2.5	6	45.0	0	71	47.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-E12	2.5	12	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-E20	2.5	20	45.0	0	85	61.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-F06	3.0	6	45.0	0	71	47.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-F12	3.0	12	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-F20	3.0	20	45.0	0	85	61.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-G08	4.0	8	45.0	0	73	49.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-G14	4.0	14	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-G25	4.0	25	45.0	0	90	66.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-H08	5.0	8	45.0	0	73	49.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-H14	5.0	14	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-H25	5.0	25	45.0	0	90	66.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-J08	6.0	8	45.0	0	73	49.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-J14	6.0	14	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L-○-J25	6.0	25	45.0	0	90	66.6

*Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter. Example) GYM25RD-D12-040

The "○" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining.

Note 1) The indicated dimensions are values for standard inserts (GM breakers). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from "TOOL NEWS B255A-G GYGW Inserts".

F

GROOVING / CUTTING OFF

SPARE PARTS

											
Clamp Screw		Blade Screw		Plug		Nozzle		Wrench 1		Wrench 2	
Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number		Order Number	
GY06013M	1	TS55	5	HSD05004S	1	NZ22042080S	1	TKY25D		TKY30R	

* Clamp Torque (lbf-in) : GY06013M=53, TS55=44

Nozzle Exchange Key : NZKH050S

IDENTIFICATION	➤ F010
INSERTS	➤ F011—F015
CUTTING CONDITIONS	➤ F194, F206
INSTRUCTION MANUAL	➤ F201, F208

GY SERIES (EXTERNAL / FACE GROOVING PSC TYPE)

8-2

00° type holder (Metric)

NEW

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

P

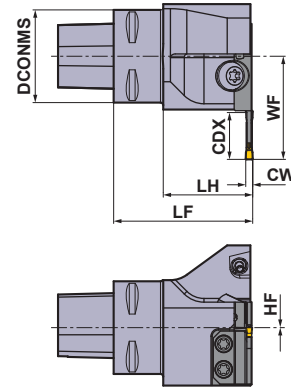
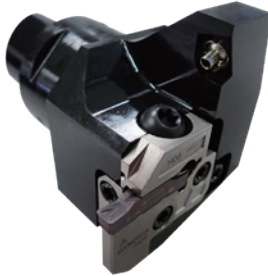
M

K

N

S

H



Left hand tool holder shown.

(mm)

Order Number	Stock	Hand (R/L)	Coolant	Mounting Size	DCONMS	CW
C4-GYHERM90-M25L	●	R	External	PSC40	40	2.0—6.35
C4-GYHELM90-M25R	●	L	External	PSC40	40	2.0—6.35
C5-GYHERM90-M25L	★	R	External	PSC50	50	2.0—6.35
C5-GYHELM90-M25R	★	L	External	PSC50	50	2.0—6.35
C6-GYHERM90-M25L	★	R	External	PSC63	63	2.0—6.35
C6-GYHELM90-M25R	★	L	External	PSC63	63	2.0—6.35

GROOVING / CUTTING OFF

Set Dimensions with Modular Blades

Holder Type	Modular Blade Type	Standard CW	CDX	WF	HF	LF	LH
C4-GYHER/LM90-M25L/R	GYM25L/R-○D06	2.0	6	30.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○D12	2.0	12	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○D20	2.0	20	44.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○E06	2.5	6	30.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○E12	2.5	12	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○E20	2.5	20	44.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○F06	3.0	6	30.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○F12	3.0	12	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○F20	3.0	20	44.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○G08	4.0	8	32.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○G14	4.0	14	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○G25	4.0	25	49.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○H08	5.0	8	32.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○H14	5.0	14	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○H25	5.0	25	49.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○J08	6.0	8	32.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○J14	6.0	14	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○J25	6.0	25	49.5	0	60	38.6

*Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter. Example) GYM25RD-D12-040

The "○" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining.

Note 1) The indicated dimensions are values for standard inserts (GM breakers). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from "TOOL NEWS B255A-G GYGW Inserts".

● : USA Stock ★ : Stocked in Japan

(mm)

Holder Type	Modular Blade Type	Standard CW	CDX	WF	HF	LF	LH
C5-GYHER/LM90-M25L/R	GYM25L/R-D06	2.0	6	33.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-D12	2.0	12	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-D20	2.0	20	47.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-E06	2.5	6	33.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-E12	2.5	12	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-E20	2.5	20	47.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-F06	3.0	6	33.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-F12	3.0	12	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-F20	3.0	20	47.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-G08	4.0	8	35.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-G14	4.0	14	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-G25	4.0	25	52.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-H08	5.0	8	35.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-H14	5.0	14	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-H25	5.0	25	52.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-J08	6.0	8	35.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-J14	6.0	14	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-J25	6.0	25	52.0	0	60	38.6
C6-GYHER/LM90-M25L/R	GYM25L/R-D06	2.0	6	40.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-D12	2.0	12	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-D20	2.0	20	54.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-E06	2.5	6	40.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-E12	2.5	12	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-E20	2.5	20	54.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-F06	3.0	6	40.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-F12	3.0	12	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-F20	3.0	20	54.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-G08	4.0	8	42.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-G14	4.0	14	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-G25	4.0	25	59.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-H08	5.0	8	42.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-H14	5.0	14	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-H25	5.0	25	59.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-J08	6.0	8	42.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-J14	6.0	14	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-J25	6.0	25	59.0	0	70	46.6

*Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter. Example) GYM25RD-D12-040

The "○" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining.

Note 1) The indicated dimensions are values for standard inserts (GM breakers). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from "TOOL NEWS B255A-G GYGW Inserts".

F

GROOVING / CUTTING OFF

SPARE PARTS

	*		*								
Clamp Screw		Blade Screw		Plug		Nozzle		Wrench 1		Wrench 2	
Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number		Order Number	
GY06013M	1	TS55	5	HSD05004S	1	NZ22042080S	1	TKY25D		TKY30R	

* Clamp Torque (lbf-in) : GY06013M=53, TS55=44

Nozzle Exchange Key : NZKH050S

IDENTIFICATION	➤ F010
INSERTS	➤ F011—F015
CUTTING CONDITIONS	➤ F194, F206
INSTRUCTION MANUAL	➤ F201, F208

GY SERIES (EXTERNAL RECESSING PSC TYPE)

9-2

50° type holder (Metric)

NEW

Note 1) For modular blades and holders, please order separately.

Note 2) Please use left hand modular blade for right hand holder and right hand modular blade for left hand holder.

P

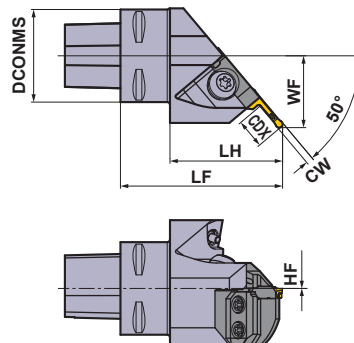
M

K

N

S

H



Left hand tool holder shown.

(mm)

Order Number	Stock	Hand (R/L)	Coolant	Mounting Size	DCONMS	CW
C4-GYHERM50-M25L	●	R	External	PSC40	40	2.0—6.35
C4-GYHELM50-M25R	●	L	External	PSC40	40	2.0—6.35
C5-GYHERM50-M25L	★	R	External	PSC50	50	2.0—6.35
C5-GYHELM50-M25R	★	L	External	PSC50	50	2.0—6.35
C6-GYHERM50-M25L	★	R	External	PSC63	63	2.0—6.35
C6-GYHELM50-M25R	★	L	External	PSC63	63	2.0—6.35

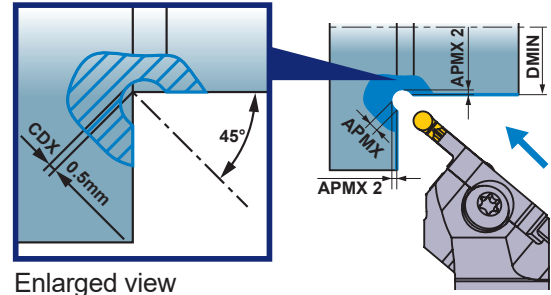
SPARE PARTS

Clamp Screw		Blade Screw		Plug		Nozzle		Wrench 1	Wrench 2
Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number	Order Number
GY06013M	1	TS55	4	HSD05004S	1	NZ22042080S	1	TKY25D	TKY30R

★ Clamp Torque (lbf-in) : GY06013M=53, TS55=44

Nozzle Exchange Key : NZKH050S

● : USA Stock ★ : Stocked in Japan



Set Dimensions with Modular Blades

(mm)

Holder Type	Modular Blade Type	Standard CW	CDX	DMIN	APMX	APMX2	WF	HF	LF	LH
C4-GYHER/LM50-M25L/R	GYM25L/RC-D005	2.0	0.5	30	1.50	0.646	30.6	0	70.2	48.8
C4-GYHER/LM50-M25L/R	GYM25L/RC-E005	2.5	0.5	30	1.75	0.720	30.8	0	70.1	48.7
C4-GYHER/LM50-M25L/R	GYM25L/RC-F005	3.0	0.5	30	2.00	0.793	31.0	0	70.0	48.6
C4-GYHER/LM50-M25L/R	GYM25L/RC-G005	4.0	0.5	20	2.50	0.939	31.4	0	69.8	48.4
C4-GYHER/LM50-M25L/R	GYM25L/RC-H005	5.0	0.5	20	2.88	1.049	31.8	0	69.6	48.2
C4-GYHER/LM50-M25L/R	GYM25L/RC-J005	6.0	0.5	20	3.50	1.232	32.4	0	69.4	48.0
C5-GYHER/LM50-M25L/R	GYM25L/RC-D005	2.0	0.5	30	1.50	0.646	32.6	0	70.2	48.8
C5-GYHER/LM50-M25L/R	GYM25L/RC-E005	2.5	0.5	30	1.75	0.720	32.8	0	70.1	48.7
C5-GYHER/LM50-M25L/R	GYM25L/RC-F005	3.0	0.5	30	2.00	0.793	33.0	0	70.0	48.6
C5-GYHER/LM50-M25L/R	GYM25L/RC-G005	4.0	0.5	20	2.50	0.939	33.4	0	69.8	48.4
C5-GYHER/LM50-M25L/R	GYM25L/RC-H005	5.0	0.5	20	2.88	1.049	33.8	0	69.6	48.2
C5-GYHER/LM50-M25L/R	GYM25L/RC-J005	6.0	0.5	20	3.50	1.232	34.4	0	69.4	48.0
C6-GYHER/LM50-M25L/R	GYM25L/RC-D005	2.0	0.5	30	1.50	0.646	39.6	0	70.2	46.8
C6-GYHER/LM50-M25L/R	GYM25L/RC-E005	2.5	0.5	30	1.75	0.720	39.8	0	70.1	46.7
C6-GYHER/LM50-M25L/R	GYM25L/RC-F005	3.0	0.5	30	2.00	0.793	40.0	0	70.0	46.6
C6-GYHER/LM50-M25L/R	GYM25L/RC-G005	4.0	0.5	20	2.50	0.939	40.4	0	69.8	46.4
C6-GYHER/LM50-M25L/R	GYM25L/RC-H005	5.0	0.5	20	2.88	1.049	40.8	0	69.6	46.2
C6-GYHER/LM50-M25L/R	GYM25L/RC-J005	6.0	0.5	20	3.50	1.232	41.4	0	69.4	46.0

DMIN = Min. Cut Diameter

*Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter. Example) GYM25RD-D12-040

The "○" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining.

Note 1) The indicated dimensions are values for standard inserts (BM breakers). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from "TOOL NEWS B255A-G GYGW Inserts".

GROOVING / CUTTING OFF

RECOMMENDED CUTTING SPEED (SFM) [For External Grooving / Cutting Off]

	Work Material	Hardness	Grade	Cutting Speed (SFM)						
				165	330	490	655	820	985	1640
P	Mild Steel	≤160HB	VP20RT		330		720			
			VP10RT		360		755			
			NX2525		295		690			
	Carbon Steel Alloy Steel	160–280HB	VP20RT		260		590			
			VP10RT		295		620			
			MY5015		360		820			
			NX2525		230		560			
		≥280HB	VP20RT		195		460			
			VP10RT		230		490			
			MY5015		295		690			
			NX2525		180		440			
M	Stainless Steel	≤270HB	VP20RT		195		460			
			VP10RT		230		490			
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT		260		590			
			VP10RT		295		620			
			MY5015				460		985	
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT		195		460			
			VP10RT		230		490			
			MY5015		295		690			
S	Heat Resistant Alloy Titanium Alloy	—	MP9015	130	330					
			MP9025	100	295					
			VP20RT	100	195					
			VP10RT / RT9010	130	230					
H	Hardened steel	≥50HRC	BC8110		260	395				
N	Aluminum Alloy	Content Si<5%	RT9010				655		1640	
	Aluminum Alloy	Content 5%≤Si≤10%	RT9010				655		1640	
	Aluminum Alloy	Content Si>10%	RT9010		330		655			

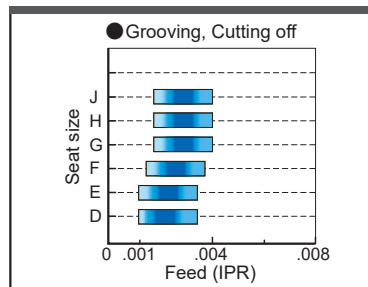
Note 1) For MP9015, MP9025, VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For External Grooving / Cutting Off]

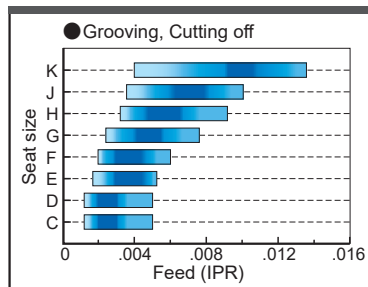
*Below are the recommended cutting conditions when using the modular type holder GYHR/L2525M00/90-M25R/L with the modular blade GYM25R/LA-○○○.

Recommended feed rate and depth of cut

GU BREAKER



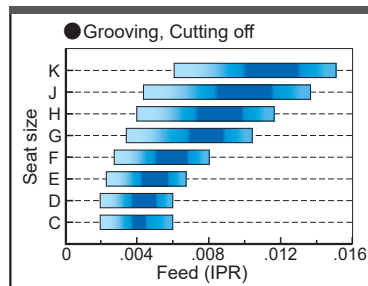
GS BREAKER



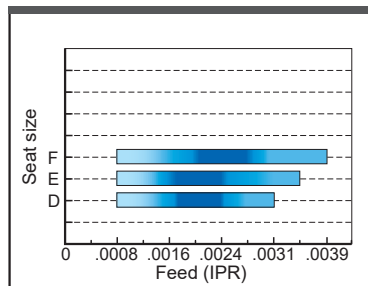
■ : 1st recommended area

Seat Size			
	Insert Width		Insert Width
C	.059", 1.50 mm	G	.157", 4.00 mm
		H	.167", 4.24 mm
D	.079", 2.00 mm		.187", 4.75 mm
	.088", 2.24 mm		.197", 5.00 mm
E	.094", 2.39 mm		.206", 5.24 mm
	.098", 2.50 mm	J	.236", 6.00 mm
F	.108", 2.74 mm		.248", 6.31 mm
			.250", 6.35 mm
	.118", 3.00 mm	K	.315", 8.00 mm
	.125", 3.18 mm		
	.128", 3.24 mm		

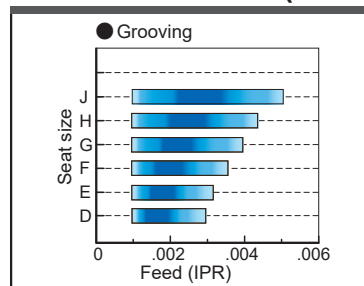
GM BREAKER



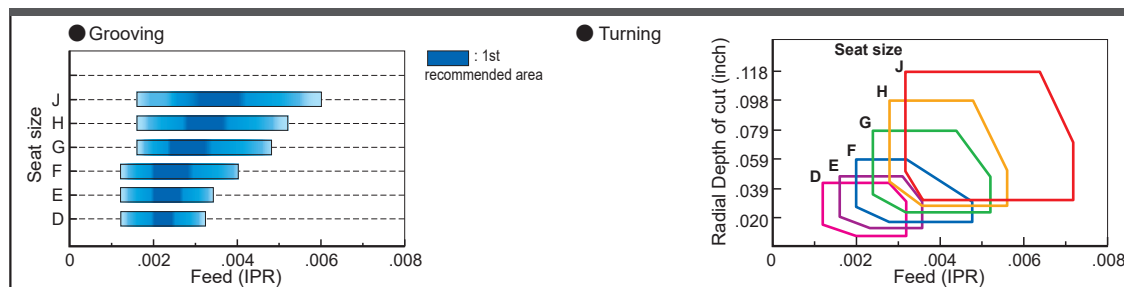
GL BREAKER



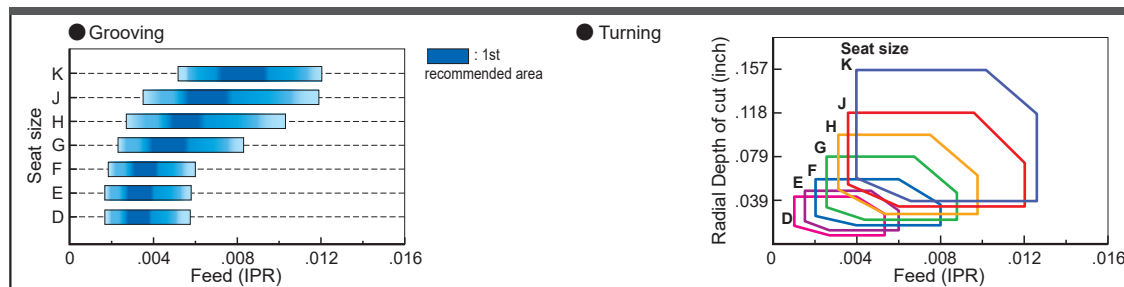
FLAT TOP GFGS (CBN)



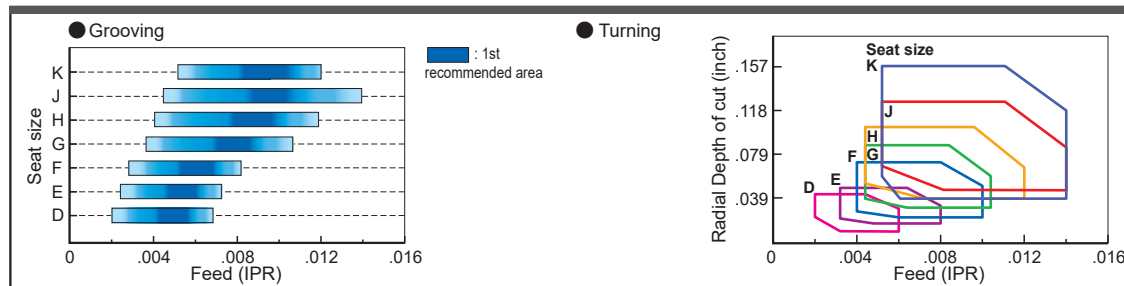
MF BREAKER



MS BREAKER



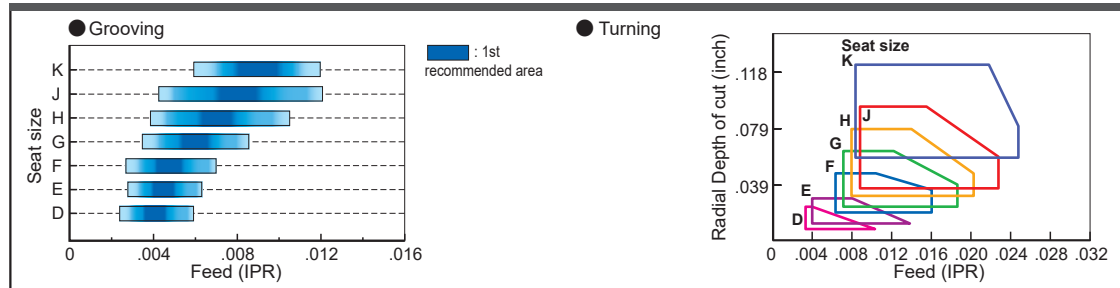
MM BREAKER



GROOVING / CUTTING OFF

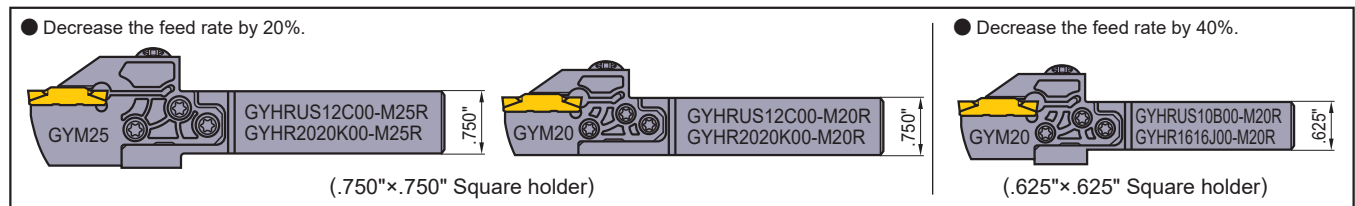
Recommended feed rate and depth of cut

BM BREAKER



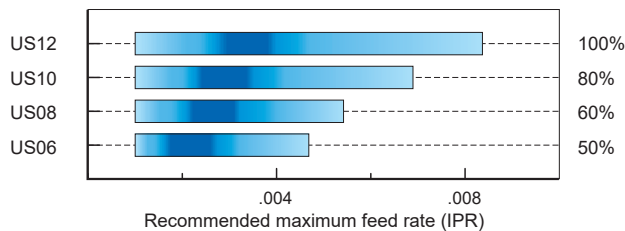
Seat Size	
Insert Width	
C	.059", 1.50 mm
D	.079", 2.00 mm
E	.094", 2.39 mm
F	.108", 2.74 mm
G	.118", 3.00 mm
H	.125", 3.18 mm
J	.128", 3.24 mm
K	.157", 4.00 mm
L	.167", 4.24 mm
M	.187", 4.75 mm
N	.197", 5.00 mm
O	.206", 5.24 mm
P	.236", 6.00 mm
Q	.248", 6.31 mm
R	.250", 6.35 mm
S	.315", 8.00 mm

Note 1) When using a combination as shown below, decrease the recommended feed rate by 20% and 40% respectively.



F

For Swiss-type lathes mono block holder

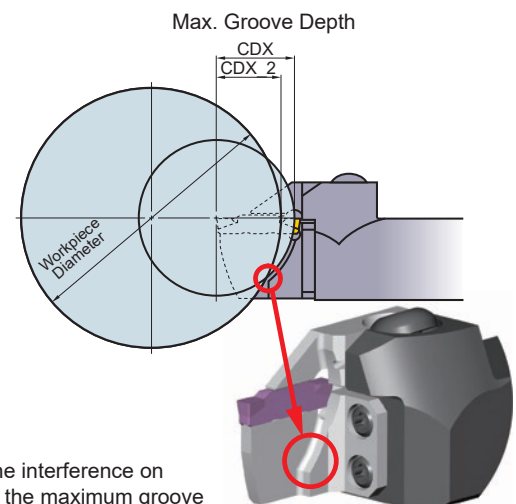
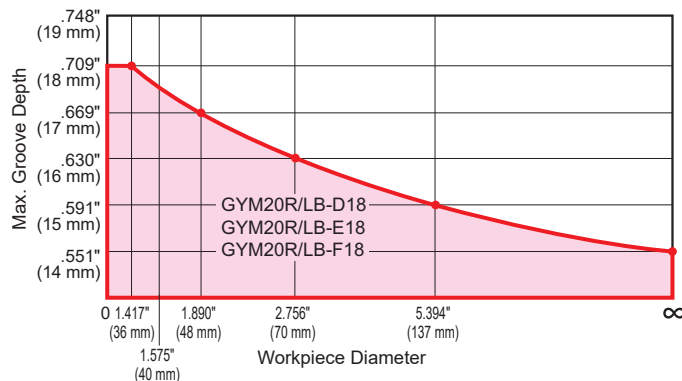


Please refer to the tables of recommended cutting conditions for external grooving. Apply the percentage ratio shown of each shank size to the values in those tables.

LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

•When using the modular blade GYM○R/LA-○○○
The maximum groove depth is not limited by the workpiece diameter.

•When using the modular blade GYM○R/LB-○○○
The maximum groove depth is limited by the workpiece diameter.

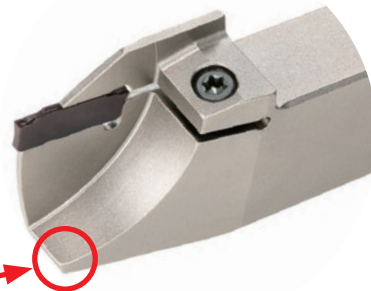
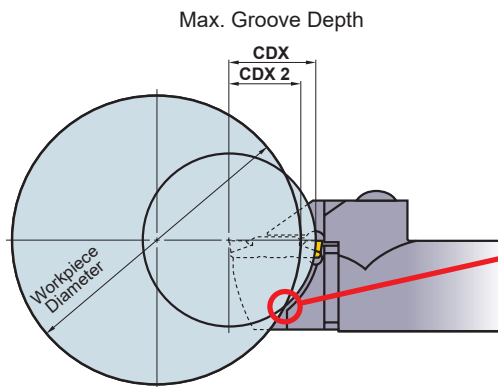


Due to the interference on this part, the maximum groove depth is limited by the workpiece diameter.

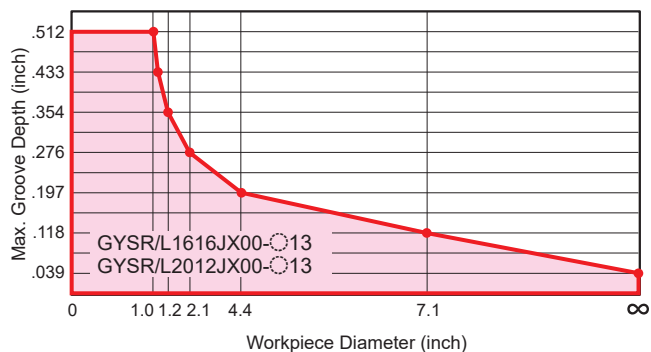
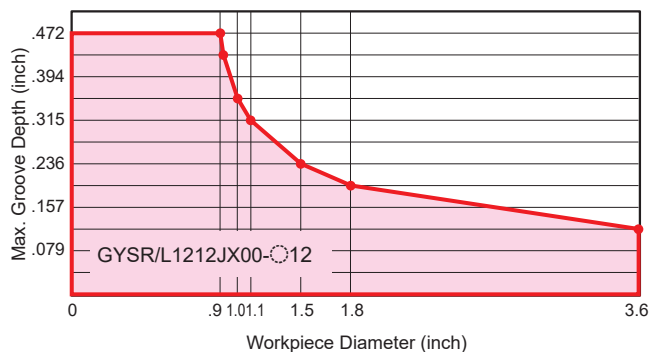
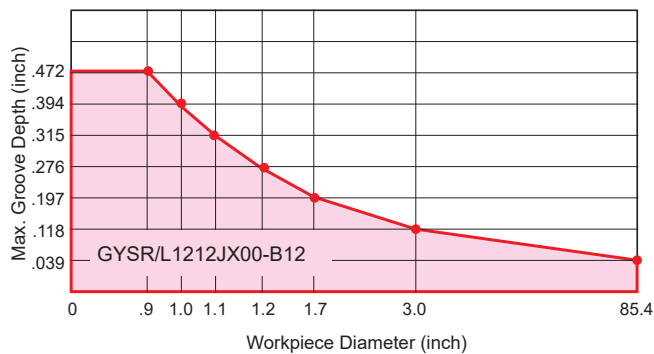
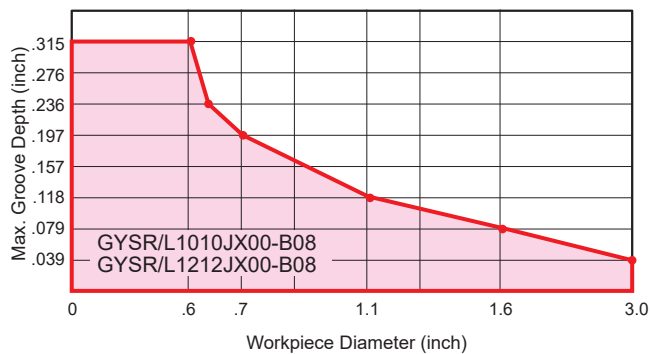
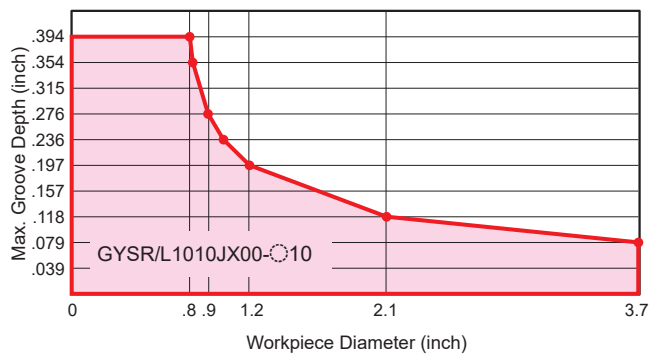
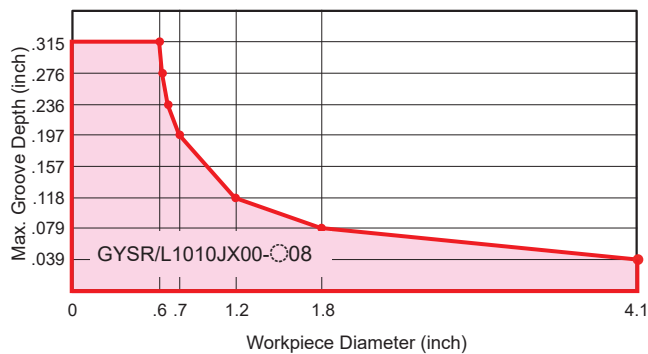
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

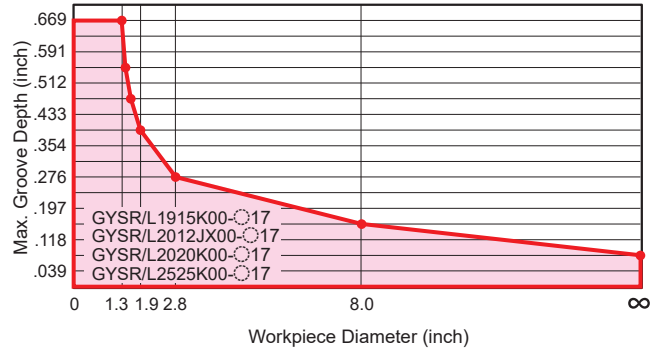
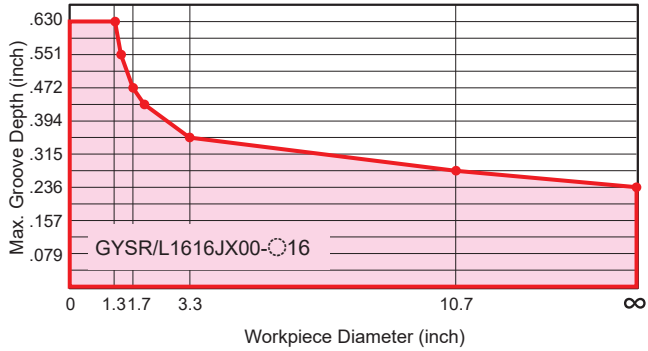
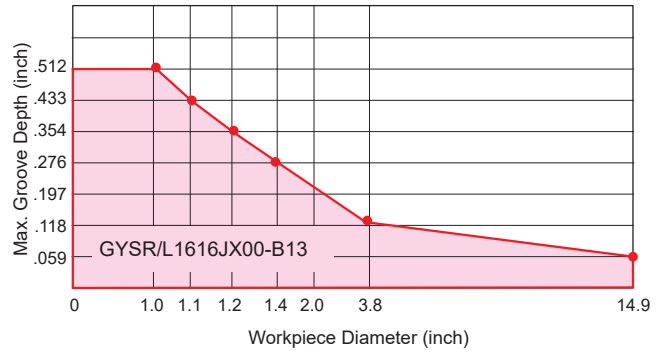
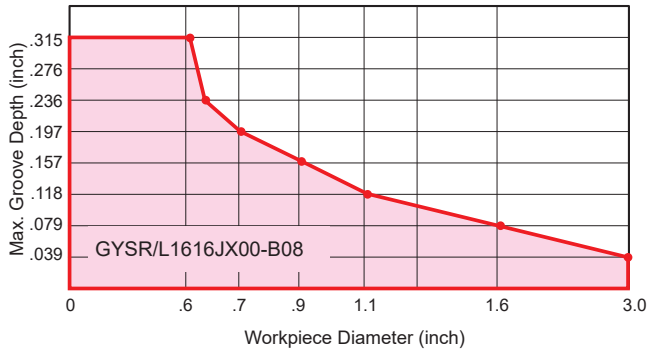
•In The Case of Mono Block Type Holder for Swiss-Type Lathes

The maximum groove depth is limited by the workpiece diameter.



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

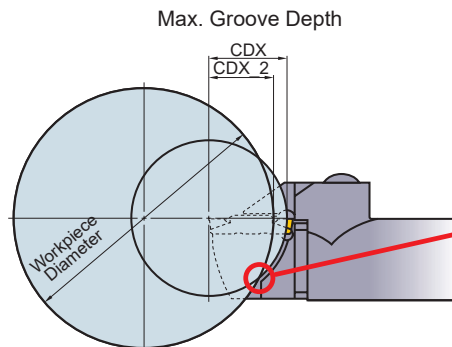




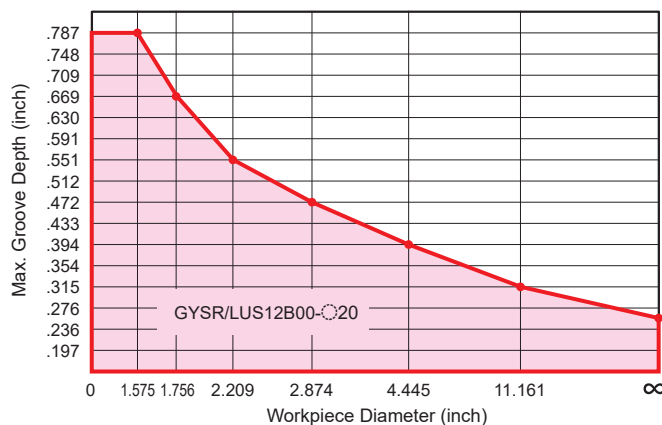
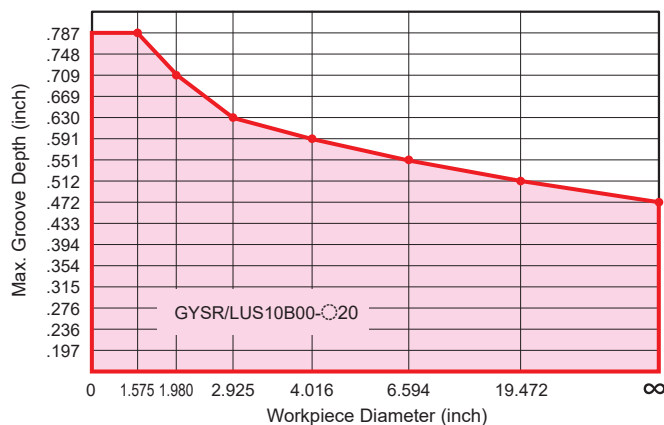
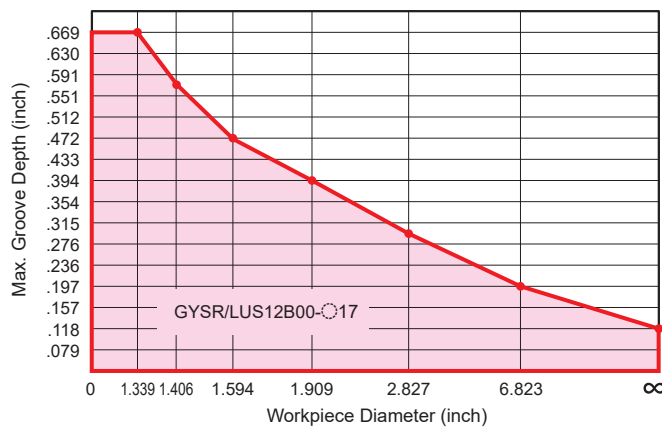
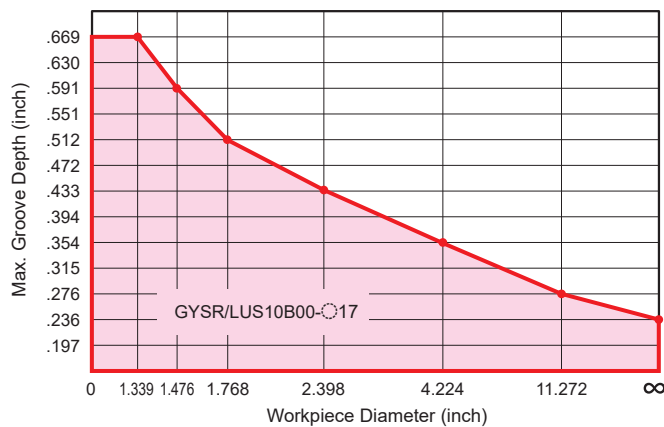
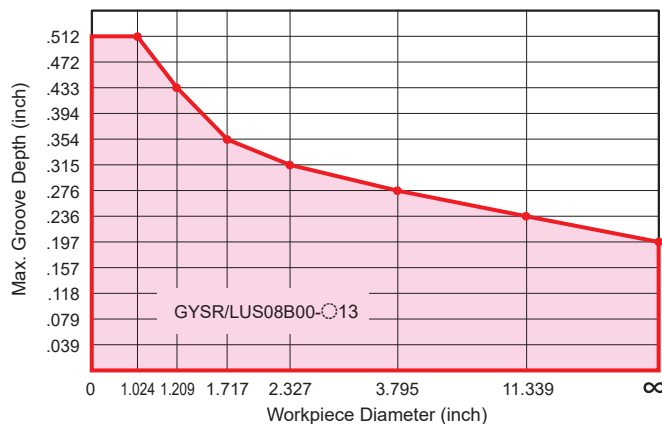
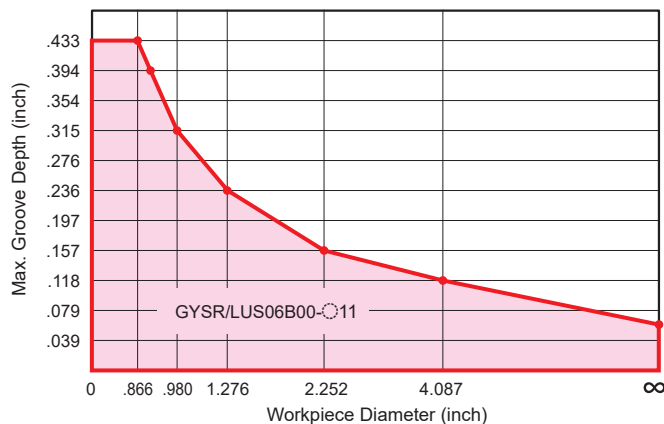
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

•For Swiss-type lathes mono block holder

The maximum groove depth is limited by the workpiece diameter.



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



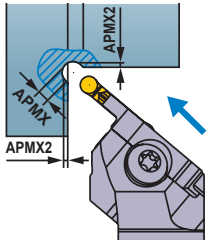
GROOVING / CUTTING OFF

RECOMMENDED CUTTING SPEED (SFM) [For External Recessing]

	Work Material	Hardness	Grade	Cutting Speed (SFM)				
				165	330	490	655	820
P	Mild Steel	≤180HB	VP20RT		260	590		
			VP10RT		295	620		
	Carbon Steel Alloy Steel	180—280HB	VP20RT	195	460			
			VP10RT	230	490			
			MY5015		295	690		
			NX2525	180	440			
		280—350HB	VP20RT	165	360			
			VP10RT	195	395			
			MY5015		260	525		
			NX2525	150	345			
M	Stainless Steel	≤350HB	VP20RT	165	360			
			VP10RT	195	395			
K	Gray Cast Iron	Tensile Strength ≤350MPa	VP20RT	195	460			
			VP10RT	230	490			
			MY5015		295	690		
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	165	360			
			VP10RT	195	395			
			MY5015		260	525		
S	Heat Resistant Alloy Titanium Alloy	—	MP9015	130	330			
			MP9025	100	295			
			VP20RT	100	195			
			VP10RT	130	230			

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

DISTANCE FROM THE WORKPIECE TO THE RECESS DEPTH

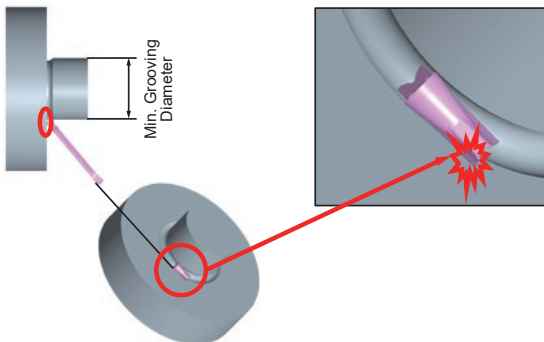


Cutting Width CW	Recessing Depth APMX	Distance workpiece to the recess depth APMX2
.079", 2.00 mm	.059", 1.50 mm	.025", 0.646 mm
.098", 2.50 mm	.069", 1.75 mm	.028", 0.720 mm
.118", 3.00 mm	.079", 2.00 mm	.031", 0.793 mm
.125", 3.18 mm	.082", 2.09 mm	.032", 0.819 mm
.157", 4.00 mm	.098", 2.50 mm	.037", 0.939 mm
.187", 4.75 mm	.113", 2.88 mm	.041", 1.049 mm
.197", 5.00 mm	.118", 3.00 mm	.043", 1.086 mm
.236", 6.00 mm	.138", 3.50 mm	.049", 1.232 mm
.250", 6.35 mm	.145", 3.68 mm	.051", 1.283 mm

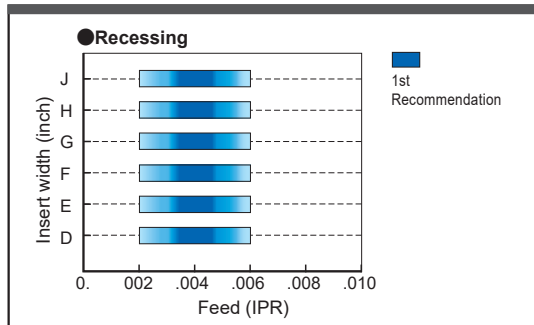
BM BREAKER

Minimum grooving diameter

Ensure the tool is suitable for the diameter being machined. Refer to the Min. Grooving Diameter as shown in the table on the first page to avoid a collision with the workpiece as shown below.



Recommended feed rate and depth of cut



TOOL SELECTION

Notes when selecting the tool body

Modular holder

GYM25 GYHRUS16D00-M25R 1.000" ☒

Modular holder

GYM25 GYHRUS12C00-M25R .750" ☐

● To ensure sufficient clamping rigidity, select a modular holder with the largest possible shank size.

Modular blade (1)

GYM25 GYHRUS12C00-M25R .750" ☒

Modular holder

GYM20 GYHRUS12C00-M20R .750" ☐

● If there is no restriction for use, select the largest modular blade for the same shank size.

Modular blade (2)

☒ ☐

● Select the shortest possible blade suitable for the application.

Modular blade (3)

☒ ☐

● Select the shortest possible blade suitable for the application.

☒ : Recommended.

Notes when setting the tool

Setting of cutting edge height

<Grooving/Cross-feed machining>
Set the cutting edge height to ± 0.004 " parallel to the central axis.

<Cutting off>
Set the cutting edge height to $0 - +0.008$ " parallel to the central axis.

Tool body setting angle

90° 90°

● Set the insert perpendicular to the central axis.

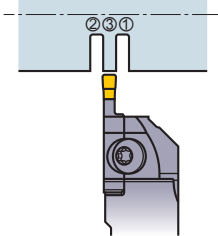
Overhang

● When setting the tool, ensure that the overhang is as short as possible and avoid the step difference part as above figure shows.

MACHINING RECOMMENDATIONS

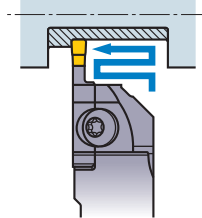
Notes on multi-functional machining (MF·MS and MM breakers)

Machining narrow grooves



- It is recommended to carry out plunging in several passes. Following the steps above makes it difficult for chips to elongate. This also improves the accuracy of workpiece wall surface.

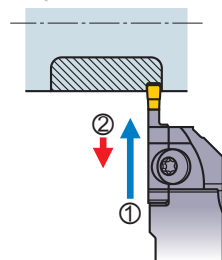
Machining wide grooves



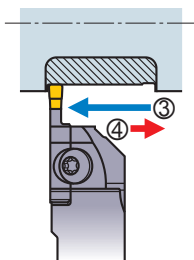
- It is recommended that cross-feed machining is used.

Machining wide grooves

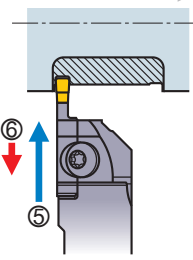
Roughing



- 1 Carry out grooving.
- 2 Retract the tool approx .004".



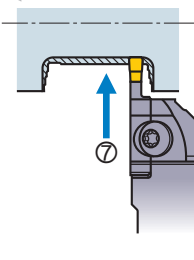
- 3 Carry out cross feed machining.
- 4 Retract the tool approx .004".



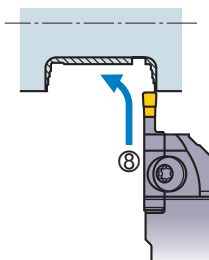
- 5 Carry out grooving.
- 6 Retract the tool approx .004".

* Repeat the steps ①-⑥.

Finishing

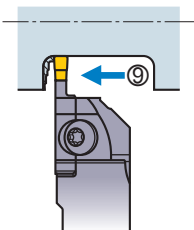


- 7 Carry out grooving to the end point of the corner radius.

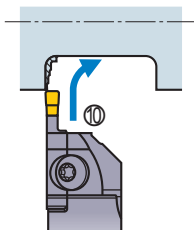


- 8 Machining of the wall surface, corner radius and bottom face should be carried out in one process.

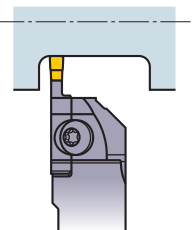
Finishing



- 9 Stop at the bottom of the corner radius.

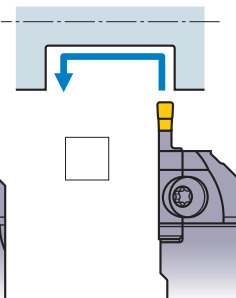
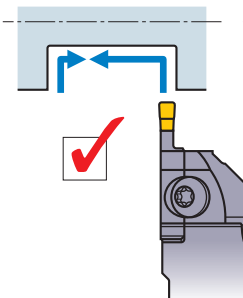


- 10 Machine the counter wall to the corner radius in one process.



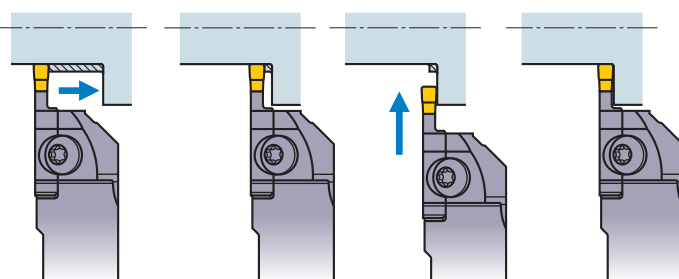
- 11 Finish machining.

Precautions when finishing walls



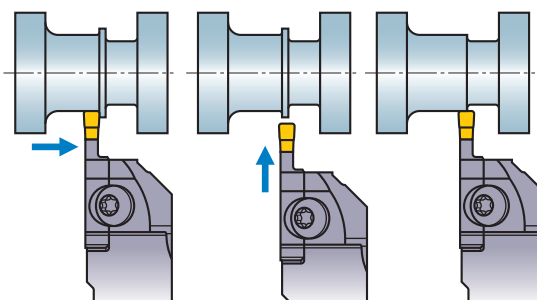
- To produce high accuracy walls using MS or MM breaker insert, do not carry out back turning. Plunging is recommended.

Wall machining



- When machining a wall, chip jamming can occur. In this case, stop cross feed machining just before the wall (at a point less than the insert width) then remove the remaining material by plunging.

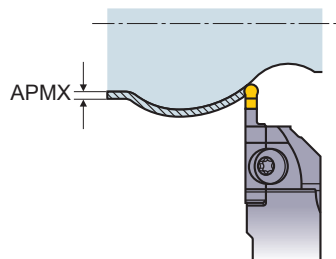
Machining of a ring section



- When a ring remains in a cross feed end process, finish cross feed machining .040"-.059" short of the end point, then remove the ring by plunging.

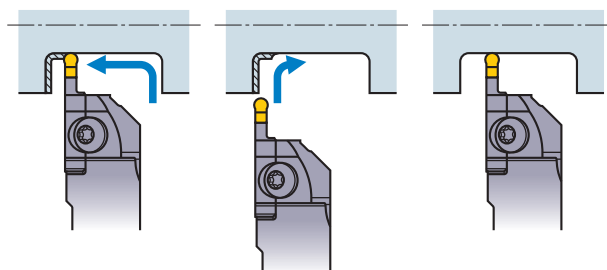
Notes on multi-functional machining (BM breaker)

Copying



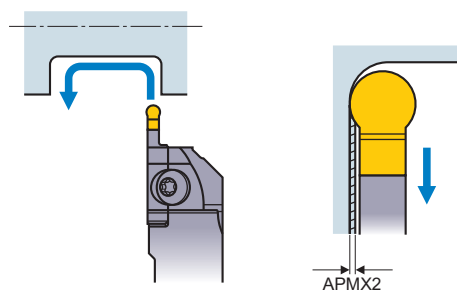
- With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (APMX) to 40% less than the insert width.

Roughing



- Use plunging and cross-feed machining. When machining the corner, vibration is likely to occur. To avoid this, reduce the feed by 50%.

Finishing



- Carry out finishing in one process. For the depth of cut (APMX2) when back turning, refer to the table on the right.

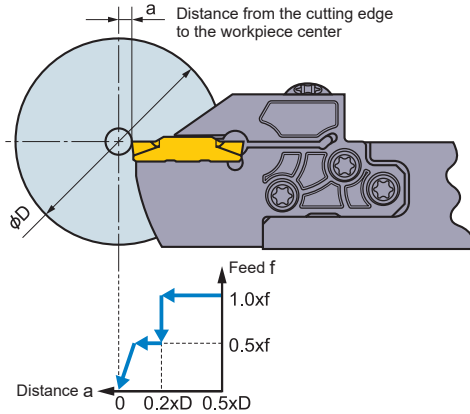
Insert	APMX2 (inch)
GY2M0200D100N-BM	.002
GY2M0250E125N-BM	.004
GY2M0300F150N-BM	.006
GY2M0318F159N-BM	.006
GY2M0400G200N-BM	.008
GY2M0475H238N-BM	.009
GY2M0500H250N-BM	.009
GY2M0600J150N-BM	.012
GY2M0635J318N-BM	.012
GY2M0800K400N-BM	.016

MACHINING RECOMMENDATIONS

Notes for cutting off

feed

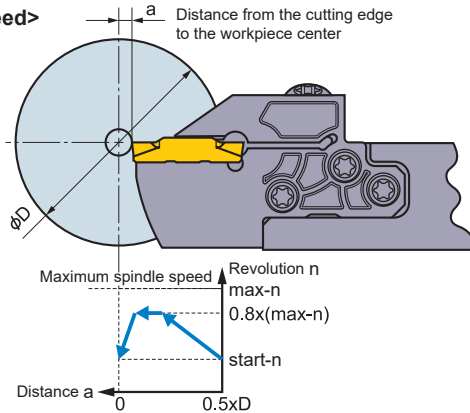
<Feed>



- When the cutting edge approaches the center, reduce the feed by 50%.
- If necessary, stop the feed prior to reaching the center of the workpiece. The part will fall off because of its own weight.

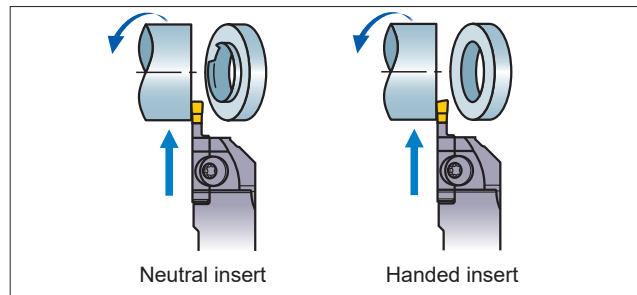
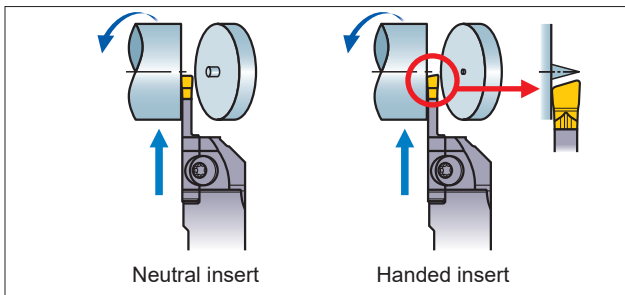
Revolution

<Spindle speed>



- When using constant cutting speed during a cutting off cycle, it is recommended to limit the spindle speed to 80% of maximum to ensure stability.
- To prevent the workpiece from being expelled, lower the spindle speed before finishing the grooving operation.

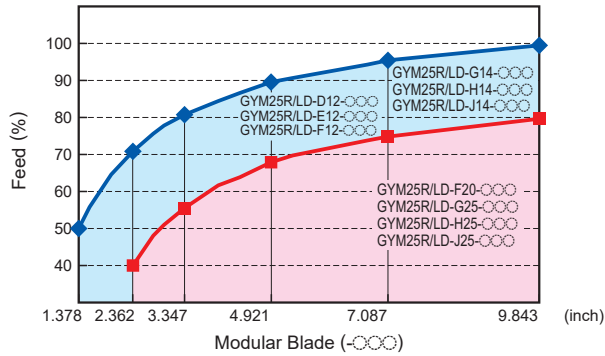
insert



- When there is a center stub on solid bar work or burrs are formed on pipe material, it is possible to decrease them by using a handed insert. With a handed insert, machining tends to be less stable when compared to using a neutral insert. Pay special attention to avoid fracturing of the cutting edge and decrease the feed when necessary.

GROOVING / CUTTING OFF

RELATIONSHIP BETWEEN THE MODULAR BLADE AND FEED PER ROTATION [For Face Grooving]



Note 1) Adjust the feed per rotation in the cutting conditions to the percentage shown in the table above.

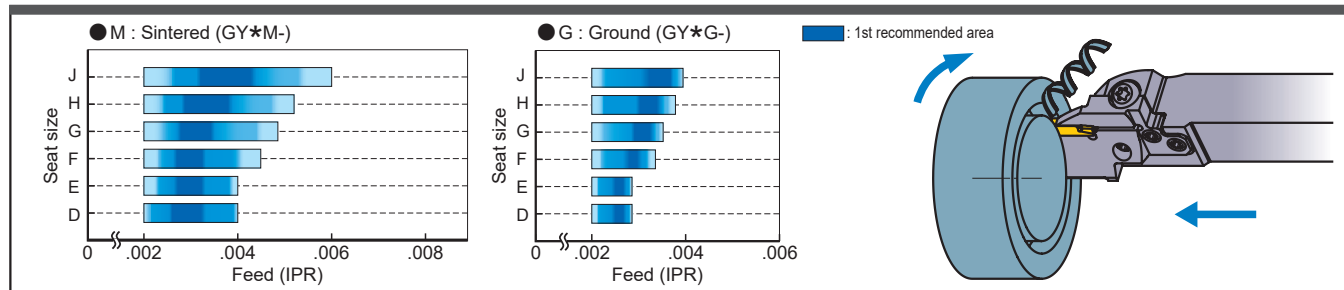
RECOMMENDED CUTTING SPEED (SFM) [For Face Grooving]

	Work Material	Hardness	Grade	Cutting Speed (SFM)					
				165	330	490	655	820	985
F	Mild Steel	≤160HB	VP20RT		260	590			
			VP10RT		295	620			
			NX2525		230	560			
	Carbon Steel Alloy Steel	160—280HB	VP20RT	195	460				
			VP10RT	230	490				
			MY5015		295	690			
			NX2525	180	440				
		≥280HB	VP20RT	165	360				
			VP10RT	195	395				
			MY5015		260	525			
			NX2525	150	345				
M	Stainless Steel	≤270HB	VP20RT	165	360				
			VP10RT	195	395				
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT	195	460				
			VP10RT	230	490				
			MY5015		295	690			
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	165	360				
			VP10RT	195	395				
			MY5015		260	525			
S	Heat Resistant Alloy Titanium Alloy	—	MP9015	130	330				
			MP9025	100	295				
			VP20RT	100	195				
			RT9010	130	230				
H	Hardened steel	≥50HRC	BC8110		195	330			

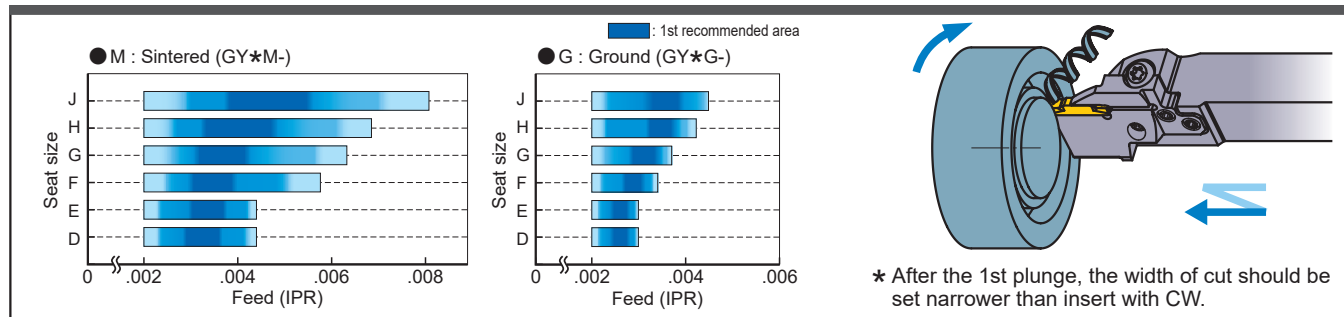
Note 1) For MP9015, MP9025, VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For Face Grooving]

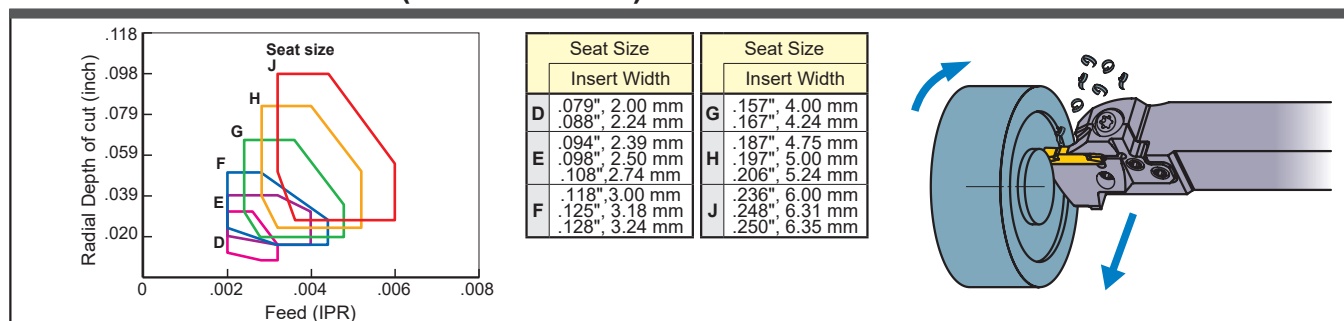
GROOVING



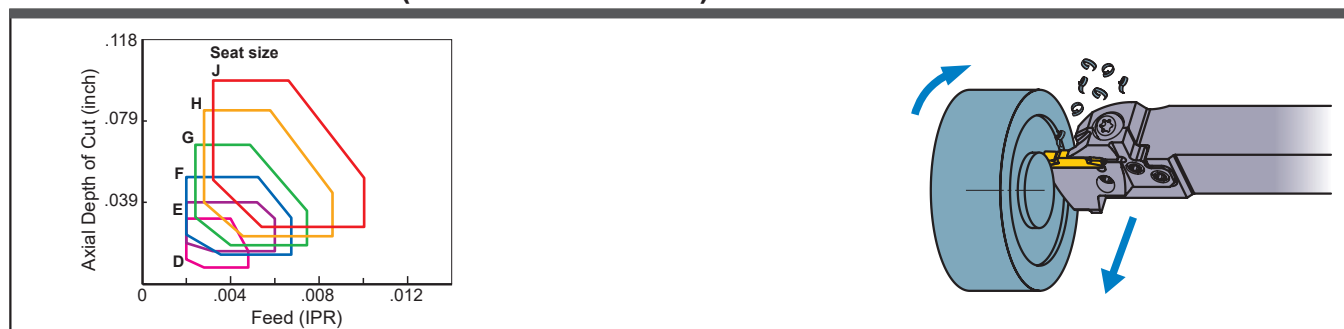
PLUNGING



TRAVERSE MACHINING (MF BREAKER)



TRAVERSE MACHINING (MM/MS BREAKER)



TRAVERSE MACHINING (BM BREAKER)

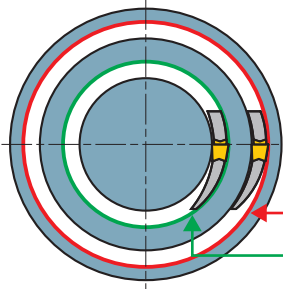


Note 1) GL chip breaker is not recommended for face grooving.

TOOL SELECTION

Notes when selecting the tool body

Modular blade (1)

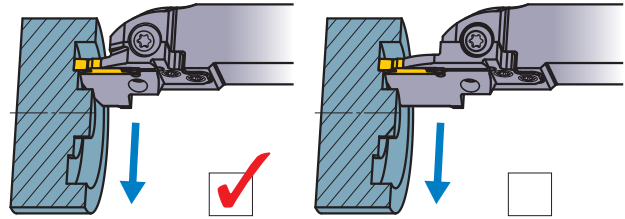


- Select a modular blade for face grooving, so that the cutting diameter at the first pass is within the range of DAXN and DAXX that are described in the table of dimensions.

DAXX (Max.)

DAXN (Min.)

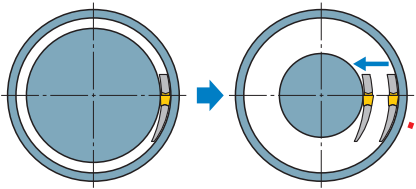
Modular blade (2)



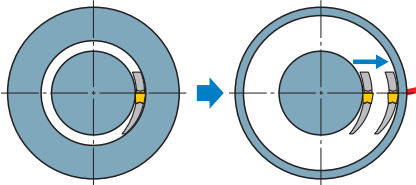
- Select the shortest possible blade suitable for the application.

Modular blade (3)

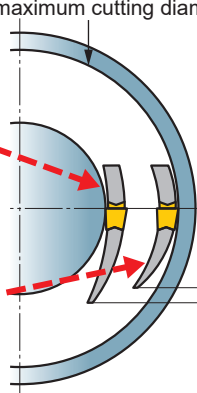
Good



NG



The maximum cutting diameter



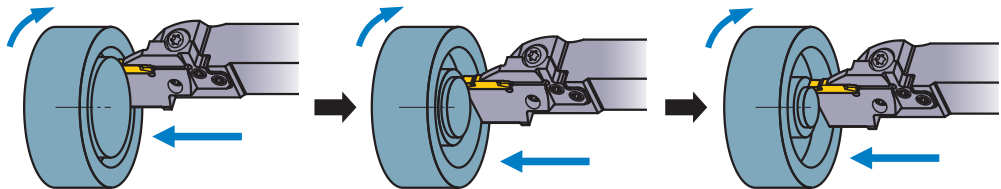
- Select the largest size blade within the maximum cutting diameter of the workpiece.
- Machine from the outer diameter towards the center.



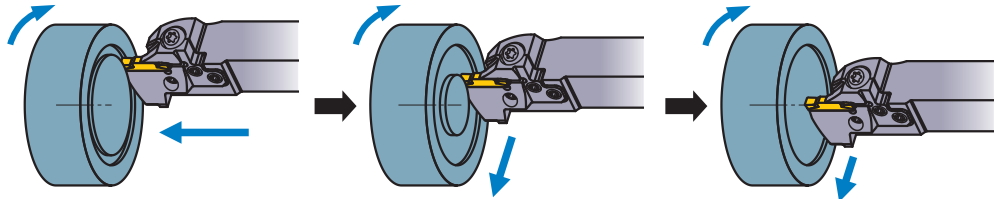
- Increased machining stability and rigidity is possible if a modular blade with the largest possible back metal is used.

- At first, machine the maximum cutting diameter, there is no restriction in the cutting diameter on the remaining process.

- When plunging in several passes.



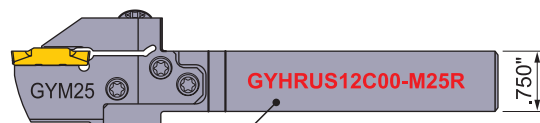
- When combining plunging and infeed machining.



Modular holder



Modular holder



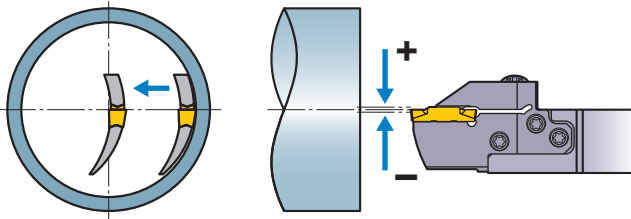
Modular holder



- To ensure sufficient clamping rigidity, select a modular holder with the largest possible shank size.

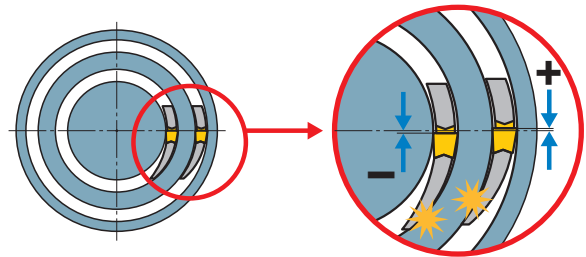
Notes when setting the tool

Setting the cutting edge height



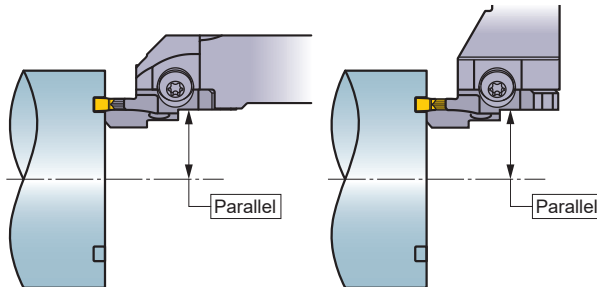
- Set the cutting edge height to ± 0.004 " parallel to the central axis.
- Cutting edge center height check should be done by traverse machining towards the center with a very small depth of cut and ensure that an even surface and no material remains at the center point afterwards.

When interfering the wall of groove and the Modular blade



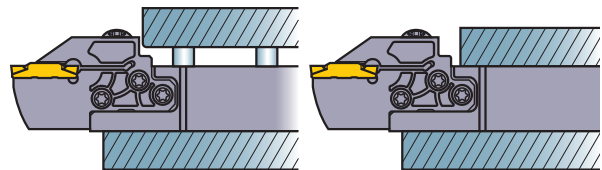
- If interference occurs even when the correct blade is used, the cutting edge height could be incorrect.
 - When interference occurs on the inner side of the blade, the cutting edge height is set too high.
 - When interference occurs on the outer side of the blade, the cutting edge height is set too low.

Setting the tool



- Set the insert parallel to the central axis.

Tool overhang



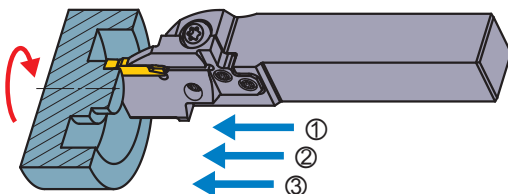
- When setting the tool, ensure that the overhang is as short as possible and avoid the step difference part as above figure shows.

MACHINING RECOMMENDATIONS

Notes when face grooving

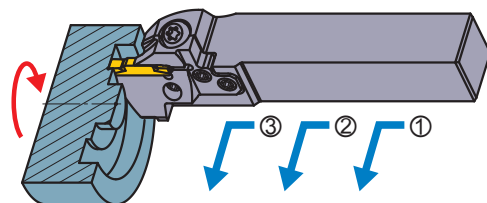
- Always machine from the outer diameter towards the center.

Machining narrow grooves



- Plunging in several passes is recommended.

Machining wide grooves

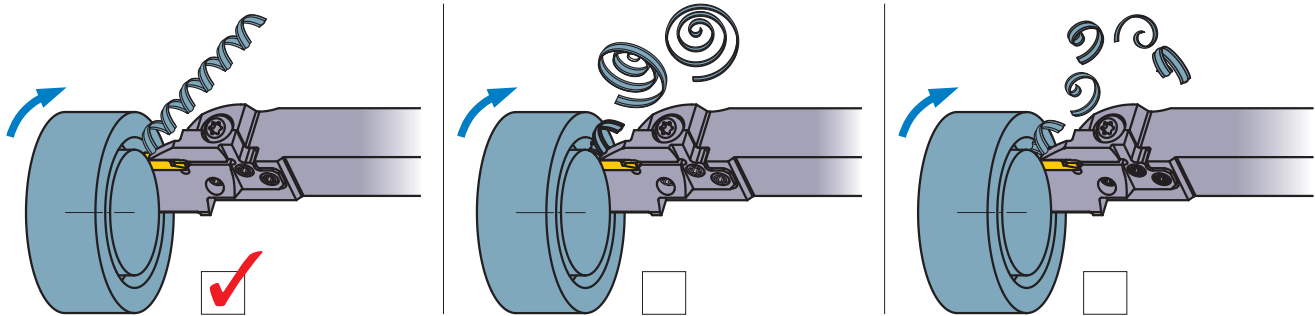


- Cross feed machining is recommended.

MACHINING RECOMMENDATIONS

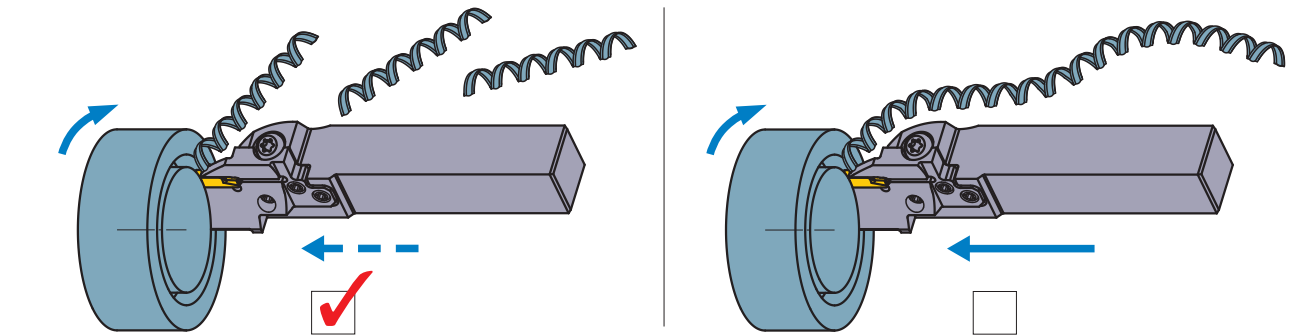
Notes when face grooving

Notes on the first pass (1)



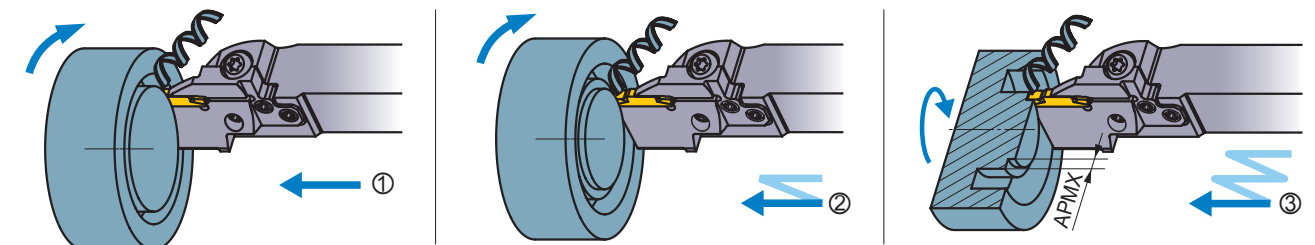
- During the first face grooving pass it is difficult to disperse broken chips and can lead to problems such as a chipped insert. Maintain longer chips that disperse easily by decreasing the feed per rotation.

Notes on the first pass (2)



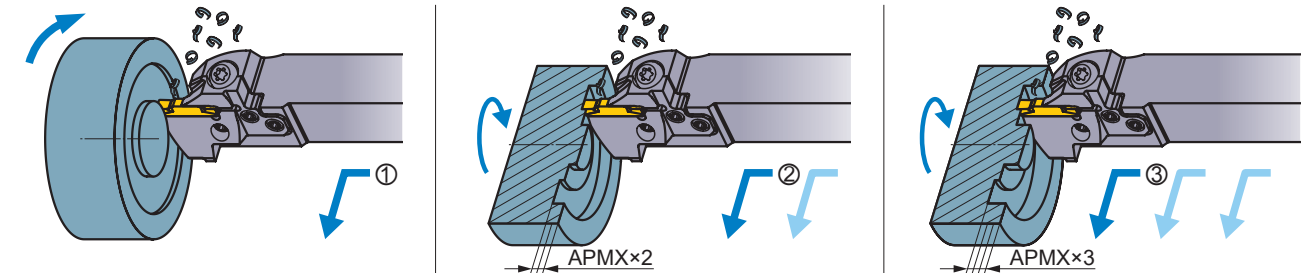
- When chips become too long, use peck feed to break them into a suitable length.

Notes when wide face grooving by plunging in several passes.



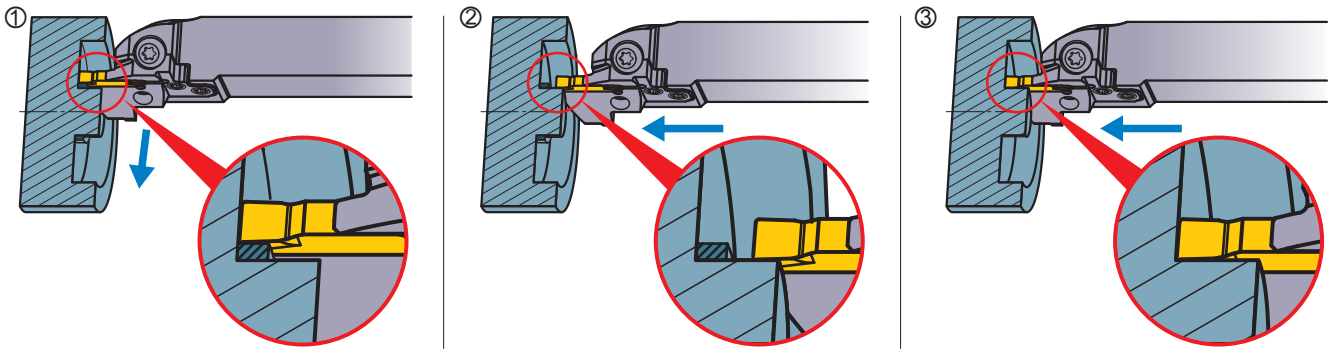
- When machining a face groove in several passes, machine from the outer diameter towards the center so that space for discharging chips is created to prevent insert damage caused by chip jamming.
- Plunging width of cut is recommended to be set at 60 - 80% of the insert width. This enhances the effect of the chipbreaker by enlarging the width of the groove to improve chip dispersal.

Notes when wide face grooving by combination of plunging and traverse machining (1)



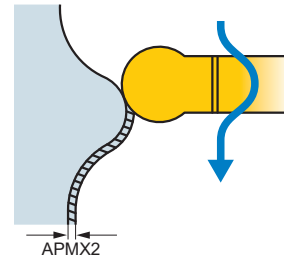
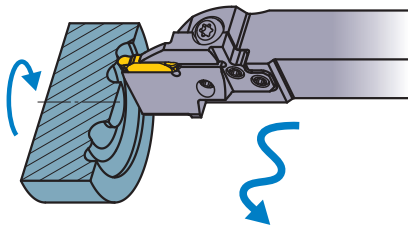
- When face groove machining by using plunge feed and traverse machining, always machine from the outer diameter towards the center to disperse chips outward to avoid chip jamming problems.
- Set the depth of cut within 40% of the insert width.

Notes when wide face grooving by combination of plunging and traverse machining (2)



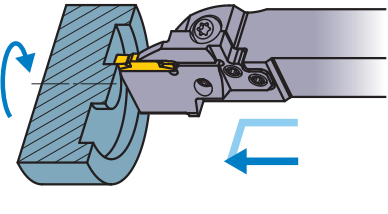
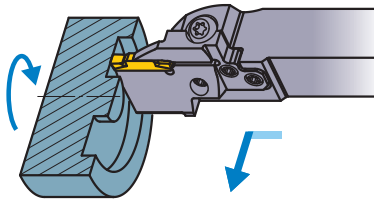
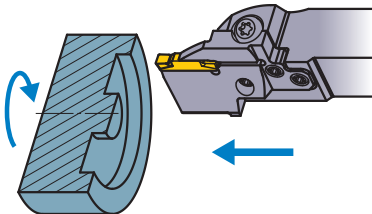
- When infeed machining at the bottom of deep groove, chips may interfere on the cutting edge near the center wall. In such cases, stop infeed machining just before the center wall (at a point less than the insert width) then remove the remaining material by plunging.

Notes when copying (BM Breaker)



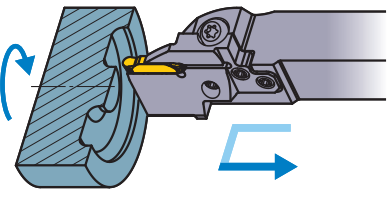
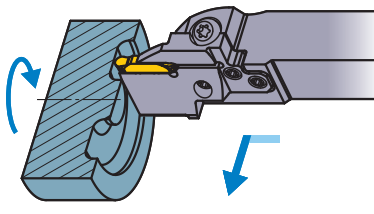
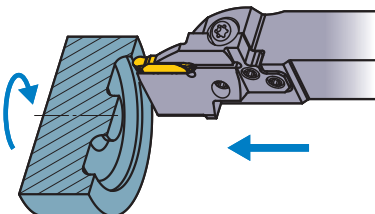
- With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (APMX2) to 30% of the insert width.

Finishing (1)

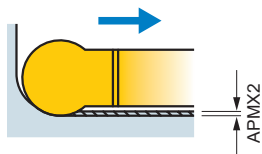


- When finish cutting, machine continuously from the outer wall to the bottom of the groove, then finally plunge cut the center wall.

Finishing (2) (BM Breaker)



- Carry out finishing in one process. For the depth of cut (APMX2) when back turning, refer to the table on the right.



Insert	APMX2 (inch)
GY2M0200D100N-BM	.004
GY2M0250E125N-BM	
GY2M0300F150N-BM	
GY2M0318F159N-BM	
GY2M0400G200N-BM	.006
GY2M0475H238N-BM	
GY2M0500H250N-BM	.008
GY2M0600J150N-BM	
GY2M0635J318N-BM	.010

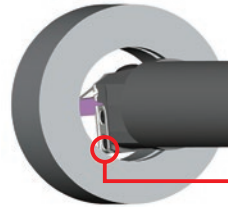
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For Internal Grooving]

•When using the mono block type

The maximum groove depth is not limited by the cutting diameter.

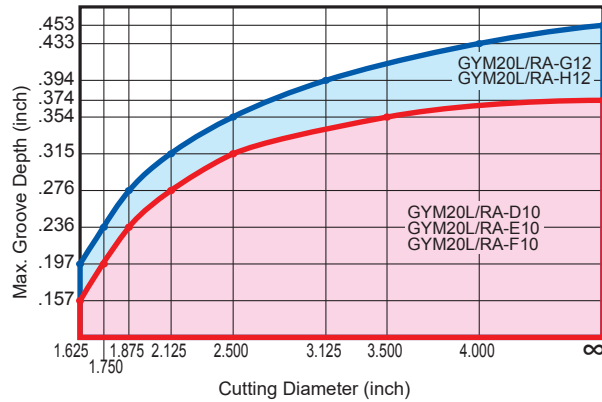
•When using the modular blade type

The maximum groove depth is limited by the cutting diameter.

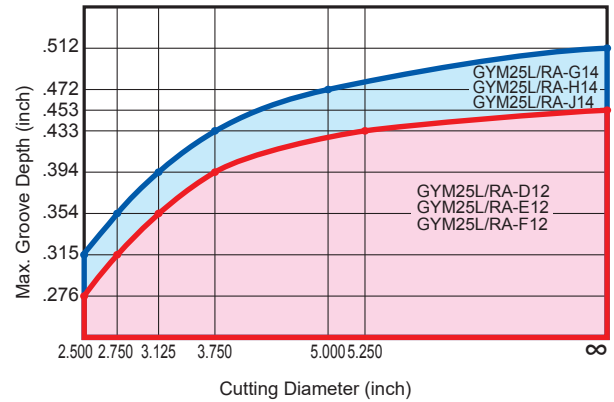


Due to interference of this part, the maximum groove depth is limited by the cutting diameter.

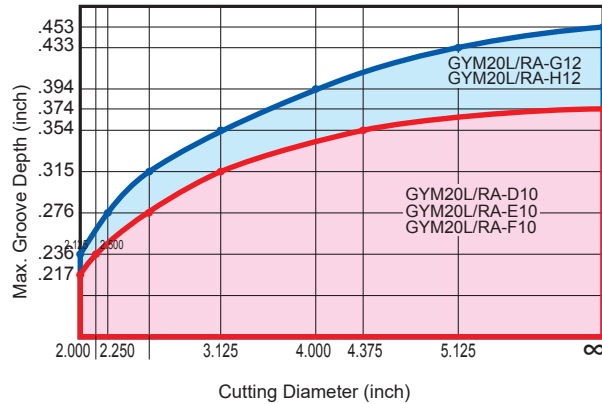
Shank Diameter=1.250 inch (GYM20 Blade)



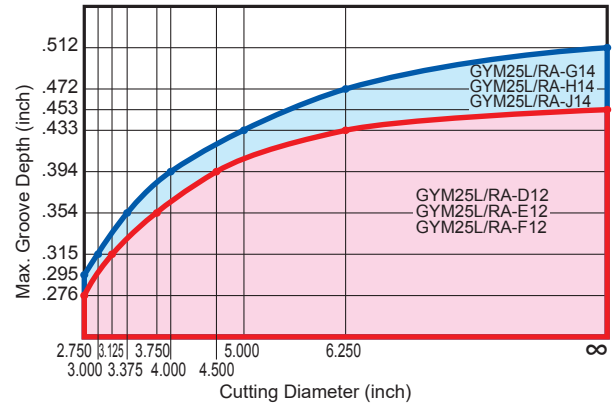
Shank Diameter=1.500 inch (GYM25 Blade)



Shank Diameter=1.500 inch (GYM20 Blade)



Shank Diameter=2.000 inch (GYM25 Blade)

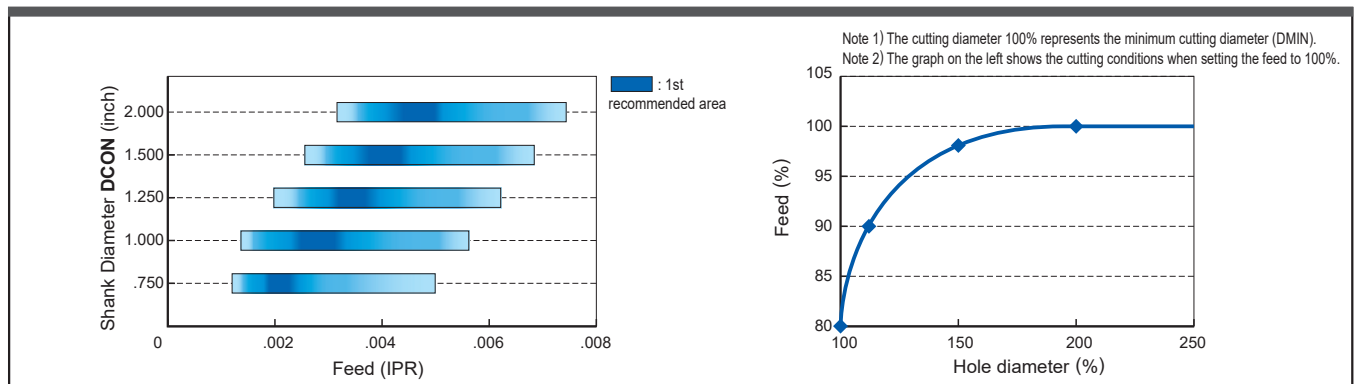


RECOMMENDED CUTTING SPEED (SFM) [For Internal Grooving]

	Work Material	Hardness	Grade	Cutting Speed (SFM)						
				165	330	490	655	820	985	1310
P	Mild Steel	≤160HB	VP20RT		260	590				
			VP10RT		295	620				
			NX2525		230	560				
	Carbon Steel Alloy Steel	160–280HB	VP20RT		195	460				
			VP10RT		230	490				
			MY5015		295	690				
			NX2525		180	440				
		≥280HB	VP20RT		165	360				
			VP10RT		195	395				
			MY5015		260	525				
			NX2525		150	345				
M	Stainless Steel	≤270HB	VP20RT		165	360				
			VP10RT		195	395				
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT		195	460				
			VP10RT		230	490				
			MY5015		295	690				
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT		165	360				
			VP10RT		195	395				
			MY5015		260	525				
S	Heat Resistant Alloy Titanium Alloy	—	MP9015		130	330				
			MP9025		100	295				
			VP20RT		100	195				
			VP10RT / RT9010		130	230				
H	Hardened steel	≥50HRC	BC8110		195	330				
N	Aluminum Alloy	Content Si<5%	RT9010			490			1310	
	Aluminum Alloy	Content 5%≤Si≤10%	RT9010			490			1310	
	Aluminum Alloy	Content Si>10%	RT9010		260	525				

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

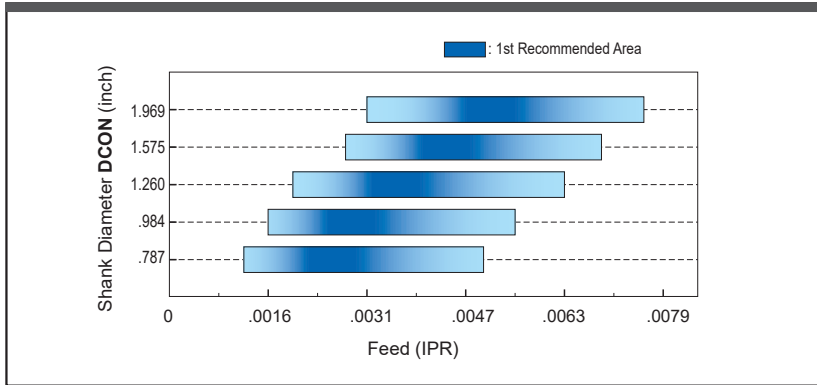
GROOVING



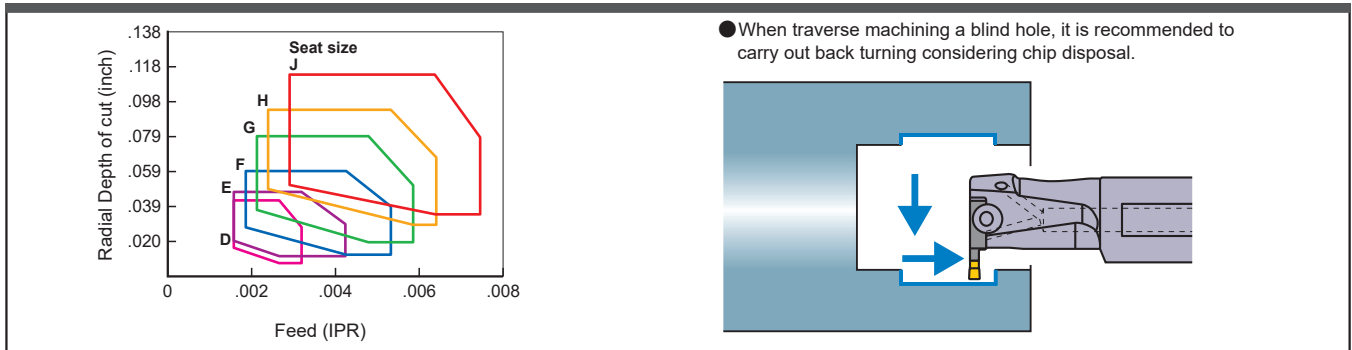
GROOVING / CUTTING OFF

RECOMMENDED CUTTING CONDITIONS [For Internal Grooving]

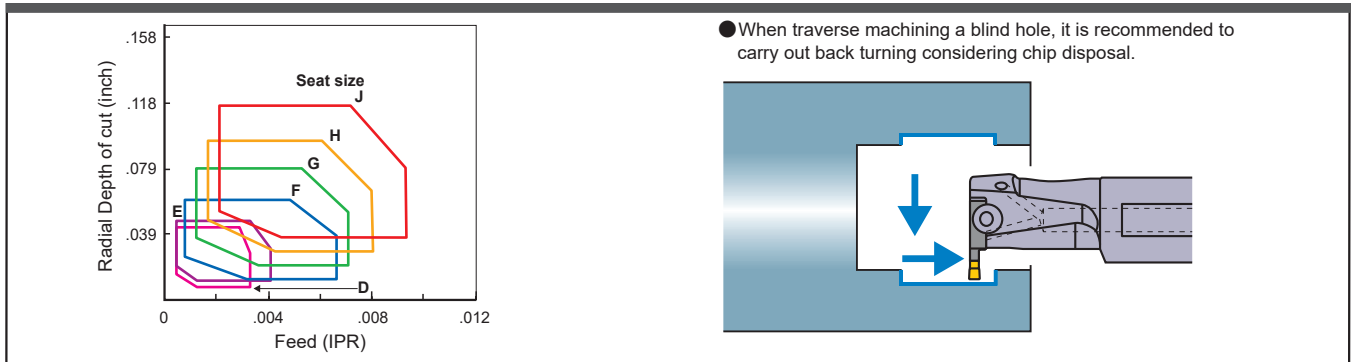
GROOVING (GL BREAKER)



TRAVERSE MACHINING (MF BREAKER)

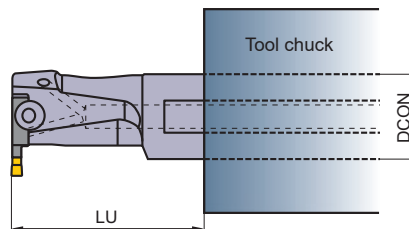


TRAVERSE MACHINING (MM/MS BREAKER)



Note 1) The above cutting conditions are for when using the tool overhang (LU) 1.6-2.0 times larger than the shank diameter (DCON). (L/D=1.6-2.0)
When using L/D larger than 2.0, reduce the cutting conditions.

Seat Size	
Insert Width	
D	.079", 2.00 mm
	.088", 2.24 mm
E	.094", 2.39 mm
	.098", 2.50 mm
	.108", 2.74 mm
F	.118", 3.00 mm
	.125", 3.18 mm
	.128", 3.24 mm
G	.157", 4.00 mm
	.167", 4.24 mm
H	.187", 4.75 mm
	.197", 5.00 mm
	.206", 5.24 mm
J	.236", 6.00 mm
	.248", 6.31 mm
	.250", 6.35 mm



TOOL SELECTION

Notes when selecting the tool body

Holder

● When the overhang is the same, select a holder with the largest possible shank size to ensure sufficient clamping rigidity.

Modular blade (1)

● For a $\phi 1.5"$ & $\phi 40$ mm shank holder, if there is no restriction for use, select a holder suitable for GYM25 blade.

Modular blade (2)

GYM20R/LA-000

GYM20R/LA-D10
GYM20R/LA-E10
GYM20R/LA-F10
GYM20R/LA-G12
GYM20R/LA-H12

GYM25R/LA-000

GYM25R/LA-D12
GYM25R/LA-E12
GYM25R/LA-F12
GYM25R/LA-G14
GYM25R/LA-H14
GYM25R/LA-J14

● For an internal holder, select a modular blade listed above.

Notes when setting the tool

Overhang

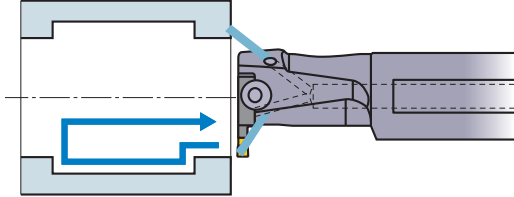
● The maximum groove depth is limited to the dimension LDRED. When machining with longer overhangs, refer to the dimension WF2 of the tool used.

MACHINING RECOMMENDATIONS

Notes on multi-function machining (MF, MS and MM breakers)

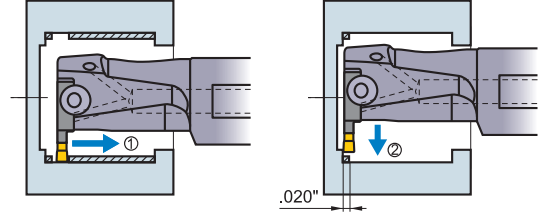
For internal grooving, the machining methods for external grooving (F202 – F203) can be used, but please note the following precautions.

Coolant



- Supply large amounts of coolant for effective chip disposal during cutting. Maintain supply until the tool has been retracted completely for improved chip disposal.

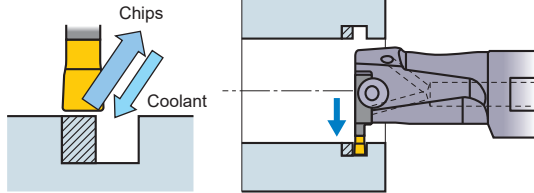
Machining blind holes



- As continuous chips tend to elongate at the back of the bore, the above operation is recommended. The recommended width of cut for ② is .020 inch.

Machining Wide Grooves

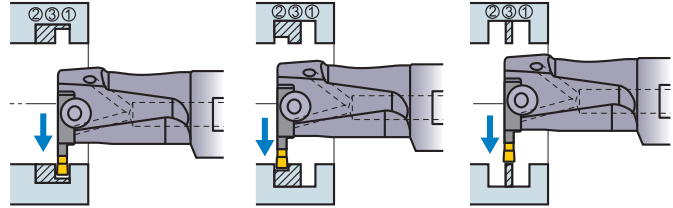
- When the insert width is $x \geq$ groove width



- When the depth of cut is shallower than the insert width, continuous chips are usually produced. When plunging in several passes, it is recommended to carry out machining in the steps above. This ensures that coolant reaches the cutting edge and chips are easily discharged.

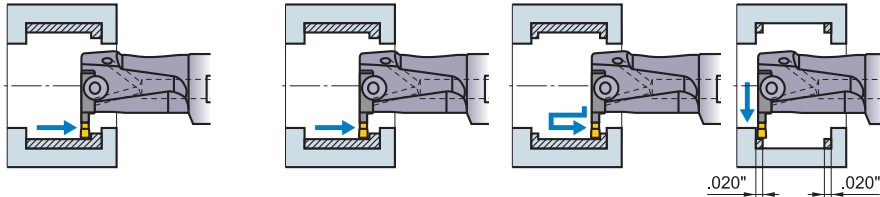
Grooving

- When the insert width is $x <$ groove width



- When the groove depth is larger than the insert width, carry out plunging in the steps above to break up chips efficiently.

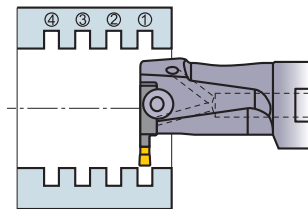
Turning



- When chip breaking and disposal are especially important, cross-feed machining is recommended.

- Wide face grooving when the corner R of the workpiece is equal to the corner R of the insert, machine as shown above. (When corner R of the workpiece is larger than corner R of the insert, refer to the description of external wide grooving.)
- If the groove depth exceeds a given level, chips may elongate at the wall. In such a case, increase the feed and carry out machining as shown above.

Machining instruction



- It is recommended to carry out grooving from the front end of the workpiece. This reduces workpiece deflection.

GW Series

Easy to Utilize Configuration that Improves Tool Handling

Clamp

Simple insert clamping method offering high rigidity.

To prevent the insert from being pulled out during machining a reverse taper angle has been designed from the front of the insert. Additionally the design also includes 3 large locating faces between the insert and the blade offering increased cutting edge reliability. The blade itself is made from a special alloy steel to suit this application.



Reverse Taper Angle

In respect to insert indexing, a unique wrench is supplied to ensure ease when changing the insert.

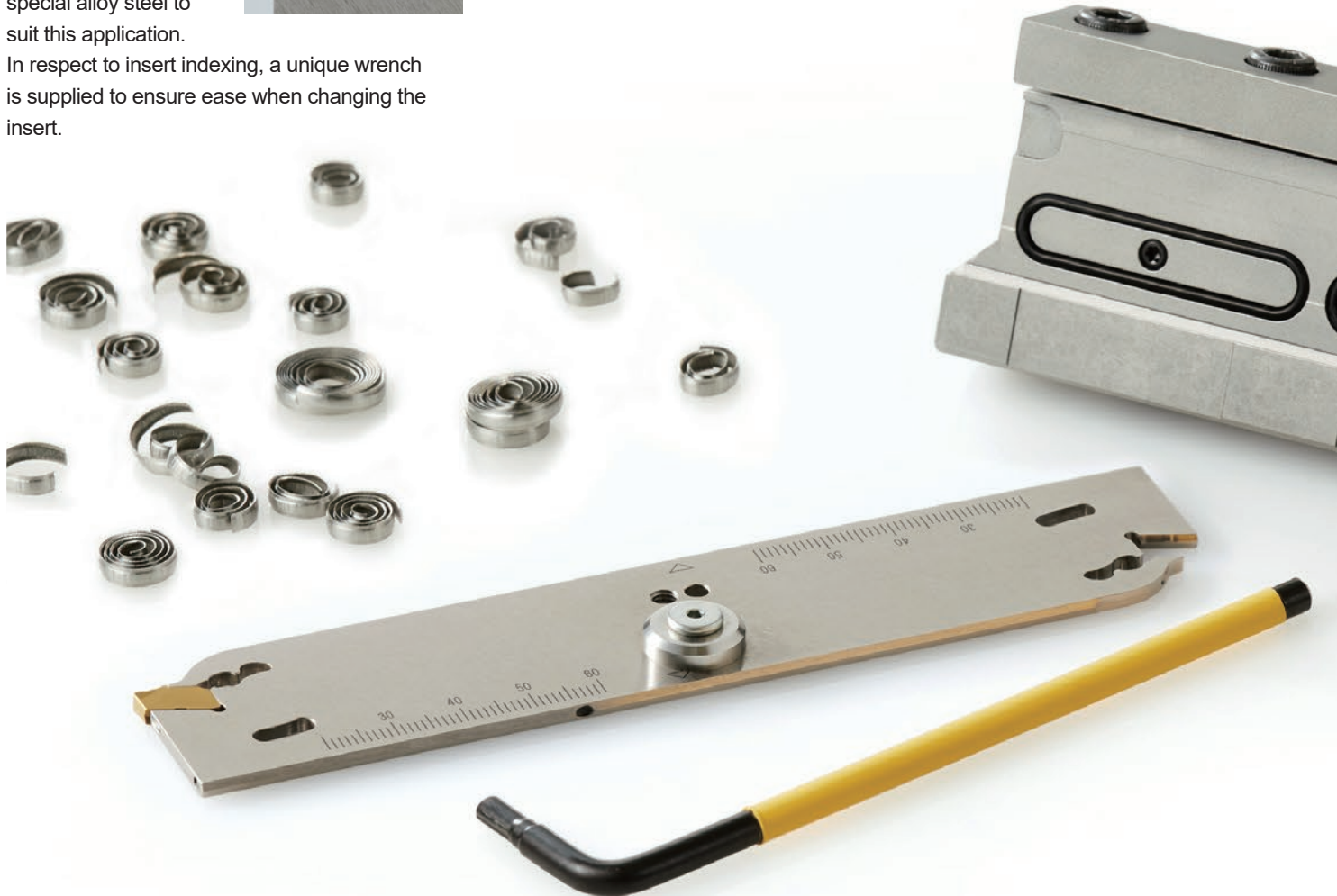
Voice of Developer

Just how easy is it to set an insert?

With the use of a unique wrench, it is possible to locate and remove the insert with one simple action making it easier for use in the workplace.

F

GROOVING / CUTTING OFF



Through Coolant Blade

Increased wear resistance due to the use of 2 through coolant ejection holes.

2 through coolant holes supply the coolant to both the rake and flank face, leading to effective cutting edge cooling and increased wear resistance.

Additionally this blade can also be used for both low pressure and high pressure coolant (1000 PSI).



Voice of Developer

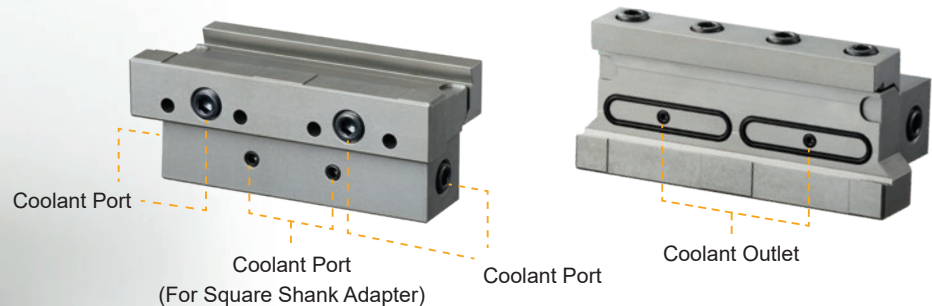
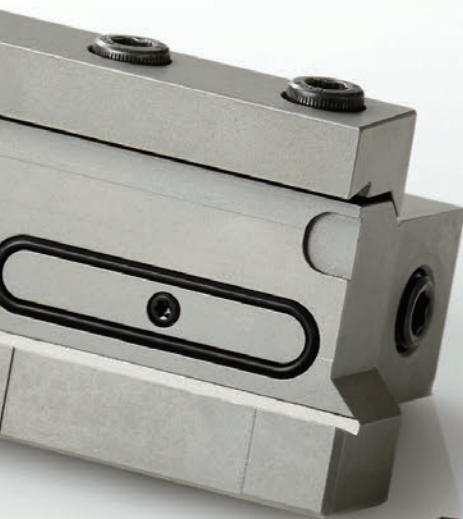
How is it possible to reduce heat generation?

The 2 coolant holes used in the blade are capable of using high coolant pressures of up to (1000 PSI). This is achieved by using as large as possible through coolant hole diameter. The ejection holes are located close to the cutting edge to improve the cutting edge cooling effect and increasing wear resistance.

Coolant Ports

Flexible set up possible with the use of 6 coolant ports.

There are 6 coolant ports designed into the tool block. This makes it easier for the end user to set up the tool block and blade to a configuration that suits their needs. If necessary it is also possible to use coolant hose. The ejection type coolant also improves cutting edge cooling and chip evacuation.



Voice of Developer

Possible set up to suit the requirements of the workplace environment.

One of the objectives of this product is to respond to the customers complaints that "the product did not fit and could not be used". Starting with the coolant outlet that prevents leaks even when oil quantity or overhangs change. Everything from the material and the shape of the O-ring, to the length of the hose has been tailored to the effective use in the workplace.

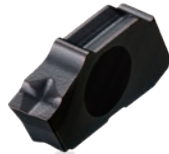
Chip Breaker

Breaker System Offering Excellent Chip Disposal Properties

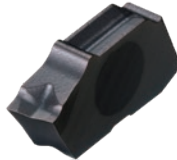
Low Feeds



Neutral



Right Hand (5°)



Right Hand (8°)

GS Breaker

Medium Feeds



Neutral



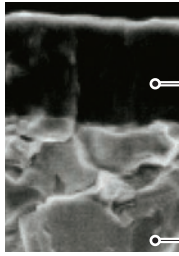
Right Hand / Left Hand (5°)

GM Breaker

Insert Grades

Work Material		Machining Condition			
		P Steel	M Stainless Steel	K Cast Iron	S Heat Resistant Alloy / Titanium Alloy
Machining Condition ↑ ↓	Stable	MY5015		MY5015	VP10RT
		VP10RT	VP10RT		
		VP20RT	VP20RT	VP10RT	
				VP20RT	VP20RT
	Unstable	VP30RT	VP30RT		

VP20RT (1st Recommendation)

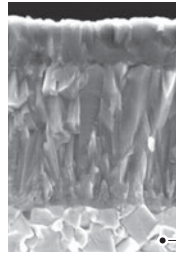


- PVD coated grade suitable for a wide range of applications. The combination of a special tough cemented carbide substrate with MIRACLE coating provides an excellent balance of wear and fracture resistance.

MIRACLE Coating

Carbide Substrate (90.5HRA)

MY5015

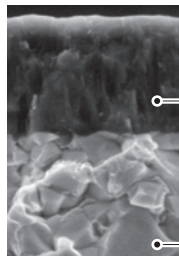


- MY5015 is a CVD coated grade with excellent wear resistance even at high temperatures. It provides longer tool life when machining cast and ductile cast iron. Also suitable for high speed continuous cutting of steels.

CVD Coated Carbide

Carbide Substrate

VP10RT

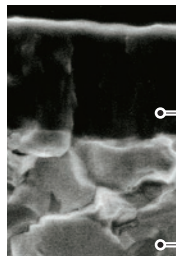


- PVD coated grade with a cemented carbide substrate harder than VP20RT. For use on difficult-to-cut materials and for extending tool life.

MIRACLE Coating

Carbide Substrate (92.0HRA)

VP30RT



- A combination of a tough, special cemented carbide substrate and MIRACLE coating. Ideal for heavy interrupted cutting of stainless and general steels.

MIRACLE Coating (Al,Ti)N

Carbide Substrate (88.8HRA)

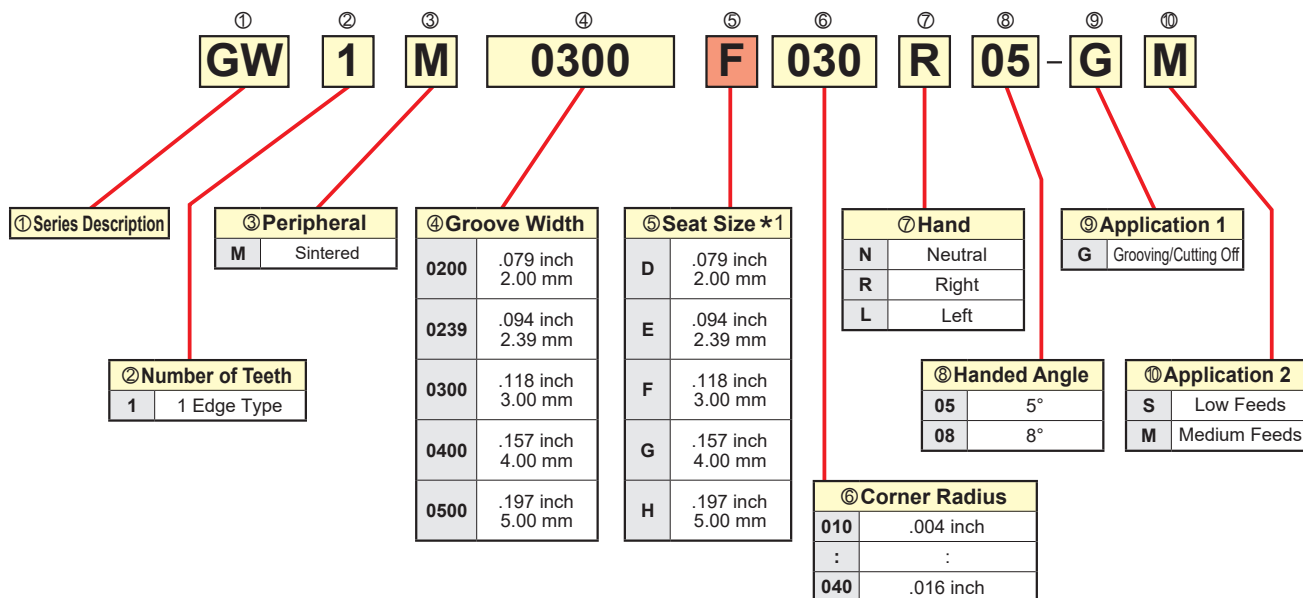
F

GROOVING / CUTTING OFF

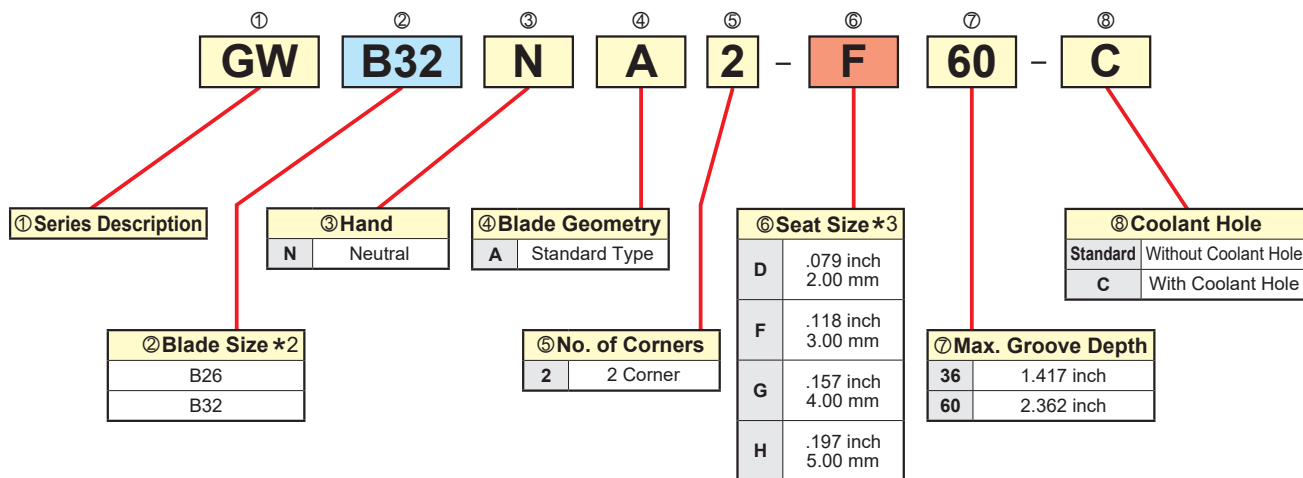
IDENTIFICATION OF GW SERIES

■ Insert / Blade / Tool Block

● Insert

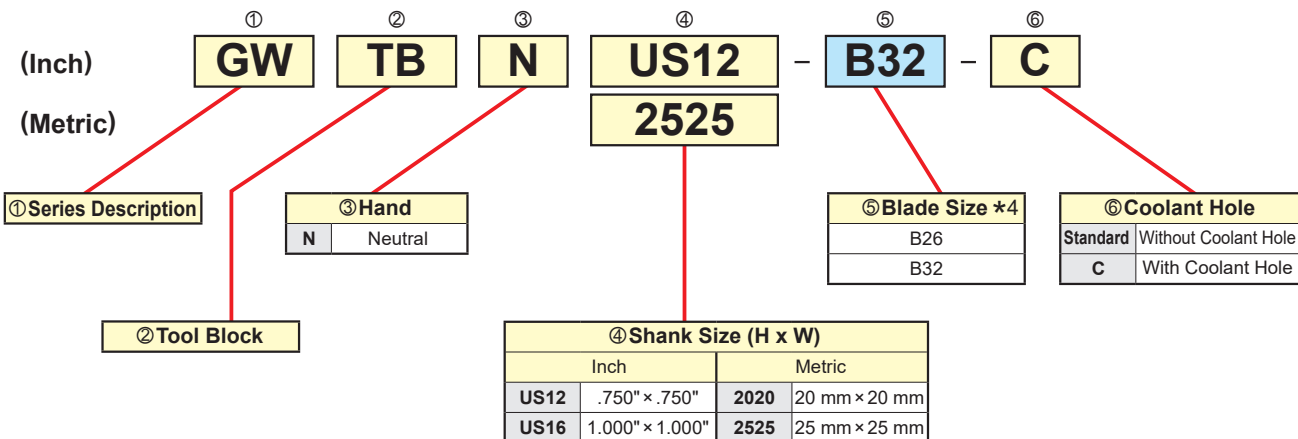


● Blade

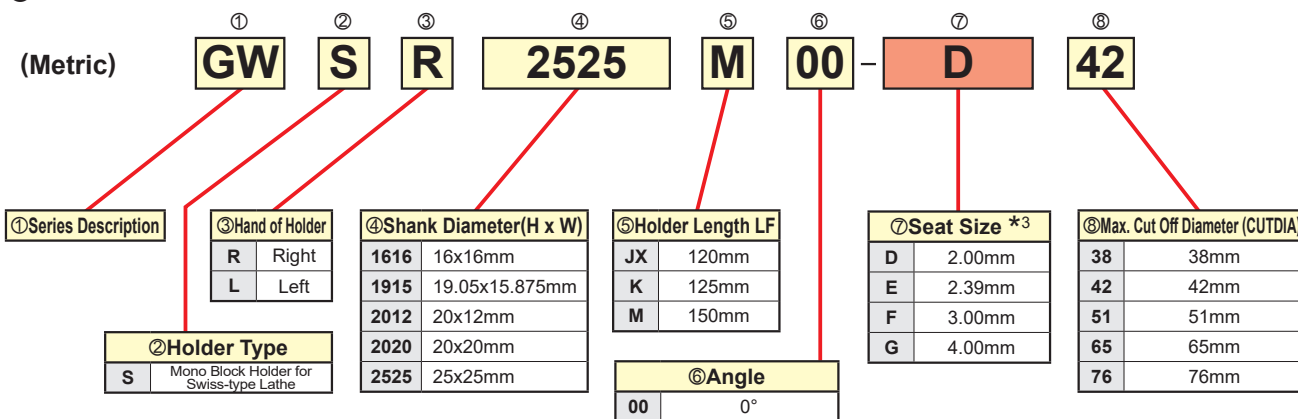


- *1 Select seat size with the same symbol as that of blade.
 *2 Select blade size with the same symbol as that of tool block.
 *3 Select seat size with the same symbol of the insert.
 *4 Select blade size with the same symbol as that of blade.

● Tool Block

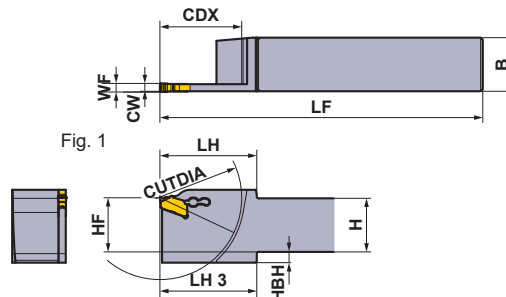
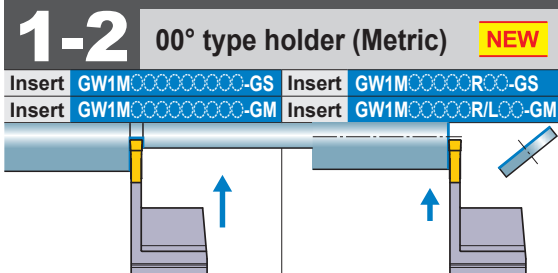


● MONO BLOCK HOLDER



- *1 Select seat size with the same symbol as that of blade.
 *2 Select blade size with the same symbol as that of tool block.
 *3 Select seat size with the same symbol of the insert.
 *4 Select blade size with the same symbol as that of blade.

GW SERIES (External for Swiss-type lathes)



Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number		Fig.	
						Holder	Stock		
D	2.00	19	38	Mono Block	R	GWSR1616JX00-D38	★	1	
				Mono Block	L	GWSL1616JX00-D38	★	1	
		21	42	Mono Block	R	GWSR1915K00-D38	★	1	
				Mono Block	L	GWSL1915K00-D38	★	1	
				Mono Block	R	GWSR2020K00-D42	★	1	
				Mono Block	L	GWSL2020K00-D42	★	1	
				Mono Block	R	GWSR2012K00-D42	★	1	
				Mono Block	L	GWSL2012K00-D42	★	1	
E	2.39	19	38	Mono Block	R	GWSR1915K00-E38	★	1	
				Mono Block	L	GWSL1915K00-E38	★	1	
		21	42	Mono Block	R	GWSR2020K00-E42	★	1	
				Mono Block	L	GWSL2020K00-E42	★	1	
				Mono Block	R	GWSR2020K00-E42-M	★	3	
				Mono Block	L	GWSL2020K00-E42-M	★	3	
				Mono Block	R	GWSR2012K00-E42	★	1	
				Mono Block	L	GWSL2012K00-E42	★	1	
F	3.00	19	38	Mono Block	R	GWSR1915K00-F38	●	1	
				Mono Block	L	GWSL1915K00-F38	●	1	
		21	42	Mono Block	R	GWSR2012K00-F42	●	1	
				Mono Block	L	GWSL2012K00-F42	●	1	
				Mono Block	R	GWSR2020K00-F42	●	1	
				Mono Block	L	GWSL2020K00-F42	●	1	
				Mono Block	R	GWSR2020K00-F42-M	●	3	
				Mono Block	L	GWSL2020K00-F42-M	●	3	
		25.5	51	Mono Block	R	GWSR2020K00-F51	●	1	
				Mono Block	L	GWSL2020K00-F51	●	1	
				Mono Block	R	GWSR2020K00-F51-M	●	3	
				Mono Block	L	GWSL2020K00-F51-M	●	3	
		32.5	65	Mono Block	R	GWSR2525M00-F51	●	1	
				Mono Block	L	GWSL2525M00-F51	●	1	
				Mono Block	R	GWSR2020M00-F65	●	1	
				Mono Block	L	GWSL2020M00-F65	●	1	
		38	76	Mono Block	R	GWSR2525M00-F76	●	1	
				Mono Block	L	GWSL2525M00-F76	●	1	
G	4.00	38	76	Mono Block	R	GWSR2525M00-G76	★	1	
				Mono Block	L	GWSL2525M00-G76	★	1	

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

● : USA Stock ★ : Stocked in Japan

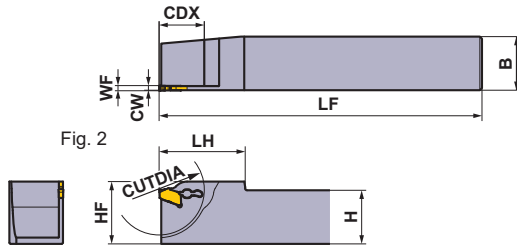


Fig. 2

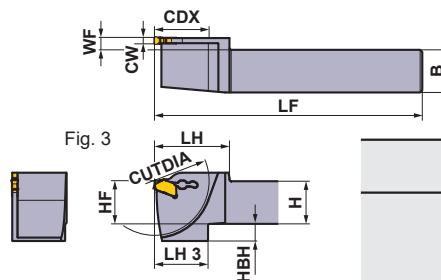


Fig. 3

Right hand tool holder shown.

Left hand tool holder shown.

SPARE PARTS

Holder	
	Wrench
GWSR/L1616JX00-D38	
GWSR/L00000000-0000	GWY39L
GWSR/L2020K00-0000-M	

Dimensions (mm)								Cutting Mode	
H	B	LF	LH	LH 3	HF	WF	HBH	Clockwise	Anticlockwise
16	16	120	30	30	16	0.3	6		
16	16	120	30	30	16	0.3	6		
19.05	15.875	125	35	35	19.05	0.3	3		
19.05	15.875	125	35	35	19.05	0.3	3		
20	20	125	35	25	20	0.3	4		
20	20	125	35	25	20	0.3	4		
20	12	125	35	25	20	0.3	4		
20	12	125	35	25	20	0.3	4		
25	25	150	40	—	25	0.3	—		
25	25	150	40	—	25	0.3	—		
19.05	15.875	125	35	35	19.05	0.2	3		
19.05	15.875	125	35	35	19.05	0.2	3		
20	20	125	35	25	20	0.2	4		
20	20	125	35	25	20	0.2	4		
20	20	125	35	25	20	5.7	8		
20	12	125	35	25	20	0.2	4		
20	12	125	35	25	20	0.2	4		
25	25	150	40	—	25	0.2	—		
25	25	150	40	—	25	0.2	—		
19.05	15.875	125	35	35	19.05	0.3	3		
19.05	15.875	125	35	35	19.05	0.3	3		
20	12	125	35	25	20	0.3	4		
20	12	125	35	25	20	0.3	4		
20	20	125	35	25	20	0.3	4		
20	20	125	35	25	20	0.3	4		
20	20	125	35	25	20	5.8	8		
20	20	125	35	25	20	0.3	8		
20	20	125	35	25	20	0.3	8		
20	20	125	35	25	20	5.8	8		
25	25	150	40	40	25	0.3	3		
25	25	150	40	40	25	0.3	3		
20	20	150	40	33	20	0.3	10		
20	20	150	40	33	20	0.3	10		
25	25	150	45	45	25	0.3	5		
25	25	150	45	45	25	0.3	5		
25	25	150	45	45	25	0.4	5		
25	25	150	45	45	25	0.4	5		

Select an Insert

Seat Size	Insert Number
D	GW1M0200D000N-Breaker
	GW1M0200D000R/L00-Breaker
E	GW1M0239E000N-Breaker
	GW1M0239E000R/L00-Breaker
F	GW1M0300F000N-Breaker
	GW1M0300F000R/L00-Breaker
G	GW1M0400G000N-Breaker
	GW1M0400G000R/L00-Breaker

For grooving/cutting off breaker > F229						
Seat Size	Breaker CW	GS (Low)	GM (Medium)	05-GS (Low)	08-GS (Low)	05-GM (Cutting off)
		Neutral	Neutral	Hand	Hand	Hand
D	.079", 2.00 mm	●	●	●	●	●
E	.094", 2.39 mm	●	●	●	●	●
F	.118", 3.00 mm	●	●	●	●	●
G	.157", 4.00 mm	●	●	●	●	●

● : Standard insert with dimensions

GROOVING / CUTTING OFF

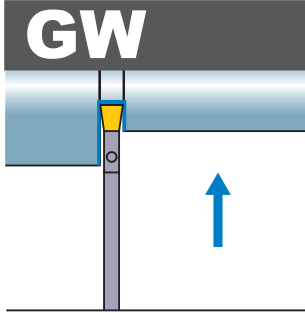
IDENTIFICATION > F222
 INSERTS > F229
 CUTTING CONDITIONS > F231
 INSTRUCTION MANUAL > F233

F225

GROOVING / CUTTING OFF

GW BLADE

- Simple insert clamping method offering high rigidity.
- The blade is possible to use with both external or through coolant.
- Groove Depth CW .079— .197 inch



For External Cutting Off / Grooving

Fig.1

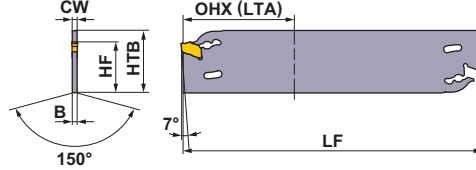
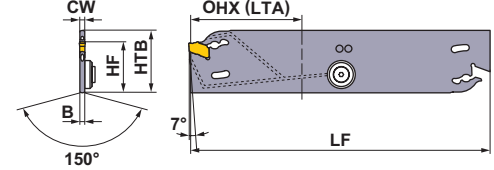


Fig.2



Without Coolant Hole

(inch)

Seat Size	CW	*1 CUTDIA	Order Number	Stock	*2 OHN	*3 OHX (LTA)	B	LF	HTB	HF	Fig.			Tool Block Type
												Insert Type	Wrench	
D	.079	2.835	GWB26NA2-D36	●	.630	1.417	.061	4.331	1.024	.843	1	GW1M0200D	GWY39L	GWTBN-B26
		4.724	GWB32NA2-D60	●	.630	2.362	.061	5.906	1.260	.984	1	GW1M0200D	GWY39L	GWTBN-B32
F	.118	2.835	GWB26NA2-F36	●	.630	1.417	.096	4.331	1.024	.843	1	GW1M0300F	GWY39L	GWTBN-B26
		4.724	GWB32NA2-F60	●	.630	2.362	.096	5.906	1.260	.984	1	GW1M0300F	GWY39L	GWTBN-B32
G	.157	2.835	GWB26NA2-G36	●	.748	1.417	.132	4.331	1.024	.843	1	GW1M0400G	GWY39L	GWTBN-B26
		4.724	GWB32NA2-G60	●	.748	2.362	.132	5.906	1.260	.984	1	GW1M0400G	GWY39L	GWTBN-B32
H	.197	2.835	GWB26NA2-H36	●	.748	1.417	.167	4.331	1.024	.843	1	GW1M0500H	GWY39L	GWTBN-B26
		4.724	GWB32NA2-H60	●	.748	2.362	.167	5.906	1.260	.984	1	GW1M0500H	GWY39L	GWTBN-B32

With Coolant Hole

(inch)

Seat Size	CW	*1 CUTDIA	Order Number	Stock	*2 OHN	*3 OHX (LTA)	B	LF	HTB	HF	Fig.			Tool Block Type
												Insert Type	Wrench	
D	.079	2.835	GWB26NA2-D36-C	●	.630	1.417	.061	4.331	1.024	.843	2	GW1M0200D	GWY39L	GWTBN-B26-C
		4.724	GWB32NA2-D60-C	●	.630	2.362	.061	5.906	1.260	.984	2	GW1M0200D	GWY39L	GWTBN-B32-C
F	.118	2.835	GWB26NA2-F36-C	●	.630	1.417	.096	4.331	1.024	.843	2	GW1M0300F	GWY39L	GWTBN-B26-C
		4.724	GWB32NA2-F60-C	●	.630	2.362	.096	5.906	1.260	.984	2	GW1M0300F	GWY39L	GWTBN-B32-C
G	.157	2.835	GWB26NA2-G36-C	●	.748	1.417	.132	4.331	1.024	.843	2	GW1M0400G	GWY39L	GWTBN-B26-C
		4.724	GWB32NA2-G60-C	●	.748	2.362	.132	5.906	1.260	.984	2	GW1M0400G	GWY39L	GWTBN-B32-C
H	.197	2.835	GWB26NA2-H36-C	●	.748	1.417	.167	4.331	1.024	.843	2	GW1M0500H	GWY39L	GWTBN-B26-C
		4.724	GWB32NA2-H60-C	●	.748	2.362	.167	5.906	1.260	.984	2	GW1M0500H	GWY39L	GWTBN-B32-C

*1 CUTDIA: Maximum Cut Off Diameter *2 OHN: Minimum Overhang Length *3 OHX(LTA): Maximum Overhang Length

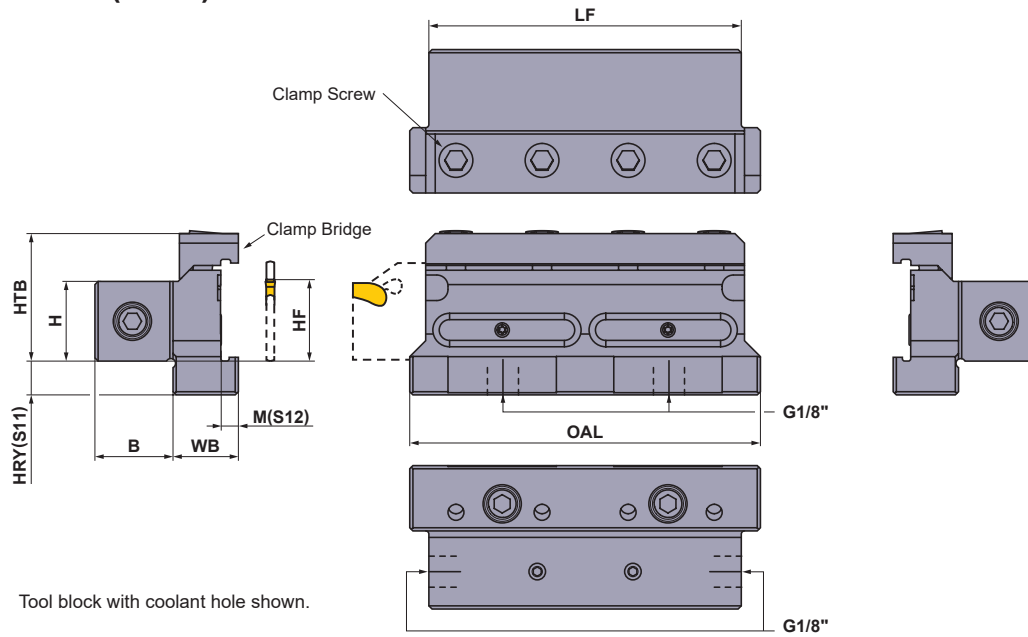
Note 1) Recommended Maximum Coolant Pressure 1000PSI

Spare Parts for Blades with Coolant Hole

(inch)

Order Number	CW			
		Washer	Clamp Screw	Plug Wrench
GWB26NA2-D36-C	.079	①GWW04038	GW04005F	HKY20R
GWB32NA2-D60-C	.079	①GWW04038	GW04005F	HKY20R
GWB26NA2-F36-C	.118	①GWW04038	GW04005F	HKY20R
GWB32NA2-F60-C	.118	①GWW04038	GW04005F	HKY20R
GWB26NA2-G36-C	.157	②GWW04026	GW04005F	HKY20R
GWB32NA2-G60-C	.157	②GWW04026	GW04005F	HKY20R
GWB26NA2-H36-C	.197	②GWW04026	GW04005F	HKY20R
GWB32NA2-H60-C	.197	②GWW04026	GW04005F	HKY20R

■ TOOL BLOCK (INCH)



Without Coolant Hole

Order Number	Stock	H	HF	HTB	HRY (S11)	B	WB	M (S12)	LF	OAL			
											Clamp Bridge	Clamp Screw	Wrench
GWTBNUS12-B26	●	.750	.750	1.28	.470	.730	.790	.200	2.950	3.350	①GWCW1	HSC06020	HKY50R
GWTBNUS12-B32	●	.750	.750	1.34	.650	.730	.810	.220	3.940	4.330	②GWCW2	HSC06020	HKY50R
GWTBNUS16-B26	●	1.000	1.000	1.53	.220	.980	.790	.200	2.950	3.350	①GWCW1	HSC06020	HKY50R
GWTBNUS16-B32	●	1.000	1.000	1.59	.400	.980	.810	.220	3.940	4.330	②GWCW2	HSC06020	HKY50R

With Coolant Hole

Order Number	Stock	H	HF	HTB	HRY (S11)	B	WB	M (S12)	LF	OAL			
											Clamp Bridge	Clamp Screw	Wrench
GWTBNUS12-B26-C	●	.750	.750	1.28	.470	.730	.790	.200	2.950	3.350	①GWCW1	HSC06020	HKY50R
GWTBNUS12-B32-C	●	.750	.750	1.34	.650	.730	.810	.220	3.940	4.330	②GWCW2	HSC06020	HKY50R
GWTBNUS16-B26-C	●	1.000	1.000	1.53	.220	.980	.790	.200	2.950	3.350	①GWCW1	HSC06020	HKY50R
GWTBNUS16-B32-C	●	1.000	1.000	1.59	.400	.980	.810	.220	3.940	4.330	②GWCW2	HSC06020	HKY50R

★ Clamp Torque (lbf-in) : HSC06020=62

Note 1) Recommended Maximum Coolant Pressure 1000 PSI

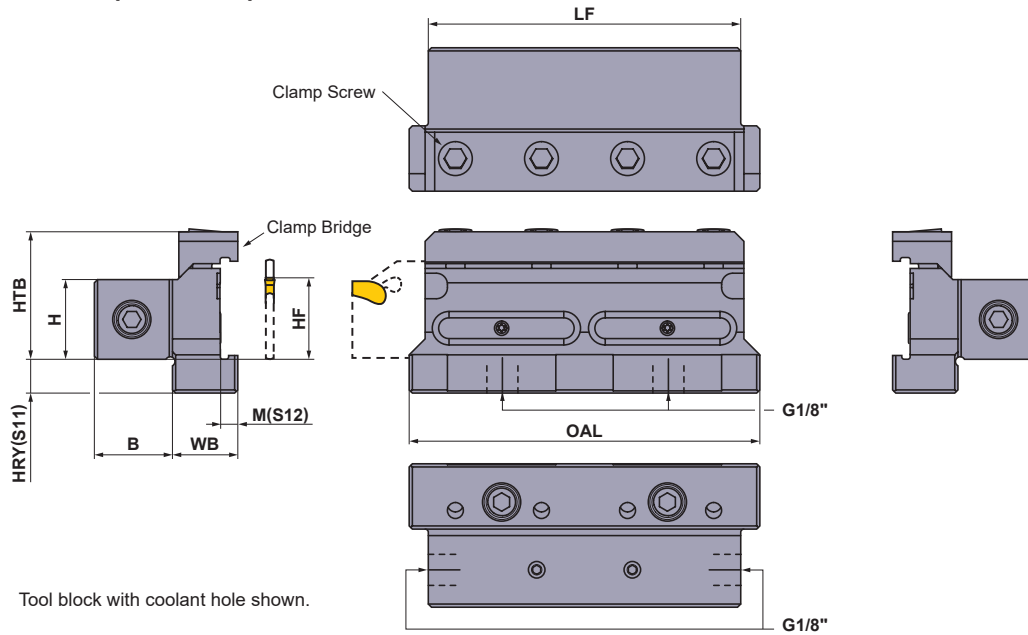
Spare Parts for Tool Block with Coolant Hole

Order Number						
	O-ring	Plug	Plug	Wrench	Plug	Wrench
GWTBNUS12-B26-C	①ORGW332N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBNUS12-B32-C	②ORGW457N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBNUS16-B26-C	①ORGW332N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBNUS16-B32-C	②ORGW457N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R

F

GROOVING / CUTTING OFF

■ TOOL BLOCK (METRIC)



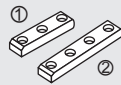
Tool block with coolant hole shown.

F

GROOVING / CUTTING OFF

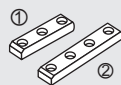
Without Coolant Hole

(mm)

Order Number	Stock	H	HF	HTB	HRY (S11)	B	WB	M (S12)	LF	OAL			
											Clamp Bridge	Clamp Screw	Wrench
GWTBN2020-B26	★	20	20	33.5	11	19.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2020-B32	★	20	20	35.0	15.6	19.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R
GWTBN2525-B26	★	25	25	38.5	6	24.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2525-B32	★	25	25	40.0	10.6	24.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R

With Coolant Hole

(mm)

Order Number	Stock	H	HF	HTB	HRY (S11)	B	WB	M (S12)	LF	OAL			
											Clamp Bridge	Clamp Screw	Wrench
GWTBN2020-B26-C	★	20	20	33.5	11	19.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2020-B32-C	★	20	20	35.0	15.6	19.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R
GWTBN2525-B26-C	★	25	25	38.5	6	24.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2525-B32-C	★	25	25	40.0	10.6	24.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R

★ Clamp Torque (N • m) : HSC06020=7.0

Note 1) Recommended Maximum Coolant Pressure 7MPa

Spare Parts for Tool Block with Coolant Hole

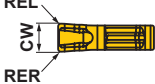
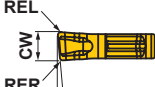
Order Number						
	O-ring	Plug	Plug	Wrench	Plug	Wrench
GWTBN2020-B26-C	①ORGW332N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBN2020-B32-C	②ORGW457N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBN2525-B26-C	①ORGW332N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBN2525-B32-C	②ORGW457N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R

● : USA Stock ★ : Stocked in Japan

<10 inserts in one case>

■ INSERTS

(inch)

Application	Order Number	Stock				Seat Size	CW			RER REL	PSIRR PSIRL	Geometry
		Coating					Cutting Width		Tolerance			
		MY5015	VP10RT	VP20RT	VP30RT							
Grooving, Cutting Off	GW1M0200D020N-GS		●	●	●	D	.079	(2.00)	±.0012	.008	—	
Grooving, Cutting Off	NEW GW1M0239E020N-GS		●	●	●	E	.094	(2.39)	±.0012	.008	—	
Grooving, Cutting Off	GW1M0300F020N-GS		●	●	●	F	.118	(3.00)	±.0012	.008	—	
Grooving, Cutting Off	GW1M0400G020N-GS		●	●	●	G	.157	(4.00)	±.0016	.008	—	
Grooving, Cutting Off	GW1M0500H030N-GS		●	●	●	H	.197	(5.00)	±.0016	.012	—	
Grooving, Cutting Off	GW1M0200D020N-GM	●	●	●	●	D	.079	(2.00)	±.0012	.008	—	
Grooving, Cutting Off	NEW GW1M0239E020N-GM	●	●	●	●	E	.094	(2.39)	±.0012	.008	—	
Grooving, Cutting Off	GW1M0300F030N-GM	●	●	●	●	F	.118	(3.00)	±.0012	.012	—	
Grooving, Cutting Off	GW1M0400G030N-GM	●	●	●	●	G	.157	(4.00)	±.0016	.012	—	
Grooving, Cutting Off	GW1M0500H040N-GM	●	●	●	●	H	.197	(5.00)	.0016	.016	—	
Cutting off, Low Feed	NEW GW1M0200D020R05-GS		●	●	●	D	.079	(2.00)	±.0012	.008	5	
Cutting off, Low Feed	NEW GW1M0239E020R05-GS		●	●	●	E	.094	(2.39)	±.0012	.008	5	
Cutting off, Low Feed	NEW GW1M0300F020R05-GS		●	●	●	F	.118	(3.00)	±.0012	.008	5	
Cutting off Low Feed, Lead Angle 8°	NEW GW1M0200D003R08-GS		●	●	●	D	.079	(2.00)	±.0012	.0012	8	
Cutting off Low Feed, Lead Angle 8°	NEW GW1M0239E003R08-GS		●	●	●	E	.094	(2.39)	±.0012	.0012	8	
Cutting off Low Feed, Lead Angle 8°	NEW GW1M0300F003R08-GS		●	●	●	F	.118	(3.00)	±.0012	.0012	8	
Cutting Off	GW1M0200D020R05-GM		●	●	●	D	.079	(2.00)	±.0012	.008	5	
Cutting Off	GW1M0200D020L05-GM		●	●	●	D	.079	(2.00)	±.0012	.008	5	
Cutting Off	NEW GW1M0239E020R05-GM		●	●	●	E	.094	(2.39)	±.0012	.008	5	
Cutting Off	NEW GW1M0239E020L05-GM		●	●	●	E	.094	(2.39)	±.0012	.008	5	
Cutting Off	GW1M0300F030R05-GM		●	●	●	F	.118	(3.00)	±.0012	.012	5	
Cutting Off	GW1M0300F030L05-GM		●	●	●	F	.118	(3.00)	±.0012	.012	5	
Cutting Off	GW1M0400G030R05-GM		●	●	●	G	.157	(4.00)	±.0016	.012	5	
Cutting Off	GW1M0400G030L05-GM		●	●	●	G	.157	(4.00)	±.0016	.012	5	
Cutting Off	GW1M0500H040R05-GM		●	●	●	H	.197	(5.00)	±.0016	.016	5	
Cutting Off	GW1M0500H040L05-GM		●	●	●	H	.197	(5.00)	±.0016	.016	5	Right hand insert shown.

Right hand insert shown.

● = **NEW**

F
GROOVING / CUTTING OFF

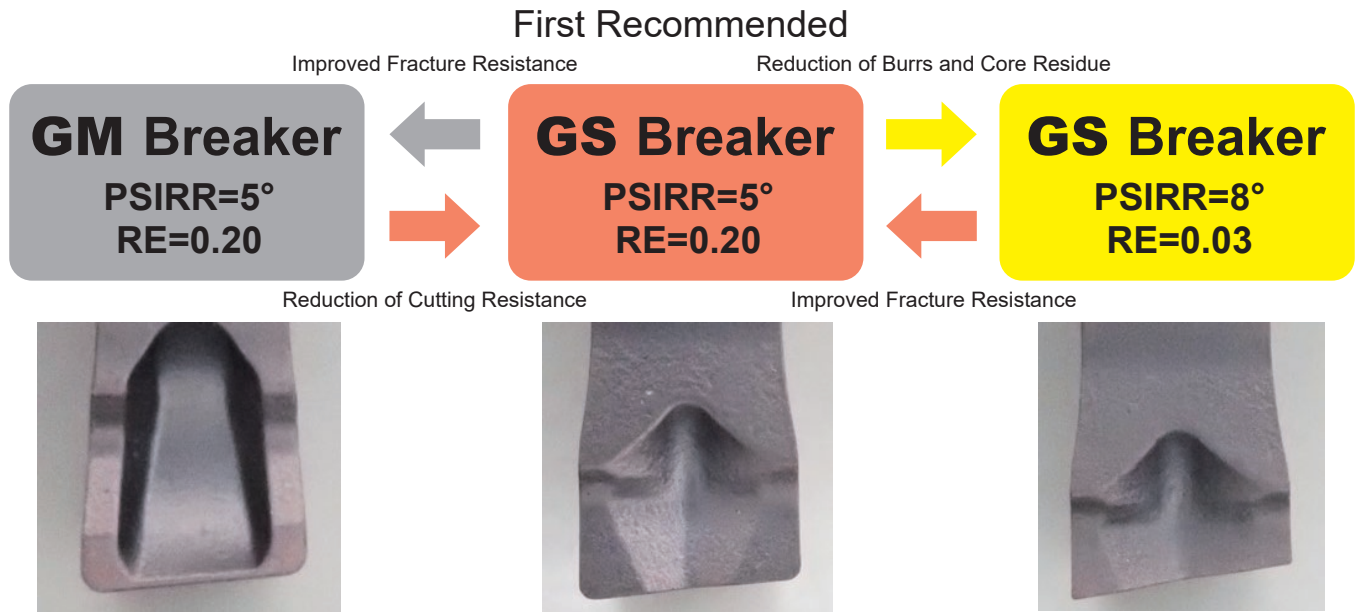
Blank Inserts

(inch)

Geometry	Order Number	Carbide		Seat Size	CW			RER	REL
		RT9010	RT9020		Grooving Width		Tolerance		
					inch	(mm)			
1 Edge Type REL CW RER 	GW1B0320D020N	★	★	D	.128	(3.24)	±0.10	.008	.008
	GW1B0440F020N	★	★	F	.175	(4.44)	±0.10	.008	.008
	GW1B0540G020N	★	★	G	.214	(5.44)	±0.10	.008	.008
	GW1B0640H020N	★	★	H	.254	(6.44)	±0.10	.008	.008

★ Insert blank is not suitable for machining without grinding.

Proper Use of GW Series Right Hand Inserts



F

GROOVING / CUTTING OFF

■ Coolant Hose Kit

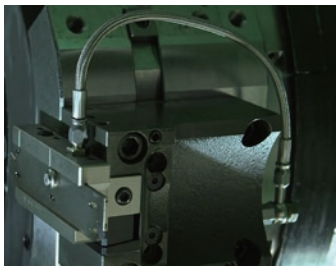
(inch)

Connector Type	Order Number	Stock	Hose Length	Kit Details								
												
				Hose	Banjo Adapter		Banjo Bolt		Adapter		Washer	
				Code No.	Code No.	QTY.	Code No.	QTY.	Code No.	QTY.	Code No.	QTY.
Straight	CS-1/8-150SS	●	5.91	HOSE-1/8-150	—	—	—	—	AD-G1/8	2	WA-M10	2
Straight	CS-1/8-200SS	●	7.87	HOSE-1/8-200	—	—	—	—	AD-G1/8	2	WA-M10	2
Straight	CS-1/8-250SS	●	9.84	HOSE-1/8-250	—	—	—	—	AD-G1/8	2	WA-M10	2
Straight	CS-1/8-300SS	●	11.81	HOSE-1/8-300	—	—	—	—	AD-G1/8	2	WA-M10	2
Elbow Straight	CS-1/8-150BS	●	5.91	HOSE-1/8-150	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	CS-1/8-200BS	●	7.87	HOSE-1/8-200	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	CS-1/8-250BS	●	9.84	HOSE-1/8-250	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	CS-1/8-300BS	●	11.81	HOSE-1/8-300	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow	CS-1/8-150BB	●	5.91	HOSE-1/8-150	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4
Elbow	CS-1/8-200BB	●	7.87	HOSE-1/8-200	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4
Elbow	CS-1/8-250BB	●	9.84	HOSE-1/8-250	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4
Elbow	CS-1/8-300BB	●	11.81	HOSE-1/8-300	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4

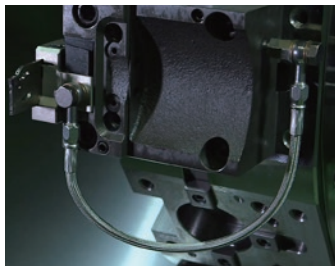
Connection Screw Size = G1/8"

Mounting Example

Elbow Straight Type



Elbow Type



● : USA Stock

RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED

	Work Material	Properties	Grade	Cutting Speed v_c (SFM)					
				165	330	490	655	820	985
P	Mild Steel	$\leq 160\text{HB}$	VP20RT		330		785		
			VP10RT		360		820		
	Carbon Steel Alloy Steel	160 – 280HB	VP20RT		260		655		
			VP10RT		295		690		
			VP30RT	195		590			
			MY5015		360		820		
		$\geq 280\text{HB}$	VP20RT	195		525			
			VP10RT		230		560		
			VP30RT	130		460			
			MY5015		295		690		
M	Stainless Steel	$\leq 270\text{HB}$	VP20RT		195		590		
			VP10RT		230		620		
			VP30RT	130		525			
K	Gray Cast Iron	Tensile Strength $\leq 300\text{MPa}$	VP20RT		260		655		
			VP10RT		295		690		
			MY5015			460		985	
	Ductile Cast Iron	Tensile Strength $\leq 800\text{MPa}$	VP20RT		195		525		
			VP10RT		230		560		
			MY5015		295		690		
S	Heat Resistant Alloy Titanium Alloy	—	VP20RT	100 195					
			VP10RT	130 230					

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

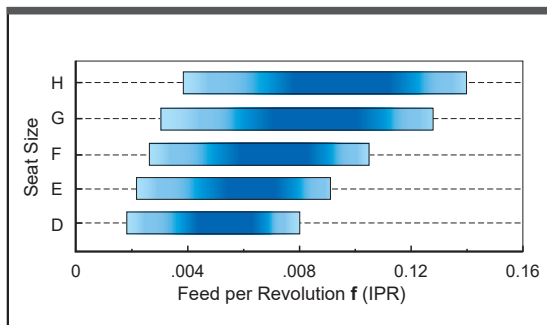
Note 2) For VP10RT, VP20RT, VP30RT and MY5015, wet cutting is recommended.

F

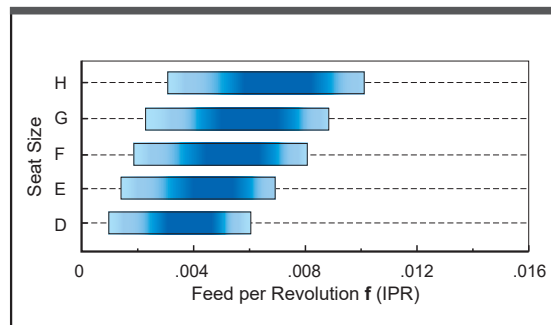
GROOVING / CUTTING OFF

FEED PER REVOLUTION

GM Breaker



GS Breaker



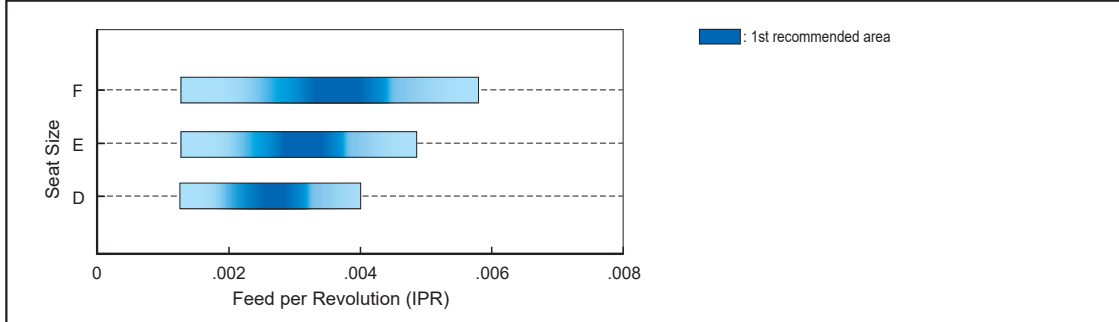
■ : 1st recommended area

Seat Size	
Insert Width	
D	.079", 2.0 mm
E	.094", 2.39 mm
F	.118", 3.0 mm
G	.157", 4.0 mm
H	.197", 5.0 mm

Chip Breaker	Feed per Revolution f (IPR)				
	Seat Size D	Seat Size E	Seat Size F	Seat Size G	Seat Size H
GM Breaker	.002 – .008	.0024 – .0091	.003 – .010	.003 – .013	.004 – .014
GS Breaker	.001 – .006	.0016 – .0067	.002 – .008	.002 – .009	.003 – .010

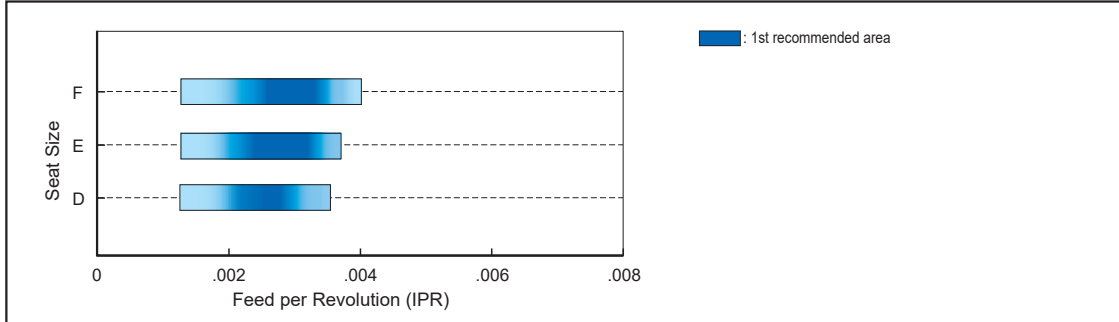
■ CUTTING OFF FEED PER REVOLUTION

R05-GS Breaker

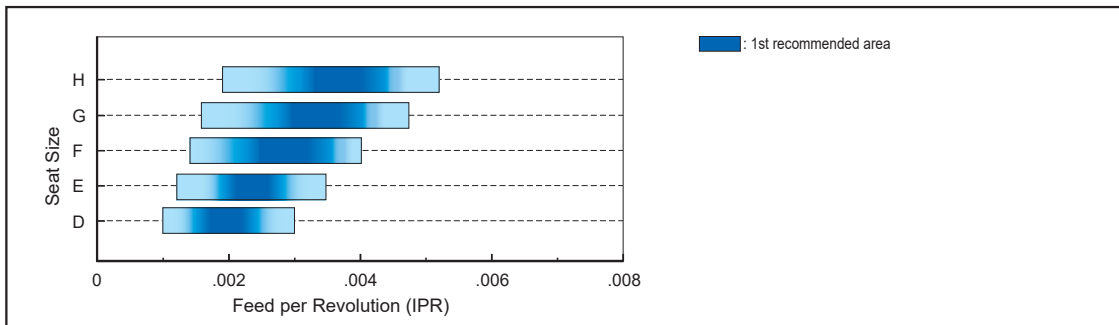


Seat Size	
Insert Width	
D	.079", 2.0 mm
E	.094", 2.39 mm
F	.118", 3.0 mm
G	.157", 4.0 mm
H	.197", 5.0 mm

R08-GS Breaker



R/L05-GM Breaker

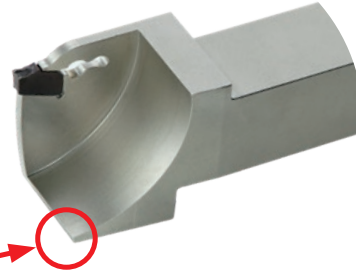
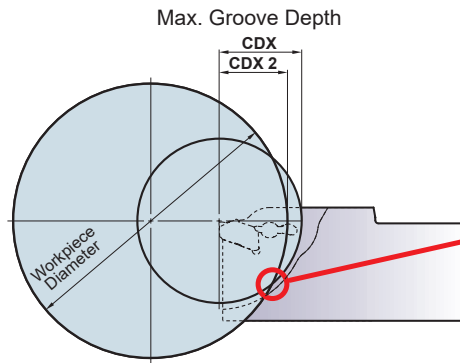


Chip Breaker	PSIPR	Hand	Feed per Revolution (IPR)				
			Seat Size D	Seat Size E	Seat Size F	Seat Size G	Seat Size H
R05-GS	5°	R	.0012 – .0039	.0012 – .0047	.0012 – .0055	—	—
R08-GS	8°	R	.0012 – .0031	.0012 – .0035	.0012 – .0055	—	—
R05-GM	5°	R/L	.0020 – .0059	.0024 – .0067	.0028 – .0079	.0031 – .0091	.0039 – .0102

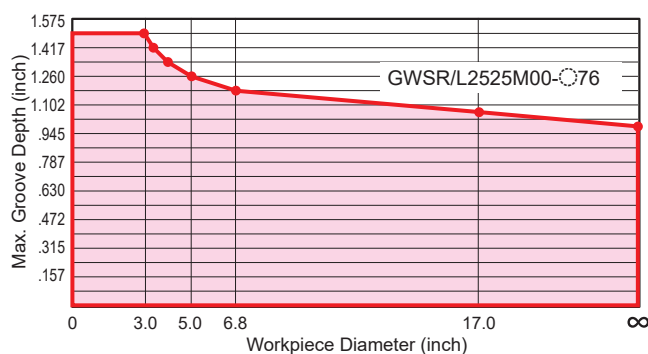
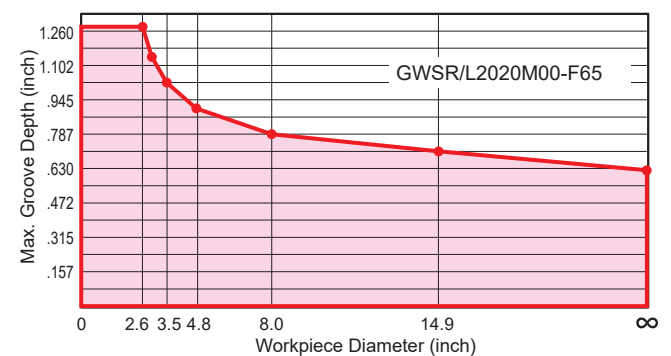
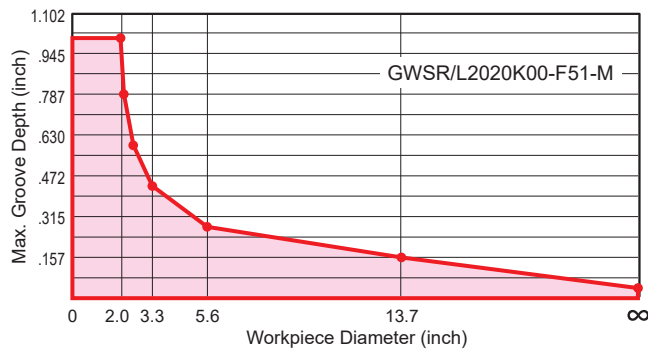
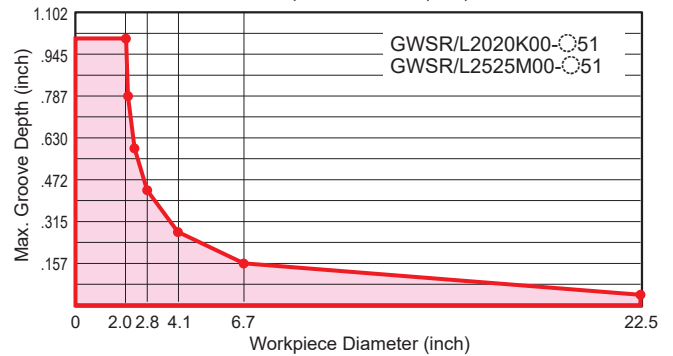
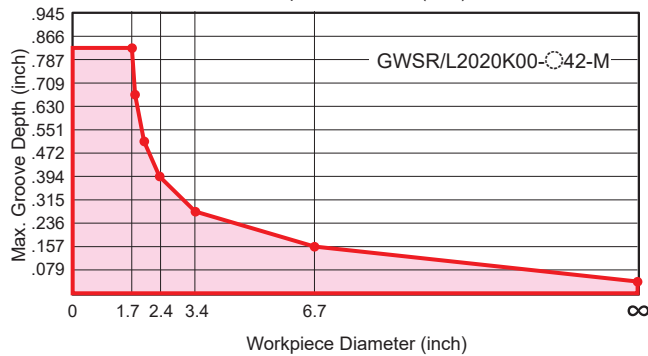
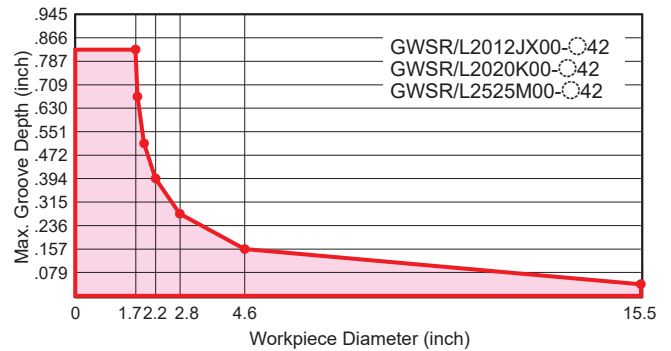
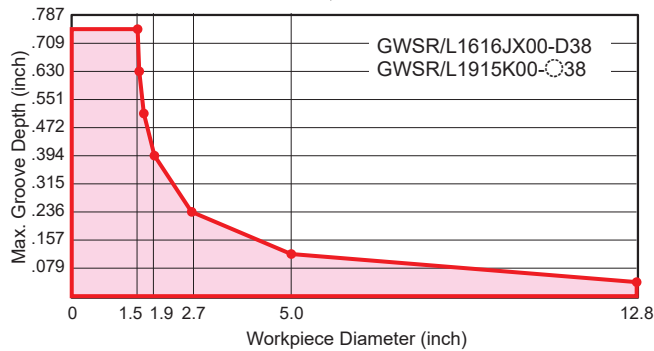
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

•For Swiss-type lathes mono block holder

The maximum groove depth is limited by the workpiece diameter.



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



GROOVING / CUTTING OFF

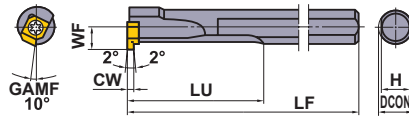
F TYPE BORING BAR

- Min. cutting diameter 10 mm.
- Screw-on type.
- Usable for various applications.
- Max. groove depth: 3 mm.

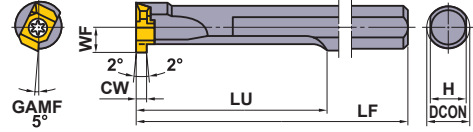
FSL51

Internal grooving, Threading

1 Corner type (FSL5108R,5110R)



2 Corner type (FSL5112R,5114R,5116R)



Metric Standard

Right hand tool holder only.

Order Number	Stock	Insert Number				Dimensions (mm)							Max. Groove Depth (mm)		
	R	Grooving		Threading	DCON	H	LF	LU	WF	CW	DMIN [*]		Clamp Screw	Wrench	
FSL5108R	★	MLG	1000L	MLT	1001L	8	7	125	30	4.8	1.2	10	1.0	TS25	TKY08F
FSL5110R	★		1000L		1001L	10	9	150	40	5.8	1.5	2.0	12	1.0	TS25
FSL5112R	★	MLG	1400L	MLT	1401L	12	10.8	180	50	6.8	1.5	14	2.0	TS32	TKY08F
FSL5114R	★		1400L		1401L	14	12.4	180	60	7.8	2.0	3.0	16	2.0	TS32
FSL5116R	★	MLG	2000L	MLT	2001L	16	14	200	70	9.7	2.0	20	3.0	TS43	TKY15F
											4.0				

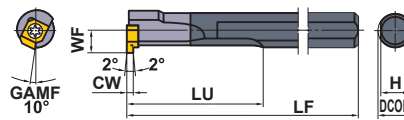
*DMIN : Min. Cutting Diameter

GROOVING / CUTTING OFF

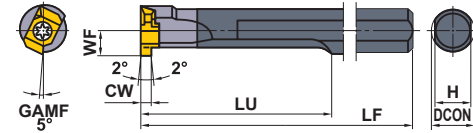
FSL52

(Carbide shank) Internal grooving, Threading

1 Corner type (FSL5208R,5210R)



2 Corner type (FSL5212R,5214R,5216R)



Metric Standard

Right hand tool holder only.

Order Number	Stock	Insert Number				Dimensions (mm)							Max. Groove Depth (mm)		
	R	Grooving		Threading		DCON	H	LF	LU	WF	CW	DMIN*		Clamp Screw	Wrench
FSL5208R	★	MLG	1000L	MLT	1001L	8	7	125	60	4.8	1.2	10	1.0	TS25	TKY08F
FSL5210R	★		1000L		1001L	10	9	150	70	5.8	1.5	2.0	12	1.0	TS25
FSL5212R	★	MLG	1400L	MLT	1401L	12	10.8	180	80	6.8	1.5	14	2.0	TS32	TKY08F
FSL5214R	★		1400L		1401L	14	12.4	180	85	7.8	3.0	16	2.0	TS32	TKY08F
FSL5216R	★	MLG	2000L	MLT	2001L	16	14	200	115	9.7	2.0 3.0 4.0	20	3.0	TS43	TKY15F

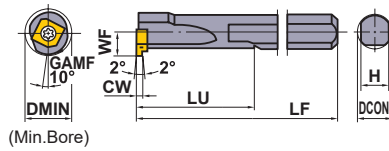
*DMIN : Min. Cutting Diameter

● : USA Stock ★ : Stocked in Japan

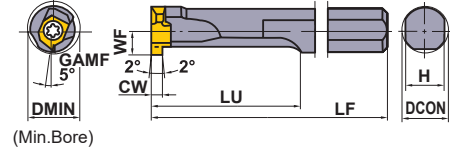
S-SL5N

Internal grooving, Threading, Boring

1 Corner type (S-SL5NR05 / 06)



2 Corner type (S-SL5NR08 / 10 / 12)



Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions (inch)								
	R	Grooving	Threading	DCON	H	LF	LU	WF	CW	DMIN	Clamp Screw	Wrench
S-SL5NR05	●	MLG10W○○○L	MLT1001L	.313	.283	5.000	1.250	.188	.062" 1.2 mm	.390	TS25	TKY08F
S-SL5NR06	●	MLG10W○○○L	MLT1001L	.375	.340	6.000	1.500	.219	1.5 mm 2.0 mm	.449	TS25	TKY08F
S-SL5NR08	●	MLG14W○○○L	MLT1401L	.500	.460	7.000	2.000	.281	.062" 1.5 mm 2.0 mm 3.0 mm	.579	TS32	TKY08F
S-SL5NR10	●	MLG20W○○○L	MLT2001L	.625	.560	8.000	3.000	.375	2.0 mm 3.0 mm	.791	TS43	TKY15F
S-SL5NR12	●	MLG20W○○○L	MLT2001L	.750	.700	10.000	4.000	.438	4.0 mm	.902	TS43	TKY15F

F
GROOVING / CUTTING OFF

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (SFM)	Feed (IPR)
P Carbon Steel Alloy Steel	180—280HB	UP20M • UTi20T	295 (195—390)	.002 (.0008—.003)
	280—350HB	UP20M • UTi20T	260 (165—330)	.001 (.0008—.0015)

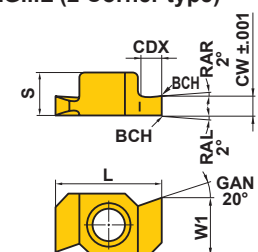
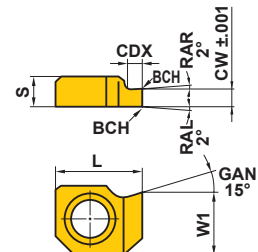
INSERTS > F236
 SPARE PARTS > M001
 TECHNICAL DATA > N001

F235

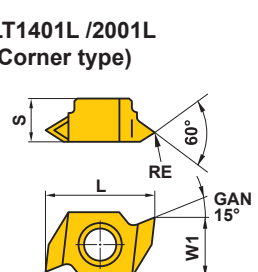
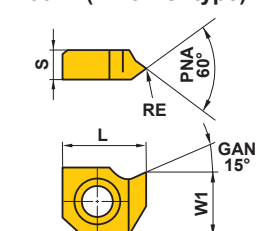
F TYPE

INSERTS

Application	CW (inch)	Order Number	Carbide		Dimensions (inch)					Geometry
			UTi20T	HTi10	L	W1	CDX	S	BCH	
Grooving	Inch	.062	MLG10W062L	●	.276	.197	.039	.094	.004	MLG...L (1 Corner type)
	Metric	.047 (1.2 mm)	MLG1012L	●	.276	.197	.039	.094	.004	
		.059 (1.5 mm)	MLG1015L	●	.276	.197	.039	.094	.004	
		.079 (2.0 mm)	MLG1020L	●	.276	.197	.039	.094	.004	
										MLG...L (2 Corner type)
	Metric	.059 (1.5 mm)	MLG1415L	●	.465	.256	.079	.187	.004	
		.079 (2.0 mm)	MLG1420L	●	.465	.256	.079	.187	.004	
		.118 (3.0 mm)	MLG1430L	●	.465	.256	.079	.187	.004	
		.079 (2.0 mm)	MLG2020L	●	.661	.356	.118	.250	.004	
		.118 (3.0 mm)	MLG2030L	●	.661	.356	.118	.250	.004	
		.157 (4.0 mm)	MLG2040L	●	.661	.356	.118	.250	.004	



Application	Pitch	Order Number	Coated	Carbide	Dimensions (inch)				Geometry
			UP20M	UTi20T	L	W1	S	RE	
Threading	13T.P.I	MLT1001L	●	●	.276	.197	.094	.004	MLT1001L (1 Corner type)
	11T.P.I	MLT1401L	●	●	.465	.256	.187	.004	
	8T.P.I	MLT2001L	●	●	.661	.356	.250	.004	
									MLT1401L /2001L (2 Corner type)

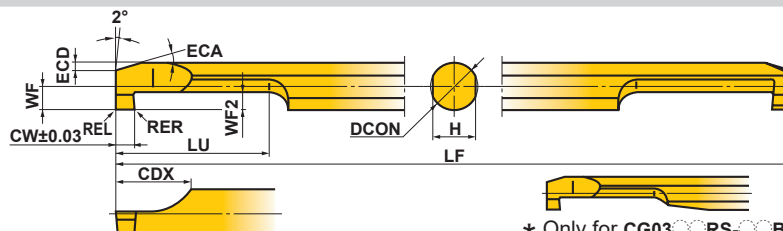
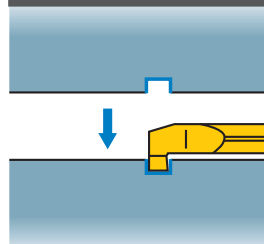


● : USA Stock

MICRO-MINI TWIN

CG

Internal grooving



* Only for CG03-00RS-00B

Order Number	Stock		Breaker	Dimensions (mm)											
	Micro Grain Carbide	Coated		DMIN	CW	WF2	RER/L	DCON	LF	LU	CDX	WF	H	ECA	ECD
	TF15	VP15TF													
CG0305RS-10	●	●	Without	3	1	1	0.05	3	50	5	6	1.3	2.7	15°	0.3
CG0305RS-10B	●	●	With	3	1	1	0.05	3	50	5	6	1.3	2.7	15°	0.3
CG0306RS-20	●	●	Without	3	2	1	0.1	3	50	6	6	1.3	2.7	15°	0.3
CG0306RS-20B	●	●	With	3	2	1	0.1	3	50	6	6	1.3	2.7	15°	0.3
CG03RS-10	●	●	Without	3	1	1	0.05	3	50	10	6	1.3	2.7	15°	0.3
CG03RS-10B	●	●	With	3	1	1	0.05	3	50	10	6	1.3	2.7	15°	0.3
CG03RS-20	●	●	Without	3	2	1	0.1	3	50	11	6	1.3	2.7	15°	0.3
CG03RS-20B	●	●	With	3	2	1	0.1	3	50	11	6	1.3	2.7	15°	0.3
CG0407RS-10	●	●	Without	4	1	1.5	0.05	4	60	7	7	1.8	3.6	15°	0.5
CG0407RS-10B	●	●	With	4	1	1.5	0.05	4	60	7	7	1.8	3.6	15°	0.5
CG0408RS-20	●	●	Without	4	2	1.5	0.1	4	60	8	7	1.8	3.6	15°	0.5
CG0408RS-20B	●	●	With	4	2	1.5	0.1	4	60	8	7	1.8	3.6	15°	0.5
CG04RS-10	●	●	Without	4	1	1.5	0.05	4	60	15	7	1.8	3.6	15°	0.5
CG04RS-10B	●	●	With	4	1	1.5	0.05	4	60	15	7	1.8	3.6	15°	0.5
CG04RS-20	●	●	Without	4	2	1.5	0.1	4	60	16	7	1.8	3.6	15°	0.5
CG04RS-20B	●	●	With	4	2	1.5	0.1	4	60	16	7	1.8	3.6	15°	0.5
CG0510RS-10	●	●	Without	5	1	2	0.05	5	70	10	8	2.3	4.5	15°	0.7
CG0510RS-10B	●	●	With	5	1	2	0.05	5	70	10	8	2.3	4.5	15°	0.7
CG0511RS-20	●	●	Without	5	2	2	0.1	5	70	11	8	2.3	4.5	15°	0.7
CG0511RS-20B	●	●	With	5	2	2	0.1	5	70	11	8	2.3	4.5	15°	0.7
CG05RS-10	●	●	Without	5	1	2	0.05	5	70	20	8	2.3	4.5	15°	0.7
CG05RS-10B	●	●	With	5	1	2	0.05	5	70	20	8	2.3	4.5	15°	0.7
CG05RS-20	●	●	Without	5	2	2	0.1	5	70	21	8	2.3	4.5	15°	0.7
CG05RS-20B	●	●	With	5	2	2	0.1	5	70	21	8	2.3	4.5	15°	0.7
CG0610RS-10	●	●	Without	6	1	2	0.05	6	75	10	8	2.8	5.4	15°	0.7
CG0610RS-10B	●	●	With	6	1	2	0.05	6	75	10	8	2.8	5.4	15°	0.7
CG0611RS-20	●	●	Without	6	2	2	0.1	6	75	11	8	2.8	5.4	15°	0.7
CG0611RS-20B	●	●	With	6	2	2	0.1	6	75	11	8	2.8	5.4	15°	0.7
CG06RS-10	●	●	Without	6	1	2	0.05	6	75	20	8	2.8	5.4	15°	0.7
CG06RS-10B	●	●	With	6	1	2	0.05	6	75	20	8	2.8	5.4	15°	0.7
CG06RS-20	●	●	Without	6	2	2	0.1	6	75	21	8	2.8	5.4	15°	0.7
CG06RS-20B	●	●	With	6	2	2	0.1	6	75	21	8	2.8	5.4	15°	0.7
CG0712RS-10	●	●	Without	7	1	2	0.05	7	85	12	8	3.3	6.4	15°	0.7
CG0712RS-10B	●	●	With	7	1	2	0.05	7	85	12	8	3.3	6.4	15°	0.7
CG0713RS-20	●	●	Without	7	2	2	0.1	7	85	13	8	3.3	6.4	15°	0.7
CG0713RS-20B	●	●	With	7	2	2	0.1	7	85	13	8	3.3	6.4	15°	0.7
CG07RS-10	●	●	Without	7	1	2	0.05	7	85	25	8	3.3	6.4	15°	0.7
CG07RS-10B	●	●	With	7	1	2	0.05	7	85	25	8	3.3	6.4	15°	0.7
CG07RS-20	●	●	Without	7	2	2	0.1	7	85	26	8	3.3	6.4	15°	0.7
CG07RS-20B	●	●	With	7	2	2	0.1	7	85	26	8	3.3	6.4	15°	0.7

GROOVING / CUTTING OFF

HOLDER

➤ E034, E036, E037

SPARE PARTS

➤ M001

TECHNICAL DATA

➤ N001

F237

HOLDER

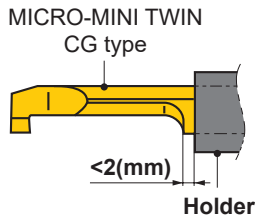
HOLDER CROSS REFERENCE LIST OF INCH SHANK STANDARD

Holder		Stock	MICRO-MINI TWIN	Machine Makers
Type	Order Number *1		CG	
Round Type Holder φ.625 inch	ID : Metric Type			
	RBH10189A	●	030 RS- (B), 03RS- (B)	Citizen Precision Machinery Co., Ltd. NC lathes
	RBH10252A	●	040 RS- (B), 04RS- (B)	
	RBH10315A	●	051 RS- (B), 05RS- (B)	
	RBH10378A	●	061 RS- (B), 06RS- (B)	
	RBH10441A	●	071 RS- (B), 07RS- (B)	
Round Type Holder φ.750 inch	ID : Metric Type			
	RBH19030N	●	030 RS- (B), 03RS- (B)	Citizen Precision Machinery Co., Ltd.
	RBH19040N	●	040 RS- (B), 04RS- (B)	
	RBH19050N	●	051 RS- (B), 05RS- (B)	
	RBH19060N	●	061 RS- (B), 06RS- (B)	
	RBH19070N	●	071 RS- (B), 07RS- (B)	
Round Type Holder φ.1.000 inch	ID : Metric Type			
	RBH16189A	●	030 RS- (B), 03RS- (B)	Citizen Precision Machinery Co., Ltd. NC lathes
	RBH16252A	●	040 RS- (B), 04RS- (B)	
	RBH16315A	●	051 RS- (B), 05RS- (B)	
	RBH16378A	●	061 RS- (B), 06RS- (B)	
	RBH16441A	●	071 RS- (B), 07RS- (B)	

* Mitsubishi Materials obtained the makers' approval before entering their names in the list.

*1 For holder details, refer to Boring Bar Section, page E034—E038.

RECOMMENDED TOOL OVERHANG



Note 1) For LU, refer to page F237.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Speed (SFM)	Feed (IPR)	
			03RS/04RS	05RS/06RS/07RS
P Carbon Steel · Alloy Steel	180—280HB	130—395	.0004—.001	.0004—.002
M Stainless Steel	≤200HB	130—395	.0004—.001	.0004—.002
K Gray Cast Iron	Tensile Strength ≤350MPa	130—395	.0004—.002	.0004—.002
N Non-Ferrous Metal	—	260—525	.0004—.002	.0004—.003

Note 1) Recommend wet machining.

● : USA Stock ★ : Stocked in Japan

HOLDER CROSS REFERENCE LIST OF METRIC SHANK STANDARD

Holder		Stock	MICRO-MINI TWIN	Machine Makers
Type	Order Number*1		CG	
Round Type Holder φ16 mm	RBH1630N	●	030 RS- (B), 03RS- (B)	MIYANO MACHINERY JAPAN INC. NC lathes
	RBH1640N	●	040 RS- (B), 04RS- (B)	
	RBH1650N	●	051 RS- (B), 05RS- (B)	
	RBH1660N	●	061 RS- (B), 06RS- (B)	
	RBH1670N	●	071 RS- (B), 07RS- (B)	
Round Type Holder φ20 mm	RBH2030N	●	030 RS- (B), 03RS- (B)	Citizen Precision Machinery Co., Ltd. Tsumagi Corporation MIYANO MACHINERY JAPAN INC. NC lathes
	RBH2040N	●	040 RS- (B), 04RS- (B)	
	RBH2050N	●	051 RS- (B), 05RS- (B)	
	RBH2060N	●	061 RS- (B), 06RS- (B)	
	RBH2070N	●	071 RS- (B), 07RS- (B)	
Round Type Holder φ22 mm	RBH2230N	●	030 RS- (B), 03RS- (B)	STAR MICRONICS CO., LTD.
	RBH2240N	●	040 RS- (B), 04RS- (B)	
	RBH2250N	●	051 RS- (B), 05RS- (B)	
	RBH2260N	●	061 RS- (B), 06RS- (B)	
	RBH2270N	●	071 RS- (B), 07RS- (B)	
Round Type Holder φ25 mm	RBH2530N	●	030 RS- (B), 03RS- (B)	Tsumagi Corporation MIYANO MACHINERY JAPAN INC. NC lathes
	RBH2540N	●	040 RS- (B), 04RS- (B)	
	RBH2550N	●	051 RS- (B), 05RS- (B)	
	RBH2560N	●	061 RS- (B), 06RS- (B)	
	RBH2570N	●	071 RS- (B), 07RS- (B)	
Square Type Holder □10 mm	SBH1030R	★	030 RS- (B), 03RS- (B)	NC lathes
	SBH1040R	★	040 RS- (B), 04RS- (B)	
	SBH1050R	★	051 RS- (B), 05RS- (B)	
	SBH1060R	★	061 RS- (B), 06RS- (B)	
	SBH1070R	★	071 RS- (B), 07RS- (B)	

* Mitsubishi Materials obtained the makers' approval before entering their names in the list.

*1 For holder details, refer to Boring Bar Section, page E034—E038.

F

GROOVING / CUTTING OFF