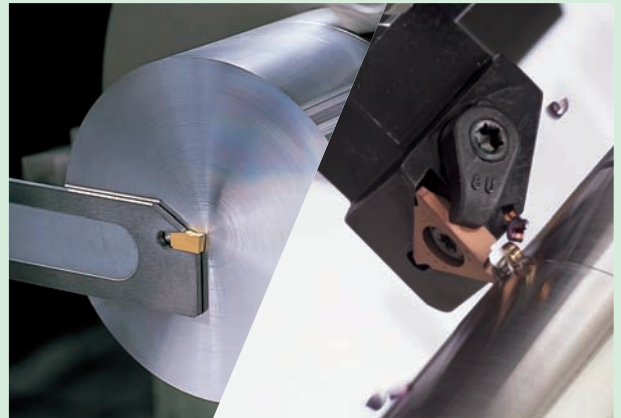
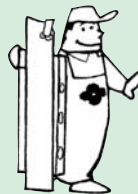


Grooving / Cut-off Holders

E1 ~ E39



■ Grooving Holders

Triangular Grooving Insert

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SEC-Small Diameter Cut Off

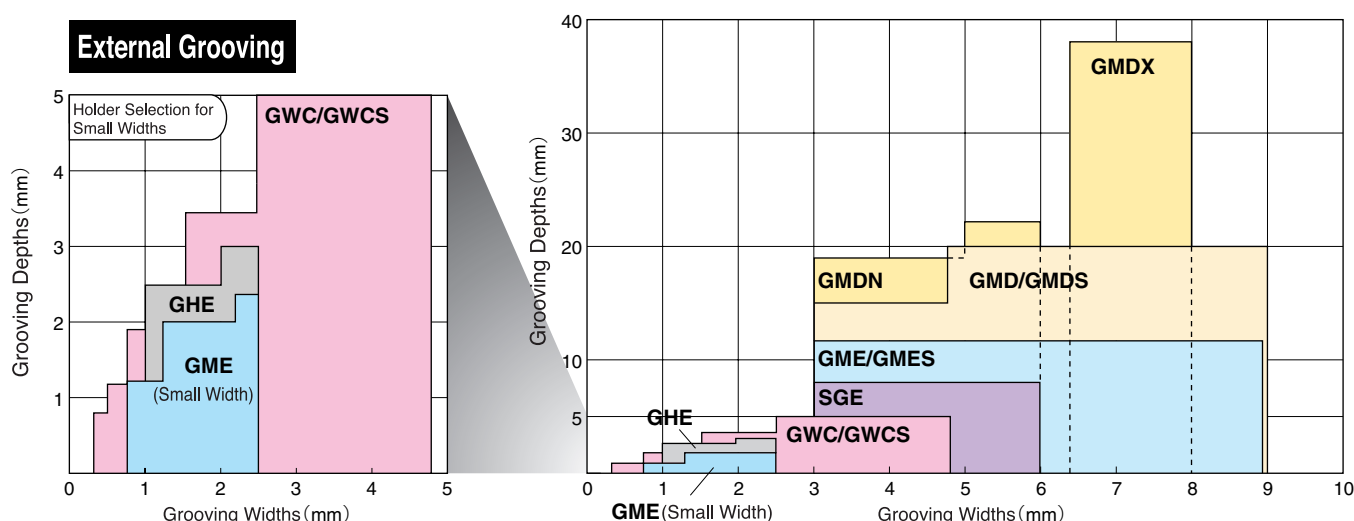
SCT Type.....E36

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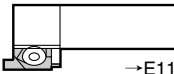
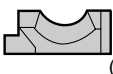
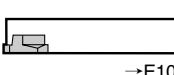
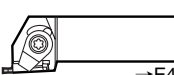
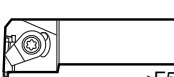
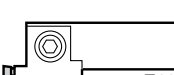
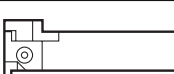
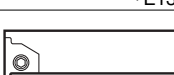
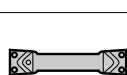
GME-CU Type.....E39

SEC-Grooving Tool Holder Series SELECTION GUIDE

External Grooving



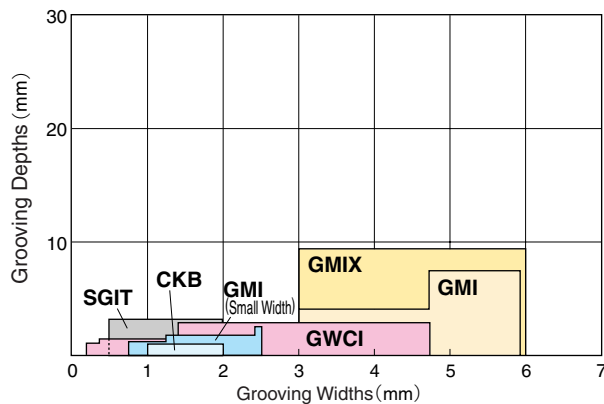
EXTERNAL GROOVING TOOLS

Application	Series	Figure	Structure			Insert Shape (): No. of corners	Depth 10 20 30 40 (mm)					Characteristics
			Screw-on	Clamp-on	Double clamp		Width 2 4 6 8 10 (mm)					
Small-Width Grooves	GME (Small Width)	 →E11	●			 (1)	2.4 0.75	2.5				- Strong and rigid clamping - Inserts for Threading and Boring are also available
	GHE	 →E10	●			 (3)	3.0 1.0	2.5				- Mini-Holder series - Shank size □ 10 and 12mm 3-cornered inserts
Shallow Grooves	GWC	 →E4		●		 (3) (Standard, with Chipbreaker)	5.0 0.33	4.8				- High rigidity double clamping - Inserts for GCE holders can be used 3-cornered inserts - Inserts with Chipbreaker are stocked <i>New</i> "L-styled" (side cut) GWC holder
	GWCS	 →E5		●			5.0 0.33	4.8				
Wide Grooves	GME	 →E12	●			 (2)	12 3.0	9.0				- Wide grooves possible with chipbreaker inserts - Support type insert holder system
	GMES	 →E12	●				12 3.0	9.0				
	SGE <i>New</i>	 →E16	●			 (2)	8.0 3.0	6.0				Wide grooves possible
Deep Grooves	GMD	 →E13	●				 (2) Turning Possible	20 3.0	9.0			
	GMDS	 →E13	●			20 3.0		9.0				"L-styled"(side cut) GMD holder
	GMDN	 →E14	●			 (2)	22 3.0	6.0				Simple 1 piece body design
	GMDX	 →E14	●				 (1)	38 6.4	8.0			

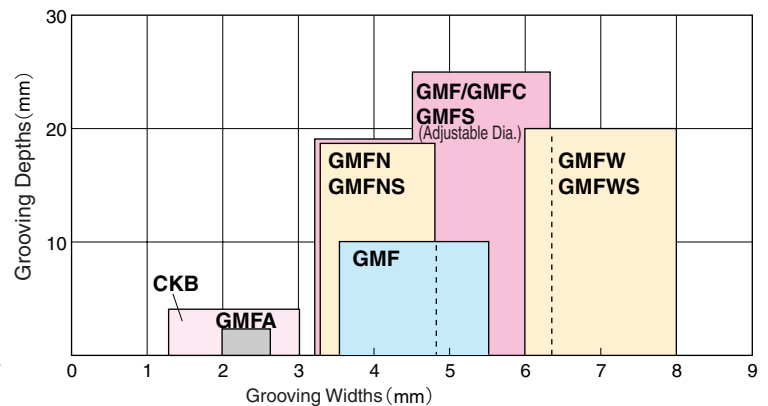
※ For Hardened Steel, please refer to (→E28) for SumiBoron Grooving Holder BNGG type

SEC-Grooving Tool Holder Series SELECTION GUIDE

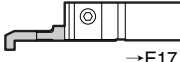
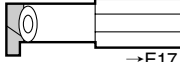
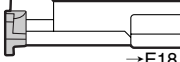
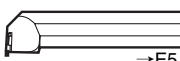
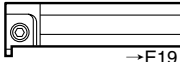
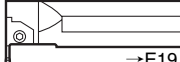
Internal Grooving



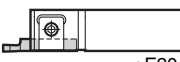
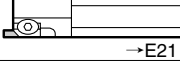
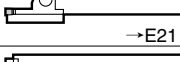
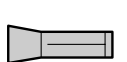
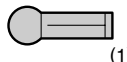
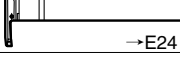
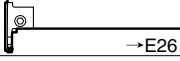
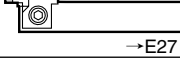
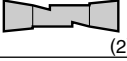
Face Grooving



INTERNAL GROOVING TOOLS

Application	Series	Figure	Structure Screw-on Clamp-on Double clamp	Insert Shape (: No. of corners)	Depth (mm)				Min. Bore Dia. (mm)	Characteristics
					Width	2	4	6		
Small-Bore Grooves	CKB	 → E17	●	 (1)	1.0	1.0	2.0		φ 4	- Very small diameter grooving - High clamping force - Huge variety of holders
	GMI (Small Width)	 → E17	●	 (1)	2.4	0.75	2.5		φ 14	- Strong and rigid clamping - Inserts for Threading and Boring are also available
	SGIT 	 → E18	●	 (3)	3.2	0.5	2.0		φ 10	3-cornered inserts
Shallow Grooves	GWCI	 → E5	●	 (3) (Standard, with Chipbreaker)	2.5	0.33	4.8		φ 35	- Using inserts for GWC holders - Inserts with Chipbreaker are stocked 
Deep Grooves	GMI	 → E19	●	 (2)	7.5	3.0	6.0		φ 32	Wide grooves possible with chipbreaker inserts
	GMIX	 → E19	●	 (2)	9.5	3.0	6.0		φ 100	High rigidity shank

FACE GROOVING TOOLS

Application	Series	Figure	Structure Screw-on Clamp-on Double clamp	Insert Shape (: No. of corners)	Depth (mm)				Work Dia. (mm)	Characteristics
					Width	2	4	6		
Very Small Dia. Grooves	CKB 	 → E20	●	 (1)	4	1.5	3		φ 6 }	Face grooving for small lathes
Small Dia. Grooves	GMFA	 → E21	●	 (1)	2.3	2.0	2.6		φ 12.7 }	High rigidity clamp
Small Dia. Deep Grooves	GMFN	 → E21	●	 (1)	19	3.2	4.8		φ 32 }	From ø32mm onwards
	GMFNS	 → E22	●		19	3.2	4.8		φ 89	"L-styled" (side cut) GMFN holder
Wide Grooves (Adjustable)	GMF	 → E23	●	 (1)	25	3.2	6.35		φ 57 }	- Work diameter adjustable - From φ 57~400mm
	GMFC	 → E23	●		25	3.2	6.35		φ 400	GMF-type holder for use in counter-rotational grooving
	GMFS	 → E24	●		25	3.2	6.35			"L-styled" (side cut) GMF holder
Deep Grooves	GMFW	 → E25	●	 (2)	20	6.0	8.0		φ 70 }	2-cornered inserts - Up to 20mm deep grooves
	GMFWS	 → E26	●	 (2)	20	6.0	8.0			"L-styled" (side cut) GMFW holder
General	GMF	 → E27	●	 (2)	10	3.5	5.5		φ 50 } φ 150	2-cornered inserts

SEC-Grooving Tool Holders GWC Type

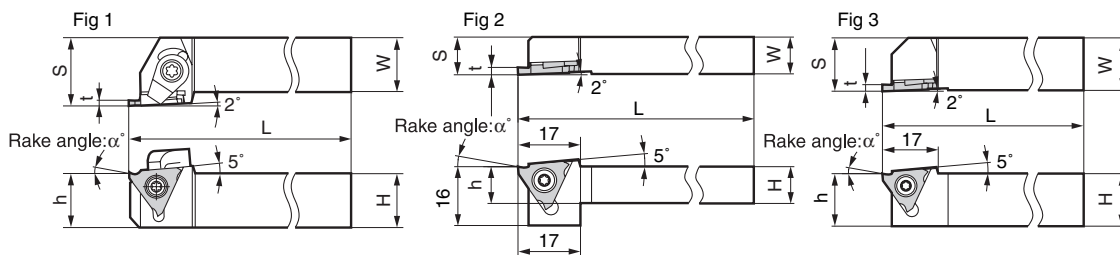
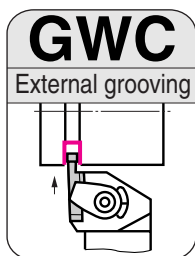


Features of GWC Series

- Similar insert can be use for both external and internal grooving
- Full range of insert grades to cover a wide range of work materials
Coated Carbide ACZ310/AC530U、Uncoated Carbide H1、
Coated Cermet T3000Z、
Cermet T1200A、
SUMIBORON BN250、
SUMIDIA DA2200 kept in stock
- A wide variation of grooving widths
Groove width 0.33mm ~ 4.8mm
- Insert with Chipbreaker, **SumiTurn B-Groove**, are now stocked
- Customers can modify the grooving width, nose radius and rake angle according to their own requirements using the grooving insert blanks

Grooving Holders

External Grooving



* Refer to insert table for α° dimensions

* Each of the above figures shows a right hand tool.

Parts

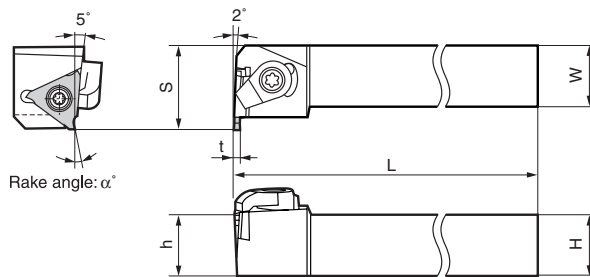
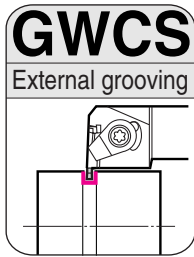
Holder

Right handed toolholders are applicable with right handed inserts.

Cat. No.	Stock		Dimensions (mm)					Fig	Grooving width (mm)		Maximum Grooving Depth (mm)	※ Group No.	Screw	Wrench	Clamp	Screw	Wrench
	R	L	H	W	L	S	h		t								
GWC R/L1010-3	●	●	10	10	125	10	10	Fig2	0.33~2.80	0.8~2.5	1	1	BFTX0409N	TRX15	—	—	—
GWC R/L1212-3	●	●	12	12	125	12	12	Fig2	0.33~2.80	0.8~2.5	1	1	BFTX0409N	TRX15	—	—	—
GWC R/L1616-3	●	●	16	16	125	16	16	Fig3	0.33~2.80	0.8~2.5	1	1	BFTX0409N	TRX15	CCM6BL/R	WB6-20T/TL	LT20
GWC R/L2020-3	●	●	20	20	125	25	20	Fig1	0.33~2.80	0.8~2.5	1	1	BFTX0409N	TRX15	CCM6BL/R	WB6-20T/TL	LT20
GWC R/L2525-3	●	●	25	25	150	30	25	Fig1	0.33~2.80	0.8~2.5	1	1	BFTX0409N	TRX15	CCM6BL/R	WB6-20T/TL	LT20
GWC R/L2020-15	●	●	20	20	125	25	20	Fig1	1.25~1.45	2.0	2	2	BFTX0509N	TRX20	CCM8UL/R	WB8-22T/TL	LT27
GWC R/L2020-25	●	●	20	20	125	25	20	Fig1	1.50~2.30	3.5	3	3	BFTX0509N	TRX20	CCM8UL/R	WB8-22T/TL	LT27
GWC R/L2020-35	●	●	20	20	125	25	20	Fig1	2.50~4.80	5.0	4	4	BFTX0509N	TRX20	CCM8UL/R	WB8-22T/TL	LT27
GWC R/L2525-15	●	●	25	25	150	30	25	Fig1	1.25~1.45	2.0	2	2	BFTX0509N	TRX20	CCM8UL/R	WB8-22T/TL	LT27
GWC R/L2525-25	●	●	25	25	150	30	25	Fig1	1.50~2.30	3.5	3	3	BFTX0509N	TRX20	CCM8UL/R	WB8-22T/TL	LT27
GWC R/L2525-35	●	●	25	25	150	30	25	Fig1	2.50~4.80	5.0	4	4	BFTX0509N	TRX20	CCM8UL/R	WB8-22T/TL	LT27

※ Refer to pages E6, E7 for applicable TGA type inserts. Select applicable inserts for the holders by using matching group numbers

External L-Styled (Side Cut)



* Refer to insert table for α° dimensions
Figures show right hand tools.

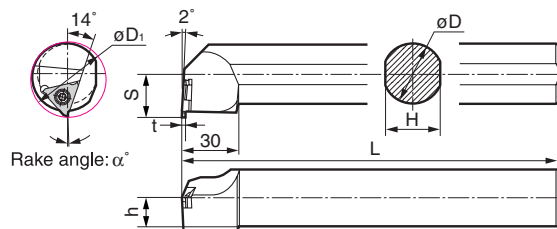
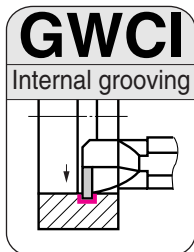
Holder

Right handed toolholders are applicable with left handed inserts.

Cat. No.	Stock		Dimensions (mm)						Maximum Grooving Depth (mm)	※ Group No.	Parts				
	R	L	H	W	L	S	h	Grooving width (mm) t			Screw	Wrench	Clamp	Screw	Wrench
GWCS R/L2020-3	●	●	20	20	125	25	20	0.33~2.80	0.8~2.5	①	BFTX0409N	TRX15	CCM6BR/L	WB6-20TL/T	LT20
GWCS R/L2525-3	●	●	25	25	150	30	25	0.33~2.80	0.8~2.5	①					
GWCS R/L2020-15	●	●	20	20	125	27	20	1.25~1.45	2.0	②					
GWCS R/L2020-25	●	●	20	20	125	27	20	1.50~2.30	3.5	③					
GWCS R/L2020-35	●	●	20	20	125	27	20	2.50~4.80	5.0	④	BFTX0509N	TRX20	CCM8UR/L	WB8-22TL/T	LT27
GWCS R/L2525-15	●	●	25	25	150	32	25	1.25~1.45	2.0	②					
GWCS R/L2525-25	●	●	25	25	150	32	25	1.50~2.30	3.5	③					
GWCS R/L2525-35	●	●	25	25	150	32	25	2.50~4.80	5.0	④					

※ Refer to pages E6, E7 for applicable TGA type inserts. Select applicable inserts for the holders by using matching group numbers

Internal Grooving



* Refer to insert table for α° dimensions
Figures show right hand tools.

Holder

Right handed toolholders are applicable with left handed inserts.

Cat. No.	Stock		Dimensions (mm)					Min. Bore øD ₁	Grooving width (mm) t	Maximum Grooving Depth (mm)	※ Group No.	Screw	Wrench
	R	L	D	H	L	S	h						
GWCI R/L325	●	●	25	23	200	17.5	11.5	35	0.33~2.80	0.8~2.0	①	BFTX0409N	TRX15
GWCI R/L432	●	●	32	30	250	22.5	15.0	40	1.25~4.80	2.0~2.5	②③④	BFTX0509N	TRX20

※ Refer to pages F6 and F7 for applicable TGA type inserts. Select applicable inserts for the holders by using matching group numbers

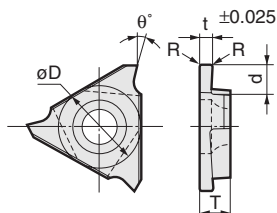
● Rake angle when fitted on holder (α°)

	Coated Carbide ACZ310 AC530U	Coated H1	Coated Cermet T3000Z	Cermet T1200A	SUMIBORON BN250	SUMIDIA DA2200
Ext. Grooving GWCR/L GWCSR/L	10°	20°	10°	5°	0°	10°
Int. Grooving GWCIR/L	1°	11°	1°	-4°	-9°	1°

Indexable Inserts for External & Internal Grooving

TGA Type

Insert



Grade		Edge Treatment	θ°
Coated Carbide	ACZ310	Honing	15°
Carbide	H1	Sharp	25°
Coated Cermet	T3000Z	Honing	15°
Cermet	T1200A	Sharp	10°
SUMIBORON	BN250	Nega-Land	5°
SUMIDIA	DA2200	Sharp	15°

※For rake angle when fitted on the holder, refer to pg E5

Above figures show right hand tools.

Cat. No. (Add E to the end of the Cat. No. for T1200A grades)	Coated		Uncoated		Coated Cermet		Cermet		SUMIBORON		SUMIDIA		Dimensions (mm) () in d represents max. depth					※ Group No.		
	ACZ310		H1		T3000Z		T1200A		BN250		DA2200		t	d	R	D	T			
	R	L	R	L	R	L	R	L	R	L	R	L								
TGA R/L3033(E)	●	●	●	●	●	●	●	●	—	—	—	—	0.33	1.0(0.8)	0.05	9.525	3.18	①		
TGA R/L3050(E)	●	●	●	●	●	●	●	●	—	—	—	—	0.50	1.4(1.2)						
TGA R/L3075(E)	●	●	●	●	●	●	●	●	—	—			0.75							
TGA R/L3095(E)	●	●	●	●	●	●	●	●	—	—			0.95		2.5 (2.0)				0.1	0.2 for T1200A
TGA R/L3100(E)	●	●	●	●	●	●	●	●					1.00							
TGA R/L3110(E)	●	●			●	●	●	●					1.10							
TGA R/L3125(E)	●	●	●	●	●	●	●	●					1.25							
TGA R/L3135(E)	●	●			●	●	●	●					1.35							
TGA R/L3145(E)	●	●	●	●	●	●	●	●					1.45							
TGA R/L3150(E)	●	●			●	●	●	●					1.50							
TGA R/L3165(E)	●	●			●	●	●	●					1.65							
TGA R/L3175(E)	●	●			●	●	●	●					1.75							
TGA R/L3185(E)	●	●	●	●	●	●	●	●					1.85							
TGA R/L3200(E)	●	●	●	●	●	●	●	●					2.00		3.0 (2.5)	0.2 for T1200A				
TGA R/L3220(E)	●	●			●	●	●	●					2.20							
TGA R/L3230(E)	●	●	●	●	●	●	●	●					2.30							
TGA R/L3250(E)	●	●	●	●	●	●	●	●					2.50							
TGA R/L3265(E)	●	●			●	●	●	●					2.65							
TGA R/L3270(E)	●	●			●	●	●	●					2.70							
TGA R/L3280(E)	●	●			●	●	●	●					2.80							
TGA R/L4125(E)	●	●	●	●	●	●	●	●	●		●		1.25	2.5 (2.0)	3.9 (3.5) Internal (2.5)	0.2 *2	12.70	4.76	②	
TGA R/L4145(E)	●	●	●	●	●	●	●	●					1.45							
TGA R/L4150(E)	●	●	●	●	●	●	●	●	●		●		1.50							
TGA R/L4165(E)	●	●			●	●	●	●					1.65							
TGA R/L4175(E)	●	●	●	●	●	●	●	●					1.75							
TGA R/L4185(E)	●	●	●	●	●	●	●	●					1.85							
TGA R/L4200(E)	●	●			●	●	●	●	●		●		2.00							
TGA R/L4220(E)	●	●			●	●	●	●					2.20		5.4 (5.0) Internal (2.5) *1	0.3 *2	12.70	4.76	③	
TGA R/L4230(E)	●	●	●	●	●	●	●	●					2.30							
TGA R/L4250(E)	●	●	●	●	●	●	●	●	●		●		2.50							
TGA R/L4265(E)	●	●	●	●	●	●	●	●					2.65							
TGA R/L4270(E)	●	●			●	●	●	●					2.70							
TGA R/L4280(E)	●	●	●	●	●	●	●	●					2.80							
TGA R/L4300(E)	●	●	●	●	●	●	●	●	●		●		3.00							
TGA R/L4320(E)	●	●			●	●	●	●					3.20		5.4 (5.0) Internal (2.5) *2	0.4 *2	12.70	4.76	④	
TGA R/L4330(E)	●	●	●	●	●	●	●	●					3.30							
TGA R/L4350(E)	●	●	●	●	●	●	●	●	●		●		3.50							
TGA R/L4370(E)	●	●			●	●	●	●					3.70							
TGA R/L4390(E)	●	●			●	●	●	●					3.90							
TGA R/L4400(E)	●	●	●	●	●	●	●	●	●		●		4.00							
TGA R/L4410(E)	●	●			●	●	●	●					4.10							
TGA R/L4420(E)	●	●			●	●	●	●					4.20		Internal (2.5)	0.4 *2	12.70	4.76	④	
TGA R/L4430(E)	●	●	●	●	●	●	●	●					4.30							
TGA R/L4440(E)	●	●			●	●	●	●					4.40							
TGA R/L4450(E)	●	●	●	●	●	●	●	●					4.50							
TGA R/L4480(E)	●	●	●	●	●	●	●	●					4.80							

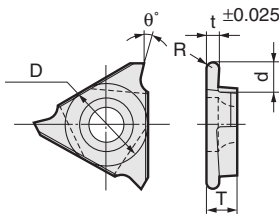
※Refer to pages E4, E5 for applicable holders GWC, GWCS and GWCI types. Select applicable inserts for the holders by using matching group numbers.

※ TGA type inserts cannot be use on GSE type and GHI type holders.

* 1 : SUMIBORON, SUMIDIA is d = 4.4 (4.0)

* 2 : SUMIBORON is R0.2. SUMIDIA is R0.1

Insert



Grade	Edge Treatment	θ°
Coated Carbide	ACZ310	Honing 15°
Carbide	H1	Sharp 25°
Coated Cermet	T3000Z	Honing 15°
SUMIBORON	BN250	Nega-Land 5°
SUMIDIA	DA2200	Sharp 15°

※For rake angle when fitted on the holder, refer to pg E5

Above figures show right hand tools.

Cat. No.	Coated		Uncoated		Coated Cermet		SUMIBORON				SUMIDIA		Dimensions (mm)					※ Group No.			
	ACZ310		H1		T3000Z		BN250				DA2200		() in d represents max. depth								
	R	L	R	L	R	L	R	L	R	L	t	d	R	D	T						
TGA R/L4050R	●	●	●	●	●	●										1.00	2.5(2.0)	0.5	12.70	4.76	②
TGA R/L4075R	●	●	●	●	●	●										1.50	3.9	0.75			③
TGA R/L4100R	●	●	●	●	●	●										2.00	Internal (3.5)	1.00			④
TGA R/L4125R	●	●	●	●	●	●										2.50		1.25			
TGA R/L4150R	●	●	●	●	●	●										3.00	5.4 Internal (5.0)	1.50			
TGA R/L4200R	●	●	●	●	●	●										4.00		2.00			

※ Refer to pages E4, E5 for applicable holders GWC, GWCS and GWC1 types.

Select applicable inserts for the holders by using matching group numbers.

※ TGA type inserts cannot be use on GSE type and GHI type holders.

Recommended Conditions

Work Material	Carbon Steel			Stainless Steel			Non-ferrous Metal		Hardened Steel
Grade	ACZ310	T3000Z	T1200A	ACZ310	T3000Z	T1200A	H1	DA2200	BN250
V (m/min)	50~150	100~180	100~180	50~150	80~150	80~120	200~300	200~300	80~120
f (mm/rev)	0.05~0.10	0.05~0.10	0.05~0.08	0.05~0.08	0.05~0.08	0.05~0.08	0.05~0.15	0.05~0.15	0.03~0.07

Insert Blanks

(Uncompleted Inserts: grooving width, nose radius and rake angle modification required)

Fig1

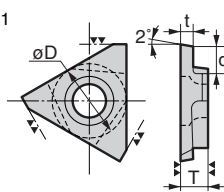
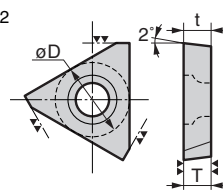


Fig2

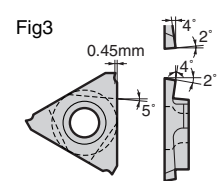
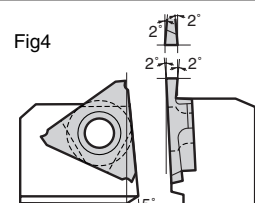


Above figures show right hand tools.

Cat. No.	Carbide						Cermet		Dimensions (mm)				Fig.
	KH03		H1		EH510		T1200A		t	d	D	T	
	R	L	R	L	R	L	R	L					
TGA R/L3-T18	●	●	●	●	●	●	●	●	1.85	(3.4)	9.525	3.18	1
TGA R/L3-T23	●	●	●	●	●	●	●	●	2.35	(3.4)	9.525	3.18	1
TGA R/L3-T31	●	●	●	●	●	●	●	●	3.18	—	9.525	3.18	2
TGA R/L4-T22	●	●	●	●	●	●	●	●	2.20	(4.8)	12.70	4.76	1
TGA R/L4-T37	●	●	●	●	●	●	●	●	3.75	(6.2)	12.70	4.76	1
TGA R/L4-T47	●	●	●	●	●	●	●	●	4.76	—	12.70	4.76	2

Precautions When Modifying Inserts

When modifying the rake face, please refer to the dimensions in Fig. 3. Dimensions shown in Fig. 4 is when the insert is mounted on the holder.

Recommended Modification

Mounted Insert Dimensions


Sumi Turn B-Groove

Indexable Triangular Inserts with chipbreaker for External & Internal Grooving

New



General Features

To solve chip control problem, grooving inserts with chipbreaker-
SumiTurn B-Groove has been added to the TGA Type insert
line-up.



Characteristics

- Achieving good chip control in a wide range of grooving processes.
- Good chip control during final wide groove touch-up with traverse tool movement.
- Inserts for a wide grooving range from 1.5 mm to 4.5 mm (total 46 items) are stocked.
- *New* New **AC530U** grade with Super ZX Coat for a longer tool life, is now available to cover various work materials from Steel, Stainless Steel to Non-ferrous metals.

Chipbreaker Insert for Square Grooves

Fig1

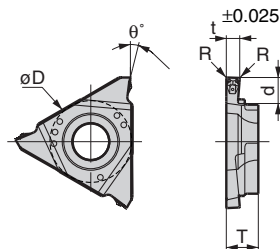
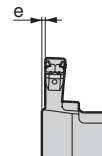


Fig2



Grade		Edge Treatment	θ°
Coated Carbide	AC530U	Honing	15°

※For rake angle when fitted on the holder, refer to pg E5

(Note 1) Please note the cutting edge position e ,
for grooving widths below 1.85 mm.
(Note 2) Figures show right hand tools.

Cat. No.	Coated						Dimensions (mm) () in d represents max. depth						Fig	※ Group No.		
	AC530U						t	d	R	D	T	e				
	R	L														
TGA R/L4150BF	●	●					1.50	3.9 (3.5) Internal (2.5)	0.2		12.70	4.76	0	1	3	
TGA R/L4165BF	●	●					1.65									0.25
TGA R/L4175BF	●	●					1.75									0.175
TGA R/L4185BF	●	●					1.85									0.125
TGA R/L4200BF	●	●					2.00									0.075
TGA R/L4220BF	●	●					2.20									
TGA R/L4230BF	●	●					2.30	5.4 (5.0) Internal (2.5)	0.3		12.70	4.76	0	1	4	
TGA R/L4250BF	●	●					2.50									
TGA R/L4265BF	●	●					2.65									
TGA R/L4270BF	●	●					2.70									
TGA R/L4280BF	●	●					2.80									
TGA R/L4300BF	●	●					3.00									
TGA R/L4320BF	●	●					3.20									
TGA R/L4330BF	●	●					3.30									
TGA R/L4350BF	●	●					3.50									
TGA R/L4370BF	●	●					3.70									
TGA R/L4390BF	●	●					3.90									
TGA R/L4400BF	●	●					4.00									0.4
TGA R/L4410BF	●	●					4.10									
TGA R/L4420BF	●	●					4.20									
TGA R/L4430BF	●	●					4.30									
TGA R/L4440BF	●	●					4.40									
TGA R/L4450BF	●	●					4.50									

※Refer to pages E4、 E5 for applicable holders GWC, GWCS and GWC1 types. Select applicable inserts for the holders by using matching group numbers.

※ TGA type inserts cannot be use on GSE type and GHI type holders.

This form is applicable to Japan domestic market only

このシートは、GWC型(→E4)、GWCS型(→E5)、GHE型(→E10)、GWCI型(→E5)用のチップに適用いたします。

特殊溝入れチップのご用命の際には、お手数ですが、下表に所定の事項(○印または寸法など)をご記入のうえ、当社の特約店もしくは、販売店へお申しつけ下さい。(本紙をコピーの上ご使用下さい。)

なお、下表以外の形状や刃幅、刃長、チップ材種の溝入れチップにつきましては、最寄りの当社営業窓口(巻末をご参照)へお問い合わせ下さい。

貴社名/ご連絡先(TEL/FAX/住所など)

型 式	①	②	③	④
形 状				
使用方法	内径用、外径用			
使用ホルダ	GWC型(→E4)、GWCS型(→E5)、GHE型(→E10)、GWCI型(→E5)			
勝 手	右勝手(R)、左勝手(L)			
チップサイズ	「3」・・・φ9.525 「4」・・・φ12.70			
t				
d				
C1				
C2				
S				
R1				
R2				
θ1				
θ2				
材 種				
数 量				
備 考				

ご記入に当たってのご注意

1. 上図は外径用右勝手あるいは内径用左勝手で記載しています。(外径用左勝手または内径用右勝手は上図の逆になります。)

2. チップサイズは次の2種類があります。

3：内接円 9.525mm

4：内接円 12.70mm

3. 刃幅や溝深さの限界寸法は次のとおりです。

(1) 最大刃幅(t)：4.5mm

・型式①と④の場合： $t \leq 4.5$ (GWC型、GWCI型は4.8mm)

・型式②の場合： $t + C_1 \leq 4.5$ (GWC型、GWCI型は4.8mm)

・型式③の場合： $t + S$ (或は $C_1 + C_2 \leq 4.5$ (GWC型、GWCI型は4.8mm)

(2) 最小刃幅(t) ・チップサイズが「3」の場合： $t \geq 0.33$ mm

・チップサイズが「4」の場合： $t \geq 0.75$ mm

(3) 溝深さ(d) ・チップサイズが「3」の場合： $d \leq 0.8 \sim d \leq 2.5$ mm (内径用： $d \leq 0.8 \sim d \leq 2.0$)

・チップサイズが「4」の場合： $d \leq 2.0 \sim d \leq 5.0$ mm (内径用： $d \leq 2.0 \sim d \leq 2.5$)

4. チップの標準公差は次のとおりです。

記 号	標準公差
t	± 0.025 mm
d	± 0.05 mm
θ1、θ2	$\pm 1^\circ$

とくにご指示のない場合は標準公差で製作いたします。

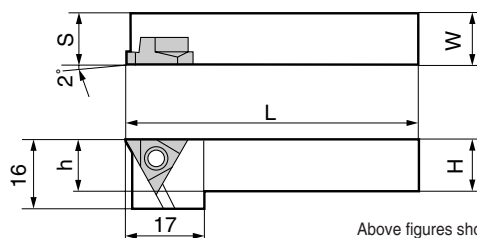
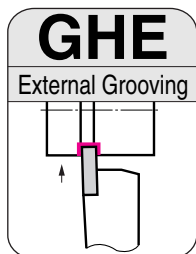
5. チップ材種は該当型番の在庫材種を基本とします。

6. 適用ホルダは型式①、②、④のチップの場合t寸法に応じたホルダをご使用下さい。型式③の場合はご相談下さい。

SEC-External Grooving Tool Holders

GHE Type

SEC-External Grooving Tool Holders



Above figures show right hand tools.

Parts

Screw	Wrench
BFX0410R/L	TH025

Holder

Cat. No.	Stock		Dimensions (mm)					Insert (Ex.)	Screw	Wrench
	R	L	H	W	L	S	h			
GHE R/L1010-33	▲	▲	10	10	100	10	10	TGE R/L300	BFX0410R/L	TH025
GHE R/L1212-33	▲	▲	12	12	100	12	12			

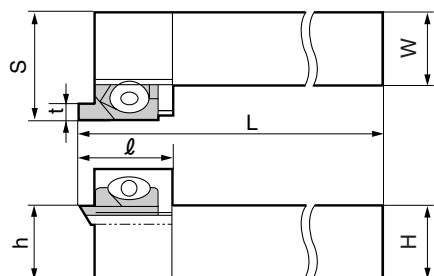
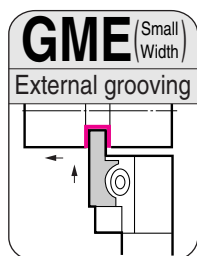
Insert

() in d represents max. depth

	Cat. No.		Dimensions (mm)						
	Cermat T1200A								
	R	L	t	d	R	D	T		
TGE R/L310	▲		1.0	2.8	0	9.525	4.76		
TGE R/L315	▲		1.5	(2.5)					
TGE R/L320	▲	▲	2.0	3.3					
TGE R/L325	▲		2.5	(3.0)					

※ 10-, 12- and 16-mm square shanked holders can also be found in the GWC type series (→ E4).

External Grooving / Traverse / Threading



Parts

	
Screw	Wrench
BXS0411	TH025

Holder

Cat. No.	Stock	Dimensions (mm)						Grooving width (mm)
		H	W	L	S	h	ℓ	t
GME R1010	●	10	10	114	16	10	15	0.75 ~ 2.50
GME R1212	●	12	12	114	18	12	15	0.75 ~ 2.50
GME R1616	●	16	16	114	22	16	21	0.75 ~ 2.50
GME R2020	●	20	20	114	26	20	21	0.75 ~ 2.50

Insert

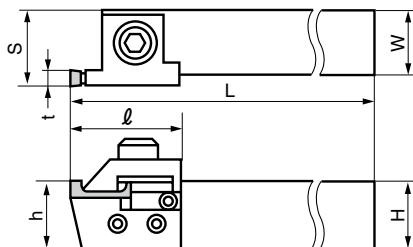
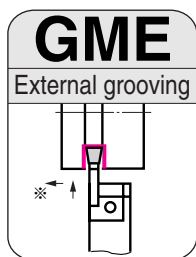
Shape	Cat. No.	Coated	Dimensions (mm)			Max. grooving depth (mm)
		GAC50	t	L	B	
Fig1	MGE R407	●	0.75	12.7	3.8	1.25
Fig1	MGE R410	●	1.00	12.7	3.8	1.25
Fig1	MGE R412	●	1.25	12.7	3.8	2.00
Fig1	MGE R415	●	1.50	12.7	3.8	2.00
Fig1	MGE R420	●	2.00	12.7	3.8	2.00
Fig1	MGE R425	●	2.50	12.7	3.8	2.40
Fig2	MGO R440	●	—	12.7	3.8	—
Fig3	MGTER440	●	—	12.7	3.8	Pitch 0.5 ~ 2.5mm

Recommended Conditions

Work material	Grooving	Turning	Threading
Cutting Speed (m/min)	40 ~ 120	40 ~ 120	40 ~ 100
Feedrate (mm/rev)	0.03 ~ 0.08	0.05 ~ 0.10	Pitch 0.5 ~ 2.5mm
D.O.C. (mm)	—	0.2 ~ 0.5	—

SEC-External Grooving Tool Holders GME/GMES Type

External Grooving / Traverse



Above figures show right hand tools.

Holder

Cat. No.	Stock		Dimensions (mm)							Maximum Grooving Depth (mm)
	R	L	H	W	L	S	h	ℓ	t	
GME R/L2525-30	●	●	25	25	150	28.9	25	41.3	3.0 ~ 3.2	12
GME R/L2525-40	●	●	25	25	150	29.0	25	41.3	4.0	12
GME R/L2525-50	●	●	25	25	150	28.3	25	41.3	4.8 ~ 6.0	12
GME R/L2525-70	●	●	25	25	150	31.4	25	41.3	7.0	12
GME R/L2525-85	●	●	25	25	150	31.3	25	41.3	3.0 ~ 9.0	12

Reference for "S" is taken when t=3.0, 4.0, 5.0, 7.0, 8.5mm respectively.

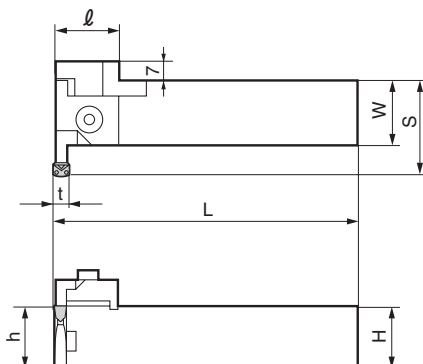
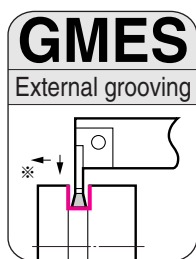
Insert (Refer to page E15)

Holder	Insert		
GME R/L2525-30	MGE R/L730	MGE N730,732	MGE N715R
GME R/L2525-40	MGE R/L740	MGE N740	MGE N720R
GME R/L2525-50	MGE R/L850	MGE N850,848	MGE N825R
GME R/L2525-70	MGE R/L860	MGE N860	MGE N830R
GME R/L2525-70	MGE R/L970	—	
GME R/L2525-85	MGE R/L980	MGE N980	
GME R/L2525-85	MGE R/L990		

Parts

Clamp	Supporter	Stopper	Screw	Wrench
GEC R/L30	GE R/L30	GES40	BX0414 (Supporter & Stopper)	LH030 (Supporter & Stopper)
GEC R/L40	GE R/L40	GES50	BX0820 (Clamp)	LH060 (Clamp)
GEC R/L50	GE R/L50	GES70		
GEC R/L70	GE R/L70			
GEC R/L85	GE R/L85			

External L-Styled (Side Cut)



Above figures show right hand tools.

Holder

Cat. No.	Stock		Dimensions (mm)							Maximum Grooving Depth (mm)
	R	L	H	W	L	S	h	ℓ	t	
GMES R/L2525-30	●	●	25	25	150	37.7	25	28	3.0 ~ 3.2	12
GMES R/L2525-40	●	●	25	25	150	37.7	25	29	4.0	12
GMES R/L2525-50	●	●	25	25	150	37.7	25	28	4.8 ~ 6.0	12
GMES R/L2525-70	●	●	25	25	150	37.7	25	31	7.0	12
GMES R/L2525-85	●	●	25	25	150	37.7	25	31	8.0 ~ 9.0	12

Reference for "L" is taken when t=3.0, 4.0, 5.0, 7.0, 9.0mm respectively.

Insert (Refer to page E15)

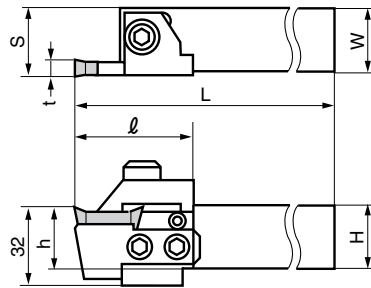
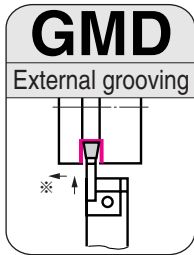
Holder	Insert		
GMES R/L2525-30	MGE L/R730	MGE N730,732	MGE N715R
GMES R/L2525-40	MGE L/R740	MGE N740	MGE N720R
GMES R/L2525-50	MGE L/R850	MGE N850,848	MGE N825R
GMES R/L2525-70	MGE L/R860	MGE N860	MGE N830R
GMES R/L2525-70	MGE L/R970	—	
GMES R/L2525-85	MGE L/R980	MGE N980	
GMES R/L2525-85	MGE L/R990		

Parts

Clamp	Supporter	Stopper	Screw	Wrench
GEC L/R30	GES L/R30	GESS L/R 40	BX0414 (Supporter)	LH030 (Supporter)
GEC L/R40	GES L/R40	GESS L/R 50	BX0820 (Clamp)	LH060 (Clamp)
GEC L/R50	GES L/R50	GESS L/R 70	BX0308 (Stopper)	LH025 (Stopper)
GEC L/R70	GES L/R70			
GEC L/R85	GES L/R85			

SEC-External Grooving Tool Holders GMD/GMDS Type

External Grooving



Above figures show right hand tools.

Holder

Cat. No.	Stock		Dimensions (mm)							Grooving width (mm)	Maximum Grooving Depth (mm)
	R	L	H	W	L	S	h	ℓ	t		
GMD R/L2525-30	●	●	25	25	150	26.2	25	44.4	3.0 ~ 3.2	15	
GMD R/L2525-40	●	●	25	25	150	26.2	25	44.4	4.0	15	
GMD R/L2525-50	●	●	25	25	150	25.6	25	49.2	4.8 ~ 6.0	20	
GMD R/L3232-50	●	●	32	32	170	32.6	32	49.2	4.8 ~ 6.0	20	
GMD R/L2525-70	●	●	25	25	150	26.2	25	49.2	7.0	20	
GMD R/L3232-70	●	●	32	32	170	35.4	32	49.2	7.0	20	
GMD R/L2525-85	●	●	25	25	150	26.2	25	49.2	8.0 ~ 9.0	20	
GMD R/L3232-85	●	●	32	32	170	35.8	32	49.2	8.0 ~ 9.0	20	

Reference for "S" is taken when t=3.0, 4.0, 5.0, 5.0, 7.0, 7.0, 8.5, 9.0mm respectively.

Insert (Refer to page E15)

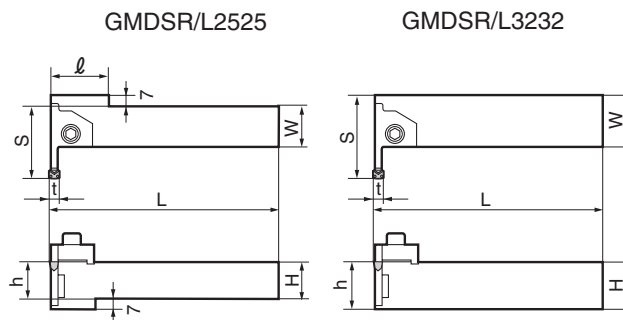
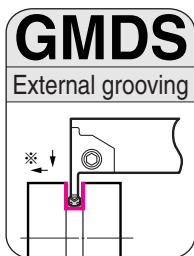
Holder	Insert		
GMDR/L2525-30	MGE R/L730	MGE N730,732	MGE N715R
GMDR/L2525-40	MGE R/L740	MGE N740	MGE N720R
GMDR/L2525-50	MGE R/L850	MGE N850,848	MGE N825R
GMDR/L3232-50	MGE R/L860	MGE N860	MGE N830R
GMDR/L2525-70	MGE R/L970	—	
GMDR/L3232-70	—	—	
GMDR/L2525-85	MGE R/L980	MGE N980	
GMDR/L3232-85	MGE R/L990	—	

Parts

Clamp	Supporter	Stopper	Screw	Wrench
GDC R/L30	GD R/L30	GDS R/L40	BXF0618 (Supporter)	LH050 (Supporter)
GDC R/L40	GD R/L40	GDS R/L50	BX0820 (Clamp)	LH060 (Clamp)
GDC R/L50	GD R/L50	GDS R/L70	BX0308 (Stopper)	LH025 (Stopper)
GDC R/L70	GD R/L70			
GDC R/L85	GD R/L85			

Grooving Holders

External L-Styled (Side Cut)



Above figures show right hand tools.

Holder

Cat. No.	Stock		Dimensions (mm)							Grooving width (mm)	Maximum Grooving Depth (mm)
	R	L	H	W	L	S	h	ℓ	t		
GMDS R/L2525-30	●	●	25	25	150	40.8	25	26	3.0 ~ 3.2	15	
GMDS R/L2525-40	●	●	25	25	150	40.8	25	26	4.0	15	
GMDS R/L2525-50	●	●	25	25	150	45.6	25	26	4.8 ~ 6.0	20	
GMDS R/L3232-50	●	●	32	32	170	52.6	32	—	4.8 ~ 6.0	20	
GMDS R/L2525-70	●	●	25	25	150	45.6	25	28	7.0	20	
GMDS R/L3232-70	●	●	32	32	170	52.6	32	—	7.0	20	
GMDS R/L2525-85	●	●	25	25	150	45.6	25	28	8.0 ~ 9.0	20	
GMDS R/L3232-85	●	●	32	32	170	52.6	32	—	8.0 ~ 9.0	20	

Reference for "L" is taken when t=3.0, 4.0, 5.0, 5.0, 7.0, 7.0, 9.0, 9.0mm respectively.

Insert (Refer to page E15)

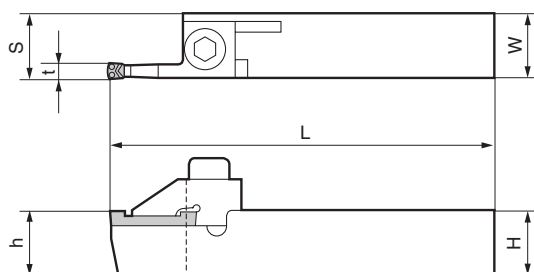
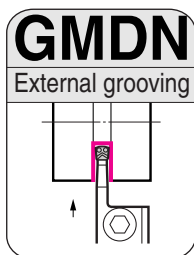
Holder	Insert		
GMDSR/L2525-30	MGE L/R730	MGE N730,732	MGE N715R
GMDSR/L2525-40	MGE L/R740	MGE N740	MGE N720R
GMDSR/L2525-50	MGE L/R850	MGE N850,848	MGE N825R
GMDSR/L3232-50	MGE L/R860	MGE N860	MGE N830R
GMDSR/L2525-70	MGE L/R970	—	
GMDSR/L3232-70	—	—	
GMDSR/L2525-85	MGE L/R980	MGE N980	
GMDSR/L3232-85	MGE L/R990	—	

Parts

Clamp	Supporter	Stopper	Screw	Wrench
GDC L/R30	GD L/R30	GDS L/R 40	BXF0618 (Supporter)	LH050 (Supporter)
GDC L/R40	GD L/R40	GDS L/R 50	BX0820 (Clamp)	LH060 (Clamp)
GDC L/R50	GD L/R50	GDS L/R 70	BX0308 (Stopper)	LH025 (Stopper)
GDC L/R70	GD L/R70			
GDC L/R85	GD L/R85			

SEC-External Grooving Tool Holders GMDN/GMDX Type

External Grooving



Holder

Above figures show right hand tools.

Cat. No.	Stock		Dimensions (mm)							Grooving width (mm)	Maximum Grooving Depth (mm)
	R	L	H	W	L	S	h			t	
GMDN R/L2020-30	●	●	20	20	125	20	20			3.0	19
GMDN R/L2525-30	●	●	25	25	150	25	25			3.0	19
GMDN R/L2020-50	●	●	20	20	125	20	20			5.0	22
GMDN R/L2525-50	●	●	25	25	150	25	25			5.0	22
GMDN R/L2020-60	●	●	20	20	125	20	20			6.0	22
GMDN R/L2525-60	●	●	25	25	150	25	25			6.0	22

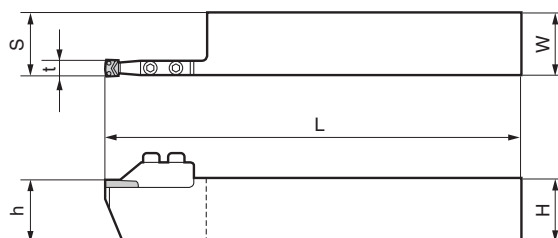
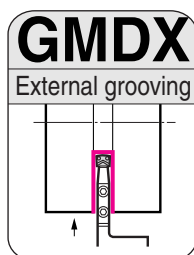
Insert (Refer to page E15)

Holder	Insert		
GMDN R/L2020-30 GMDN R/L2525-30	MGE R/L730	MGE N730	MGE N715R
GMDN R/L2020-50 GMDN R/L2525-50	MGE R/L850	MGE N850	MGE N825R
GMDN R/L2020-60 GMDN R/L2525-60	MGE R/L860	MGE N860	MGE N830R

Parts

Clamp	Screw	Wrench
GDN R/L30	BX0615	LH050
GDN R/L50		

External Grooving



Holder

Above figures show right hand tools.

Cat. No.	Stock		Dimensions (mm)							Grooving width (mm)	Maximum Grooving Depth (mm)
	R	L	H	W	L	S	h			t	
GMDX R/L2525-60	●	●	25	25	150	25	25			6.4	38
GMDX R/L3232-60	●	●	32	32	170	32	32			6.4	38
GMDX R/L2525-80	●	●	25	25	150	25	25			8.0	38
GMDX R/L3232-80	●	●	32	32	170	32	32			8.0	38

Insert (Refer to page E15)

Holder	Insert
GMDX R/L2525-60 GMDX R/L3232-60	MGE N464S
GMDX R/L2525-80 GMDX R/L3232-80	MGE N580S

Parts

Clamp	Screw	Wrench
GDX60	BX0315	LH025
	BX0320	

■ For GME/GMES /GMD/GMDS /GMDN (No Breaker)

Cat. No.	Coated		Carbide		SUMIBORON		Dimensions (mm)			
	ACZ310		A30		BN250		t	L	B	R
	R	L	R	L	R	L				
MGE R/L730	●	●	●				3.0	22.2	6.12	0.2
MGE R/L740	●	●	●		●		4.0	22.2	6.12	0.2
MGE R/L850	●	●	●		●		5.0	25.4	6.12	0.2
MGE R/L860	●	●	●		●		6.0	25.4	6.12	0.2
MGE R/L970	●	●	●				7.0	28.6	8.28	0.2
MGE R/L980	●	●	●				8.0	28.6	8.28	0.2
MGE R/L990	●	●	●				9.0	28.6	8.28	0.2

Above figures show right hand tools.

■ For GME/GMES /GMD/GMDS /GMDN (Full R Type)

Cat. No.	Coated	Dimensions (mm)			
	ACZ310	t	L	B	R
MGE N715R	●	3.0	22.2	6.12	1.5
MGE N720R	●	4.0	22.2	6.12	2.0
MGE N825R	●	5.0	25.4	6.12	2.5
MGE N830R	●	6.0	25.4	6.12	3.0

■ For GME/GMES /GMD/GMDS /GMDN (With Chipbreaker)

Cat. No.	Coated	Carbide	Dimensions (mm)			
	ACZ310	A30	t	L	B	R
MGE N730	●	●	3.0	22.2	6.12	0.25
MGE N732	●	●	3.2	22.2	6.12	0.25
MGE N740	●	●	4.0	22.2	6.12	0.25
MGE N848	●	●	4.8	25.4	6.12	0.25
MGE N850	●	●	5.0	25.4	6.12	0.25
MGE N860	●	●	6.0	25.4	6.12	0.25
MGE N980	●	●	8.0	28.6	8.28	0.25

■ For GMDX (With Chipbreaker)

Cat. No.	Coated	Dimensions (mm)			
	ACZ310	t	L	B	R
MGE N464S	●	6.4	12.4	6.12	0.25
MGE N580S	●	8.0	14.0	8.28	0.25

■ Recommended Conditions

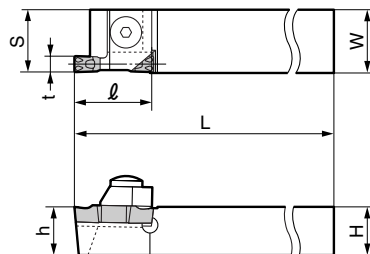
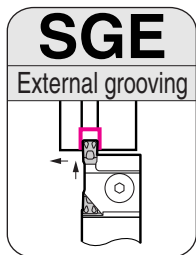
Work Material	Carbon Steel		Alloy Steel		Stainless Steel		Hardened Steel
Grade	A30	ACZ310	A30	ACZ310	A30	ACZ310	BN250
Cutting Speed (m/min)	70~100	80~150	60~120	70~120	60~100	70~120	80~120
Feedrate (mm/rev)	0.08~0.15	0.06~0.12	0.08~0.12	0.06~0.12	0.08~0.10	0.06~0.10	0.03~0.07

For traverse cut	
Depth of cut (mm)	Within grooving width × 0.5
Applicable insert	MGEN○○○ (With Chipbreaker)

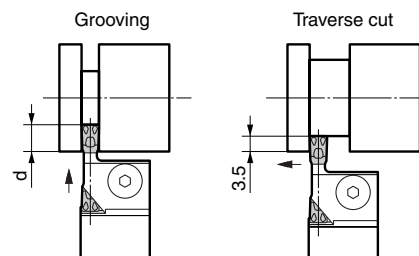
SEC-External Grooving Tool Holders SGE Type

External Shallow Grooves

New



Maximum Grooving Depth



Parts

Clamp	Clamp Bolt	Spring	Wrench
GEN3000	FBH 0516NT	GSP-5	LH025NT
GEN4000	FBH 0520NT		
GEN5000	FBH 0516NT		
GEN6000	FBH 0520NT		

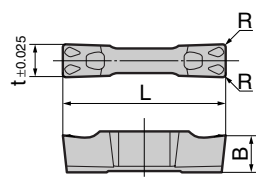
Holder

Above figures show right hand tools.

Cat. No.	Stock		Holder Dimensions(mm)						Grooving width (mm)	Maximum Grooving Depth d (mm)	Applicable Insert	Clamp	Clamp Bolt	Spring	Wrench		
	R	L	H	L	S	W	h	ℓ	t								
SGE R/L1016-3	●	●	10	120	15.7	16	10	19.5	3.0	6.2	GEN30○○	GCL R/L-3	FBH 0516NT	GSP-5	LH025NT		
SGE R/L1216-3	●	●	12	120	15.7	16	12	19.5								FBH 0520NT	
SGE R/L1616-3	●	●	16	120	15.7	16	16	22.0		8.0							
SGE R/L2020-3	●	●	20	120	19.7	20	20	22.0									
SGE R/L1016-45	●	●	10	120	15.7*	16	10	19.5	4.0 5.0	6.2	GEN40○○ GEN50○○	GCL R/L-4	FBH 0516NT				
SGE R/L1216-45	●	●	12	120	15.7*	16	12	19.5								FBH 0520NT	
SGE R/L1616-45	●	●	16	120	15.7*	16	16	22.0		8.0							
SGE R/L2020-45	●	●	20	120	19.7*	20	20	22.0									
SGE R/L1020-6	●	●	10	120	19.7	20	10	19.5	6.0	6.2	GEN60○○	GCL R/L-6	FBH 0516NT				
SGE R/L1220-6	●	●	12	120	19.7	20	12	19.5								FBH 0520NT	
SGE R/L1620-6	●	●	16	120	19.7	20	16	22.0		8.0							
SGE R/L2020-6	●	●	20	120	19.7	20	20	22.0									

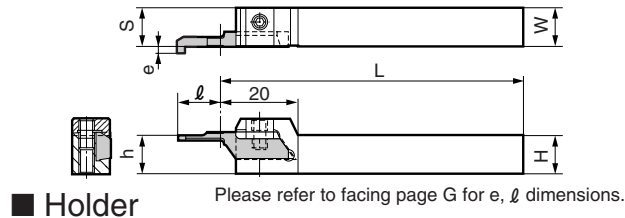
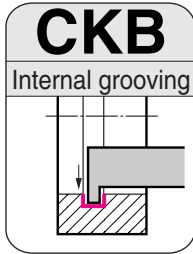
*Reference for "S" taken when t=4.0mm. When t=5.0mm, "S" is larger by 0.5mm

Insert



Cat. No.	Coated	Dimensions (mm)				Applicable toolholder
	ACZ150	t	L	B	R	
GEN3002	●	3.00	20	4.64	0.2	SGE R/L 0000-3
GEN3004	●	3.00	20	4.64	0.4	
GEN4002	●	4.00	20	4.5	0.2	SGE R/L 0000-45
GEN4004	●	4.00	20	4.5	0.4	
GEN5002	●	5.00	20	4.5	0.2	
GEN5004	●	5.00	20	4.5	0.4	
GEN6002	●	6.00	20	4.5	0.2	SGE R/L 0000-6
GEN6004	●	6.00	20	4.5	0.4	

Internal Grooving

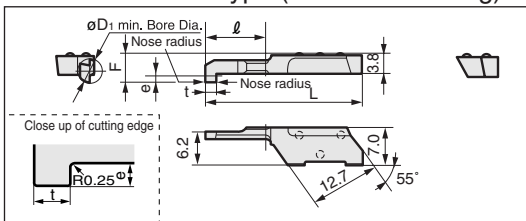


Parts

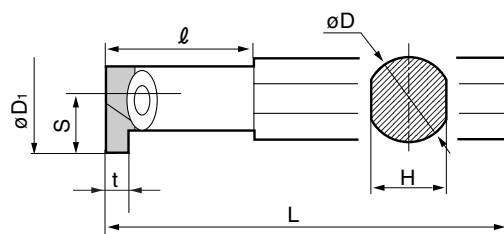
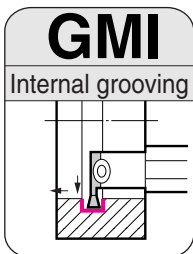
Clamp	Screw	Wrench
CKBW16	WB4-8	LH020

Cat. No.	Stock	Dimensions (mm)				
		H	W	L	S	h
CKBR1010-16	●	10	10	100	10	10
CKBR1212-16	●	12	12	125	12	12
CKBR1616-16	●	16	16	125	16	16
CKBR2020-16	●	20	20	125	20	20
CKBR2525-16	●	25	25	150	25	25

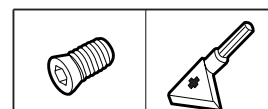
Insert KBMG Type (Internal Grooving)



Cat. No.	Coated	Min. Bore	Dimensions (mm)					
	ACZ310	Dia.	t	F	e	Nose radius	L	l
KBMGR0411-05	●	4.0	1.00	4.90	1.1	0.05	28.5	11
KBMGR0411-10	●	4.0	2.00	4.90	1.1	0.10	28.5	11
KBMGR0511-05	●	5.0	1.00	5.10	1.3	0.05	28.5	11
KBMGR0511-10	●	5.0	2.00	5.10	1.3	0.10	28.5	11



Parts



Holder

Cat. No.	Stock	Dimensions (mm)					Min. Bore øD ₁ (mm)	Screw	Wrench
		øD	H	L	S	l			
GMIR212	●	12	10.3	153	8	25.4	14 and above	BXS0411	TH025
GMIR216	●	16	14.3	153	10	0	20 and above		

Insert

Shape	Cat. No.	Coated	Uncoated		Dimensions (mm)			Maximum Grooving Depth (mm)
		GAC50	A30	G10E	t	L	B	
Fig1 Grooving	MGIR407	●	—	—	0.75	12.7	3.8	1.25
Fig1 Turning	MGIR410	●	—	—	1.00	12.7	3.8	1.25
Fig1 Threading	MGIR412	●	—	—	1.25	12.7	3.8	2.00
	MGIR415	●	—	—	1.50	12.7	3.8	2.00
	MGIR420	●	—	—	2.00	12.7	3.8	2.00
	MGIR424	—	●	—	2.40	12.7	3.8	2.40
	MGIR425	●	—	—	2.50	12.7	3.8	2.40
	MGBR440	●	—	—	—	12.7	3.8	—
	MGTIR440	●	—	—	—	12.7	3.8	Pitch 0.5 ~ 2.5mm

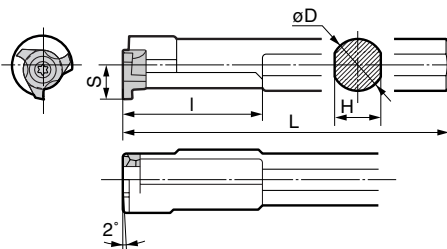
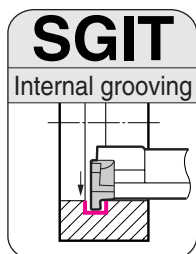
Recommended Conditions

	Grooving	Turning	Threading
Cutting Speed (m/min)	40 ~ 100	40 ~ 100	40 ~ 100
Feedrate (mm/rev)	0.03 ~ 0.08	0.05 ~ 0.10	Pitch 0.5 ~ 2.5mm
D.O.C. (mm)	—	0.2 ~ 0.5	—

SEC-Internal Grooving Tool Holders SGIT Type

Internal Grooving

New



Parts

Holder

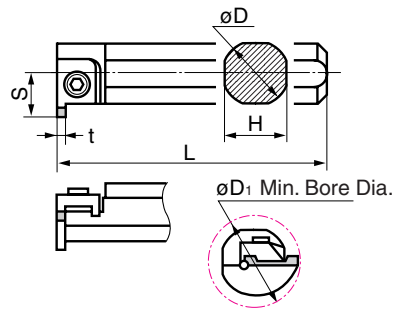
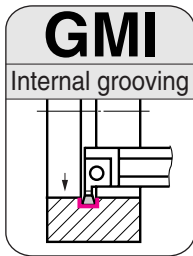
Cat. No.	Stock	Dimensions (mm)					Min. Bore Dia.	Maximum Grooving Depth (mm)	Applicable Insert	Screw	Wrench
		øD	H	L	S	ℓ					
SGITR08	●	8	7.0	125	5.0	20	10.0	0.8*	GITL3○○○	BFTX02506NS	RT08
SGITR10	●	10	9.0	150	6.0	25	12.0	0.8*			
SGITR12	●	12	11.0	180	7.0	30	14.0	1.8	GITL5○○○	BFTX0307NS	RT10
SGITR14	●	14	13.0	180	8.0	35	16.0	1.8			
SGITR16	●	16	15.0	200	10.0	40	20.0	2.8	GITL6○○○		
SGITR20	●	20	19.0	200	12.0	40	25.0	2.8			

*Maximum grooving depth is 0.5mm when GITL3050 is set.

Insert

	Cat. No.	Coated	Dimensions (mm)				Applicable toolholder
		ACZ150	t	d	R	ϕD	
	GITL3050	●	0.50	1.2	0.05	5.56	SGITR08 SGITR10
	GITL3065	●	0.65	1.2	0.05	5.56	
	GITL3075	●	0.75	1.2	0.05	5.56	
	GITL3100	●	1.00	1.2	0.05	5.56	
	GITL3125	●	1.25	1.2	0.2	5.56	
	GITL3145	●	1.45	1.2	0.2	5.56	
	GITL3150	●	1.50	1.2	0.05	5.56	
	GITL3200	●	2.00	1.2	0.1	5.56	
	GITL5100	●	1.00	2.2	0.05	7.94	SGITR12 SGITR14
	GITL5145	●	1.45	2.2	0.2	7.94	
	GITL5150	●	1.50	2.2	0.05	7.94	
	GITL5175	●	1.75	2.2	0.2	7.94	
	GITL5200	●	2.00	2.2	0.1	7.94	
	GITL6150	●	1.50	3.2	0.2	9.525	SGITR16 SGITR20
	GITL6175	●	1.75	3.2	0.2	9.525	
	GITL6200	●	2.00	3.2	0.2	9.525	

Internal Grooving



Parts

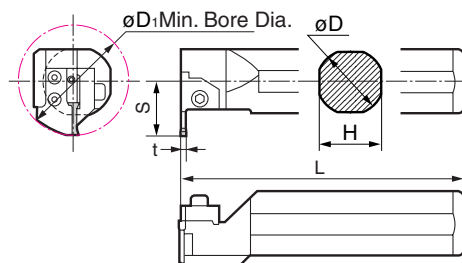
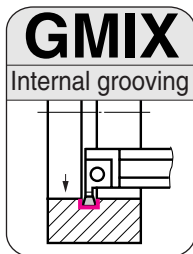
Clamp	Screw	Wrench
GIC R/L32	BX0615	LH050
GIC R/L42		
GIC R/L52		
GIC R/L42		
GIC R/L52		

Holder

Above figures show right hand tools.

Cat. No.	Stock		Dimensions (mm)				Min Bore ϕD_1	Grooving width (mm)		Maximum Grooving Depth (mm)
	R	L	ϕD	H	L	S		t		
GMI R/L325	●	●	25	23	200	16	32	3.0 ~ 3.2	4	GIC R/L32
GMI R/L425	●	●	25	23	200	16	32	4.0	4	GIC R/L42
GMI R/L525	●	●	25	23	200	19	38	4.8 ~ 6.0	7.5	GIC R/L52
GMI R/L432	●	●	32	30	250	19.5	39	4.0	4	GIC R/L42
GMI R/L532	●	●	32	30	250	22.5	45	4.8 ~ 6.0	7.5	GIC R/L52

Internal Grooving



Parts

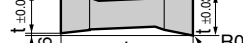
Clamp	Supporter	Stopper	Screw	Wrench
GIC R/L35	GC R/L35	GIS35	BXF0620 (supporter)	LH050 (supporter)
GIC R/L55	GC R/L55	GIS50	BX0308 (Stopper)	LH025 (Stopper)
GIC R/L65	GC R/L65		BX0820 (Clamp)	LH060 (Clamp)

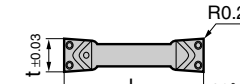
Holder

Above figures show right hand tools.

Cat. No.	Stock		Dimensions (mm)				Min Bore ϕD_1	Grooving width (mm)		Maximum Grooving Depth (mm)
	R	L	ϕD	H	L	S		t		
GMIX R/L350			50	48	350	34.9	100	3.0 ~ 3.2	9.5	GIC R/L35
GMIX R/L550			50	48	350	39.7	100	4.8 ~ 5.0	9.5	GC R/L55
GMIX R/L650			50	48	350	39.7	100	6.0	9.5	GC R/L65

Insert

	Cat. No.	Coated		Uncoated		SUMIBORON	Dimensions (mm)				Applicable toolholder	
		ACZ310		A30		BN250	t	L	B	R		
		R	L	R	L	R						
	MGI R/L730	●	●	●			3	22.2	6.12	0.2	GMI R/L325	GMIX R/L350
	MGI R/L740	●	●	●		●	4	22.2	6.12	0.2	GMI R/L425	GMIR/L432
	MGI R/L850	●	●	●			5	25.4	6.12	0.2	GMIX R/L550	GMI R/L525 GMI R/L532
	MGI R/L860	●	●	●			6	25.4	6.12	0.2	GMIX R/L650	

	Cat. No.	Coated	Uncoated		Dimensions (mm)				Applicable toolholder	
		ACZ310	A30		t	L	B	R		
		N	N							
	MGI N730	●			3	22.2	6.12	0.25	GMI R/L325	GMIX R/L350
	MGI N732	●			3.2	22.2	6.12	0.25	GMI R/L425	GMIR/L432
	MGI N740	●			4	22.2	6.12	0.25	GMIX R/L550	GMI R/L525 GMI R/L532
	MGI N848	●			4.8	25.4	6.12	0.25		
	MGI N850	●	▲		5	25.4	6.12	0.25		
	MGI N860	●			6	25.4	6.12	0.25	GMIX R/L650	

SEC-Face Grooving Tool Holders

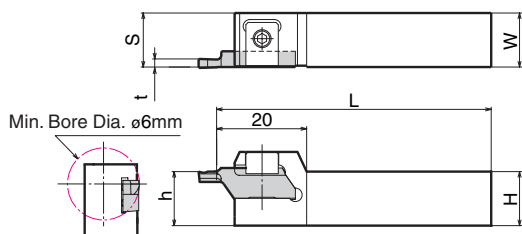
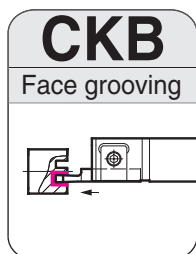
Face Grooving Variations/CKB Type

Face Grooving Variations and Applicable Holder

Face Grooving Variations and Tooling Positions		Work Rotation	Applicable Holder			
			Adjustable type	Adjustable type, L-Styled	Non-adjustable type	Non-adjustable type, L-Styled
			 GMFR	—	—	—
			 GMFCL	—	—	—
			 GMFL	 GMFSR	 GMFNL GMFWL GMFR	 GMFNSR GMFWSR
			 GMFCR	 GMFSL	 GMFNR GMFWR GMFL	 GMFNSL GMFWSL

Very Small Diameter Face Grooving

New



Parts

Clamp	Double Screw	Wrench
CKBW16	WB4-8	LH020

Holder

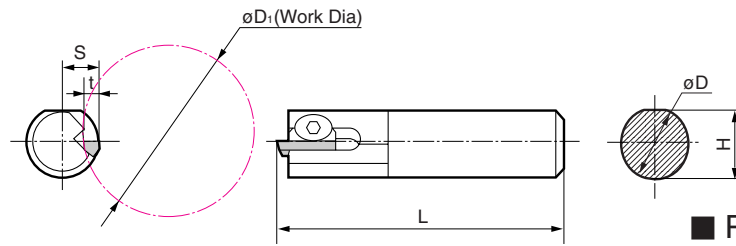
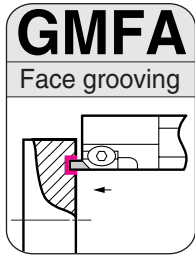
Cat. No.	Stock	Dimensions (mm)					Clamp	Double Screw	Wrench
		H	W	L	S	h			
CKBR1010-16	●	10	10	100	10	10	CKBW16	WB4-8	LH020
CKBR1212-16	●	12	12	125	12	12			
CKBR1616-16	●	16	16	125	16	16			
CKBR2020-16	●	20	20	125	20	20			
CKBR2525-16	●	25	25	150	25	25			

※ For round shank holder, refer to page D12.

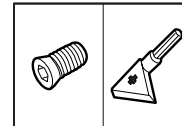
Insert

Cat. No.	Coated	Min. Bore Dia. (mm)	Dimensions (mm)					Maximum Grooving Depth (mm)
	ACZ150		F	e	t	Nose R	L	
	R							
KBFR0615-05	●	6.0	4.0	0.2	1.5	0.05	21.8	4.0
KBFR0620-05	●	6.0	4.0	0.2	2	0.05	21.8	4.0
KBFR0630-05	●	6.0	4.0	0.2	3	0.05	21.8	4.0

Face Grooving



Parts



Above figures show right hand tools.

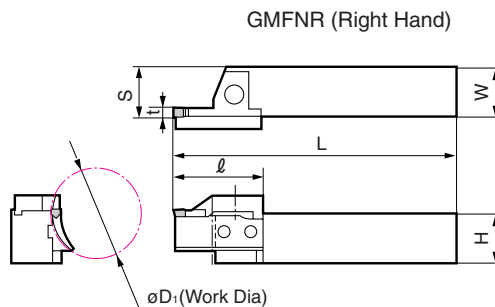
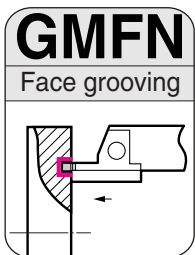
Holder

Cat. No.	Stock		Dimensions (mm)						Grooving width (mm)	Work Dia.	Screw	Wrench
	R	L	ϕD	H	L	S			t	ϕD_1		
GMFA R/L216	●	●	16	15	152.4	6.4			2.00 ~ 2.60	12.7 ~	BXS0411	TH025

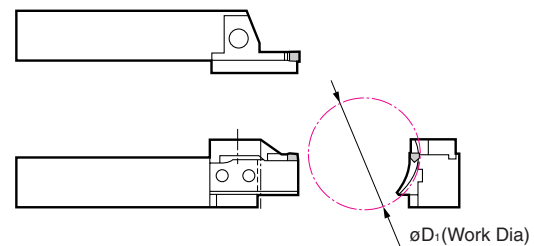
Insert

	Cat. No.	Coated		Dimensions (mm)				Maximum Grooving Depth (mm)
		GAC50		t	L	B	R	
		R	L					
	MGF R/L420	●	●	2.00	12.7	3.8	0.05	2.30
MGF R/L424	●	●	2.40	12.7	3.8	0.05	2.30	
MGF R/L426	●	●	2.60	12.7	3.8	0.05	2.30	

Face Grooving (Non-adjustable type)



GMFNL (Left Hand)



Parts

Clamp	Supporter	Screw	Wrench
	GM R/L32-32		
	GM R/L32-38		
GMC R/L32	GM R/L32-48	BXF0416 BX0620	LH030 LH050
	GM R/L32-64		
GMC R/L48	GM R/L48-48		
	GM R/L48-64		

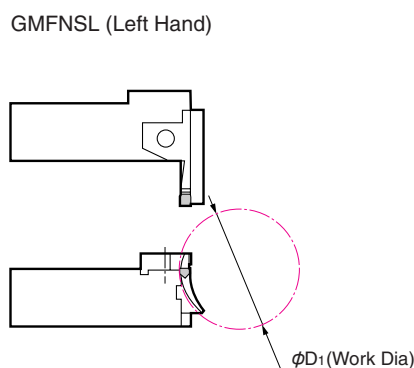
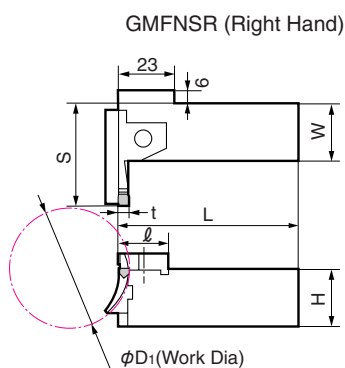
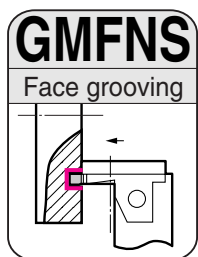
Holder

Cat. No.	Stock		Dimensions (mm)						Work Dia.	Grooving width	Maximum Grooving Depth (mm)
	R	L	H	W	L	S	ϕ		ϕD_1	t	
GMFN R/L2525-32-32	●	●	25	25	150	25	43.5	32~38	3.2	13	
GMFN R/L2525-32-38	●	●	25	25	150	25	43.5	38~48	3.2	13	
GMFN R/L2525-32-48	●	●	25	25	150	25	43.5	48~64	3.2	19	
GMFN R/L2525-32-64	●	●	25	25	150	25	43.5	64~89	3.2	19	
GMFN R/L2525-48-48	●	●	25	25	150	25	43.5	48~64	4.8	19	
GMFN R/L2525-48-64	●	●	25	25	150	25	43.5	64~89	4.8	19	

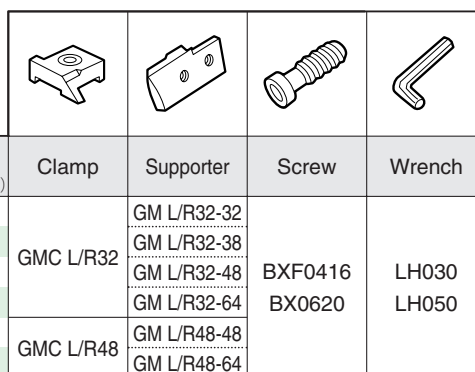
※ Please set the cutting edge 1.0mm higher from the center position.

SEC-Face Grooving Tool Holders GMFNS Type

Face Grooving L-Styled (Side Cut)



■ Parts



※ Please set the cutting edge 1.0mm higher from the center position.

- Holder

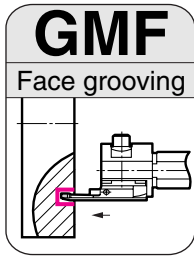
Cat. No.	Stock		Dimensions (mm)					Work Dia.	Grooving width (mm)	Maximum Grooving Depth (mm)
	R	L	H	W	L	S	ℓ	øD ₁	t	
GMFNS R/L2525-32-32	●	●	25	25	150	44.5	22	32~38	3.2	13
GMFNS R/L2525-32-38	●	●	25	25	150	44.5	22	38~48	3.2	13
GMFNS R/L2525-32-48	●	●	25	25	150	44.5	22	48~64	3.2	19
GMFNS R/L2525-32-64	●	●	25	25	150	44.5	22	64~89	3.2	19
GMFNS R/L2525-48-48	●	●	25	25	150	44.5	22	48~64	4.8	19
GMFNS R/L2525-48-64	●	●	25	25	150	44.5	22	64~89	4.8	19

■ Insert

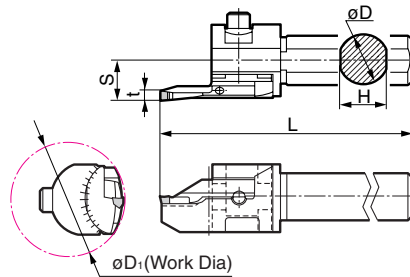
Fig1		Shape	Cat. No.	Coated	Dimensions (mm)		Applicable toolholder
				GAC50	t	R	
Fig1		Fig1	MGFR532-60	●	3.2	0.25	GMFNL, GMFNSR
		Fig1	MGFL532-60	●	3.2	0.25	GMFNR, GMFNSL
Fig2		Fig1	MGFR548-60	●	4.8	0.25	GMFNR/L, GMFNSR/L
		Fig2	MGFR516R-60	●	3.2	1.6	GMFNL, GMFNSR
		Fig2	MGFL516R-60	●	3.2	1.6	GMFNR, GMFNSL
		Fig2	MGFR524R-60	●	4.8	2.4	GMFNR/L, GMFNSR/L

SEC-Face Grooving Tool Holders GMF/GMFC Type

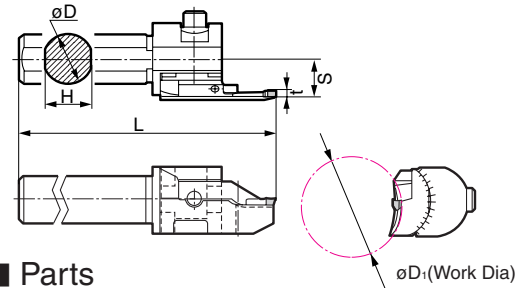
Facing Grooving (Adjustable type)



GMFR (Right Hand)

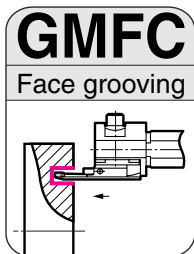


GMFL (Left Hand)

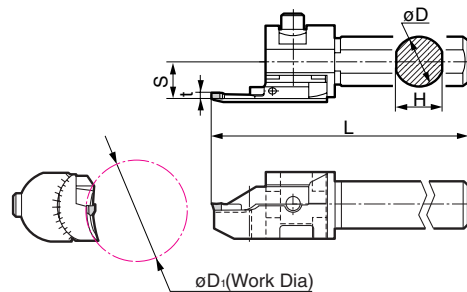


Holder

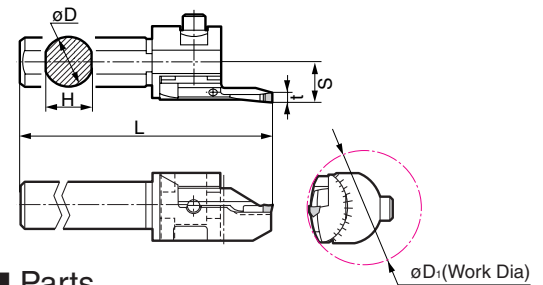
Cat. No.	Stock		Dimensions (mm)					Work Dia. øD ₁	Grooving width (mm) t	Maximum Grooving Depth (mm)	Clamp	Support	Screw	Washer	Wrench
	R	L	H	øD	L	S	øD ₁								
GMF R/L2525	●	●	23	25	200	20.3	57~400		3.2	19	GFC R/L32-60	GF R/L32-60	BX0825 WB5-18	PW80	LH060 TH025
GMF R/L3232	●	●	30	32	200	20.3	57~400		3.2	19	GFC R/L32-60	GF R/L32-60			
GMF R/L2525-48	●	●	23	25	200	20.3	57~400		4.8	25	GFC R/L48-60	GF R/L48-60			
GMF R/L3232-48	●	●	30	32	200	20.3	57~400		4.8	25	GFC R/L48-60	GF R/L48-60			
GMF R/L2525-63	●	●	23	25	200	20.3	57~400		6.35	25	GFC R/L63-60	GF R/L63-60			
GMF R/L3232-63	●	●	30	32	200	20.3	57~400		6.35	25	GFC R/L63-60	GF R/L63-60			



GMFCR (Right Hand)



GMFCL (Left Hand)

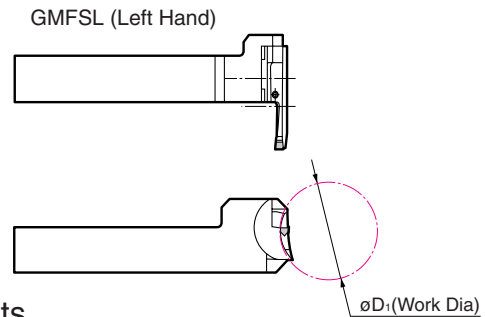
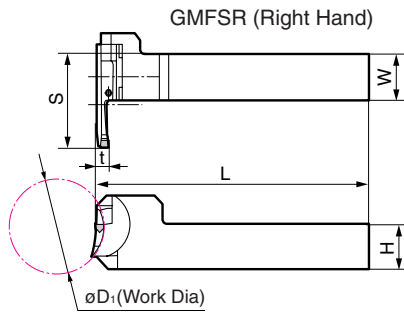
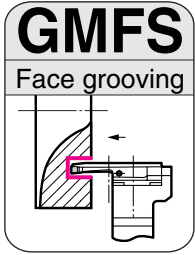


Holder

Cat. No.	Stock		Dimensions (mm)					Work Dia. øD ₁	Grooving width (mm) t	Maximum Grooving Depth (mm)	Clamp	Support	Screw	Washer	Wrench
	R	L	H	øD	L	S	øD ₁								
GMFC R/L2525	●	●	23	25	200	20.3	57~400		3.2	19	GFCW R/L32-60	GFW R/L32-60	BX0825 WB5-18	PW80	LH060 TH025
GMFC R/L3232	●	●	30	32	200	20.3	57~400		3.2	19	GFCW R/L32-60	GFW R/L32-60			
GMFC R/L2525-48	●	●	23	25	200	20.3	57~400		4.8	25	GFCW R/L48-60	GFW R/L48-60			
GMFC R/L3232-48	●	●	30	32	200	20.3	57~400		4.8	25	GFCW R/L48-60	GFW R/L48-60			
GMFC R/L2525-63	●	●	23	25	200	20.3	57~400		6.35	25	GFCW R/L63-60	GFW R/L63-60			
GMFC R/L3232-63	●	●	30	32	200	20.3	57~400		6.35	25	GFCW R/L63-60	GFW R/L63-60			

SEC-Face Grooving Tool Holders GMFS Type

Face Grooving L-Styled (Adjustable type)



Parts

Clamp	Support	Screw	Washer	Wrench
For R-Hand For L-Hand	For R-Hand For L-Hand			
GFCL32-60 GFCWR32-60	GFL32-60 GFWR32-60	BX0825A WB5-18	PW80A	LH060 TH025
GFCL48-60 GFCWR48-60	GFL48-60 GFWR48-60			
GFCL63-60 GFCWR63-60	GFL63-60 GFWR63-60			

Holder

Cat. No.	Stock		Dimensions (mm)				Work Dia. øD1	Grooving width (mm) t	Maximum Grooving Depth (mm)	Clamp	Support	Screw	Washer	Wrench
	R	L	H	W	L	S								
GMFS R/L2525	●	●	25	25	150	52	57~400	3.2	19	GFCL32-60 GFCWR32-60	GFL32-60 GFWR32-60	BX0825A WB5-18	PW80A	LH060 TH025
GMFS R/L2525-48	●	●	25	25	150	52	57~400	4.8	25	GFCL48-60 GFCWR48-60	GFL48-60 GFWR48-60			
GMFS R/L2525-63	●	●	25	25	150	52	57~400	6.35	25	GFCL63-60 GFCWR63-60	GFL63-60 GFWR63-60			

Insert

Fig1	Shape	Cat. No.	Coated	Dimensions (mm)		Applicable toolholder
			GAC50	t	R	
Fig1	Fig1	MGFR532-60	●	3.2	—	GMF R/L, GMFSR
	Fig1	MGFL532-60	●	3.2	—	GMFC R/L, GMFSL
	Fig1	MGFR548-60	●	4.8	—	GMF R/L, GMFC R/L, GMFS R/L
	Fig1	MGFR563-60	●	6.35	—	GMF R/L, GMFC R/L, GMFS R/L
Fig2	Fig2	MGFR516R-60	●	3.2	1.6	GMF R/L, GMFSR
	Fig2	MGFL516R-60	●	3.2	1.6	GMFC R/L, GMFSL
	Fig2	MGFR524R-60	●	4.8	2.4	GMF R/L, GMFC R/L, GMFS R/L
	Fig2	MGFR532R-60	●	6.35	3.2	GMF R/L, GMFC R/L, GMFS R/L

Recommended Conditions

Work Material	Carbon steel	Alloy steel	Stainless steel
Cutting Speed (m/min)	50~100	50~80	50~70
Feedrate (mm/rev)	0.05~0.10	0.05~0.10	0.05~0.10

For traverse cut	
D.O.C (mm)	below 1.0
Feedrate (mm/rev)	0.05~0.10

Diameter

Adjustment Method

(Ex.1) To set dial for ø 100mm

1		To adjust dial, loosen the securing screw.
2		Align '57' to the highest graduation for setting.
3		Then, adjust the dial to coincide with the desired setting and tighten the screw.

(Ex.2) To set dial for ø 170mm

1		To adjust dial, loosen the securing screw.
2		Align '57' to the highest graduation for setting.
3		'170' is between '150' & '200'. Initially adjust to '150' as shown in diagram. Always move dial downwards to the next graduation.
4		Move '150' slightly downwards because '170' is slightly greater than '150'.

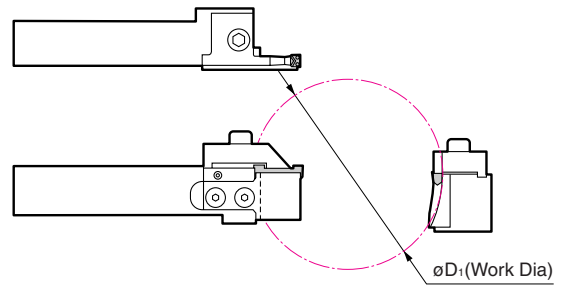
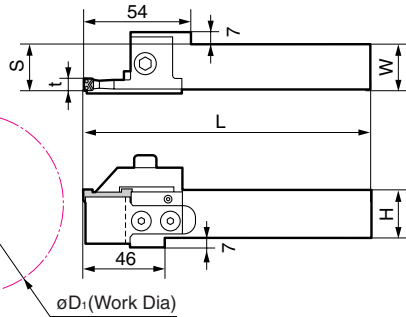
SEC-Face Grooving Tool Holders GMFW Type

Face Grooving (Non-adjustable type)

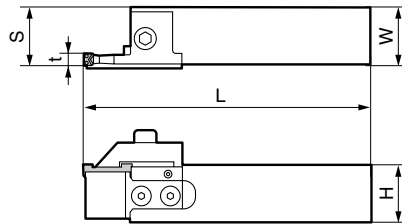


GMFWR2525 (Right Hand)

GMFWL2525 (Left Hand)



GMFWR3232 (Right Hand)



Holder

Cat. No.	Stock		Dimensions (mm)					Work Dia.	Grooving width (mm)	Maximum Grooving Depth (mm)	Parts			
	R	L	H	W	L	S	ϕD_1	t			Clamp (Stopper)	Support	Screw	Wrench
GMFW R/L2525-60-70	●	●	25	25	150	26	70~100	6	20		GDC R/L60 (GDSR/L60)	GD R/L60-70	BXF0618 (For Support)	LH050 (For Support)
GMFW R/L2525-60-100	●	●	25	25	150	26	100~150	6	20			GD R/L60-100		
GMFW R/L2525-60-150	●	●	25	25	150	26	150~300	6	20			GD R/L60-150		
GMFW R/L2525-60-300	●	●	25	25	150	26	300~450	6	20			GD R/L60-300		
GMFW R/L2525-60-450	●	●	25	25	150	26	450~	6	20			GD R/L60-450		
GMFW R/L3232-60-70	●	●	32	32	170	33	70~100	6	20			GD R/L60-70		
GMFW R/L3232-60-100	●	●	32	32	170	33	100~150	6	20			GD R/L60-100		
GMFW R/L3232-60-150	●	●	32	32	170	33	150~300	6	20			GD R/L60-150		
GMFW R/L3232-60-300	●	●	32	32	170	33	300~450	6	20		GDC R/L80 (GDSR/L80)	GD R/L60-300	BXF0618 (For Support)	LH050 (For Support)
GMFW R/L3232-60-450	●	●	32	32	170	33	450~	6	20			GD R/L60-450		
GMFW R/L2525-80-70	●	●	25	25	150	26	70~100	8	20			GD R/L80-70	BX0820 (For Clamp)	LH060 (For Clamp)
GMFW R/L2525-80-100	●	●	25	25	150	26	100~150	8	20			GD R/L80-100		
GMFW R/L2525-80-150	●	●	25	25	150	26	150~300	8	20			GD R/L80-150		
GMFW R/L2525-80-300	●	●	25	25	150	26	300~450	8	20			GD R/L80-300		
GMFW R/L2525-80-450	●	●	25	25	150	26	450~	8	20			GD R/L80-450	BX0308 (For Stopper)	LH025 (For Stopper)
GMFW R/L3232-80-70	●	●	32	32	170	33	70~100	8	20			GD R/L80-70		
GMFW R/L3232-80-100	●	●	32	32	170	33	100~150	8	20			GD R/L80-100		
GMFW R/L3232-80-150	●	●	32	32	170	33	150~300	8	20			GD R/L80-150		
GMFW R/L3232-80-300	●	●	32	32	170	33	300~450	8	20			GD R/L80-300		
GMFW R/L3232-80-450	●	●	32	32	170	33	450~	8	20			GD R/L80-450		

※ Please set the cutting edge 1.0mm higher from the center position.

Insert

Right Hand (R) Holder + Right Hand (R) Insert

Fig1												
		Fig2										
				Fig2 show right hand tools.								
Shape	Cat. No.	Coated		Uncoated		SUMIBORON		Dimensions (mm)				Applicable toolholder
		ACZ310		A30		BN250		t	L	B	R	
		R	L	R	L	R	L					
Fig1	MGE N860	●		●		—		6	25.4	6.12	0.25	(t)6mm
Fig1	MGE N980	●		●		—		8	28.6	8.28	0.25	(t)8mm
Fig2	MGE R/L860	●	●	●		●		6	25.4	6.12	0.2	(t)6mm
Fig2	MGE R/L980	●	●	●		●		8	28.6	8.28	0.2	(t)8mm

Fig2 show right hand tools.

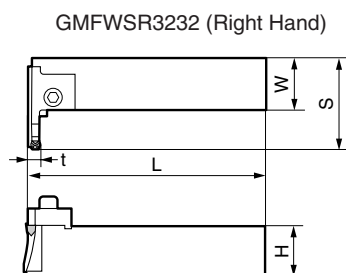
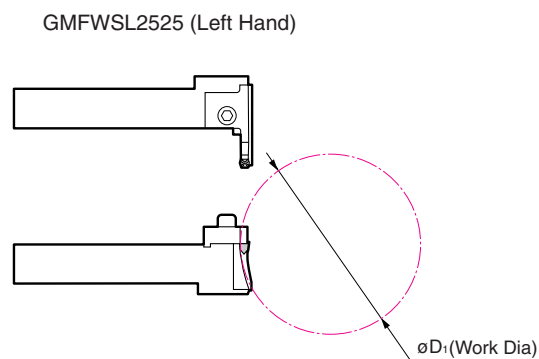
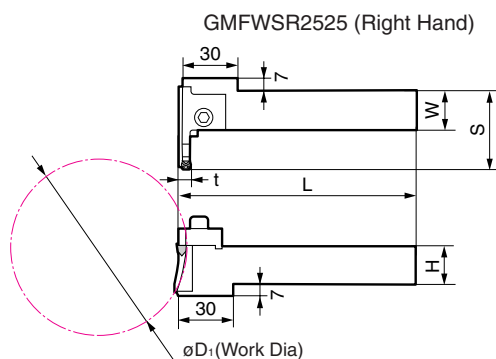
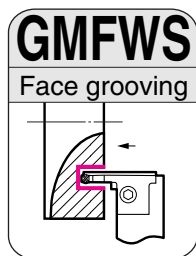
MGEN is a neutral-hand insert

Recommended Conditions

Work Material	Carbon steel		Alloy steel		Stainless steel		Hardened steel	For traverse cut	
Grade	A30	ACZ310	A30	ACZ310	A30	ACZ310	BN250	Depth of cut (mm)	Within grooving width $\times 0.5$
Cutting Speed (m/min)	50 ~ 80	60 ~ 100	50 ~ 80	50 ~ 80	50 ~ 70	50 ~ 70	50 ~ 80	Applicable Insert	MGEN○○○ (With Chipbreaker)
Feedrate (mm/rev)	0.05 ~ 0.10	0.05 ~ 0.10	0.05 ~ 0.10	0.05 ~ 0.10	0.05 ~ 0.10	0.05 ~ 0.10	0.03 ~ 0.07		

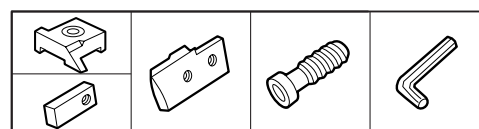
SEC-Face Grooving Tool Holders GMFWS Type

Face Grooving L-Styled (Non-adjustable type)



- Holder

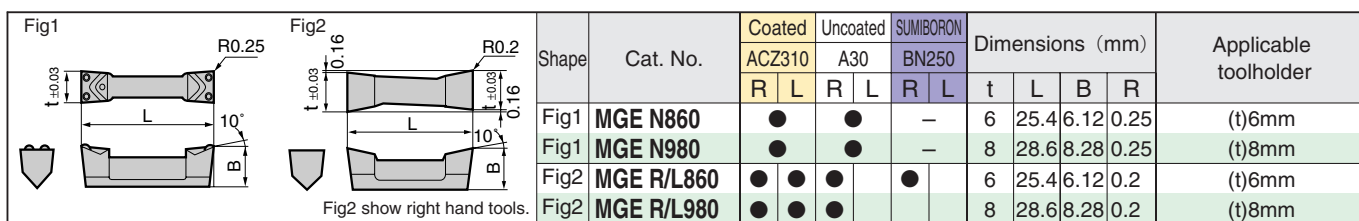
■ Parts



Cat. No.	Stock		Dimensions (mm)				Work Dia.	Grooving width (mm)	Maximum Grooving Depth (mm)	Clamp (Stopper)	Support	Screw	Wrench
	R	L	H	W	L	S	øD ₁	t					
GMFWS R/L2525-60-70	●	●	25	25	150	49	70~100	6	20	GDC L/R60 (GDSL/R60)	GD L/R60-70	BXF0618 (For Support)	LH050 (For Support)
GMFWS R/L2525-60-100	●	●	25	25	150	49	100~150	6	20		GD L/R60-100		
GMFWS R/L2525-60-150	●	●	25	25	150	49	150~300	6	20		GD L/R60-150		
GMFWS R/L2525-60-300	●	●	25	25	150	49	300~450	6	20		GD L/R60-300		
GMFWS R/L2525-60-450	●	●	25	25	150	49	450~	6	20		GD L/R60-450		
GMFWS R/L3232-60-70	●	●	32	32	170	56	70~100	6	20		GD L/R60-70		
GMFWS R/L3232-60-100	●	●	32	32	170	56	100~150	6	20		GD L/R60-100		
GMFWS R/L3232-60-150	●	●	32	32	170	56	150~300	6	20		GD L/R60-150		
GMFWS R/L3232-60-300	●	●	32	32	170	56	300~450	6	20		GD L/R60-300		
GMFWS R/L3232-60-450	●	●	32	32	170	56	450~	6	20		GD L/R60-450		
GMFWS R/L2525-80-70	●	●	25	25	150	49	70~100	8	20	GDC L/R80 (GDSL/R80)	GD L/R80-70	BX0820 (For Clamp)	LH060 (For Clamp)
GMFWS R/L2525-80-100	●	●	25	25	150	49	100~150	8	20		GD L/R80-100		
GMFWS R/L2525-80-150	●	●	25	25	150	49	150~300	8	20		GD L/R80-150	BX0308 (For Stopper)	LH025 (For Stopper)
GMFWS R/L2525-80-300	●	●	25	25	150	49	300~450	8	20		GD L/R80-300		
GMFWS R/L2525-80-450	●	●	25	25	150	49	450~	8	20		GD L/R80-450		
GMFWS R/L3232-80-70	●	●	32	32	170	56	70~100	8	20		GD L/R80-70		
GMFWS R/L3232-80-100	●	●	32	32	170	56	100~150	8	20		GD L/R80-100		
GMFWS R/L3232-80-150	●	●	32	32	170	56	150~300	8	20		GD L/R80-150		
GMFWS R/L3232-80-300	●	●	32	32	170	56	300~450	8	20		GD L/R80-300		
GMFWS R/L3232-80-450	●	●	32	32	170	56	450~	8	20		GD L/R80-450		

※ Please set the cutting edge 1.0mm higher from the center position.

■ **Insert** Right Hand (R) Holder + Left Right Hand (L) Insert.



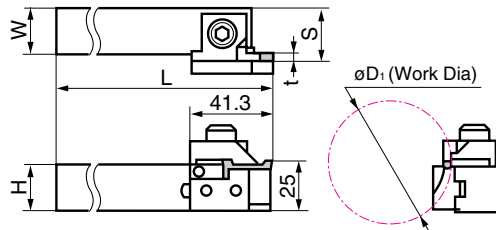
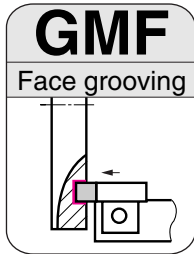
MGEN is a neutral hand insert

■ Recommended Conditions

Work Material	Carbon steel		Alloy steel		Stainless steel		Hardened steel
Grade	A30	ACZ310	A30	ACZ310	A30	ACZ310	BN250
Cutting Speed (m/min)	50~80	60~100	50~80	50~80	50~70	50~70	50~80
Feedrate (mm/rev)	0.05~0.10	0.05~0.10	0.05~0.10	0.05~0.10	0.05~0.10	0.05~0.10	0.03~0.07

For traverse cut	
Depth of cut (mm)	Within grooving width × 0.5
Applicable Insert	MGEN○○○ (With Chipbreaker)

Face Grooving (Non-adjustable type)



Above figures show right hand tools.

Holder

Cat. No.	Stock		Dimensions (mm)				Work Dia. øD ₁	Grooving width (mm) t	Maximum Grooving Depth (mm)	Parts				
	R	L	H	W	L	S				Clamp	Support	Stopper	Screw	Wrench
GMF R/L2525-35-50	●		25	25	150	28.9	50~60	3.5	10	GFC R/L35-50	GF R/L35-50	GFS50	BX0414 For Support & Stopper	LH030 For Support & Stopper
GMF R/L2525-35-60	●		25	25	150	28.9	60~75	3.5	10		GF R/L35-60	GFS50		
GMF R/L2525-35-75	●		25	25	150	28.9	75~100	3.5	10	GFC R/L35-75	GF R/L35-75	GFS75		
GMF R/L2525-35-100	●		25	25	150	28.9	100~150	3.5	10		GF R/L35-100	GFS75		
GMF R/L2525-55-50	●		25	25	150	28.8	50~60	5.5	10	GFC R/L55-50	GF R/L55-50	GFS50	BX0820 For Clamp	LH060 For Clamp
GMF R/L2525-55-60	●		25	25	150	28.8	60~75	5.5	10		GF R/L55-60	GFS50		
GMF R/L2525-55-75	●		25	25	150	28.8	75~100	5.5	10	GFC R/L55-75	GF R/L55-75	GFS75		
GMF R/L2525-55-100	●		25	25	150	28.8	100~150	5.5	10		GF R/L55-100	GFS75		

※ Please set the cutting edge 1.0mm higher from the center position.

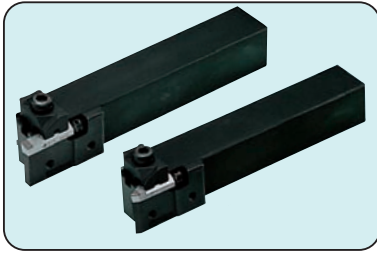
Insert

Fig1		Shape	Cat. No.	Uncoated		SUMIBORON		Dimensions (mm)				Applicable toolholder
				A30		BN250		t	L	B	R	
				R	L	R	L					
		Fig1	MGF R/L835-50	●				3.5	24.9	4.50	0.2	GMF R/L2525-35-50 GMF R/L2525-35-60
Fig2		Shape	Cat. No.	Uncoated		SUMIBORON		Dimensions (mm)				Applicable toolholder
				A30		BN250		t	L	B	R	
				R	L	R	L					
		Fig1	MGF R/L855-50	●				5.5	24.9	4.50	0.2	GMF R/L2525-55-50 GMF R/L2525-55-60
		Fig2	MGF R/L835-75	●				3.5	24.9	6.12	0.2	GMF R/L2525-35-75 GMF R/L2525-35-100
		Fig2	MGF R/L855-75	●				5.5	24.9	6.12	0.2	GMF R/L2525-55-75 GMF R/L2525-55-100

Recommended Conditions

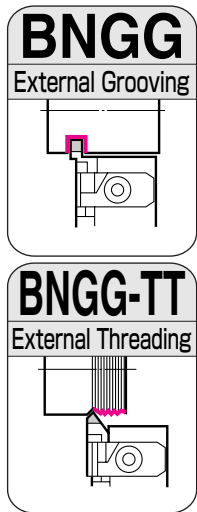
Work Material	Carbon steel	Alloy steel	Stainless steel	Hardened steel
Grade	A30			BN250
Cutting Speed (m/min)	50 ~ 100	50 ~ 80	50 ~ 70	80 ~ 120
Feedrate (mm/rev)	0.05 ~ 0.10	0.05 ~ 0.10	0.05 ~ 0.10	0.03 ~ 0.07

SUMIBORON Grooving Tool Holder BNGG Type



- **High rigidity improves tool life**
 - Strong clamping reduces vibration and enhance chipping resistance.
- **Grooving and Threading operations**
 - Grooving and Threading can be adopted by changing the support.

SEC-Grooving Holder + SUMIBORON Insert can be use for Hardened steel grooving.



Holder

Inserts are not included

	Catalogue No.	Stock		Dimensions (mm)			Shape	Applicable Holder
		R	L	S	ℓ	L		
Grooving	BNGG R/L2525-200	●		30.5	4	150	Fig1	BNGNT0200R/L
	BNGG R/L2525-250	●		30.5	4	150		BNGNT0250R/L
	BNGG R/L2525-300	●		30.5	5	150		BNGNT0300R/L
	BNGG R/L2525-400	●		30.5	6	151		BNGNT0400R/L
	BNGG R/L2525-500	●		30.5	6	151		BNGNT0500R/L
	BNGG R/L2525-600	●		30.5	7	152		BNGNT0600R/L
Threading	BNGG R/L2525-TT	●		28.5	5	150	Fig2	BNTT1020R/L BNTT1530R/L

※ Holder can be configured for grooving or threading by changing the support.

Insert

Fig 1 Grooving

Fig 2 Threading

	Catalogue No.	Stock								Dimensions (mm)					Shape	Applicable Holder
		BN250		BNX20		BN350		BNX25								
		R	L	R	L	R	L	R	L	W	ℓ	R	L	S		
Grooving	BNGNT0200R/L	●				●				2.0	4.0	0.2	25	6.0	Fig1	BNGGR/L2525-200
	BNGNT0250R/L	●				●				2.5	4.0	0.2	25	6.0		BNGGR/L2525-250
	BNGNT0300R/L	●				●				3.0	5.0	0.4	25	6.0		BNGGR/L2525-300
	BNGNT0400R/L	●				●				4.0	6.0	0.4	26	6.0		BNGGR/L2525-400
	BNGNT0500R/L	●				●				5.0	6.0	0.4	26	6.0		BNGGR/L2525-500
	BNGNT0600R/L	●				●				6.0	7.0	0.4	27	6.0		BNGGR/L2525-600
Threading	BNTT1020R/L	●								Pitch 1.0~2.0	0.14	25	4.0	Fig2	BNGGR/L2525-TT	
	BNTT1530R/L	●								Pitch 1.5~3.0	0.20	25	4.0			

Parts

Applicable Holder	Support	Clamp	Axial Screw	Spring	Cap Screw	Wrench	
BNGG R/L2525-200	BNGSR/L200						
BNGG R/L2525-250	BNGSR/L250						
BNGG R/L2525-300	BNGSR/L300						
BNGG R/L2525-400	BNGSR/L400	BNGCR/L	FMJ	GSP06	BX0615 (Clamp)	LH050 (Clamp)	1.8 x 45
BNGG R/L2525-500	BNGSR/L500						
BNGG R/L2525-600	BNGSR/L600				BX0414 (Support)	LH030 (Support)	
BNGG R/L2525-TT	BNGSR/LTT						

Recommended Conditions

For Grooving

Cutting Speed (V)	80~120 m/min
Feedrate (f)	0.03~0.07 mm/rev

For Threading

Cutting Speed (V)	80~120 m/min
Feedrate (f)	Largest Pitch 3.0 mm

SEC-Grooving Tool Holder GSE Type

Insert

Figures show right hand tools

d() : Maximum grooving depth

Cat. No.	Cermet				Dimensions (mm)				Applicable toolholder			
	T1200A				D	t	R	d				
	R	L										
TGE R/L3033	▲				9.525	0.33	0.05	1.0 (0.8)	GSE R/L 1616-3A 2020-3A 2525-3A			
TGE R/L3050	▲	▲				0.50		1.4 (1.2)				
TGE R/L3075	▲	▲				0.75	0.2	2.5 (2.0)				
TGE R/L3095	▲	▲				0.95						
TGE R/L3100	▲	▲				1.00						
TGE R/L3110	▲	▲				1.10						
TGE R/L3125	▲	▲				1.25						
TGE R/L3135	▲	▲				1.35						
TGE R/L3145	▲	▲			1.45	9.525	0.2	2.5 (2.0)	GSE R/L 1616-3B 2020-3B 2525-3B			
TGE R/L3150	▲	▲			1.50							
TGE R/L3165	▲	▲			1.65							
TGE R/L3175	▲	▲			1.75							
TGE R/L3185	▲	▲			1.85							
TGE R/L3200	▲	▲			2.00							
TGE R/L3220	▲	▲			2.20							
TGE R/L3230	▲				2.30					0.3		
TGE R/L3250	▲	▲			2.50							
TGE R/L3265	▲				9.525	2.65	0.3	2.5 (2.0)	GSE R/L 1616-3C 2020-3C 2525-3C			
TGE R/L3270	▲					2.70						
TGE R/L3280	▲	▲				2.80						
TGE R/L3300						3.00						
TGE R/L3320						3.20						
TGE R/L3330						3.30						
TGE R/L3350						3.50						
TGE R/L4150	▲	▲				12.70				1.50	0.2	4.2 (3.8)
TGE R/L4165	▲	▲			1.65							
TGE R/L4175	▲	▲			1.75							
TGE R/L4185	▲	▲			1.85							
TGE R/L4200	▲	▲			2.00							
TGE R/L4220	▲	▲			2.20							
TGE R/L4230	▲	▲			2.30							
TGE R/L4250	▲	▲			2.50		0.3					
TGE R/L4265	▲				2.65							
TGE R/L4270	▲	▲			12.70	2.70	0.3	4.2 (3.8)	GSE R/L 1616-4C 2020-4C 2525-4C			
TGE R/L4280	▲	▲				2.80						
TGE R/L4300	▲	▲				3.00						
TGE R/L4320	▲	▲				3.20						
TGE R/L4330	▲					3.30						
TGE R/L4350	▲	▲				3.50						
TGE R/L4370	▲	▲				3.70				0.3		
TGE R/L4390	▲	▲				3.90						
TGE R/L4400	▲	▲			4.00	12.70	0.4	4.2 (3.8)	GSE R/L 1616-4D 2020-4D 2525-4D			
TGE R/L4410	▲	▲			4.10							
TGE R/L4420	▲	▲			4.20							
TGE R/L4430	▲				4.30							
TGE R/L4440	▲	▲			4.40							
TGE R/L4450	▲	▲			4.50							

※ Right handed toolholders are applicable with right handed inserts.

※ GWC type holders with TGA type inserts are our first recommendations

※ TGE type inserts cannot be use on GWC type holders

Parts

Screw	Screw	Clamp	Wrench	Cassette	Applicable toolholder
BFX0410R	BX0512	BCH05R	LH025 LH040	S3 R/L-AP S3 R/L-BP S3 R/L-CP	GSE R/L1616-3A GSE R/L1616-3B GSE R/L1616-3C
BFX0511R	BX0512	BCH05R	LH025 LH030 LH040	S4 R/L-BP S4 R/L-CP S4 R/L-DP	GSE R/L1616-4B GSE R/L1616-4C GSE R/L1616-4D
BFX0410R	BX0512	BCH05R	LH025 LH040	S3 R/L-A S3 R/L-B S3 R/L-C	GSE R/L2020-3A GSE R/L2525-3A GSE R/L2020-3B GSE R/L2525-3B GSE R/L2020-3C GSE R/L2525-3C
BFX0511R	BX0512	BCH05R	LH025 LH030 LH040	S4 R/L-B S4 R/L-C S4 R/L-D	GSE R/L2020-4B GSE R/L2525-4B GSE R/L2020-4C GSE R/L2525-4C GSE R/L2020-4D GSE R/L2525-4D

SEC-Grooving Tool Holder GCE Type

Parts

Clamp	Screw	Wrench	Applicable toolholder	Group No.
CCM6UL/R	WB6-20	LH030	GC R/L2020-3 GC R/L2525-3	① ①
CCM8UL/R	WB8-24	LH040	GC R/L2020-A	②
			GC R/L2020-B	③
			GC R/L2020-C	④
			GC R/L2525-A	②
			GC R/L2525-B	③
			GC R/L2525-C	④

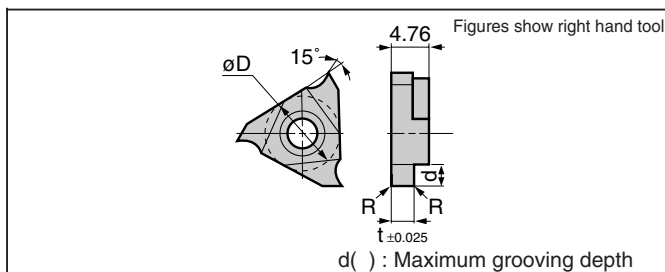
※ TGA type inserts on pages E6 and E7 can be mounted. Use in combination with applicable group number.

※ Right handed toolholders are applicable with right handed inserts.

Inserts and Parts for Discontinued Series

SEC-Grooving Tool Holder GHI Type

■ Insert



Cat. No.	Cermet				Dimensions (mm)				Applicable toolholder
	T1200A	R	L		D	t	R	d	
TGI R/L3050	▲					0.50	0.05	1.4 (1.2)	GHI R/L325
TGI R/L3075	▲	▲				0.75			
TGI R/L3095	▲	▲				0.95			
TGI R/L3100	▲	▲				1.00			
TGI R/L3110	▲	▲				1.10			
TGI R/L3125	▲	▲				1.25			
TGI R/L3135	▲	▲				1.35			
TGI R/L3145	▲	▲				1.45	0.2		
TGI R/L3150	▲	▲				1.50			
TGI R/L3165	▲	▲			9.525	1.65		2.5 (2.0)	
TGI R/L3175	▲					1.75			
TGI R/L3185	▲					1.85			
TGI R/L3200	▲	▲				2.00			
TGI R/L3220	▲					2.20			
TGI R/L3230	▲	▲				2.30			
TGI R/L3250	▲	▲				2.50	0.3		
TGI R/L3265	▲					2.65			GHI R/L432
TGI R/L3270	▲					2.70			
TGI R/L3280	▲	▲				2.80			
TGI R/L4150	▲					1.50			
TGI R/L4165	▲					1.65			
TGI R/L4175	▲					1.75	0.2		
TGI R/L4185	▲					1.85			
TGI R/L4200	▲	▲				2.00			
TGI R/L4220	▲					2.20			
TGI R/L4230	▲					2.30			
TGI R/L4250	▲	▲				2.50			
TGI R/L4270	▲	▲				2.70		4.2 (2.5)	
TGI R/L4280	▲					2.80			
TGI R/L4300	▲	▲				3.00			
TGI R/L4320	▲	▲				3.20	0.3		
TGI R/L4330	▲					3.30			
TGI R/L4350	▲					3.50			
TGI R/L4400	▲					4.00			
TGI R/L4410	▲					4.10			
TGI R/L4420	▲					4.20			
TGI R/L4430	▲					4.30	0.4		
TGI R/L4440	▲					4.40			

※ Right handed toolholders are applicable with right handed inserts.

※ GWCI type holders with TGA type inserts are our first recommendations

※ TGI type inserts cannot be use on GWC type holders

■ Parts

				Applicable toolholder
Cassette	Screw	Screw	Wrench	
G3 R/L	BFX0410 R/L	BX0512	TH025	GHI R/L325
G4 R/L	BFX0511 R/L		LH030	GHI R/L432

SumiGrip Jr.



General Features

SumiGrip Jr. is the next generation steel blade cut-off series expansion of the carbide SumiGrip.

With a stronger gripping force, SumiGrip Jr. is applicable for small diameter work pieces with stable cutting even for interrupted cutting of hexagonal bars.

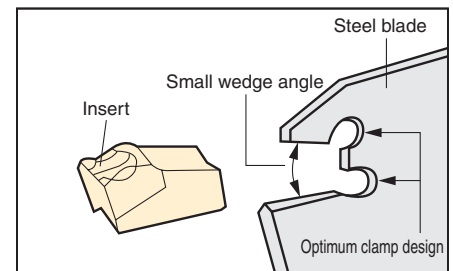
Series and Characteristics

Series

- ① Tool block type (max. cut-off diameter ϕ 100mm)
- ② Shank type (max. cut-off diameter ϕ 50mm)

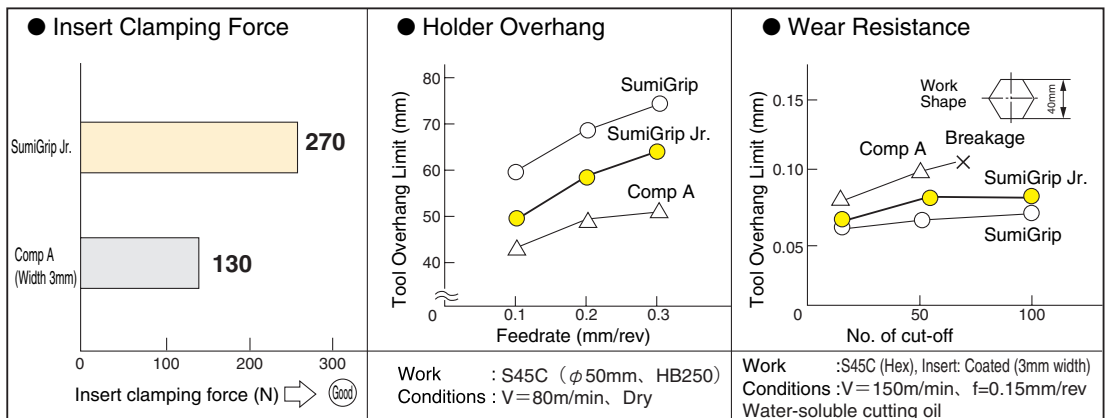
Characteristics

- Double the gripping force of conventional holders
- Lower cutting force
- Interrupted cutting is possible
- Wide application (cut-off, grooving, chamfering)

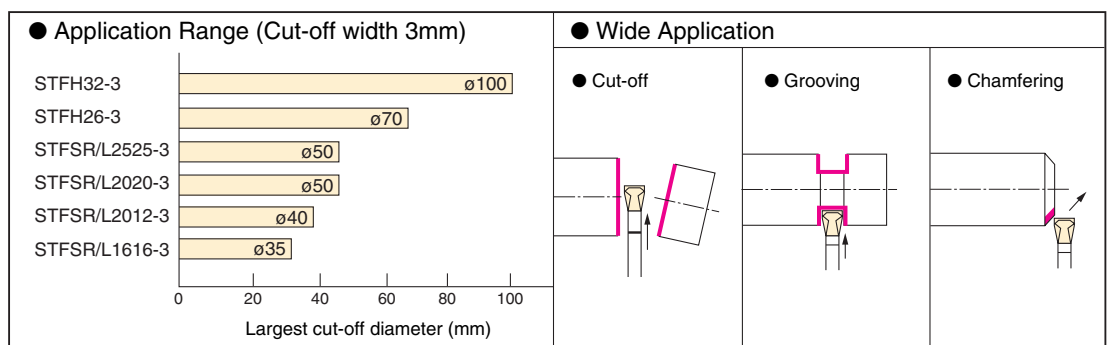


Cut Off Holders

Efficiency



Application Range

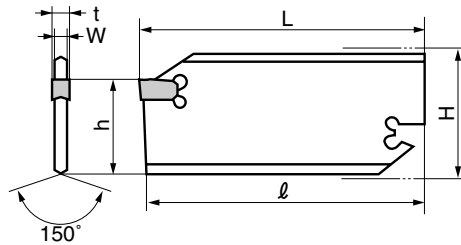
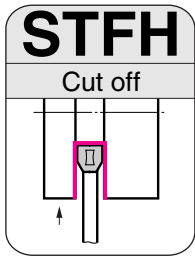


Insert

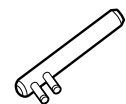
● Features and Characteristics	● Recommended Conditions			● Application Examples
WCF type insert for SumiGrip Jr. is a single-edge insert that provides excellent chip control with longer tool life. Available in a wide variety of grades to suit different work materials.	Work	Grade	C/Speed (m/min) Feedrate (mm/rev)	Socket SNC415 <Tool> Holder: STF32-3 Insert: WCFN3A(AC225) <Cond. > V=100m/min, f=0.1mm/rev Water-soluble cutting oil <Results> Stable cutting of work piece. No work adhesion problems that is usually cause by unstable insert clamping
	General Steel	AC3000	100 — 200 0.1 — 0.3	
		AC225	80 — 200 0.08 — 0.25	
	Soft Steel	T130A	100 — 230 0.05 — 0.2	
	Stainless Steel	AC225	60 — 180 0.05 — 0.2	
	Cast Iron	G10E	50 — 120 0.06 — 0.2	

SEC-Cut Off Tool Holders STFH Type

Cut off (Tool block type)



■ Parts



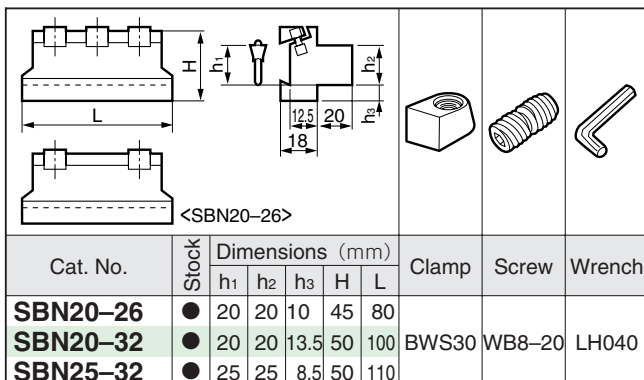
■ Holder

Cat. No.	Stock	Dimensions (mm)							Maximum cut off diameter	Applicable Insert	Applicable tool block	Wrench	
		H	W	L	h	ℓ	t						
STFH26-2	●	26	1.6	109	21.4	108	2		40	WCFO2□	SBN20-26 SBU20-26	SL-4	
STFH26-3	●	26	2.4	109	21.4	108	3		70	WCFO3□			
STFH26-4	●	26	3.4	109	21.4	108	4		70	WCFO4□			
STFH26-5	●	26	4.3	109	21.4	108	5		70	WCFO5□			
STFH32-2	●	32	1.6	149	25	148	2		40	WCFO2□	SBN20-32 SBN25-32 SBU20-32 SBU25-32		SL-4
STFH32-3	●	32	2.4	149	25	148	3		100	WCFO3□			
STFH32-4	●	32	3.4	149	25	148	4		100	WCFO4□			
STFH32-5	●	32	4.3	149	25	148	5		100	WCFO5□			

* Shape of STF32-2 is slightly different from the above figure.

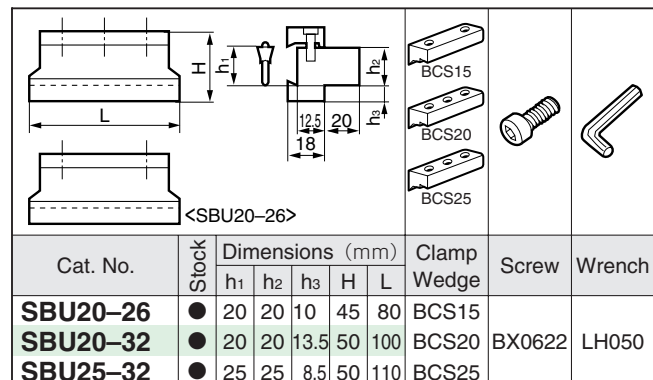
■ Tool block (One unit)

■ Parts

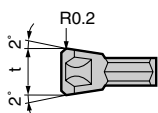
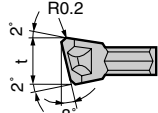


■ Tool block (2 piece unit) ■ Parts

■ Parts



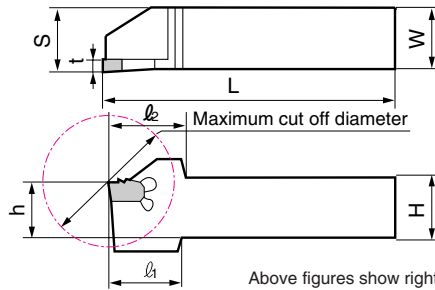
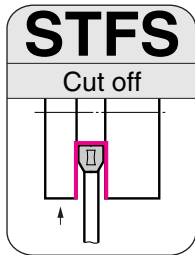
■ Insert

Neutral (N)	WC□□ General Steel	WC□2T Small Dia. Low Force	WC□□OA Exotic Metal, Low Feed	WC□□OB Cast Iron, Non ferrous metal	Applicable toolholder									
	 	 	 											
Right hand (R)	Cat. No.	Coated AC3000	t	Cat. No.	Coated AC225	Cermet T1200A	T130A	Uncoated A30	G10E	t	Cat. No.	Uncoated G10E	t	STFH26-2 STFH32-2
	WCFN2T	●	2	WCFN2A	●	-	-	-	-	2	-	-	-	
	WCFR2T	●	2	-	-	-	-	-	-	-	-	-	-	
	WCFL2T	●	2	-	-	-	-	-	-	-	-	-	-	
	WCFN3	●	3	WCFN3A	●	●	●	●	●	3	WCFN3B	●	3	
	WCFR3	●	3	WCFR3A	●			●		3	WCFR3B	●	3	
	WCFL3	●	3	WCFL3A	●					3	WCFL3B	●	3	
	WCFN4	●	4	WCFN4A	●					4	WCFN4B	●	4	
	WCFR4	●	4	WCFR4A	●					4	WCFR4B	●	4	
	WCFL4	●	4	WCFL4A	●					4	WCFL4B	●	4	
	WCFN5	●	5	WCFN5A	●					5	WCFN5B	●	5	
	WCFR5	●	5	WCFR5A						5	WCFR5B		5	
	WCFL5	●	5	WCFL5A						5	WCFL5B	●	5	

WCF ☐ ☐ B type is similar in shape with WCF ☐ ☐ type but with smaller edge treatment

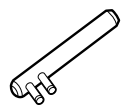
SEC-Cut Off Tool Holders STFS Type

Cut off (Shank type)



Above figures show right hand tools.

Parts



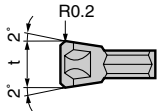
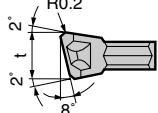
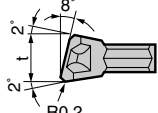
Holder

Cat. No.	Stock		Dimensions (mm)									Maximum cut off diameter	Applicable Insert	Wrench
	R	L	H	W	L	S	h	ℓ ₁	ℓ ₂	t				
STFS R/L1010-2	●	●	10	10	86	10	10	17	17	2	28	WCFO2□	SL-4	
STFS R/L1212-2	●	●	12	12	110	12	12	18	18	2	30			
STFS R/L1616-2	●	●	16	16	110	16	16	—	19	2	32			
STFS R/L2020-2	●	●	20	20	125	20	20	—	24	2	40			
STFS R/L1616-3	●	●	16	16	110	16	16	20	22	3	35	WCFO3□		
STFS R/L2012-3	●	●	20	12	110	12	20	—	24	3	40			
STFS R/L2020-3	●	●	20	20	125	20	20	—	30	3	50			
STFS R/L2525-3	●	●	25	25	150	25	25	—	30	3	50			
STFS R/L2020-4	●	●	20	20	125	20	20	—	33	4	55	WCFO4□		
STFS R/L2525-4	●	●	25	25	150	25	25	—	38	4	65			
STFS R/L2020-5	●	●	20	20	125	20	20	—	35	5	60	WCFO5□		
STFS R/L2525-5	●	●	25	25	150	25	25	—	40	5	70			

Recommended conditions

Grade	V(m/min) f(mm/rev)	Medium Steel	Low Carbon Steel	Stainless steel	Die Steel	Cast Iron
AC3000	V	100 ~ 230	120 ~ 250	80 ~ 200	60 ~ 150	—
	f	0.10 ~ 0.30	0.08 ~ 0.15	0.08 ~ 0.25	0.08 ~ 0.15	
	For	50 ~ 230	50 ~ 250	50 ~ 200	50 ~ 150	—
	WCFO2T	0.03 ~ 0.10	0.02 ~ 0.10	0.03 ~ 0.10	0.03 ~ 0.10	
AC225	V	80 ~ 200	100 ~ 230	60 ~ 180	60 ~ 150	—
	f	0.08 ~ 0.25	0.04 ~ 0.20	0.05 ~ 0.20	0.04 ~ 0.20	
T1200A	V	80 ~ 200	100 ~ 230	60 ~ 180	60 ~ 150	—
	f	0.03 ~ 0.15	0.05 ~ 0.20	0.03 ~ 0.10	0.03 ~ 0.08	
A30/G10E	V	50 ~ 120	70 ~ 150	70 ~ 150	50 ~ 120	* 50 ~ 120
	f	0.05 ~ 0.20	0.04 ~ 0.15	0.04 ~ 0.15	0.04 ~ 0.15	* 0.06 ~ 0.20

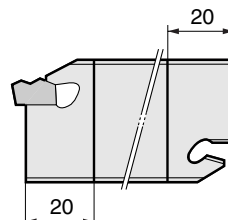
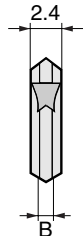
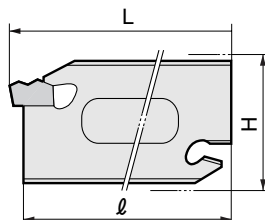
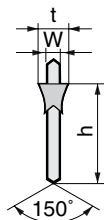
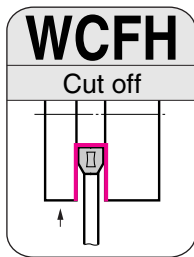
Insert

Neutral (N) 	WCFC□ General Steel			WCFC□2T Small Dia. Low Force			WCFC□OA Exotic Metal, Low Feed			WCFC□OB Cast Iron, Non ferrous metal			Applicable toolholder	
	Cat. No.	Coated AC3000	t	Cat. No.	Coated AC225	Cermet T1200A	Uncoated T130A	A30	G10E	t	Cat. No.	Uncoated G10E		t
Right hand (R) 	WCFN2T	●	2	WCFN2A	●	—	—	—	—	2	—	—	—	STFS R/L1010-2, STFS R/L2020-2, STFS R/L1212-2, STFS R/L1616-2
	WCFR2T	●	2	—	—	—	—	—	—	—	—	—	—	
	WCFL2T	●	2	—	—	—	—	—	—	—	—	—	—	
Left hand (L)  WCFC□ 2T : R=0.15	WCFN3	●	3	WCFN3A	●	●	●	●	●	3	WCFN3B	●	3	STFS R/L1616-3, STFS R/L2525-3, STFS R/L2020-3, STFS R/L2012-3
	WCFR3	●	3	WCFR3A	●	—	—	●	—	3	WCFR3B	●	3	
	WCFL3	●	3	WCFL3A	●	—	—	—	—	3	WCFL3B	●	3	
	WCFN4	●	4	WCFN4A	●	—	—	—	—	4	WCFN4B	●	4	STFS R/L2020-4, STFS R/L2525-4
	WCFR4	●	4	WCFR4A	●	—	—	—	—	4	WCFR4B	●	4	
	WCFL4	●	4	WCFL4A	●	—	—	—	—	4	WCFL4B	—	4	
WCFN5	●	5	WCFN5A	●	—	—	—	—	5	WCFN5B	●	5	STFS R/L2020-5, STFS R/L2525-5	
WCFR5	●	5	WCFR5A	—	—	—	—	—	5	WCFR5B	—	5		
WCFL5	●	5	WCFL5A	—	—	—	—	—	5	WCFL5B	●	5		

WCF□ ○ B type is similar in shape with WCF□ ○ type but with smaller edge treatment

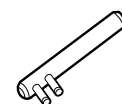
SEC-Cut Off Tool Holders WCFH Type

Cut off (Tool block type)



(WCFH32-2)

■ Parts



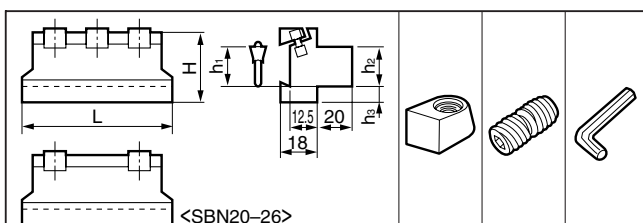
Above figures show right hand tools.

- Holder

Cat. No.	Stock	Dimensions (mm)							Maximum cut off diameter	Applicable Insert	Applicable tool block	Wrench
		H	W	L	h	ℓ	t					
WCFH26-2	●	26	1.7	110	21.4	109	2		40	WCF□2O	SBN20-26 SBU20-26	SL-2
WCFH26-3	●	26	2.4	110	21.4	108.5	3		80	WCF□3O		
WCFH26-4	●	26	3.4	110	21.4	108.5	4		80	WCF□4O		SL-1
WCFH26-5	●	26	4.3	110	21.4	108.5	5		80	WCF□5O		
WCFH32-2	●	32	1.7	150	25	149	2		40	WCF□2O	SBN20-32 SBN25-32 SBU20-32 SBU25-32	SL-2
WCFH32-3	●	32	2.4	150	25	148.5	3		140	WCF□3O		
WCFH32-4	●	32	3.4	150	25	148.5	4		140	WCF□4O		SL-1
WCFH32-5	●	32	4.3	150	25	148.5	5		140	WCF□5O		

■ Tool block (one unit)

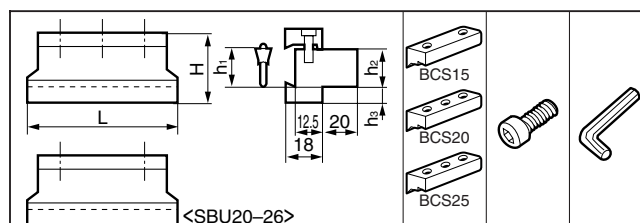
■ Parts



Cat. No.	Stock	Dimensions (mm)						Clamp	Screw	Wrench
		h ₁	h ₂	h ₃	H	L				
SBN20-26	●	20	20	10	45	80	BWS30	WB8-20	LH040	
SBN20-32	●	20	20	13.5	50	100				
SBN25-32	●	25	25	8.5	50	110				

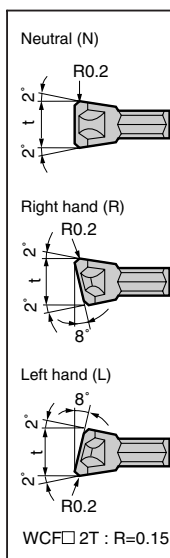
■ Tool block (2 piece unit)

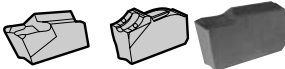
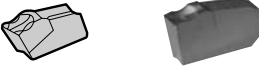
■ Parts



Cat. No.	Stock	Dimensions (mm)						Clamp	Screw	Wrench
		h ₁	h ₂	h ₃	H	L				
SBU20-26	●	20	20	10	45	80	BCS15	BX0622	LH050	
SBU20-32	●	20	20	13.5	50	100	BCS20			
SBU25-32	●	25	25	8.5	50	110	BCS25			

■ Insert

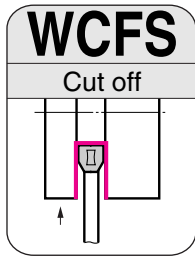


WCF□○2T General Steel Small Dia. Low Force			WCF□○A Exotic Metal, Low Feed						WCF□○B Cast Iron, Non ferrous metal			Applicable toolholder	
													
Cat. No.	Coated AC3000	t	Cat. No.	Coated AC225	Cermet T1200A	T130A	Uncoated A30 G10E		t	Cat. No.	Uncoated G10E		t
WCFN2T	●	2	WCFN2A	●	—	—			2	—	—	—	WCFH26-2 WCFH32-2
WCFR2T	●	2	—	—	—	—	—	—	—	—	—	—	
WCFL2T	●	2	—	—	—	—	—	—	—	—	—	—	
WCFN3	●	3	WCFN3A	●	●	●	●	●	3	WCFN3B	●	3	WCFH26-3 WCFH32-3
WCFR3	●	3	WCFR3A	●			●		3	WCFR3B	●	3	
WCFL3	●	3	WCFL3A	●					3	WCFL3B	●	3	
WCFN4	●	4	WCFN4A	●					4	WCFN4B	●	4	WCFH26-4 WCFH32-4
WCFR4	●	4	WCFR4A	●					4	WCFR4B	●	4	
WCFL4	●	4	WCFL4A	●					4	WCFL4B		4	
WCFN5	●	5	WCFN5A	●					5	WCFN5B	●	5	WCFH26-5 WCFH32-5
WCFR5	●	5	WCFR5A						5	WCFR5B		5	
WCFL5	●	5	WCFL5A						5	WCFL5B	●	5	

WCF ☐ ☐ B type is similar in shape with WCF ☐ ☐ type but with smaller edge treatment

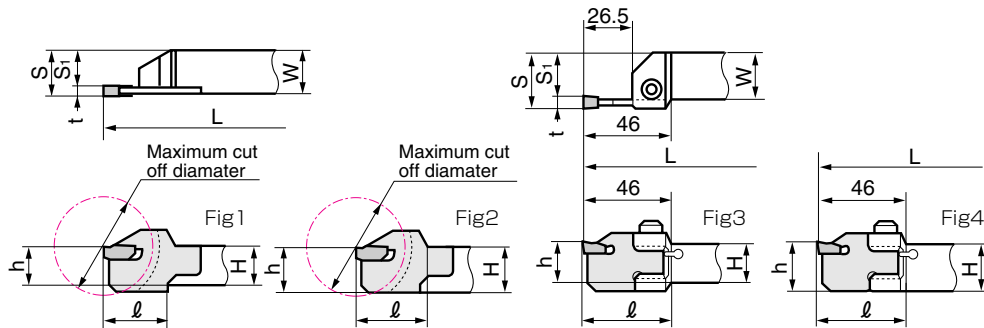
SEC-Cut Off Tool Holders WCFS Type

Cut off (Shank type)

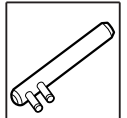


Brazed type

Clamp type



Parts



Holder

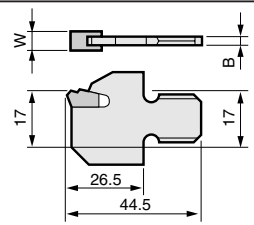
Above figures show right hand tools.

Type	Cat. No.	Stock		Dimensions (mm)								Maximum cut off diameter	Applicable Insert	Shape	Wrench
		R	L	H	W	L	S	S ₁	h	ℓ	t				
Brazed type	WCFS R/L1010-2	●	●	10	10	86	10	8	10	10	2	28	WCF□2O	Fig1	SL-2
	WCFS R/L1212-2	●	●	12	12	110	12	10	12	18	2	30	WCF□2O	Fig1	
	WCFS R/L1616-2	●	●	16	16	100	16	14	16	25	2	35	WCF□2O	Fig2	SL-1
	WCFS R/L1616-3	●	●	16	16	100	16	13	16	25	3	35	WCF□3O	Fig2	
Clamp type	WCFS R/L20-3	●	●	20	20	125	23	20	20	46	3	50	WCF□3O	Fig3	SL-1
	WCFS R/L20-4	●	●	20	20	125	24	20	20	46	4	50	WCF□4O	Fig3	
	WCFS R/L20-5	●	●	20	20	125	25	20	20	46	5	50	WCF□5O	Fig3	
	WCFS R/L25-3	●	●	25	25	150	28	25	25	46	3	50	WCF□3O	Fig4	
	WCFS R/L25-4	●	●	25	25	150	29	25	25	46	4	50	WCF□4O	Fig4	
	WCFS R/L25-5	●	●	25	25	150	30	25	25	46	5	50	WCF□5O	Fig4	

Blade

Parts

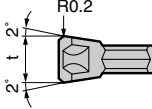
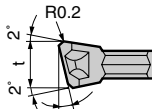
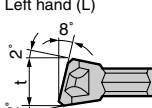
Blade is included with the holder



Cat. No.	Stock	Dimensions (mm)		Applicable toolholder
		W	B	
WCFH17-3	●	3	2.4	WCFS R/L20-3,25-3
WCFH17-4	●	4	3.4	WCFS R/L20-4,25-4
WCFH17-5	●	5	4.3	WCFS R/L20-5,25-5

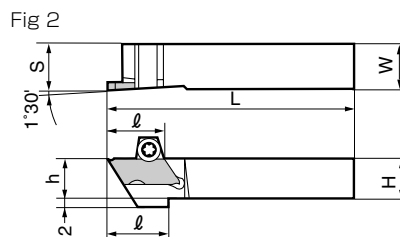
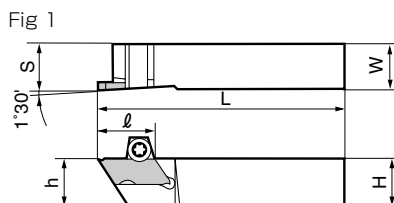
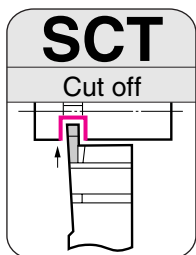
		Applicable toolholder
Screw	Wrench	
BX0622	LH050	All clamp type

Insert

Neutral (N) 	WCF□□ General Steel			WCF□2T Small Dia. Low Force			WCF□OA Exotic Metal, Low Feed			WCF□OB Cast Iron, Non ferrous metal			Applicable toolholder	
	Cat. No.	Coated	t	Cat. No.	Coated	Cermet	Uncoated		t	Cat. No.	Uncoated	t		
		AC3000			AC225	T1200A	T130A	A30			G10E			G10E
Right hand (R) 	WCFN2T	●	2	WCFN2A	●	—	—	A30	G10E	2	—	—	WCFS R/L1010-2	
	WCFR2T	●	2	—	—	—	—	—	—	—	—	—	WCFS R/L1212-2	
	WCFL2T	●	2	—	—	—	—	—	—	—	—	—	WCFS R/L1616-2	
Left hand (L)  WCF□2T : R=0.15	WCFN3	●	3	WCFN3A	●	●	●	●	●	3	WCFN3B	●	3	WCFS R/L1616-3
	WCFR3	●	3	WCFR3A	●			●		3	WCFR3B	●	3	WCFS R/L20-3
	WCFL3	●	3	WCFL3A	●					3	WCFL3B	●	3	WCFS R/L25-3
	WCFN4	●	4	WCFN4A	●					4	WCFN4B	●	4	WCFS R/L20-4 WCFS R/L25-4
	WCFR4	●	4	WCFR4A	●					4	WCFR4B	●	4	
	WCFL4	●	4	WCFL4A	●					4	WCFL4B	●	4	
	WCFN5	●	5	WCFN5A	●					5	WCFN5B	●	5	WCFS R/L20-5 WCFS R/L25-5
	WCFR5	●	5	WCFR5A					5	WCFR5B		5		
	WCFL5	●	5	WCFL5A					5	WCFL5B	●	5		

WCF□OB type is similar in shape with WCF□O type but with smaller edge treatment

SEC-Cut Off Tool Holders SCT Type



Holder (Right Hand)

Cat. No.	Stock	Dimensions (mm)						Applicable Insert	Shape	Screw	Wrench
		H	W	L	S	h	ℓ				
SCT R1010	●	10	10	120	10	10	15	CTR050000(-NB) CTR120000(-NB)	Fig1	BFTX0410T8L	TRX08
SCT R1212	●	12	12	120	12	12	15				
SCT R1616	●	16	16	120	16	16	15				
SCT R1010-16	●	10	10	120	10	10	18	CTR160000(-NB)	Fig2		
SCT R1212-16	●	12	12	120	12	12	18		Fig1		
SCT R1616-16	●	16	16	120	16	16	18				

Holder (Left Hand)

SCT L1010	●	10	10	120	10	10	15	CTL05○○○○(-NB)	Fig1	BFTX0410T8R	TRX08
SCT L1212	●	12	12	120	12	12	15	CTL12○○○○(-NB)			
SCT L1616	●	16	16	120	16	16	15		Fig2		
SCT L1010-16	●	10	10	120	10	10	18	CTL16○○○○(-NB)			
SCT L1212-16	●	12	12	120	12	12	18		Fig1		
SCT L1616-16	●	16	16	120	16	16	18				

Characteristics

New clamping system

New clamping system makes it possible to change corners by only loosening the screw from the back

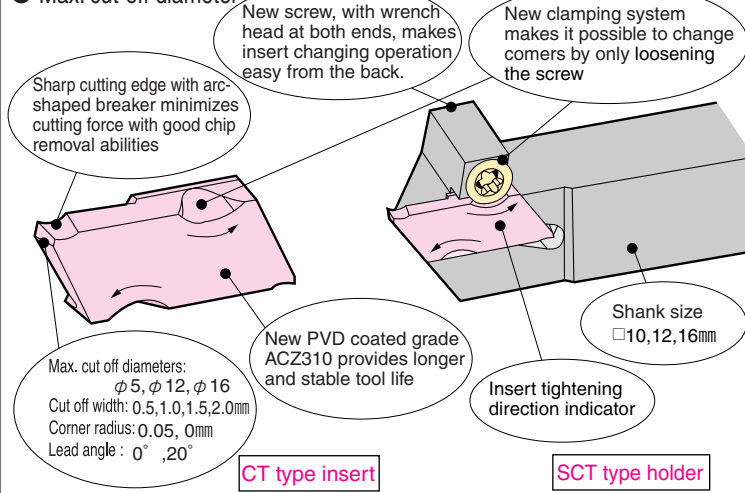
High quality surface finish

Excellent chip removal with good surface finish even at the centre of the end face.

Stable and long tool life

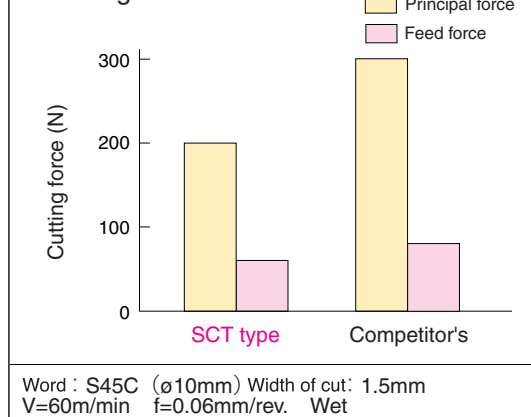
New PVD coated grade ACZ310 provides longer and stable tool life

Max. cut-off diameter

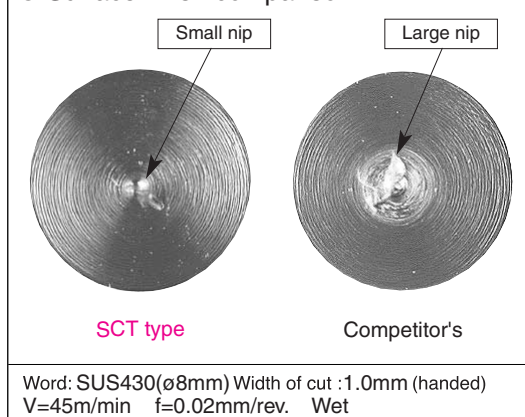


Comparison test

Cutting Force



Surface finish comparison



SEC-Cut Off Tool Holders

SCT Type

■ Insert and Holder Variations (Illustrations below show Inserts with chipbreaker)

Holder Style	SCTR			SCTL		
Insert	CTROOR	CTROON	CTROOL	CTLOOR	CTLOON	CTLOOL
Orientation						
Insert Shape and Dimensions						

■ Insert (For right-handed holders)

Cat. No.	Stock			Max. Cut-off Dia. (mm)	Dimensions (mm)				Chipbreaker	Applicable toolholder	
	ACZ310				t	R	W	H			
	R	N	L								
CTR050505 R/N/L	●	●	●	5	0.5	0.05	19	7	Yes	SCTR1010 SCTR1212 SCTR1616	
CTR050500 R/N/L	●	●	●	5		0					
CTR121005 R/N/L	●	●	●	12	1.0						
CTR121505 R/N/L	●	●	●	12	1.5						
CTR122005 R/N/L	●	●	●	12	2.0						
CTR121000 R/N/L	●	●	●	12	1.0						
CTR121500 R/N/L	●	●	●	12	1.5						
CTR122000 R/N/L	●	●	●	12	2.0						
CTR161005 R/N/L				16	1.0	0.05	23.1	8.3	Yes	SCTR1010-16 SCTR1212-16 SCTR1616-16	
CTR161505 R/N/L	●	●	●	16	1.5						
CTR162005 R/N/L	●	●	●	16	2.0						
CTR161000 R/N/L				16	1.0						
CTR161500 R/N/L	●	●	●	16	1.5						
CTR162000 R/N/L	●	●	●	16	2.0						
CTR050500 R/N/L-NB	●	●	●	5	0.5	0	19	7	No	SCTR1010 SCTR1212 SCTR1616	
CTR121000 R/N/L-NB	●	●	●	12	1.0						
CTR121500 R/N/L-NB	●	●	●	12	1.5						
CTR122000 R/N/L-NB	●	●	●	12	2.0						
CTR161000 R/N/L-NB				16	1.0		23.1	8.3		SCTR1010-16 SCTR1212-16 SCTR1616-16	
CTR161500 R/N/L-NB	●	●	●	16	1.5						
CTR162000 R/N/L-NB	●	●	●	16	2.0						

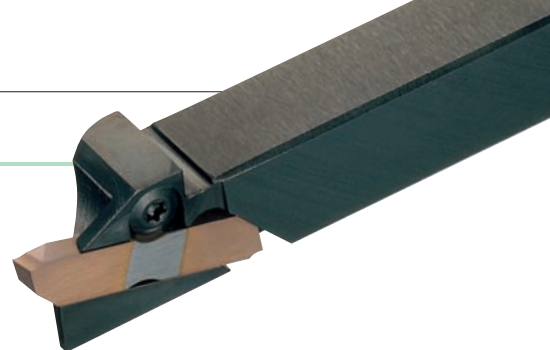
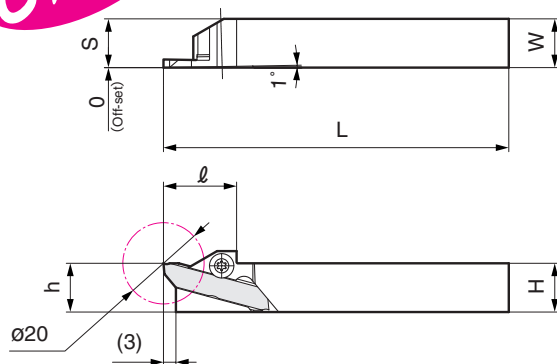
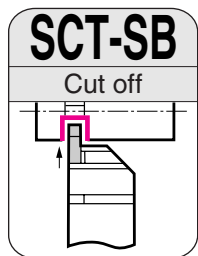
■ Insert (For left-handed holders)

Cat. No.	Stock			Max. Cut-off Dia. (mm)	Dimensions (mm)				Chipbreaker	Applicable toolholder				
	ACZ310				t	R	W	H						
	R	N	L											
CTL050505 R/N/L	●	●	●	5	0.5	0.05	19	7	Yes	SCTL1010 SCTL1212 SCTL1616				
CTL050500 R/N/L	●	●	●	5		0								
CTL121005 R/N/L	●	●	●	12	1.0									
CTL121505 R/N/L	●	●	●	12	1.5									
CTL122005 R/N/L	●	●	●	12	2.0									
CTL121000 R/N/L	●	●	●	12	1.0									
CTL121500 R/N/L	●	●	●	12	1.5									
CTL122000 R/N/L	●	●	●	12	2.0									
CTL161005 R/N/L				16	1.0	0.05	23.1	8.3		SCTL1010-16 SCTL1212-16 SCTL1616-16				
CTL161505 R/N/L	●	●	●	16	1.5									
CTL162005 R/N/L	●	●	●	16	2.0									
CTL161000 R/N/L				16	1.0									
CTL161500 R/N/L	●	●	●	16	1.5	0								
CTL162000 R/N/L	●	●	●	16	2.0									
CTL050500 R/N/L-NB	●	●	●	5	0.5	0					19	7	No	SCTL1010 SCTL1212 SCTL1616
CTL121000 R/N/L-NB	●	●	●	12	1.0									
CTL121500 R/N/L-NB	●	●	●	12	1.5									
CTL122000 R/N/L-NB	●	●	●	12	2.0									
CTL161000 R/N/L-NB				16	1.0		23.1	8.3		SCTL1010-16 SCTL1212-16 SCTL1616-16				
CTL161500 R/N/L-NB	●	●	●	16	1.5									
CTL162000 R/N/L-NB	●	●	●	16	2.0									

SEC-Cut Off Tool Holders SCT-SB Type

Cut off (Shank type)

New



Holder

Above figures show right hand tools.

	Cat. No.	Stock	Dimensions (mm)						Applicable Insert	Screw	Wrench
			H	W	L	S	h	l			
Right Hand	SCTR1212-SBK	●	12	12	125	12	12	18	CTSB R□□□□R/N	BFTX0410T8L	TRX08
	SCTR1212-SBF	●	12	12	85	12	12	18			
	SCTR1616-SBK	●	16	16	125	16	16	18			
Left Hand	SCTL1212-SBK	●	12	12	125	12	12	18	CTSB L□□□□L/N	BFTX0410T8R	TRX08
	SCTL1212-SBF	●	12	12	85	12	12	18			
	SCTL1616-SBK	●	16	16	125	16	16	18			

Parts



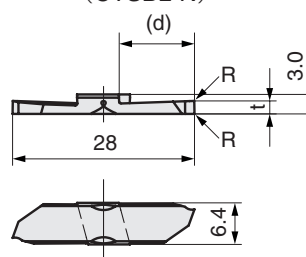
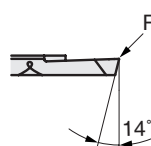
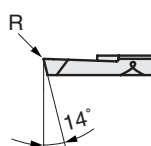
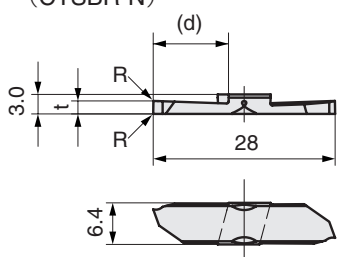
Insert

SCTR
(CTSB R-N)

(CTSB R-R)

SCTL
(CTSB L-L)

(CTSB L-N)



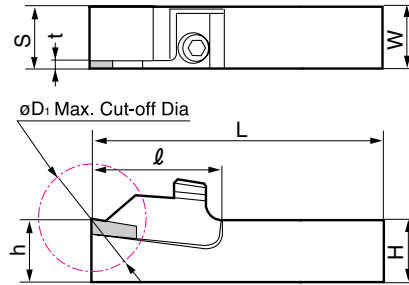
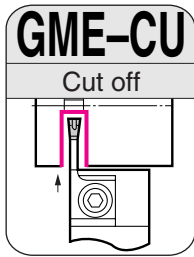
Holder Style	Cat. No.	Stock			Max. Cut-off Dia. (mm)	Dimensions (mm)			Applicable toolholder
		ACZ310				t	d	R	
		R	N	L					
Right Hand	CTSB R101505R/N	●	●	—	10	1.5	6	0.05	SCTR□□□□-SBO
	CTSB R102005R/N	●	●	—	10	2.0	6		
	CTSB R202005R/N	●	●	—	20	2.0	11		
	CTSB R202505R/N	●	●	—	20	2.5	11		
Left Hand	CTSB L101505N/L	—	●	●	10	1.5	6	0.05	SCTL□□□□-SBO
	CTSB L102005N/L	—	●	●	10	2.0	6		
	CTSB L202005N/L	—	●	●	20	2.0	11		
	CTSB L202505N/L	—	●	●	20	2.5	11		

Recommended Conditions

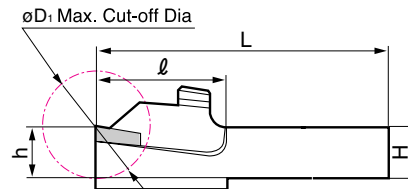
Work Material	Carbon steel	Free-cutting Steel	Stainless steel
Cutting Speed (m/min)	50~150	50~150	50~100
Feedrate (mm/rev)	0.02~0.1	0.02~0.1	0.02~0.05

SEC-Cut Off Tool Holders GME-CU Type

Cut off (Shank type)



(GME/L 1212CU, 1616CU and 2020CU)



(GME/L 1010CU)

Above figures show right hand tools.

Parts

Holder

Cat. No.	Stock		Dimensions (mm)							Max. Cut-off Dia. (mm)	Clamp	Screw	Wrench
	R	L	H	W	L	S	h	l	t				
GME R/L1010CU	●	●	10	10	75	10	10	20	2.4	20	GCC R/L10	BX0412	LH030
GME R/L1212CU	●	●	12	12	90	12	12	20	2.4	20		BX0416	
GME R/L1616CU	●	●	16	16	115	16	16	20	2.4	20		BX0520	LH040
GME R/L2020CU	●	●	20	20	115	20	20	32.8	2.4	38	GCC R/L20	BX0520	

Insert

Fig1	Fig2	Fig3	Cat. No.	Coated	θ°	Shape	Applicable toolholder
				GAC50			
			MGCN24	●	—	Fig1	GME R/L□□□□-CU
			MGCR24	●	4	Fig2	
			MGCL24	●	4	Fig3	
			MGCR24-12	●	12	Fig2	
			MGCL24-12	●	12	Fig3	

Recommended Conditions

Work Material	Carbon steel	Alloy steel	Stainless steel
Cutting Speed (m/min)	50 ~ 100	50 ~ 100	50 ~ 80
Feedrate (mm/rev)	0.03 ~ 0.10	0.03 ~ 0.10	0.03 ~ 0.08