

Grooving System

# GY Series

For small lathes.  
Mono-block holder  
now included

# Grooving Revolution

Innovative clamping system ensures reliable grooving.

## Side A

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## Side B

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# Widened application area for the GY series!



## Holder for small lathes

Insert width 1.5–3.24mm

10mm×10mm  
12mm×12mm  
16mm×16mm  
20mm×12mm

> P13

R/L  
**32**  
ITEM



## Mono-block type holder with zero offset between the holder and cutting edge

Insert width 2.0–6.35mm

20mm×20mm  
25mm×25mm

> P15, P19, P21, P23, P25

R/L  
**40**  
ITEM



R/L  
**22**  
ITEM

**For recessing**

Insert width 2.0–6.35mm

20mm×20mm  
25mm×25mm

> P35



**112**  
ITEM

**For finishing,  
O-ring and Circlip groove**

Ground insert for multi-functional machining  
Insert width

2mm/2.24mm/2.39mm/  
2.5mm/2.74mm/3mm/  
3.18mm/3.24mm/4mm/  
4.24mm/4.75mm/5mm/  
5.24mm/6mm/6.31mm/  
6.35mm

✗ 4 grades

> P10

**Inserts available for groove widths from 1.5mm up to 8mm.**

1.5mm Inserts



3 grades 6 items

> P9

8mm Inserts



3 grades 17 items

> P9, P10, P11

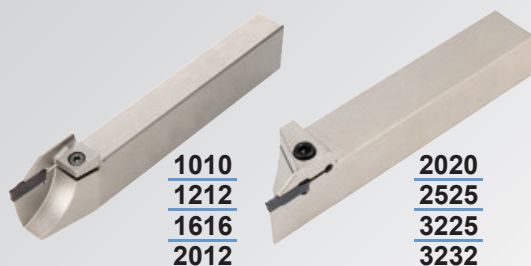
# GY SERIES

## A wide selection of holders and inserts available for diverse grooving applications.

### External • Face holders

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

FEATURES

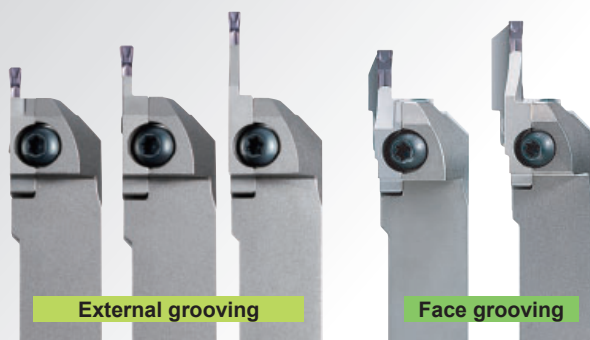


**Mono block type**



**Modular type**

● Modular type holders can be used over a wide range of applications by using different modular blades.

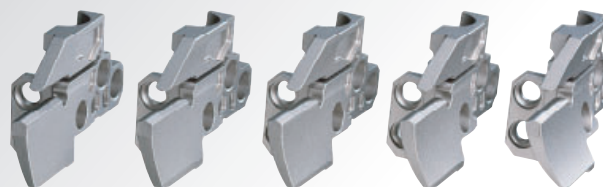


External grooving

Face grooving

The same holder

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



### Internal holders

● A wide range of holders available from minimum diameter of  $\phi 25$ mm.

**Mono block type**  
Min. cutting diameter  
 $\phi 25$ ,  $\phi 32$

**Modular type**  
Min. cutting diameter  
 $\phi 40$ ,  $\phi 50$ ,  
 $\phi 60$ ,  $\phi 70$



● Short shank types are standard stocked.

**Mono block type**

**Modular type**



Short

Standard

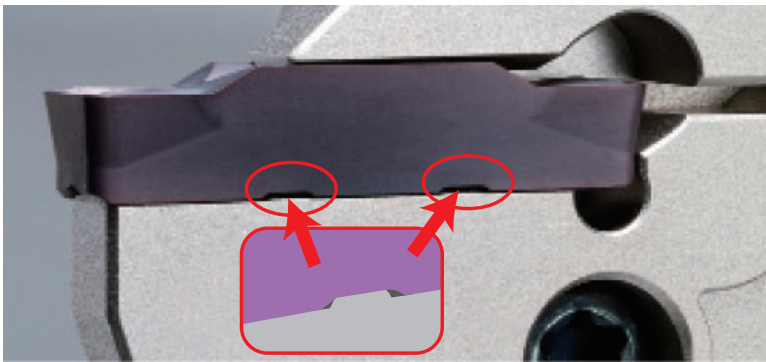
Short

Standard

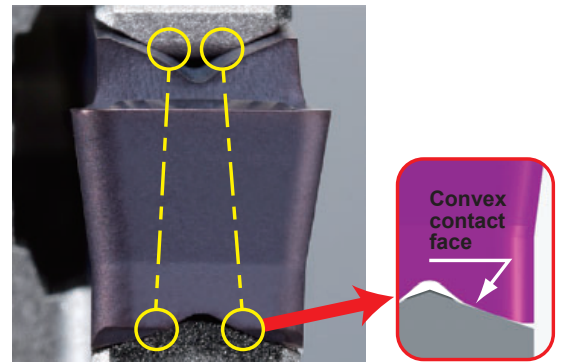
# Original insert design leading the way to new grooving applications !

## ● Highly reliable insert clamping

Safety keys prevent insert movement.



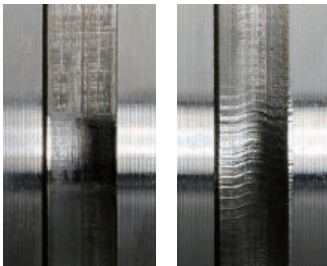
The convex geometry ensures high precision clamping.



FEATURES

## Face grooving test results

GY series can achieve stable machining at the cutting conditions which created vibration with a conventional modular type tool.



GY

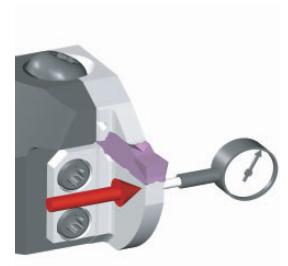
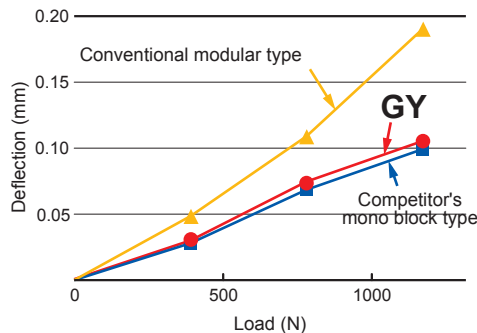
Conventional modular type

<Cutting Conditions>

Workpiece : SCM440  
 Insert width : 5mm  
 Cutting speed : 150m/min  
 Feed : 0.2mm/rev  
 Groove depth : 23mm

## Rigidity comparison

The GY series provides rigidity comparable to a mono block type grooving tool.

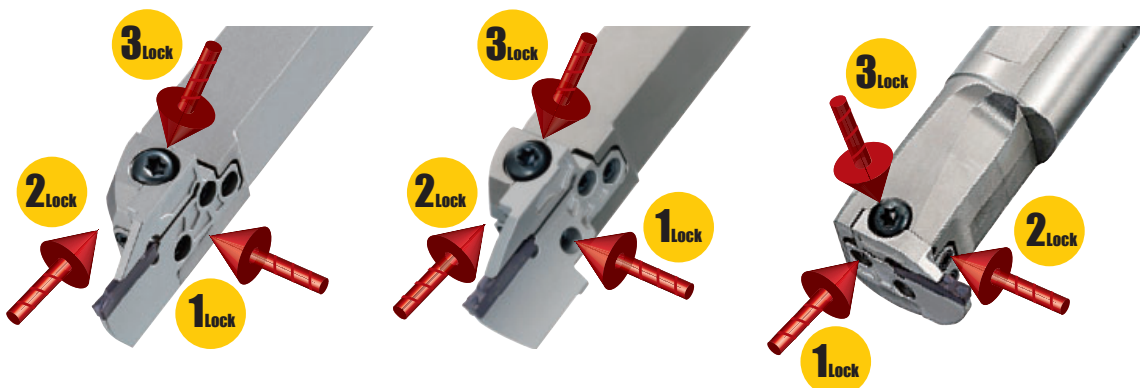


(Tool body for 5mm insert)

# New TRI-LOCK System for increased stability and performance!

## ● TRI-LOCK System

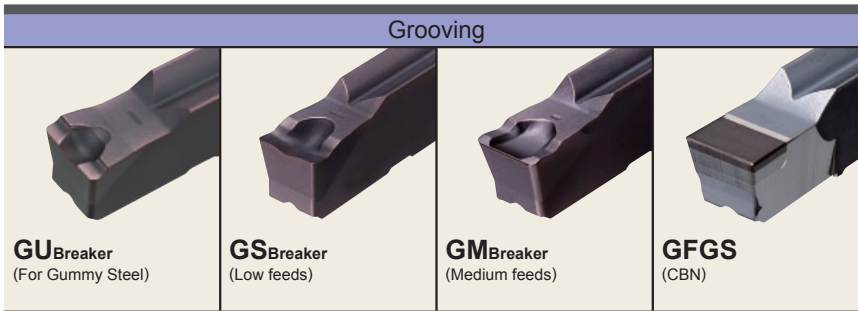
The TRI-LOCK system ensures the blade is securely fixed in 3 directions (side, front and top), giving high rigidity for stable grooving performance.



## INSERT

### ● A WIDE SELECTION OF INSERTS

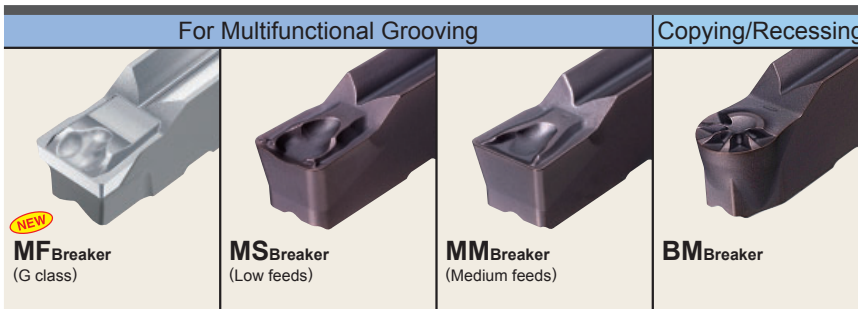
#### ● Breaker system



#### ● Selection of groove widths

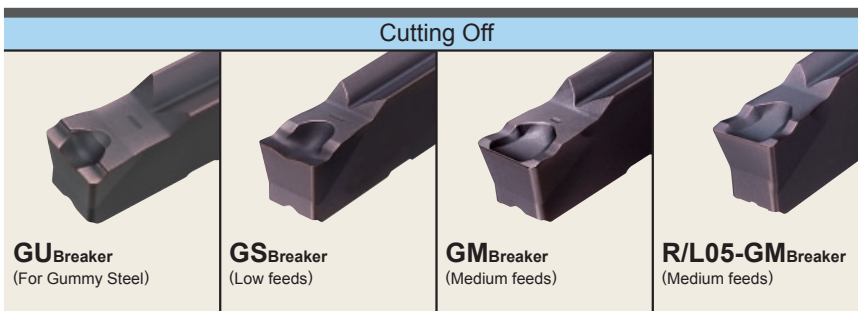


#### ● Different corner radii available



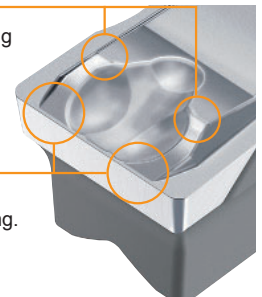
**NEW**

#### ● MF Breaker



Efficient chip breaking when cross-feed machining.

Chips are controlled when finish machining.



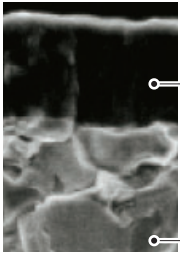
### ● INSERT GRADE

Work Material Machining Condition	P Steel	M Stainless Steel	K Cast Iron	S Heat resistant Alloy / Titanium Alloy	H Hardened steel
	Stable  Machining Condition  Unstable	NX2525 MY5015 VP10RT VP20RT	VP10RT VP20RT	MY5015 VP10RT VP20RT	VP10RT RT9010 VP20RT

Note1) VP20RT is the first recommended grade for materials other than hardened steel.

Note2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

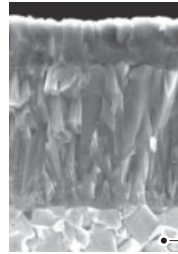
### VP20RT (1st Recommendation)



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

MIRACLE Coating  
Carbide substrate (HRA90.5)

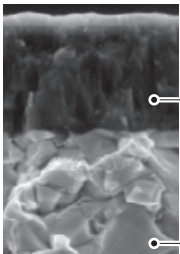
### MY5015



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

CVD Coated Carbide  
Carbide substrate

### VP10RT (2nd Recommendation)



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

MIRACLE Coating  
Carbide substrate (HRA92.0)

### RT9010

● First recommended grade for titanium alloys. It is not recommended for use on non-ferrous alloys.

### NX2525

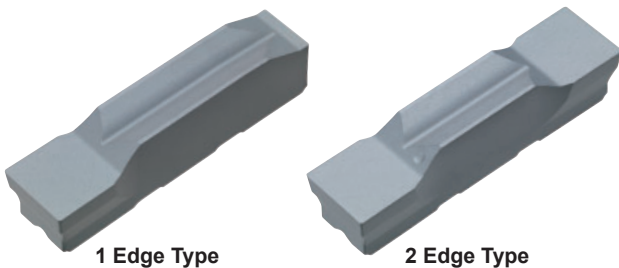
● NX2525, a cermet grade for finish machining of steels and for good surface finishes at lower cutting speeds.

### MB8025

● MB8025 is a sintered CBN grade for hardened steel.

## ● BLANK INSERTS

● Blank inserts for custom grinding



1 Edge Type

2 Edge Type

\* Blank inserts to be ground by customers.

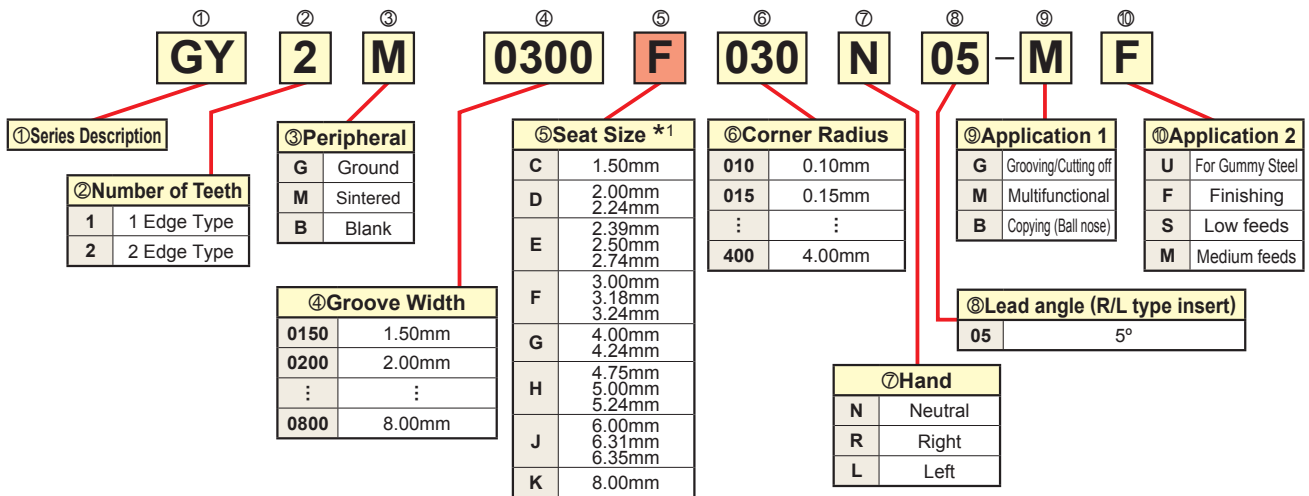
### RT9010/RT9020 for blank insert

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

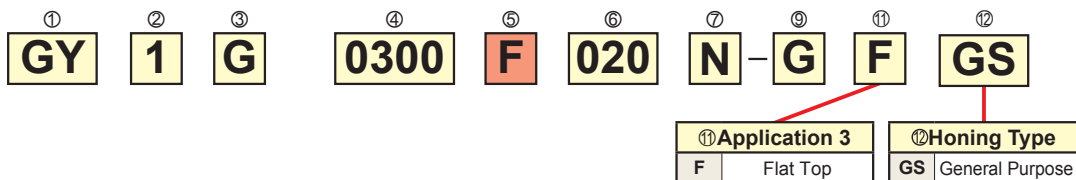
# IDENTIFICATION OF GY SERIES

ORDER NUMBER

## INSERT



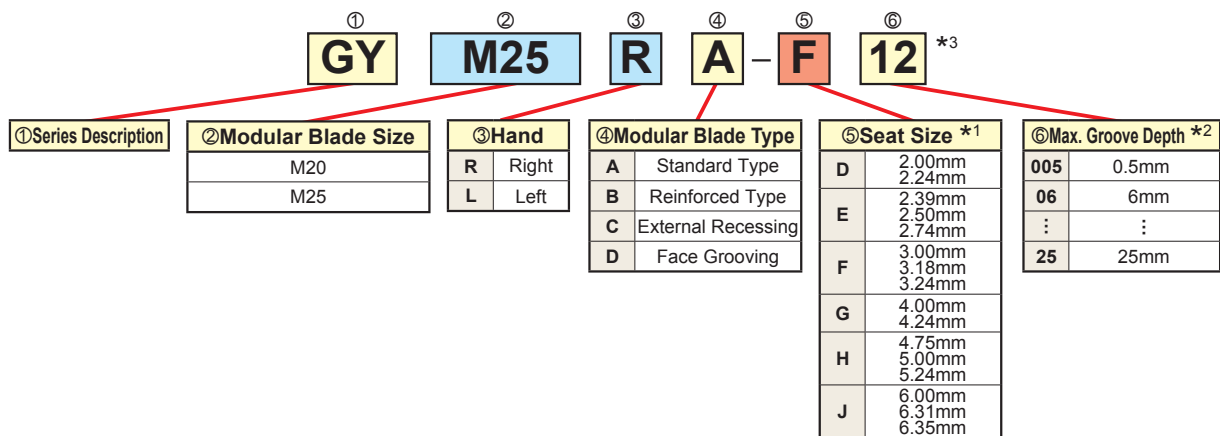
## CBN INSERT



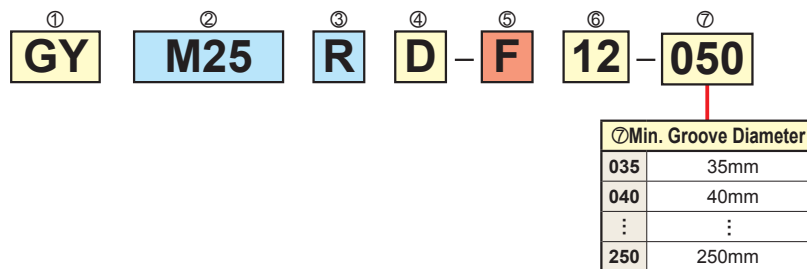
\*1 Select a seat size with the same symbol as that of modular blade and mono block holder.

## MODULAR BLADE

### EXTERNAL/INTERNAL/RECESSING



### FACE GROOVING



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

\*2 The maximum groove depth is a value when used for external grooving and changes according to the insert used. For internal grooving, refer to the maximum groove depth on pages 79—85.

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



**EXTERNAL/FACE GROOVING/RECESSING**

**● MONO BLOCK HOLDER**

① **GY** ② **P** ③ **R** ④ **2525** ⑤ **M** ⑥ **00** - ⑦ **K** ⑧ **25**

① Series Description

③ Hand of Holder

④ Shank Diameter

⑤ Holder Length

⑤ Seat Size \*1

⑧ Max. Groove Depth

② Holder Type

S	Mono Block Holder for Small Lathe
P	Offset Mono Block Holder
Q	Zero Offset Mono Block Holder
H	Modular Type Holder

R	Right
L	Left

1010	10mmx10mm
1212	12mmx12mm
1616	16mmx16mm
2012	20mmx12mm
2020	20mmx20mm
2525	25mmx25mm
3225	32mmx25mm
3232	32mmx32mm

J	110mm
JX	120mm
K	125mm
M	150mm
P	170mm

⑥ Angle (degree)	
00	0°
50	50°
90	90°

C	1.50mm
D	2.00mm 2.24mm
E	2.39mm 2.50mm 2.74mm
F	3.00mm 3.18mm 3.24mm
G	4.00mm 4.24mm
H	4.75mm 5.00mm 5.24mm
J	6.00mm 6.31mm 6.35mm
K	8.00mm

06	6mm
08	8mm
:	:
25	25mm

**● MODULAR TYPE HOLDER**

① **GY** ② **H** ③ **R** ④ **2525** ⑤ **M** ⑥ **00** - ⑦ **M25** ⑧ **R**

⑦ Modular Blade Size	
M20	
M25	

⑧ Hand of Modular Blade	
R	Right
L	Left

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

**INTERNAL**

**● MONO BLOCK HOLDER**

① **GY** ② **A** ③ **R** ④ **20** ⑤ **K** ⑥ **90** ⑦ **A** - ⑧ **F** ⑨ **06**

① Series Description

③ Hand of Holder

④ Shank Diameter

⑤ Holder Length

⑥ Angle (degree)

⑨ Max. Groove Depth

② Holder Type

A	Mono Block
D	Modular Type Holder

R	Right
L	Left

20	20mm
25	25mm
32	32mm
40	40mm
50	50mm

K	125mm
L	140mm
M	150mm
P	170mm
Q	180mm
R	200mm
S	250mm
T	300mm

90	90°
----	-----

⑦ Neck Length	
A	30mm
B	40mm
C	50mm
D	60mm
F	80mm

⑧ Seat Size *1	
D	2.00mm 2.24mm
E	2.39mm 2.50mm 2.74mm
F	3.00mm 3.18mm 3.24mm
G	4.00mm 4.24mm
H	4.75mm 5.00mm 5.24mm
J	6.00mm 6.31mm 6.24mm

06	6mm
07	7mm

**● MODULAR TYPE HOLDER**

① **GY** ② **D** ③ **R** ④ **40** ⑤ **M** ⑥ **90** ⑦ **D** - ⑧ **M25** ⑨ **L**

⑧ Modular Blade Size	
M20	
M25	

⑨ Hand of Modular Blade	
R	Right
L	Left

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

# GY INSERTS

## INSERTS

Applications	Geometry	Order Number	Stock							Seat Size	Dimensions (mm)				
			Coated		Cermet		Carbide		CBN		W <sub>3</sub>		Re	ar (Max.)	L <sub>2</sub>
			VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020			MB8025	Grooving Width			
For Grooving / Cutting off	<b>GU Breaker</b> (For gummy steel) 	GY2M0200D020N-GU	●	●	●					D	2.00	±0.03	0.2	19.7	20.70
		GY2M0239E020N-GU	●	●	●					E	2.39	±0.03	0.2	19.8	20.70
		GY2M0250E020N-GU	●	●	●					E	2.50	±0.03	0.2	19.5	20.70
		GY2M0300F030N-GU	●	●	●					F	3.00	±0.03	0.3	19.3	20.70
		GY2M0318F030N-GU	●	●	●					F	3.18	±0.03	0.3	19.3	20.70
		GY2M0400G030N-GU	●	●	●					G	4.00	±0.04	0.3	24.2	25.65
		GY2M0475H040N-GU	●	●	●					H	4.75	±0.04	0.4	24.2	25.65
		GY2M0500H040N-GU	●	●	●					H	5.00	±0.04	0.4	24.2	25.65
		GY2M0600J040N-GU	●	●	●					J	6.00	±0.04	0.4	24.2	25.65
		GY2M0635J040N-GU	●	●	●					J	6.35	±0.04	0.4	24.2	25.65
For Grooving / Cutting off	<b>GS Breaker</b> (Low feeds) 	<b>NEW</b> GY2M0150C010N-GS	●	●	●					C	1.50	±0.03	0.1	13.4	14.70
		GY2M0200D020N-GS	●	●	●					D	2.00	±0.03	0.2	18.7	20.70
		GY2M0239E020N-GS	●	●	●					E	2.39	±0.03	0.2	18.5	20.70
		GY2M0250E020N-GS	●	●	●					E	2.50	±0.03	0.2	18.5	20.70
		GY2M0300F020N-GS	●	●	●					F	3.00	±0.03	0.2	18.5	20.70
		GY2M0318F020N-GS	●	●	●					F	3.18	±0.03	0.2	18.5	20.70
		GY2M0400G020N-GS	●	●	●					G	4.00	±0.04	0.2	23.9	25.65
		GY2M0475H030N-GS	●	●	●					H	4.75	±0.04	0.3	23.9	25.65
		GY2M0500H030N-GS	●	●	●					H	5.00	±0.04	0.3	24.0	25.65
		GY2M0600J030N-GS	●	●	●					J	6.00	±0.04	0.3	24.1	25.65
For Grooving / Cutting off	<b>GM Breaker</b> (Medium feeds) 	<b>NEW</b> GY2M0800K030N-GS	●	●	●					K	8.00	±0.04	0.3	29.1	30.50
		<b>NEW</b> GY2M0150C020N-GM	●	●	●					C	1.50	±0.03	0.2	13.9	14.70
		GY2M0200D020N-GM	●	●	●					D	2.00	±0.03	0.2	19.4	20.70
		GY2M0239E020N-GM	●	●	●					E	2.39	±0.03	0.2	19.4	20.70
		GY2M0250E020N-GM	●	●	●					E	2.50	±0.03	0.2	19.4	20.70
		GY2M0300F030N-GM	●	●	●					F	3.00	±0.03	0.3	19.4	20.70
		GY2M0318F030N-GM	●	●	●					F	3.18	±0.03	0.3	19.4	20.70
		GY2M0400G030N-GM	●	●	●					G	4.00	±0.04	0.3	24.4	25.65
		GY2M0475H040N-GM	●	●	●					H	4.75	±0.04	0.4	24.3	25.65
		GY2M0500H040N-GM	●	●	●					H	5.00	±0.04	0.4	24.3	25.65
For Cutting off	<b>R/L05-GM Breaker</b> 	GY2M0200D020R05-GM	●	●						D	2.00	±0.03	0.2	19.5	20.80
		GY2M0200D020L05-GM	●	●						D	2.00	±0.03	0.2	19.5	20.80
		GY2M0250E020R05-GM	●	●						E	2.50	±0.03	0.2	19.5	20.825
		GY2M0250E020L05-GM	●	●						E	2.50	±0.03	0.2	19.5	20.825
		GY2M0300F030R05-GM	●	●						F	3.00	±0.03	0.3	19.5	20.85
		GY2M0300F030L05-GM	●	●						F	3.00	±0.03	0.3	19.5	20.85
		GY2M0400G030R05-GM	●	●						G	4.00	±0.04	0.3	24.5	25.85
		GY2M0400G030L05-GM	●	●						G	4.00	±0.04	0.3	24.5	25.85
		GY2M0500H040R05-GM	●	●						H	5.00	±0.04	0.4	24.5	25.95
		GY2M0500H040L05-GM	●	●						H	5.00	±0.04	0.4	24.5	25.95

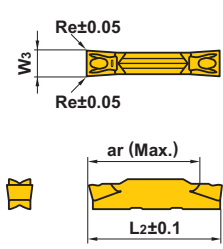
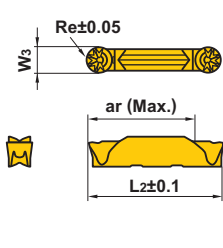
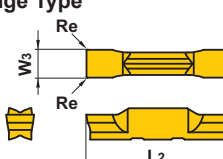
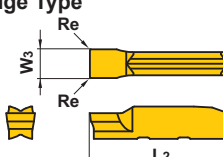
● : Inventory maintained. (10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

Applications	Geometry	Order Number	Stock						Seat Size	Dimensions (mm)					
			Coated		Cermet	Carbide		CBN		W3		Re	ar (Max.)	L2	
			VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020		MB8025	Grooving Width				Tolerance
For Grooving	<b>Flat Top (For Hardened material)</b> 	<b>GY1G0200D020N-GFGS</b>						●	D	2.00	±0.03	0.2	—	20.40	
		<b>GY1G0239E020N-GFGS</b>						●	E	2.39	±0.03	0.2	—	20.40	
		<b>GY1G0250E020N-GFGS</b>						●	E	2.50	±0.03	0.2	—	20.40	
		<b>GY1G0300F020N-GFGS</b>						●	F	3.00	±0.03	0.2	—	20.40	
		<b>GY1G0318F020N-GFGS</b>						●	F	3.18	±0.03	0.2	—	20.40	
		<b>GY1G0400G020N-GFGS</b>						●	G	4.00	±0.03	0.2	—	25.30	
		<b>GY1G0475H020N-GFGS</b>						●	H	4.75	±0.03	0.2	—	25.30	
		<b>GY1G0500H020N-GFGS</b>						●	H	5.00	±0.03	0.2	—	25.30	
For Multifunctional Grooving	<b>MF Breaker (Finishing)</b> 	<b>GY2G0200D020N-MF</b>	●	●	●	●			D	2.00	±0.02	0.2	19.5	21.05	
		*1 <b>GY2G0224D015N-MF</b>	●	●	●	●				D	2.24	±0.02	0.15	19.8	21.05
		<b>GY2G0239E020N-MF</b>	●	●	●	●				E	2.39	±0.02	0.2	19.2	21.05
		<b>GY2G0250E020N-MF</b>	●	●	●	●				E	2.50	±0.02	0.2	19.4	21.05
		*1 <b>GY2G0274E020N-MF</b>	●	●	●	●				E	2.74	±0.02	0.2	19.7	21.05
		<b>GY2G0300F020N-MF</b>	●	●	●	●				F	3.00	±0.02	0.2	19.5	21.05
		<b>GY2G0300F040N-MF</b>	●	●	●	●				F	3.00	±0.02	0.4	19.3	21.05
		<b>GY2G0318F020N-MF</b>	●	●	●	●				F	3.18	±0.02	0.2	19.5	21.05
		<b>GY2G0318F040N-MF</b>	●	●	●	●				F	3.18	±0.02	0.4	19.3	21.05
		*1 <b>GY2G0324F020N-MF</b>	●	●	●	●				F	3.24	±0.02	0.2	19.5	21.05
		<b>GY2G0400G020N-MF</b>	●	●	●	●				G	4.00	±0.02	0.2	24.9	25.95
		<b>GY2G0400G040N-MF</b>	●	●	●	●				G	4.00	±0.02	0.4	24.7	25.95
		<b>GY2G0400G080N-MF</b>	●	●	●	●				G	4.00	±0.02	0.8	24.3	25.95
		*1 <b>GY2G0424G020N-MF</b>	●	●	●	●				G	4.24	±0.02	0.2	24.9	25.95
		<b>GY2G0475H020N-MF</b>	●	●	●	●				H	4.75	±0.02	0.2	24.4	25.95
		<b>GY2G0475H040N-MF</b>	●	●	●	●				H	4.75	±0.02	0.4	24.2	25.95
		<b>GY2G0475H080N-MF</b>	●	●	●	●				H	4.75	±0.02	0.8	23.8	25.95
		<b>GY2G0500H020N-MF</b>	●	●	●	●				H	5.00	±0.02	0.2	24.4	25.95
		<b>GY2G0500H040N-MF</b>	●	●	●	●				H	5.00	±0.02	0.4	24.2	25.95
		<b>GY2G0500H080N-MF</b>	●	●	●	●				H	5.00	±0.02	0.8	23.8	25.95
		*1 <b>GY2G0524H020N-MF</b>	●	●	●	●				H	5.24	±0.02	0.2	24.4	25.95
		<b>GY2G0600J020N-MF</b>	●	●	●	●				J	6.00	±0.02	0.2	24.4	25.95
		<b>GY2G0600J040N-MF</b>	●	●	●	●				J	6.00	±0.02	0.4	24.2	25.95
		<b>GY2G0600J080N-MF</b>	●	●	●	●				J	6.00	±0.02	0.8	23.8	25.95
		*1 <b>GY2G0631J020N-MF</b>	●	●	●	●				J	6.31	±0.02	0.2	24.4	25.95
		<b>GY2G0635J020N-MF</b>	●	●	●	●				J	6.35	±0.02	0.2	24.4	25.95
		<b>GY2G0635J040N-MF</b>	●	●	●	●				J	6.35	±0.02	0.4	24.2	25.95
		<b>GY2G0635J080N-MF</b>	●	●	●	●				J	6.35	±0.02	0.8	23.8	25.95
<b>MS Breaker (Low feeds)</b> 	<b>GY2M0200D020N-MS</b>	●	●	●	●				D	2.00	±0.03	0.2	19.1	20.70	
	<b>GY2M0250E020N-MS</b>	●	●	●	●				E	2.50	±0.03	0.2	19.1	20.70	
	<b>GY2M0300F020N-MS</b>	●	●	●	●				F	3.00	±0.03	0.2	19.2	20.70	
	<b>GY2M0300F040N-MS</b>	●	●	●	●				F	3.00	±0.03	0.4	18.9	20.70	
	<b>GY2M0400G020N-MS</b>	●	●	●	●				G	4.00	±0.04	0.2	24.2	25.65	
	<b>GY2M0400G040N-MS</b>	●	●	●	●				G	4.00	±0.04	0.4	23.9	25.65	
	<b>GY2M0500H040N-MS</b>	●	●	●	●				H	5.00	±0.04	0.4	23.9	25.65	
	<b>GY2M0500H080N-MS</b>	●	●	●	●				H	5.00	±0.04	0.8	23.5	25.65	
	<b>GY2M0600J040N-MS</b>	●	●	●	●				J	6.00	±0.04	0.4	23.9	25.65	
	<b>GY2M0600J080N-MS</b>	●	●	●	●				J	6.00	±0.04	0.8	23.5	25.65	
<b>NEW</b> <b>GY2M0800K080N-MS</b>	●	●	●					K	8.00	±0.04	0.8	28.5	30.50		

\*1 Groove width corresponding to the circlip.

# GY INSERTS

## INSERTS




Applications	Geometry	Order Number	Stock							Seat Size	Dimensions (mm)						
			Coated		Cermet		Carbide		CBN		W <sub>3</sub>		Re	ar (Max.)	L <sub>2</sub>		
			VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020			MB8025	Grooving Width				Tolerance	
For Multifunctional Grooving	<b>MM Breaker</b> (Medium feeds) 	GY2M0200D020N-MM	●	●	●	●					D	2.00	±0.03	0.2	19.1	20.70	
		GY2M0250E020N-MM	●	●	●	●					E	2.50	±0.03	0.2	19.1	20.70	
		GY2M0300F020N-MM	●	●	●	●					F	3.00	±0.03	0.2	19.1	20.70	
		GY2M0300F040N-MM	●	●	●	●					F	3.00	±0.03	0.4	18.9	20.70	
		GY2M0300F080N-MM	●	●	●	●					F	3.00	±0.03	0.8	18.5	20.70	
		GY2M0400G020N-MM	●	●	●	●					G	4.00	±0.04	0.2	24.1	25.65	
		GY2M0400G040N-MM	●	●	●	●					G	4.00	±0.04	0.4	23.9	25.65	
		GY2M0400G080N-MM	●	●	●	●					G	4.00	±0.04	0.8	23.5	25.65	
		GY2M0500H040N-MM	●	●	●	●					H	5.00	±0.04	0.4	23.9	25.65	
		GY2M0500H080N-MM	●	●	●	●					H	5.00	±0.04	0.8	23.5	25.65	
		GY2M0600J040N-MM	●	●	●	●					J	6.00	±0.04	0.4	23.9	25.65	
		GY2M0600J080N-MM	●	●	●	●					J	6.00	±0.04	0.8	23.5	25.65	
		GY2M0800K080N-MM	●	●	●						K	8.00	±0.04	0.8	28.5	30.50	
<b>NEW</b>	GY2M0800K120N-MM	●	●	●					K	8.00	±0.04	1.2	28.1	30.50			
For Copying / Reversing	<b>BM Breaker</b> 	GY2M0200D100N-BM	●	●	●	●					D	2.00	±0.03	1.00	19.5	20.90	
		GY2M0250E125N-BM	●	●	●	●					E	2.50	±0.03	1.25	19.3	20.90	
		GY2M0300F150N-BM	●	●	●	●					F	3.00	±0.03	1.50	19.0	20.90	
		GY2M0318F159N-BM	●	●	●	●					F	3.18	±0.03	1.59	18.9	20.90	
		GY2M0400G200N-BM	●	●	●	●					G	4.00	±0.04	2.00	23.4	25.80	
		GY2M0475H238N-BM	●	●	●	●					H	4.75	±0.04	2.38	22.9	25.80	
		GY2M0500H250N-BM	●	●	●	●					H	5.00	±0.04	2.50	22.8	25.80	
		GY2M0600J300N-BM	●	●	●	●					J	6.00	±0.04	3.00	22.5	25.90	
		GY2M0635J318N-BM	●	●	●	●					J	6.35	±0.04	3.18	22.3	25.90	
		<b>NEW</b>	GY2M0800K400N-BM	●	●	●					K	8.00	±0.04	4.00	26.5	30.80	
Blank	<b>2 Edge Type</b> 	GY2B0220D020N			●	●	●				D	2.20	±0.10	0.2	—	21.05	
		GY2E0270E020N			●	●	●				E	2.70	±0.10	0.2	—	21.05	
		GY2E0340F020N			●	●	●				F	3.40	±0.10	0.2	—	21.05	
		GY2E0420G020N			●	●	●				G	4.20	±0.10	0.2	—	26.00	
		GY2E0520H020N			●	●	●				H	5.20	±0.10	0.2	—	26.00	
		GY2E0655J020N			●	●	●				J	6.55	±0.10	0.2	—	26.00	
	<b>1 Edge Type</b> 	GY1B0220D020N			●	●	●					D	2.20	±0.10	0.2	—	21.07
		GY1E0270E020N			●	●	●					E	2.70	±0.10	0.2	—	21.10
		GY1E0340F020N			●	●	●					F	3.40	±0.10	0.2	—	21.00
		GY1E0420G020N			●	●	●					G	4.20	±0.10	0.2	—	25.86
		GY1E0520H020N			●	●	●					H	5.20	±0.10	0.2	—	25.90
		GY1E0655J020N			●	●	●					J	6.55	±0.10	0.2	—	25.90

\*2 Blank inserts to be ground by customers.

● : Inventory maintained. (10 inserts in one case)

(Reference Data)

## CIRCLIP STANDARDS

Category	Application		Name of Standard	Width (Tolerance)									
				For Shaft				For Hole					
C type circlip 	For Shaft	For Hole		0.5	+0.14 0	0.305	+0.051	1.15	+0.14 0	9	+0.14 0	0.457	+0.051
				0.7		0.457	0	1.35		1.1		0.737	0
0.8	0.737	+0.076	1.75	1.3		0.991	+0.076						
0.9	0.991	0	1.95	1.6		1.168	0						
1.1	1.168	0	2.2	1.85		1.422	+0.102						
1.3	1.422	+0.102	2.7	2.15		1.727	0						
1.6	1.727	0	3.2	2.65		2.184	+0.127						
1.85	2.184	+0.127	4.2	3.15		2.616	0						
2.15	2.616	0		4.15		3.048	+0.127						
2.65	3.048	0		5.15			0						
3.15	3.531	+0.152		6.2		+0.22							
4.15		0				0							
5.15		0				0							
6.2		0				0							
C type retaining ring 	For Shaft	For Hole	ANSI B27.7/27.8 (US) BS 3673 (UK) DIN 471/472 (De) NF E 22 163 (Fr) UNI 7435/7438 (It)										
			JIS B 2804 (JP)										
E type circlip 	For Shaft		N1*** American	0.32	+0.05	0.305	+0.051	0.3	+0.05				
			0.5	0	0.457	0	0.4	0					
				0.7	+0.10	0.584		0.5					
				1.0	0	0.737	+0.076	0.7	+0.10				
				1.2	+0.14	0.991	0	0.9	0				
				1.4	0	1.168		1.15					
						1.422	+0.102	1.75	+0.14				
						1.727	0	2.2	0				

## O-RING STANDARDS

Category	Name of Standard	Width (Tolerance)									
		General		For oil pressure		For air pressure					
Static Use	DIN 3770/3771 (De)	2.54	+0.13 0	1.9	+0.1	2.3	+0.2 0				
	3.18	2.3		0	3.1						
4.32	2.9	+0.15		3.7							
6.1	3.6	+0.2		6.4							
JIS B 2401 (JP) ISO 3601	3.2	2.5	4.5	0	9.0						
	4.0	+0.2	5.5	+0.3	2.4	+0.25 0	2.3	+0.2 0	2.2	+0.25 0	
	7.5	0	7.0	0	3.6		3.1				
	11.0		8.6	+0.4	4.8		3.4				
			10.7	+0.5	7.1		4.6				
Dynamic Use	SMS 1586/1588 (Se) BS 1806/4518 (UK)	2.39	+0.25 0			9.5		6.4		6.9	
		3.58						9.0		9.3	
	4.78										
	7.14										
SAE AS-568 (US)	9.58										

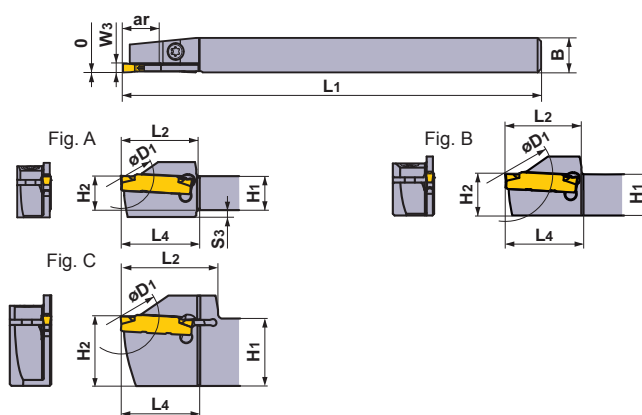
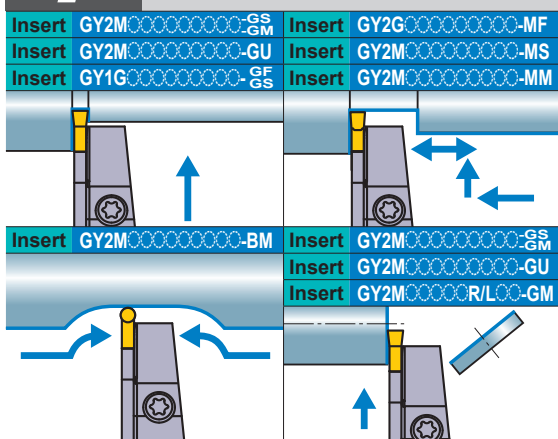
- G-class insert with MF breaker is available for single-step machining.
- Conventional GY series insert is available for single-step machining.
- Machined in multiple steps or by cross feed machining.

# GY SERIES (EXTERNAL GROOVING for Swiss style lathes)

## 1

### 00° type holder

NEW



Right hand tool holder shown.

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

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Max. Cut Off Diameter



\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

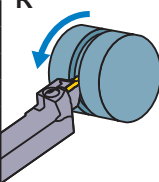
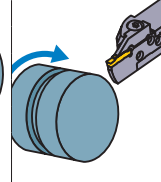
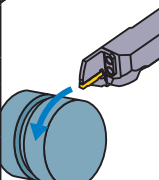
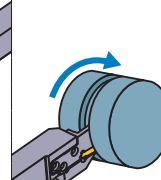
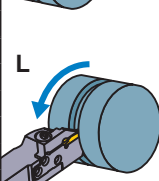
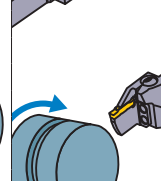
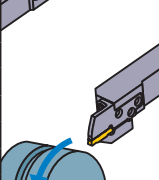
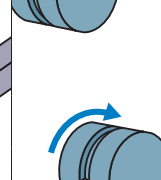
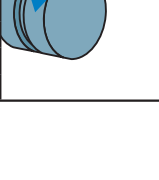
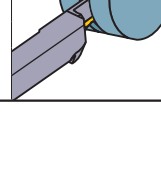






\*2 The maximum cut off diameter D<sub>1</sub> varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

\*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub> and L<sub>4</sub> values may vary.

\*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

## SPARE PARTS

Holder Number		
	Clamp Screw	Wrench
<b>GYSR/L1010JX00-11</b>	CS350990T (Clamp Torque : 2.5N·m)	TKY10R
<b>GYSR/L1212JX00-13</b>		
<b>GYSR/L2012JX00-18</b>		
<b>GYSR/L1616JX00-17</b>	TS4SBL (Clamp Torque : 3.5N·m)	TKY15R

Dimensions (mm) *3								Cutting Mode	
H1	B	L1	L2	L4	H2	S3		Clockwise	Anticlockwise
10	10	120	22	16	10	2	R		
10	10	120	22	16	10	2			
12	12	120	22	16	12	—	R		
12	12	120	22	16	12	—			
16	16	120	27	17	16	—	R		
16	16	120	27	17	16	—			
20	12	120	28	16	20	—	R		
20	12	120	28	16	20	—			
10	10	120	22	23	10	2	L		
10	10	120	22	23	10	2			
12	12	120	22	23	12	—	L		
12	12	120	22	23	12	—			
16	16	120	27	24	16	—	L		
16	16	120	27	24	16	—			
20	12	120	28	23	20	—	L		
20	12	120	28	23	20	—			
10	10	120	22	23	10	2	L		
10	10	120	22	23	10	2			
12	12	120	22	23	12	—	L		
12	12	120	22	23	12	—			
16	16	120	27	24	16	—	L		
16	16	120	27	24	16	—			
20	12	120	28	23	20	—	L		
20	12	120	28	23	20	—			

### Select an Insert

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

For Grooving/Cutting off		> P9, P10				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
C	1.50mm	●	●	●	●	●
D	2.00mm	●	●	●	●	●
E	2.39mm	●	●	●	●	●
F	2.50mm	●	●	●	●	●
	3.00mm	●	●	●	●	●
F	3.18mm	●	●	●	●	●

For Multifunctional Grooving		> P10, P11			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
D	2.00mm	●	●	●	●
	2.24mm	●	●	●	●
	2.39mm	●	●	●	●
E	2.50mm	●	●	●	●
	2.74mm	●	●	●	●
F	3.00mm	●	●	●	●
	Re 0.2	●	●	●	●
	Re 0.4	●	●	●	●
	Re 0.8	●	●	●	●
	3.18mm	●	●	●	●
	3.18mm	●	●	●	●

● : Gauge insert shown dimensions

EXTERNAL GROOVING

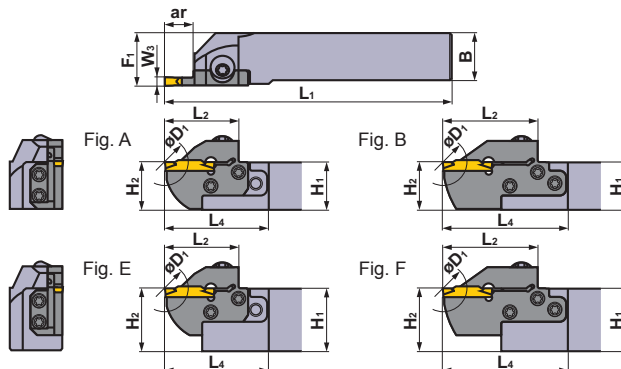
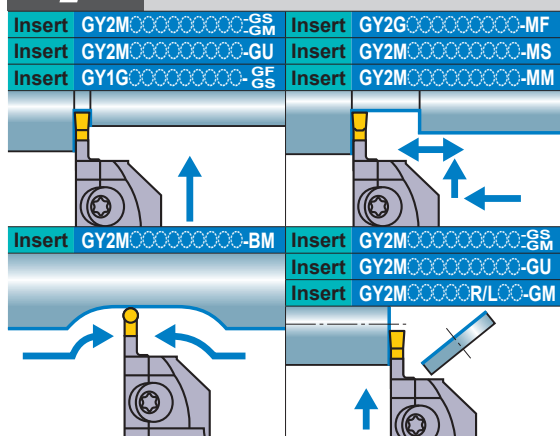
# GY SERIES (EXTERNAL GROOVING)

## 1

### 00° type holder

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

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



Right hand tool holder shown.

EXTERNAL GROOVING

Seat Size	W <sub>3</sub> (mm)	ar (mm)	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	6	12	Modular	R	<b>GYHR1616J00-M20R</b>	●	<b>GYM20RA-D06</b>	●	C
					L	<b>GYHL1616J00-M20L</b>	●	<b>GYM20LA-D06</b>	●	C
				Mono Block	R	<b>GYQR2020K00-D06</b>	●	—	—	G
					L	<b>GYQL2020K00-D06</b>	●	—	—	G
				Modular	R	<b>GYHR2020K00-M20R</b>	●	<b>GYM20RA-D06</b>	●	A
					L	<b>GYHL2020K00-M20L</b>	●	<b>GYM20LA-D06</b>	●	A
				Modular	R	<b>GYHR2020K00-M25R</b>	●	<b>GYM25RA-D06</b>	●	C
					L	<b>GYHL2020K00-M25L</b>	●	<b>GYM25LA-D06</b>	●	C
				Mono Block	R	<b>GYQR2525M00-D06</b>	●	—	—	G
					L	<b>GYQL2525M00-D06</b>	●	—	—	G
				Modular	R	<b>GYHR2525M00-M25R</b>	●	<b>GYM25RA-D06</b>	●	A
					L	<b>GYHL2525M00-M25L</b>	●	<b>GYM25LA-D06</b>	●	A
		Modular	R	<b>GYHR3225P00-M25R</b>	●	<b>GYM25RA-D06</b>	●	E		
			L	<b>GYHL3225P00-M25L</b>	●	<b>GYM25LA-D06</b>	●	E		
		Modular	R	<b>GYHR3232P00-M25R</b>	●	<b>GYM25RA-D06</b>	●	E		
			L	<b>GYHL3232P00-M25L</b>	●	<b>GYM25LA-D06</b>	●	E		
		10	20	Modular	R	<b>GYHR1616J00-M20R</b>	●	<b>GYM20RA-D10</b>	●	C
					L	<b>GYHL1616J00-M20L</b>	●	<b>GYM20LA-D10</b>	●	C
				Modular	R	<b>GYHR2020K00-M20R</b>	●	<b>GYM20RA-D10</b>	●	A
					L	<b>GYHL2020K00-M20L</b>	●	<b>GYM20LA-D10</b>	●	A
				Modular	R	<b>GYHR2020K00-M25R</b>	●	<b>GYM25RA-D12</b>	●	C
					L	<b>GYHL2020K00-M25L</b>	●	<b>GYM25LA-D12</b>	●	C
		12	24	Modular	R	<b>GYHR2525M00-M25R</b>	●	<b>GYM25RA-D12</b>	●	A
					L	<b>GYHL2525M00-M25L</b>	●	<b>GYM25LA-D12</b>	●	A
Modular	R			<b>GYHR3225P00-M25R</b>	●	<b>GYM25RA-D12</b>	●	E		
	L			<b>GYHL3225P00-M25L</b>	●	<b>GYM25LA-D12</b>	●	E		
18 *4	36	Modular	R	<b>GYHR1616J00-M20R</b>	●	<b>GYM20RB-D18</b>	●	D		
			L	<b>GYHL1616J00-M20L</b>	●	<b>GYM20LB-D18</b>	●	D		
		Mono Block	R	<b>GYQR2020K00-D18</b>	●	—	—	G		
			L	<b>GYQL2020K00-D18</b>	●	—	—	G		
20 *1	40 *2	Modular	R	<b>GYHR2020K00-M20R</b>	●	<b>GYM20RB-D18</b>	●	B		
			L	<b>GYHL2020K00-M20L</b>	●	<b>GYM20LB-D18</b>	●	B		
		Modular	R	<b>GYHR2020K00-M25R</b>	●	<b>GYM25RA-D20</b>	●	D		
			L	<b>GYHL2020K00-M25L</b>	●	<b>GYM25LA-D20</b>	●	D		
		Mono Block	R	<b>GYQR2525M00-D20</b>	●	—	—	G		
			L	<b>GYQL2525M00-D20</b>	●	—	—	G		
Modular	R	<b>GYHR2525M00-M25R</b>	●	<b>GYM25RA-D20</b>	●	B				
	L	<b>GYHL2525M00-M25L</b>	●	<b>GYM25LA-D20</b>	●	B				
Modular	R	<b>GYHR3225P00-M25R</b>	●	<b>GYM25RA-D20</b>	●	F				
	L	<b>GYHL3225P00-M25L</b>	●	<b>GYM25LA-D20</b>	●	F				
Modular	R	<b>GYHR3232P00-M25R</b>	●	<b>GYM25RA-D20</b>	●	F				
	L	<b>GYHL3232P00-M25L</b>	●	<b>GYM25LA-D20</b>	●	F				

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Max. Cut Off Diameter

\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

\*2 The maximum cut off diameter D<sub>1</sub> varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

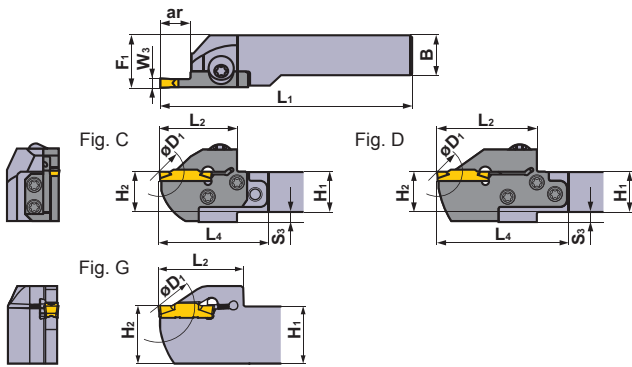
\*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub> and F<sub>1</sub> values may vary.

\*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

● : Inventory maintained in Japan.



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



Right hand tool holder shown.

### SPARE PARTS

Holder Number		5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYQR/L	HSC05030 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHR/L			TS55 (Clamp Torque : 5.0N·m)

Dimensions (mm) *3									Cutting Mode	
H1	B	L1	L2	L4	H2	F1	S3		Clockwise	Anticlockwise
16	16	104	28	44	16	20	4	<b>R</b>		
16	16	104	28	44	16	20	4			
20	20	125	36	—	20	20.15	—			
20	20	125	36	—	20	20.15	—			
20	20	119	28	43	20	23	—			
20	20	119	28	43	20	23	—			
20	20	117	31	52	20	26	5			
20	20	117	31	52	20	26	5			
25	25	150	36	—	25	25.15	—			
25	25	150	36	—	25	25.15	—			
25	25	142	31	49	25	28	—			
25	25	142	31	49	25	28	—			
32	25	162	31	49	32	28	—			
32	25	162	31	49	32	28	—			
32	32	162	31	49	32	35	—			
32	32	162	31	49	32	35	—			
16	16	110	34	50	16	20	4			
16	16	110	34	50	16	20	4			
20	20	125	34	49	20	23	—			
20	20	125	34	49	20	23	—			
20	20	125	39	60	20	26	5			
20	20	125	39	60	20	26	5			
25	25	150	39	57	25	28	—			
25	25	150	39	57	25	28	—			
32	25	170	39	57	32	28	—			
32	25	170	39	57	32	28	—			
32	32	170	39	57	32	35	—			
32	32	170	39	57	32	35	—			
16	16	116	40	56	16	20	4			
16	16	116	40	56	16	20	4			
20	20	125	39	—	20	20.1	—			
20	20	125	39	—	20	20.1	—			
20	20	131	40	55	20	23	—			
20	20	131	40	55	20	23	—			
20	20	131	45	66	20	26	5			
20	20	131	45	66	20	26	5			
25	25	150	41	—	25	25.1	—			
25	25	150	41	—	25	25.1	—			
25	25	156	45	63	25	28	—			
25	25	156	45	63	25	28	—			
32	25	176	45	63	32	28	—			
32	25	176	45	63	32	28	—			
32	32	176	45	63	32	35	—			
32	32	176	45	63	32	35	—			

### Select an Insert

Seat Size	Insert Number
D	GY000200/0224D0000-Breaker

For Grooving/Cutting off > P9, P10						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		W3	Neutral	Neutral	Neutral	Hand
D	2.00mm	●	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
D	2.00mm	●	●	●	●
	2.24mm	●			

● : Gauge insert shown dimensions

EXTERNAL GROOVING

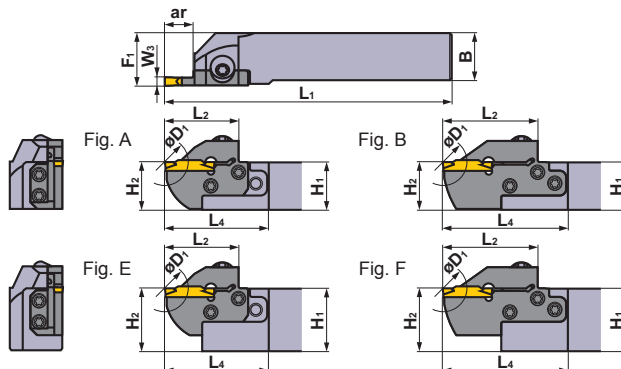
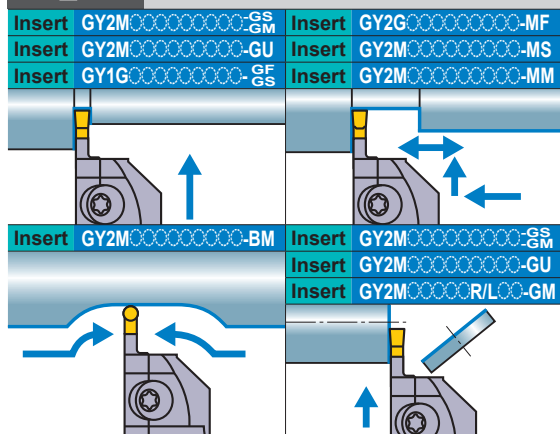
# GY SERIES (EXTERNAL GROOVING)

## 1

### 00° type holder

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

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



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	ar (mm)	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-E06	●	C
				Modular	L	GYHL1616J00-M20L	●	GYM20LA-E06	●	C
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-E06	●	A
				Modular	L	GYHL2020K00-M20L	●	GYM20LA-E06	●	A
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-E06	●	C
				Modular	L	GYHL2020K00-M25L	●	GYM25LA-E06	●	C
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-E06	●	A		
		Modular	L	GYHL2525M00-M25L	●	GYM25LA-E06	●	A		
		Modular	R	GYHR3225P00-M25R	●	GYM25RA-E06	●	E		
		Modular	L	GYHL3225P00-M25L	●	GYM25LA-E06	●	E		
		Modular	R	GYHR3232P00-M25R	●	GYM25RA-E06	●	E		
		Modular	L	GYHL3232P00-M25L	●	GYM25LA-E06	●	E		
		Modular	R	GYHR1616J00-M20R	●	GYM20RA-E10	●	C		
		Modular	L	GYHL1616J00-M20L	●	GYM20LA-E10	●	C		
		Modular	R	GYHR2020K00-M20R	●	GYM20RA-E10	●	A		
		Modular	L	GYHL2020K00-M20L	●	GYM20LA-E10	●	A		
		Modular	R	GYHR2020K00-M25R	●	GYM25RA-E12	●	C		
		Modular	L	GYHL2020K00-M25L	●	GYM25LA-E12	●	C		
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-E12	●	A		
		Modular	L	GYHL2525M00-M25L	●	GYM25LA-E12	●	A		
		Modular	R	GYHR3225P00-M25R	●	GYM25RA-E12	●	E		
		Modular	L	GYHL3225P00-M25L	●	GYM25LA-E12	●	E		
		Modular	R	GYHR3232P00-M25R	●	GYM25RA-E12	●	E		
		Modular	L	GYHL3232P00-M25L	●	GYM25LA-E12	●	E		
Modular	R	GYHR1616J00-M20R	●	GYM20RB-E18	●	D				
Modular	L	GYHL1616J00-M20L	●	GYM20LB-E18	●	D				
Modular	R	GYHR2020K00-M20R	●	GYM20RB-E18	●	B				
Modular	L	GYHL2020K00-M20L	●	GYM20LB-E18	●	B				
Modular	R	GYHR2020K00-M25R	●	GYM25RA-E20	●	D				
Modular	L	GYHL2020K00-M25L	●	GYM25LA-E20	●	D				
Modular	R	GYHR2525M00-M25R	●	GYM25RA-E20	●	B				
Modular	L	GYHL2525M00-M25L	●	GYM25LA-E20	●	B				
Modular	R	GYHR3225P00-M25R	●	GYM25RA-E20	●	F				
Modular	L	GYHL3225P00-M25L	●	GYM25LA-E20	●	F				
Modular	R	GYHR3232P00-M25R	●	GYM25RA-E20	●	F				
Modular	L	GYHL3232P00-M25L	●	GYM25LA-E20	●	F				

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Max. Cut Off Diameter

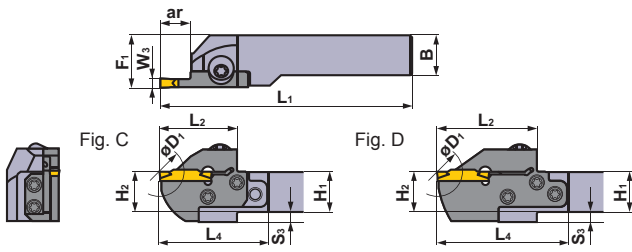
\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

\*2 The maximum cut off diameter D<sub>1</sub> varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

\*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub> and F<sub>1</sub> values may vary.

\*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

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



Right hand tool holder shown.

### SPARE PARTS

Holder Number		5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYQR/L	HSC05030 (Clamp Torque : 7.0N·m)	—	①HKY40R
GYHR/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHR/L			TS55 (Clamp Torque : 5.0N·m)

Dimensions (mm) *3									Cutting Mode	
H1	B	L1	L2	L4	H2	F1	S3		Clockwise	Anticlockwise
16	16	104	28	44	16	20	4	<b>R</b>		
16	16	104	28	44	16	20	4			
20	20	119	28	43	20	23	—			
20	20	119	28	43	20	23	—			
20	20	117	31	52	20	26	5			
20	20	117	31	52	20	26	5			
25	25	142	31	49	25	28	—			
25	25	142	31	49	25	28	—			
32	25	162	31	49	32	28	—			
32	25	162	31	49	32	28	—			
32	32	162	31	49	32	35	—	<b>L</b>		
32	32	162	31	49	32	35	—			
16	16	110	34	50	16	20	4			
16	16	110	34	50	16	20	4			
20	20	125	34	49	20	23	—			
20	20	125	34	49	20	23	—			
20	20	125	39	60	20	26	5			
20	20	125	39	60	20	26	5			
25	25	150	39	57	25	28	—			
25	25	150	39	57	25	28	—			
32	25	170	39	57	32	28	—			
32	25	170	39	57	32	28	—			
32	32	170	39	57	32	35	—			
32	32	170	39	57	32	35	—			
16	16	116	40	56	16	20	4			
16	16	116	40	56	16	20	4			
20	20	131	40	55	20	23	—			
20	20	131	40	55	20	23	—			
20	20	131	45	66	20	26	5			
20	20	131	45	66	20	26	5			
25	25	156	45	63	25	28	—			
25	25	156	45	63	25	28	—			
32	25	176	45	63	32	28	—			
32	25	176	45	63	32	28	—			
32	32	176	45	63	32	35	—			
32	32	176	45	63	32	35	—			

### Select an Insert

Seat Size	Insert Number
E	GY00239/0250/0274E-Breaker

For Grooving/Cutting off > P9, P10						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
E	2.39mm	●	●	●	●	●
	2.50mm	●	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
E	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			

● : Gauge insert shown dimensions

EXTERNAL GROOVING

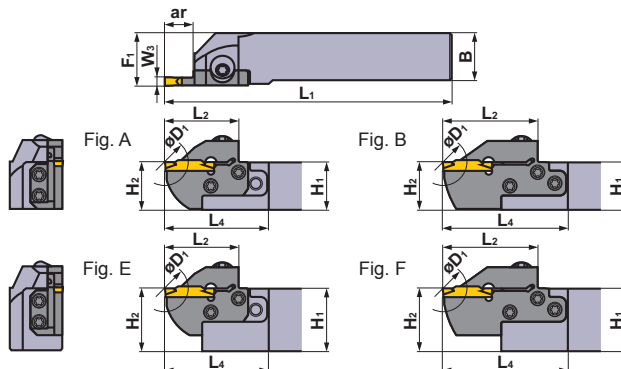
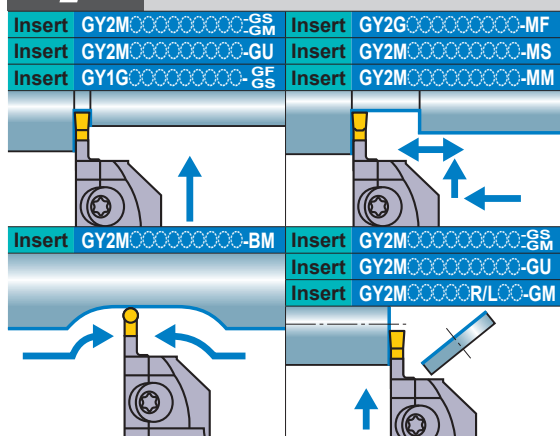
# GY SERIES (EXTERNAL GROOVING)

## 1

### 00° type holder

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

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



Right hand tool holder shown.

EXTERNAL GROOVING

Seat Size	W <sub>3</sub> (mm)	ar (mm)	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	6	12	Modular	R	<b>GYHR1616J00-M20R</b>	●	<b>GYM20RA-F06</b>	●	C
					L	<b>GYHL1616J00-M20L</b>	●	<b>GYM20LA-F06</b>	●	C
				Mono Block	R	<b>GYQR2020K00-F06</b>	●	—	—	G
					L	<b>GYQL2020K00-F06</b>	●	—	—	G
				Modular	R	<b>GYHR2020K00-M20R</b>	●	<b>GYM20RA-F06</b>	●	A
					L	<b>GYHL2020K00-M20L</b>	●	<b>GYM20LA-F06</b>	●	A
				Modular	R	<b>GYHR2020K00-M25R</b>	●	<b>GYM25RA-F06</b>	●	C
					L	<b>GYHL2020K00-M25L</b>	●	<b>GYM25LA-F06</b>	●	C
				Mono Block	R	<b>GYQR2525M00-F06</b>	●	—	—	G
					L	<b>GYQL2525M00-F06</b>	●	—	—	G
				Modular	R	<b>GYHR2525M00-M25R</b>	●	<b>GYM25RA-F06</b>	●	A
					L	<b>GYHL2525M00-M25L</b>	●	<b>GYM25LA-F06</b>	●	A
		Modular	R	<b>GYHR3225P00-M25R</b>	●	<b>GYM25RA-F06</b>	●	E		
			L	<b>GYHL3225P00-M25L</b>	●	<b>GYM25LA-F06</b>	●	E		
		Modular	R	<b>GYHR3232P00-M25R</b>	●	<b>GYM25RA-F06</b>	●	E		
			L	<b>GYHL3232P00-M25L</b>	●	<b>GYM25LA-F06</b>	●	E		
		10	20	Modular	R	<b>GYHR1616J00-M20R</b>	●	<b>GYM20RA-F10</b>	●	C
					L	<b>GYHL1616J00-M20L</b>	●	<b>GYM20LA-F10</b>	●	C
				Modular	R	<b>GYHR2020K00-M20R</b>	●	<b>GYM20RA-F10</b>	●	A
					L	<b>GYHL2020K00-M20L</b>	●	<b>GYM20LA-F10</b>	●	A
				Modular	R	<b>GYHR2020K00-M25R</b>	●	<b>GYM25RA-F12</b>	●	C
					L	<b>GYHL2020K00-M25L</b>	●	<b>GYM25LA-F12</b>	●	C
		12	24	Modular	R	<b>GYHR2525M00-M25R</b>	●	<b>GYM25RA-F12</b>	●	A
					L	<b>GYHL2525M00-M25L</b>	●	<b>GYM25LA-F12</b>	●	A
Modular	R			<b>GYHR3225P00-M25R</b>	●	<b>GYM25RA-F12</b>	●	E		
	L			<b>GYHL3225P00-M25L</b>	●	<b>GYM25LA-F12</b>	●	E		
18 *4	36	Modular	R	<b>GYHR2020K00-M25R</b>	●	<b>GYM25RA-F12</b>	●	E		
			L	<b>GYHL2020K00-M25L</b>	●	<b>GYM25LA-F12</b>	●	E		
		Modular	R	<b>GYHR3232P00-M25R</b>	●	<b>GYM25RA-F12</b>	●	E		
			L	<b>GYHL3232P00-M25L</b>	●	<b>GYM25LA-F12</b>	●	E		
20 *1	40 *2	Modular	R	<b>GYHR1616J00-M20R</b>	●	<b>GYM20RB-F18</b>	●	D		
			L	<b>GYHL1616J00-M20L</b>	●	<b>GYM20LB-F18</b>	●	D		
		Mono Block	R	<b>GYQR2020K00-F18</b>	●	—	—	G		
			L	<b>GYQL2020K00-F18</b>	●	—	—	G		
		Modular	R	<b>GYHR2020K00-M20R</b>	●	<b>GYM20RB-F18</b>	●	B		
			L	<b>GYHL2020K00-M20L</b>	●	<b>GYM20LB-F18</b>	●	B		
		Modular	R	<b>GYHR2020K00-M25R</b>	●	<b>GYM25RA-F20</b>	●	D		
			L	<b>GYHL2020K00-M25L</b>	●	<b>GYM25LA-F20</b>	●	D		
Mono Block	R	<b>GYQR2525M00-F20</b>	●	—	—	G				
	L	<b>GYQL2525M00-F20</b>	●	—	—	G				
	Modular	R	<b>GYHR2525M00-M25R</b>	●	<b>GYM25RA-F20</b>	●	B			
		L	<b>GYHL2525M00-M25L</b>	●	<b>GYM25LA-F20</b>	●	B			
Modular	R	<b>GYHR3225P00-M25R</b>	●	<b>GYM25RA-F20</b>	●	F				
	L	<b>GYHL3225P00-M25L</b>	●	<b>GYM25LA-F20</b>	●	F				
Modular	R	<b>GYHR3232P00-M25R</b>	●	<b>GYM25RA-F20</b>	●	F				
	L	<b>GYHL3232P00-M25L</b>	●	<b>GYM25LA-F20</b>	●	F				

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Max. Cut Off Diameter

\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

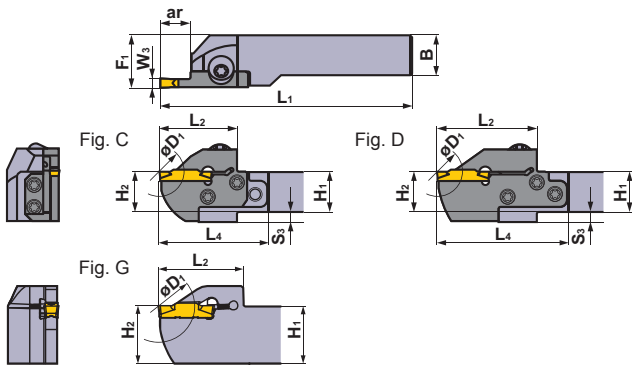
\*2 The maximum cut off diameter D<sub>1</sub> varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

\*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub> and F<sub>1</sub> values may vary.

\*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

● : Inventory maintained in Japan.

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



Right hand tool holder shown.

### SPARE PARTS

Holder Number		5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYQR/L	HSC05030 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHR/L			TS55 (Clamp Torque : 5.0N·m)

Dimensions (mm) *3									Cutting Mode	
H1	B	L1	L2	L4	H2	F1	S3		Clockwise	Anticlockwise
16	16	104	28	44	16	20	4	<b>R</b>		
16	16	104	28	44	16	20	4			
20	20	125	36	—	20	20.3	—			
20	20	125	36	—	20	20.3	—			
20	20	119	28	43	20	23	—			
20	20	119	28	43	20	23	—			
20	20	117	31	52	20	26	5			
20	20	117	31	52	20	26	5			
25	25	150	36	—	25	25.3	—			
25	25	150	36	—	25	25.3	—			
25	25	142	31	49	25	28	—			
25	25	142	31	49	25	28	—			
32	25	162	31	49	32	28	—			
32	25	162	31	49	32	28	—			
32	32	162	31	49	32	35	—			
32	32	162	31	49	32	35	—			
16	16	110	34	50	16	20	4			
16	16	110	34	50	16	20	4			
20	20	125	34	49	20	23	—			
20	20	125	34	49	20	23	—			
20	20	125	39	60	20	26	5			
20	20	125	39	60	20	26	5			
25	25	150	39	57	25	28	—			
25	25	150	39	57	25	28	—			
32	25	170	39	57	32	28	—			
32	25	170	39	57	32	28	—			
32	32	170	39	57	32	35	—			
32	32	170	39	57	32	35	—			
16	16	116	40	56	16	20	4			
16	16	116	40	56	16	20	4			
20	20	125	39	—	20	20.25	—			
20	20	125	39	—	20	20.25	—			
20	20	131	40	55	20	23	—			
20	20	131	40	55	20	23	—			
20	20	131	45	66	20	26	5			
20	20	131	45	66	20	26	5			
25	25	150	41	—	25	25.25	—			
25	25	150	41	—	25	25.25	—			
25	25	156	45	63	25	28	—			
25	25	156	45	63	25	28	—			
32	25	176	45	63	32	28	—			
32	25	176	45	63	32	28	—			
32	32	176	45	63	32	35	—			
32	32	176	45	63	32	35	—			

### Select an Insert

Seat Size	Insert Number
F	GY00239/0250/0274E-Breaker

For Grooving/Cutting off > P9, P10						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
F	3.00mm	●	●	●	●	●
	3.18mm	●	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
F	3.00mm	●	●	●	●
	Re 0.2	●	●	●	●
	Re 0.4	●	●	●	●
	Re 0.8			●	●
	3.18mm				●
	Re 0.2	●			
Re 0.4	●				
3.24mm	●				

● : Gauge insert shown dimensions

EXTERNAL GROOVING

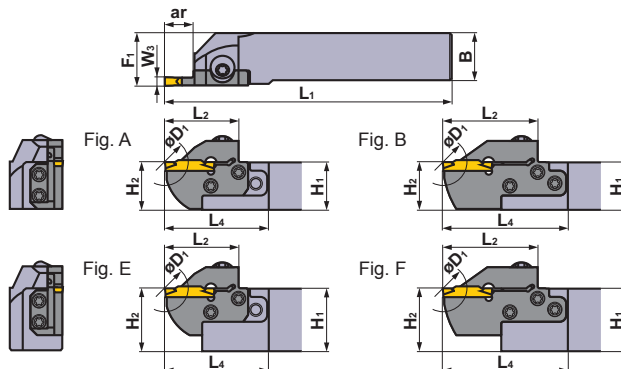
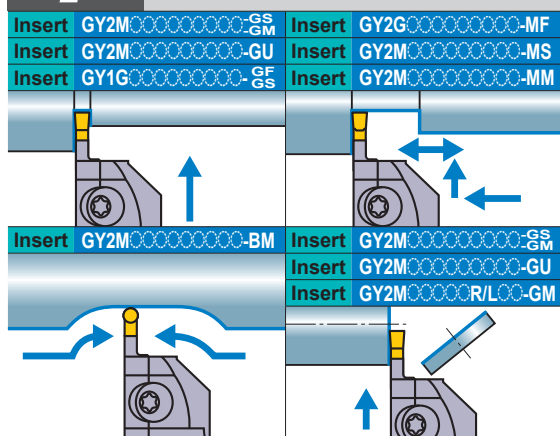
# GY SERIES (EXTERNAL GROOVING)

## 1

### 00° type holder

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

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



Right hand tool holder shown.

Seat Size	W3 (mm)	ar (mm)	D1 (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	8	16	NEW Mono Block	R	GYQR2020K00-G08	●	—	—	G
					L	GYQL2020K00-G08	●	—	—	G
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-G08	●	C
					L	GYHL2020K00-M25L	●	GYM25LA-G08	●	C
				NEW Mono Block	R	GYQR2525M00-G08	●	—	—	G
					L	GYQL2525M00-G08	●	—	—	G
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-G08	●	A
					L	GYHL2525M00-M25L	●	GYM25LA-G08	●	A
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-G08	●	E
					L	GYHL3225P00-M25L	●	GYM25LA-G08	●	E
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-G08	●	E
					L	GYHL3232P00-M25L	●	GYM25LA-G08	●	E
		12	24	Modular	R	GYHR1616J00-M20R	●	GYM20RA-G12	●	C
					L	GYHL1616J00-M20L	●	GYM20LA-G12	●	C
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-G12	●	A
					L	GYHL2020K00-M20L	●	GYM20LA-G12	●	A
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-G14	●	C
					L	GYHL2020K00-M25L	●	GYM25LA-G14	●	C
		14	28	Modular	R	GYHR2525M00-M25R	●	GYM25RA-G14	●	A
					L	GYHL2525M00-M25L	●	GYM25LA-G14	●	A
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-G14	●	E
					L	GYHL3225P00-M25L	●	GYM25LA-G14	●	E
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-G14	●	E
					L	GYHL3232P00-M25L	●	GYM25LA-G14	●	E
25 *1	50 *2	NEW Mono Block	R	GYQR2020K00-G25	●	—	—	H		
			L	GYQL2020K00-G25	●	—	—	H		
		Modular	R	GYHR2020K00-M25R	●	GYM25RA-G25	●	D		
			L	GYHL2020K00-M25L	●	GYM25LA-G25	●	D		
		NEW Mono Block	R	GYQR2525M00-G25	●	—	—	G		
			L	GYQL2525M00-G25	●	—	—	G		
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-G25	●	B		
			L	GYHL2525M00-M25L	●	GYM25LA-G25	●	B		
		Modular	R	GYHR3225P00-M25R	●	GYM25RA-G25	●	F		
			L	GYHL3225P00-M25L	●	GYM25LA-G25	●	F		
Modular	R	GYHR3232P00-M25R	●	GYM25RA-G25	●	F				
	L	GYHL3232P00-M25L	●	GYM25LA-G25	●	F				

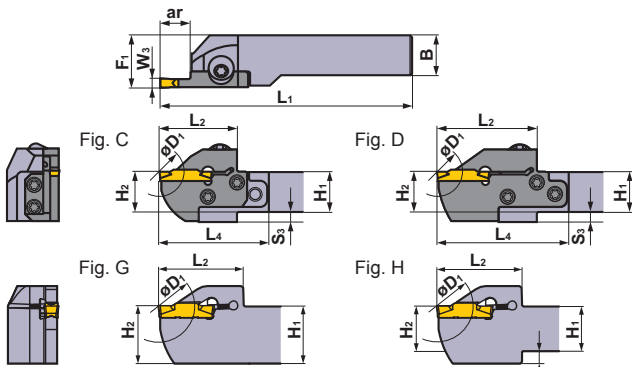
W3 = Insert Width      ar = Max. Groove Depth      D1 = Max. Cut Off Diameter

\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

\*2 The maximum cut off diameter D1 varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

\*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2, L4 and F1 values may vary.

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



Right hand tool holder shown.

### SPARE PARTS

Holder Number		5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYQR/L	HSC05030 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHR/L			TS55 (Clamp Torque : 5.0N·m)

Dimensions (mm) *3									Cutting Mode	
H1	B	L1	L2	L4	H2	F1	S3		Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—	R		
20	20	125	41	—	20	20.35	—			
20	20	119	33	54	20	26	5	R		
20	20	119	33	54	20	26	5			
25	25	150	41	—	25	25.35	—	R		
25	25	150	41	—	25	25.35	—			
25	25	144	33	51	25	28	—	R		
25	25	144	33	51	25	28	—			
32	25	164	33	51	32	28	—	R		
32	25	164	33	51	32	28	—			
32	32	164	33	51	32	35	—	R		
32	32	164	33	51	32	35	—			
16	16	110	34	50	16	20	4	L		
16	16	110	34	50	16	20	4			
20	20	125	34	49	20	23	—	L		
20	20	125	34	49	20	23	—			
20	20	125	39	60	20	26	5	L		
20	20	125	39	60	20	26	5			
25	25	150	39	57	25	28	—	L		
25	25	150	39	57	25	28	—			
32	25	170	39	57	32	28	—	L		
32	25	170	39	57	32	28	—			
32	32	170	39	57	32	35	—	L		
32	32	170	39	57	32	35	—			
20	20	125	46	—	20	20.35	4	L		
20	20	125	46	—	20	20.35	4			
20	20	136	50	71	20	26	5	L		
20	20	136	50	71	20	26	5			
25	25	150	46	—	25	25.35	—	L		
25	25	150	46	—	25	25.35	—			
25	25	161	50	68	25	28	—	L		
25	25	161	50	68	25	28	—			
32	25	181	50	68	32	28	—	L		
32	25	181	50	68	32	28	—			
32	32	181	50	68	32	35	—	L		
32	32	181	50	68	32	35	—			

### Select an Insert

Seat Size	Insert Number
G	GY00239/0250/0274E-Breaker

For Grooving/Cutting off > P9, P10						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		W3	Neutral	Neutral	Neutral	Hand
G	4.00mm	●	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
G	4.00mm				●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8	●		●	
	4.24mm	●			

● : Gauge insert shown dimensions

EXTERNAL GROOVING

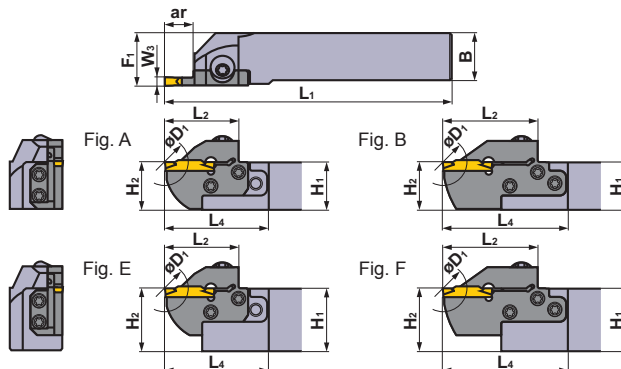
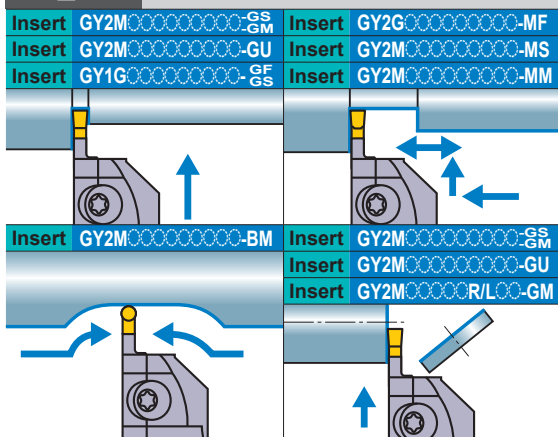
# GY SERIES (EXTERNAL GROOVING)

## 1

### 00° type holder

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

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



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	ar (mm)	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	8	16	NEW Mono Block	R	<b>GYQR2020K00-H08</b>	●	—	—	G
					L	<b>GYQL2020K00-H08</b>	●	—	—	G
				Modular	R	<b>GYHR2020K00-M25R</b>	●	<b>GYM25RA-H08</b>	●	C
					L	<b>GYHL2020K00-M25L</b>	●	<b>GYM25LA-H08</b>	●	C
				NEW Mono Block	R	<b>GYQR2525M00-H08</b>	●	—	—	G
					L	<b>GYQL2525M00-H08</b>	●	—	—	G
				Modular	R	<b>GYHR2525M00-M25R</b>	●	<b>GYM25RA-H08</b>	●	A
					L	<b>GYHL2525M00-M25L</b>	●	<b>GYM25LA-H08</b>	●	A
				Modular	R	<b>GYHR3225P00-M25R</b>	●	<b>GYM25RA-H08</b>	●	E
					L	<b>GYHL3225P00-M25L</b>	●	<b>GYM25LA-H08</b>	●	E
				Modular	R	<b>GYHR3232P00-M25R</b>	●	<b>GYM25RA-H08</b>	●	E
					L	<b>GYHL3232P00-M25L</b>	●	<b>GYM25LA-H08</b>	●	E
		12	24	Modular	R	<b>GYHR1616J00-M20R</b>	●	<b>GYM20RA-H12</b>	●	C
					L	<b>GYHL1616J00-M20L</b>	●	<b>GYM20LA-H12</b>	●	C
				Modular	R	<b>GYHR2020K00-M20R</b>	●	<b>GYM20RA-H12</b>	●	A
					L	<b>GYHL2020K00-M20L</b>	●	<b>GYM20LA-H12</b>	●	A
				Modular	R	<b>GYHR2020K00-M25R</b>	●	<b>GYM25RA-H14</b>	●	C
					L	<b>GYHL2020K00-M25L</b>	●	<b>GYM25LA-H14</b>	●	C
		14	28	Modular	R	<b>GYHR2525M00-M25R</b>	●	<b>GYM25RA-H14</b>	●	A
					L	<b>GYHL2525M00-M25L</b>	●	<b>GYM25LA-H14</b>	●	A
				Modular	R	<b>GYHR3225P00-M25R</b>	●	<b>GYM25RA-H14</b>	●	E
					L	<b>GYHL3225P00-M25L</b>	●	<b>GYM25LA-H14</b>	●	E
				Modular	R	<b>GYHR3232P00-M25R</b>	●	<b>GYM25RA-H14</b>	●	E
					L	<b>GYHL3232P00-M25L</b>	●	<b>GYM25LA-H14</b>	●	E
25 *1	50 *2	NEW Mono Block	R	<b>GYQR2020K00-H25</b>	●	—	—	H		
			L	<b>GYQL2020K00-H25</b>	●	—	—	H		
		Modular	R	<b>GYHR2020K00-M25R</b>	●	<b>GYM25RA-H25</b>	●	D		
			L	<b>GYHL2020K00-M25L</b>	●	<b>GYM25LA-H25</b>	●	D		
		NEW Mono Block	R	<b>GYQR2525M00-H25</b>	●	—	—	G		
			L	<b>GYQL2525M00-H25</b>	●	—	—	G		
		Modular	R	<b>GYHR2525M00-M25R</b>	●	<b>GYM25RA-H25</b>	●	B		
			L	<b>GYHL2525M00-M25L</b>	●	<b>GYM25LA-H25</b>	●	B		
		Modular	R	<b>GYHR3225P00-M25R</b>	●	<b>GYM25RA-H25</b>	●	F		
			L	<b>GYHL3225P00-M25L</b>	●	<b>GYM25LA-H25</b>	●	F		
Modular	R	<b>GYHR3232P00-M25R</b>	●	<b>GYM25RA-H25</b>	●	F				
	L	<b>GYHL3232P00-M25L</b>	●	<b>GYM25LA-H25</b>	●	F				

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Max. Cut Off Diameter

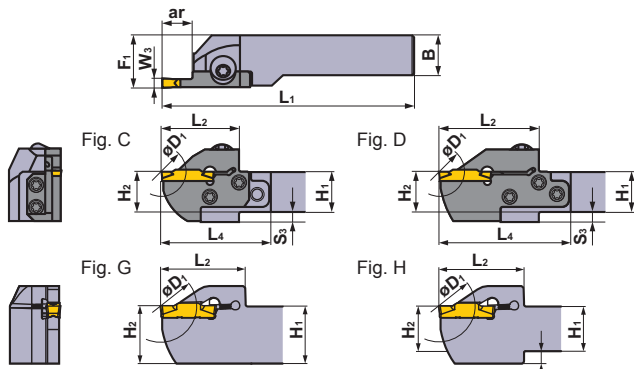
\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

\*2 The maximum cut off diameter D<sub>1</sub> varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

\*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub> and F<sub>1</sub> values may vary.



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



Right hand tool holder shown.

### SPARE PARTS

Holder Number		5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYQR/L	HSC05030 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYHR/L			TS55 (Clamp Torque : 5.0N·m)

Dimensions (mm) *3									Cutting Mode	
H1	B	L1	L2	L4	H2	F1	S3		Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—	R		
20	20	125	41	—	20	20.35	—			
20	20	119	33	54	20	26	5			
20	20	119	33	54	20	26	5			
25	25	150	41	—	25	25.35	—			
25	25	150	41	—	25	25.35	—			
25	25	144	33	51	25	28	—			
25	25	144	33	51	25	28	—			
32	25	164	33	51	32	28	—			
32	25	164	33	51	32	28	—			
32	32	164	33	51	32	35	—			
32	32	164	33	51	32	35	—			
16	16	110	34	50	16	20	4			
16	16	110	34	50	16	20	4			
20	20	125	34	49	20	23	—			
20	20	125	34	49	20	23	—			
20	20	125	39	60	20	26	5			
20	20	125	39	60	20	26	5			
25	25	150	39	57	25	28	—			
25	25	150	39	57	25	28	—			
32	25	170	39	57	32	28	—			
32	25	170	39	57	32	28	—			
32	32	170	39	57	32	35	—			
32	32	170	39	57	32	35	—			
20	20	125	46	—	20	20.35	4			
20	20	125	46	—	20	20.35	4			
20	20	136	50	71	20	26	5			
20	20	136	50	71	20	26	5			
25	25	150	46	—	25	25.35	—			
25	25	150	46	—	25	25.35	—			
25	25	161	50	68	25	28	—			
25	25	161	50	68	25	28	—			
32	25	181	50	68	32	28	—			
32	25	181	50	68	32	28	—			
32	32	181	50	68	32	35	—			
32	32	181	50	68	32	35	—			

### Select an Insert

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

For Grooving/Cutting off > P9, P10						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		W3	Neutral	Neutral	Neutral	Hand
H	4.75mm	●	●	●	●	●
	5.00mm	●	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
H	4.75mm				●
	Re 0.2	●			
	Re 0.4	●			
	Re 0.8	●			
	5.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
5.24mm	●				

● : Gauge insert shown dimensions

EXTERNAL GROOVING

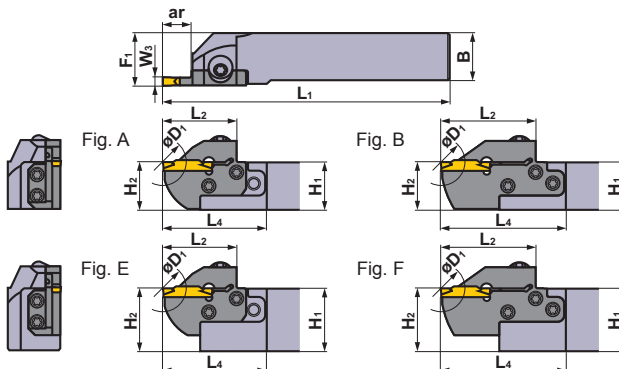
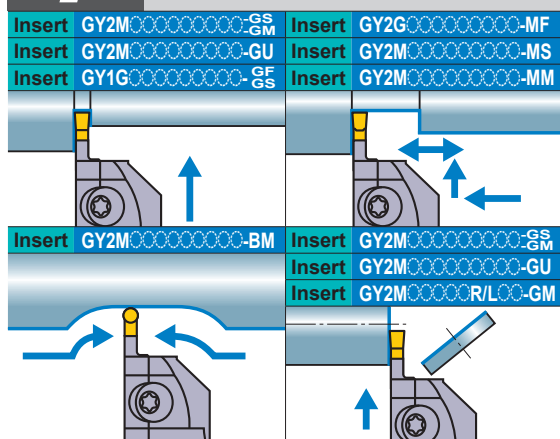
# GY SERIES (EXTERNAL GROOVING)

## 1

### 00° type holder

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

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



Right hand tool holder shown.

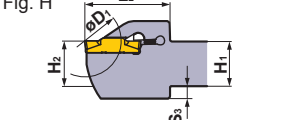
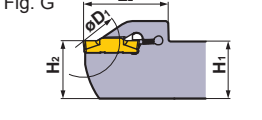
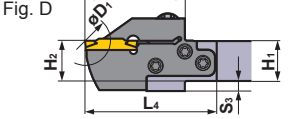
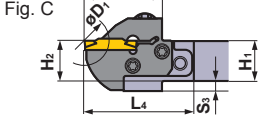
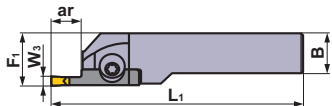
Seat Size	W <sub>3</sub> (mm)	ar (mm)	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
J	6.00 6.31 6.35	8	16	NEW Mono Block	R	GYQR2020K00-J08	●	—	—	G
					L	GYQL2020K00-J08	●	—	—	G
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-J08	●	C
					L	GYHL2020K00-M25L	●	GYM25LA-J08	●	C
				NEW Mono Block	R	GYQR2525M00-J08	●	—	—	G
					L	GYQL2525M00-J08	●	—	—	G
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-J08	●	A		
			L	GYHL2525M00-M25L	●	GYM25LA-J08	●	A		
		Modular	R	GYHR3225P00-M25R	●	GYM25RA-J08	●	E		
			L	GYHL3225P00-M25L	●	GYM25LA-J08	●	E		
		Modular	R	GYHR3232P00-M25R	●	GYM25RA-J08	●	E		
			L	GYHL3232P00-M25L	●	GYM25LA-J08	●	E		
	14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-J14	●	C	
				L	GYHL2020K00-M25L	●	GYM25LA-J14	●	C	
			Modular	R	GYHR2525M00-M25R	●	GYM25RA-J14	●	A	
				L	GYHL2525M00-M25L	●	GYM25LA-J14	●	A	
			Modular	R	GYHR3225P00-M25R	●	GYM25RA-J14	●	E	
				L	GYHL3225P00-M25L	●	GYM25LA-J14	●	E	
	Modular	R	GYHR3232P00-M25R	●	GYM25RA-J14	●	E			
		L	GYHL3232P00-M25L	●	GYM25LA-J14	●	E			
25 *1	50 *2	NEW Mono Block	R	GYQR2020K00-J25	●	—	—	H		
			L	GYQL2020K00-J25	●	—	—	H		
		Modular	R	GYHR2020K00-M25R	●	GYM25RA-J25	●	D		
			L	GYHL2020K00-M25L	●	GYM25LA-J25	●	D		
		NEW Mono Block	R	GYQR2525M00-J25	●	—	—	G		
			L	GYQL2525M00-J25	●	—	—	G		
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-J25	●	B		
			L	GYHL2525M00-M25L	●	GYM25LA-J25	●	B		
Modular	R	GYHR3225P00-M25R	●	GYM25RA-J25	●	F				
	L	GYHL3225P00-M25L	●	GYM25LA-J25	●	F				
Modular	R	GYHR3232P00-M25R	●	GYM25RA-J25	●	F				
	L	GYHL3232P00-M25L	●	GYM25LA-J25	●	F				

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Max. Cut Off Diameter

\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

\*2 The maximum cut off diameter D<sub>1</sub> varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

\*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub> and F<sub>1</sub> values may vary.



Right hand tool holder shown.

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

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYQR/L	HSC05030 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D

Dimensions (mm) *3									Cutting Mode	
H1	B	L1	L2	L4	H2	F1	S3		Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—	R		
20	20	125	41	—	20	20.35	—			
20	20	119	33	54	20	26	5	R		
20	20	119	33	54	20	26	5			
25	25	150	41	—	25	25.35	—	R		
25	25	150	41	—	25	25.35	—			
25	25	144	33	51	25	28	—	R		
25	25	144	33	51	25	28	—			
32	25	164	33	51	32	28	—	R		
32	25	164	33	51	32	28	—			
32	32	164	33	51	32	35	—	R		
32	32	164	33	51	32	35	—			
20	20	125	39	60	20	26	5	L		
20	20	125	39	60	20	26	5			
25	25	150	39	57	25	28	—	L		
25	25	150	39	57	25	28	—			
32	25	170	39	57	32	28	—	L		
32	25	170	39	57	32	28	—			
32	32	170	39	57	32	35	—	L		
32	32	170	39	57	32	35	—			
20	20	125	46	—	20	20.35	4	L		
20	20	125	46	—	20	20.35	4			
20	20	136	50	71	20	26	5	L		
20	20	136	50	71	20	26	5			
25	25	150	46	—	25	25.35	—	L		
25	25	150	46	—	25	25.35	—			
25	25	161	50	68	25	28	—	L		
25	25	161	50	68	25	28	—			
32	25	181	50	68	32	28	—	L		
32	25	181	50	68	32	28	—			
32	32	181	50	68	32	35	—	L		
32	32	181	50	68	32	35	—			

Select an Insert

Seat Size	Insert Number
J	GY0600/0631/0635J-Breaker

For Grooving/Cutting off > P9						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
J	6.00mm	●	●	●		
	6.35mm	●	●	●		

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
J	6.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	Re 0.2	●			
	Re 0.8	●			

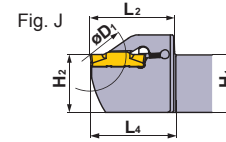
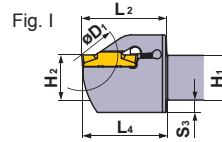
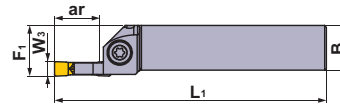
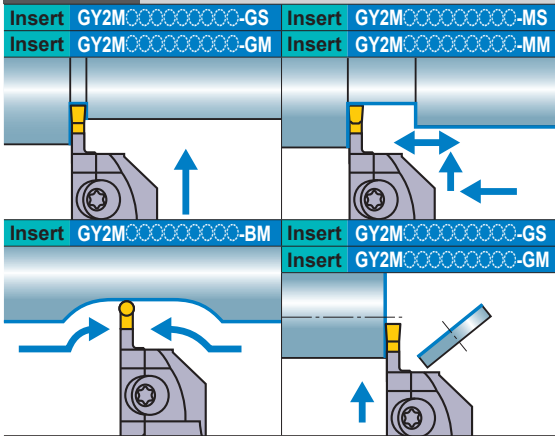
● : Gauge insert shown dimensions

EXTERNAL GROOVING

# GY SERIES (EXTERNAL GROOVING)

## 1

### 00° type holder



Right hand tool holder shown.

EXTERNAL GROOVING

Seat Size	W3 (mm)	ar (mm)	D1 (mm)	Type	Hand (R/L)	Order Number				Fig.		
						Holder	Stock	Modular Blade	Stock			
K	8.00	25 *1	50 *2	Mono Block	R	<b>GYPR2525M00-K25</b>	●	—	—	I		
					L	<b>GYPL2525M00-K25</b>	●	—	—	I		
				Mono Block	R	<b>GYPR3225P00-K25</b>	●	—	—	J		
					L	<b>GYPL3225P00-K25</b>	●	—	—	J		
		Mono Block	R	<b>GYPR3232P00-K25</b>	●	—	—	K				
			L	<b>GYPL3232P00-K25</b>	●	—	—	K				

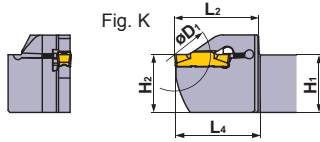
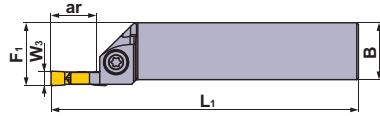
W3 = Insert Width      ar = Max. Groove Depth      D1 = Max. Cut Off Diameter

\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

\*2 The maximum cut off diameter D1 varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

\*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2, L4 and F1 values may vary.

● : Inventory maintained in Japan.



Right hand tool holder shown.

### SPARE PARTS

Holder Number		
	Clamp Screw	Wrench
<b>GYPR/L○○○○○○○○00-K25</b>	GY06013M (Clamp Torque : 6.0N·m)	TKY30R

	Dimensions (mm) *3								Cutting Mode	
	H1	B	L1	L2	L4	H2	F1	S3	Clockwise	Anticlockwise
	25	25	150	47	48	25	28	7	R	
	25	25	150	47	48	25	28	7		
	32	25	170	47	48	32	28	—	L	
	32	25	170	47	48	32	28	—		
	32	32	170	47	48	32	35	—	L	
	32	32	170	47	48	32	35	—		

### Select an Insert

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

For Grooving/Cutting off > P9						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		W3	Neutral	Neutral	Neutral	Hand
K	8.00mm		●	●		

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
K	8.00mm				●
	Re 0.8		●		
	Re 1.2			●	

● : Gauge insert shown dimensions

EXTERNAL GROOVING

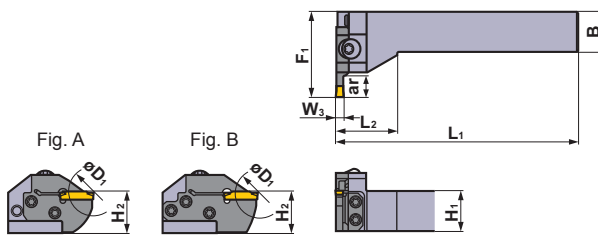
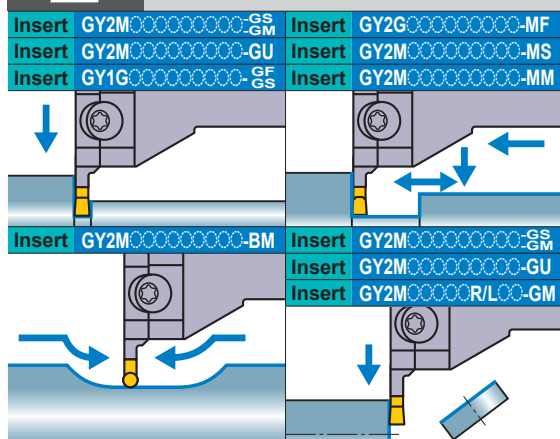
# GY SERIES (EXTERNAL GROOVING)

## 2

### 90° type holder

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

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



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	ar (mm)	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	6	12	Modular	R	<b>GYHR2020K90-M20L</b>	●	<b>GYM20LA-D06</b>	●	A
				L	<b>GYHL2020K90-M20R</b>	●	<b>GYM20RA-D06</b>	●	A	
		10	20	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-D06</b>	●	A
				L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-D06</b>	●	A	
		12	24	Modular	R	<b>GYHR2020K90-M20L</b>	●	<b>GYM20LA-D10</b>	●	A
				L	<b>GYHL2020K90-M20R</b>	●	<b>GYM20RA-D10</b>	●	A	
		18 *4	36	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-D12</b>	●	A
				L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-D12</b>	●	A	
		20 *1	40 *2	Modular	R	<b>GYHR2020K90-M20L</b>	●	<b>GYM20LB-D18</b>	●	B
				L	<b>GYHL2020K90-M20R</b>	●	<b>GYM20RB-D18</b>	●	B	
E	2.39 2.50 2.74	6	12	Modular	R	<b>GYHR2020K90-M20L</b>	●	<b>GYM20LA-E06</b>	●	A
				L	<b>GYHL2020K90-M20R</b>	●	<b>GYM20RA-E06</b>	●	A	
		10	20	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-E06</b>	●	A
				L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-E06</b>	●	A	
		12	24	Modular	R	<b>GYHR2020K90-M20L</b>	●	<b>GYM20LA-E10</b>	●	A
				L	<b>GYHL2020K90-M20R</b>	●	<b>GYM20RA-E10</b>	●	A	
		18 *4	36	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-E12</b>	●	A
				L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-E12</b>	●	A	
		20 *1	40 *2	Modular	R	<b>GYHR2020K90-M20L</b>	●	<b>GYM20LB-E18</b>	●	B
				L	<b>GYHL2020K90-M20R</b>	●	<b>GYM20RB-E18</b>	●	B	
20 *1	40 *2	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-E20</b>	●	B		
		L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-E20</b>	●	B			

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Max. Cut Off Diameter




\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

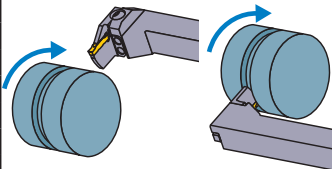
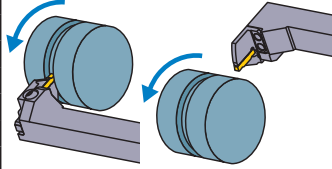
\*2 The maximum cut off diameter D<sub>1</sub> varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

\*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub> and F<sub>1</sub> values may vary.

\*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
<b>GYHR2020K90-M20L</b>	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R
<b>GYHL2020K90-M20R</b>			②TKY15D
<b>GYHR2525M90-M25L</b>		TS55 (Clamp Torque : 5.0N·m)	①TKY30R
<b>GYHL2525M90-M25R</b>			②TKY25D

	Dimensions (mm) *3						Cutting Mode
	H1	B	L1	L2	H2	F1	
	20	20	125	35	20	39	<b>R</b> 
	20	20	125	35	20	39	
	25	25	150	38	25	45	
	25	25	150	38	25	45	
	20	20	125	35	20	45	
	20	20	125	35	20	45	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	20	20	125	35	20	51	
	20	20	125	35	20	51	
	25	25	150	38	25	59	<b>L</b> 
	25	25	150	38	25	59	
	20	20	125	35	20	39	
	20	20	125	35	20	39	
	25	25	150	38	25	45	
	25	25	150	38	25	45	
	20	20	125	35	20	45	
	20	20	125	35	20	45	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	20	20	125	35	20	51	
	20	20	125	35	20	51	
	25	25	150	38	25	59	
	25	25	150	38	25	59	

### Select an Insert

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

For Grooving/Cutting off > P9, P10						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
D	2.00mm	●	●	●	●	●
	2.39mm	●	●	●	●	●
E	2.50mm	●	●	●	●	●
	2.50mm	●	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
D	2.00mm	●	●	●	●
	2.24mm	●			
E	2.39mm	●			
	2.50mm	●	●	●	●
E	2.50mm	●			
	2.74mm	●			

● : Gauge insert shown dimensions

EXTERNAL GROOVING

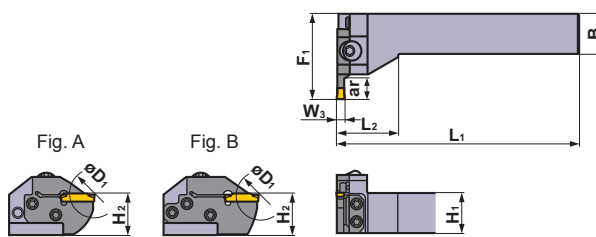
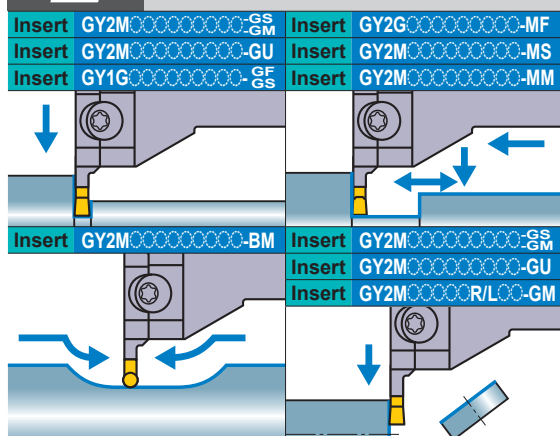
## GY SERIES (EXTERNAL GROOVING)

### 2

### 90° type holder

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

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



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	ar (mm)	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	6	12	Modular	R	<b>GYHR2020K90-M20L</b>	●	<b>GYM20LA-F06</b>	●	A
				Modular	L	<b>GYHL2020K90-M20R</b>	●	<b>GYM20RA-F06</b>	●	A
		10	20	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-F06</b>	●	A
				Modular	L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-F06</b>	●	A
		12	24	Modular	R	<b>GYHR2020K90-M20L</b>	●	<b>GYM20LA-F10</b>	●	A
				Modular	L	<b>GYHL2020K90-M20R</b>	●	<b>GYM20RA-F10</b>	●	A
18 *4	36	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-F12</b>	●	A		
		Modular	L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-F12</b>	●	A		
G	4.00 4.24	18 *4	36	Modular	R	<b>GYHR2020K90-M20L</b>	●	<b>GYM20LB-F18</b>	●	B
				Modular	L	<b>GYHL2020K90-M20R</b>	●	<b>GYM20RB-F18</b>	●	B
		20 *1	40 *2	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-F20</b>	●	B
				Modular	L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-F20</b>	●	B
		8	16	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-G08</b>	●	A
				Modular	L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-G08</b>	●	A
12	24	Modular	R	<b>GYHR2020K90-M20L</b>	●	<b>GYM20LA-G12</b>	●	A		
		Modular	L	<b>GYHL2020K90-M20R</b>	●	<b>GYM20RA-G12</b>	●	A		
14	28	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-G14</b>	●	A		
		Modular	L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-G14</b>	●	A		
25 *1	50 *2	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-G25</b>	●	B		
		Modular	L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-G25</b>	●	B		

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Max. Cut Off Diameter

\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.




\*2 The maximum cut off diameter D<sub>1</sub> varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

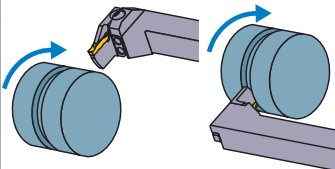
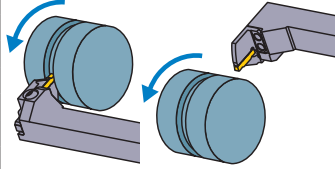
\*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub> and F<sub>1</sub> values may vary.

\*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.



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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
<b>GYHR2020K90-M20L</b>	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R
<b>GYHL2020K90-M20R</b>			②TKY15D
<b>GYHR2525M90-M25L</b>		TS55 (Clamp Torque : 5.0N·m)	①TKY30R
<b>GYHL2525M90-M25R</b>			②TKY25D

	Dimensions (mm) *3						Cutting Mode
	H1	B	L1	L2	H2	F1	
	20	20	125	35	20	39	<b>R</b> 
	20	20	125	35	20	39	
	25	25	150	38	25	45	
	25	25	150	38	25	45	
	20	20	125	35	20	45	
	20	20	125	35	20	45	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	20	20	125	35	20	51	
	20	20	125	35	20	51	
	25	25	150	38	25	59	<b>L</b> 
	25	25	150	38	25	59	
	25	25	150	38	25	47	
	25	25	150	38	25	47	
	20	20	125	35	20	45	
	20	20	125	35	20	45	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	

Select an Insert

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

For Grooving/Cutting off > P9, P10

Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
F	3.00mm	●	●	●	●	●
	3.18mm	●	●	●	●	●
G	4.00mm	●	●	●	●	●

For Multifunctional Grooving > P10, P11

Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
F	3.00mm				●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8			●	
	3.18mm				●
	Re 0.2	●			
G	3.24mm	●			
	4.00mm				●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8	●		●	
G	4.24mm	●			

● : Gauge insert shown dimensions

EXTERNAL GROOVING

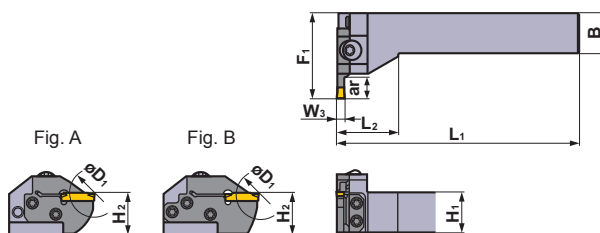
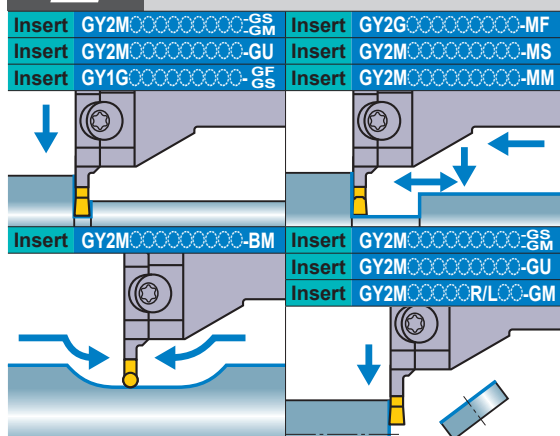
## GY SERIES (EXTERNAL GROOVING)

### 2

### 90° type holder

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

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



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	ar (mm)	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
H	4.75 5.00 5.24	8	16	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-H08</b>	●	A	
					L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-H08</b>	●	A	
		12	24	Modular	R	<b>GYHR2020K90-M20L</b>	●	<b>GYM20LA-H12</b>	●	A	
					L	<b>GYHL2020K90-M20R</b>	●	<b>GYM20RA-H12</b>	●	A	
		14	28	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-H14</b>	●	A	
					L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-H14</b>	●	A	
		25 *1	50 *2	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-H25</b>	●	B	
					L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-H25</b>	●	B	
J	6.00 6.31 6.35	8	16	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-J08</b>	●	A	
					L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-J08</b>	●	A	
		14	28	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-J14</b>	●	A	
					L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-J14</b>	●	A	
		25 *1	50 *2	Modular	R	<b>GYHR2525M90-M25L</b>	●	<b>GYM25LA-J25</b>	●	B	
					L	<b>GYHL2525M90-M25R</b>	●	<b>GYM25RA-J25</b>	●	B	




W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Max. Cut Off Diameter

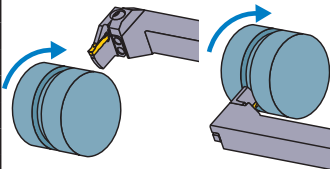
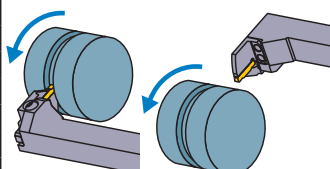
\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

\*2 The maximum cut off diameter D<sub>1</sub> varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

\*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub> and F<sub>1</sub> values may vary.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
<b>GYHR2020K90-M20L</b>	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R
<b>GYHL2020K90-M20R</b>			②TKY15D
<b>GYHR2525M90-M25L</b>		TS55 (Clamp Torque : 5.0N·m)	①TKY30R
<b>GYHL2525M90-M25R</b>			②TKY25D

	Dimensions (mm) *3						Cutting Mode
	H1	B	L1	L2	H2	F1	
	25	25	150	38	25	47	<b>R</b> 
	25	25	150	38	25	47	
	20	20	125	35	20	45	
	20	20	125	35	20	45	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	47	<b>L</b> 
	25	25	150	38	25	47	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	

Select an Insert

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

For Grooving/Cutting off > P9, P10						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
H	4.75mm	●	●	●	●	●
	5.00mm	●	●	●	●	●
J	6.00mm	●	●	●		
	6.35mm	●	●	●		

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
H	4.75mm				●
	Re 0.2	●			
	Re 0.4	●			
	Re 0.8	●			
	5.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
J	5.24mm	●			
	6.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	Re 0.2	●			
Re 0.4	●				
Re 0.8	●				

● : Gauge insert shown dimensions

EXTERNAL GROOVING

# GY SERIES (EXTERNAL RECESSING)

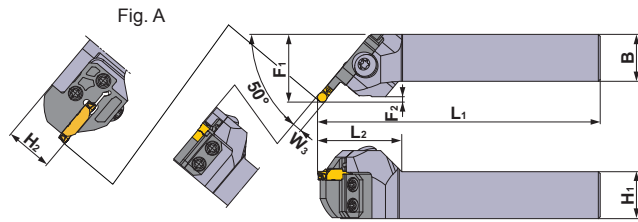
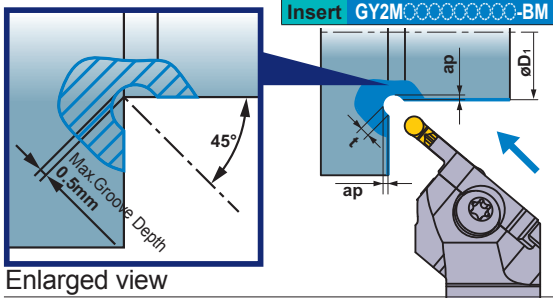
## 3

### 50° type holder

**NEW**

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

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



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	ar (mm)	D <sub>1</sub> (mm)	t (mm)	ap (mm)	Type	Hand (R/L)	Order Number				Fig.
								Holder	Stock	Modular Blade	Stock	
D	2.00		30	1.5	0.646	Modular	R	<b>GYHR2020K50-M20L</b>	●	<b>GYM20LC-D005</b>	●	A
						Modular	L	<b>GYHL2020K50-M20R</b>	●	<b>GYM20RC-D005</b>	●	A
E	2.50		30	1.75	0.72	Modular	R	<b>GYHR2525M50-M25L</b>	●	<b>GYM25LC-D005</b>	●	A
						Modular	L	<b>GYHL2525M50-M25R</b>	●	<b>GYM25RC-D005</b>	●	A
F	3.00 3.18	0.5	30	2	0.793	Modular	R	<b>GYHR2020K50-M20L</b>	●	<b>GYM20LC-E005</b>	●	A
						Modular	L	<b>GYHL2020K50-M20R</b>	●	<b>GYM20RC-E005</b>	●	A
G	4.00		20	2.5	0.939	Modular	R	<b>GYHR2525M50-M25L</b>	●	<b>GYM25LC-E005</b>	●	A
						Modular	L	<b>GYHL2525M50-M25R</b>	●	<b>GYM25RC-E005</b>	●	A
H	4.75 5.00		20	2.88	1.049	Modular	R	<b>GYHR2020K50-M20L</b>	●	<b>GYM20LC-F005</b>	●	A
						Modular	L	<b>GYHL2020K50-M20R</b>	●	<b>GYM20RC-F005</b>	●	A
J	6.00 6.35		20	3.5	1.232	Modular	R	<b>GYHR2525M50-M25L</b>	●	<b>GYM25LC-F005</b>	●	A
						Modular	L	<b>GYHL2525M50-M25R</b>	●	<b>GYM25RC-F005</b>	●	A




W<sub>3</sub> = Insert Width    ar = Max. Groove Depth    D<sub>1</sub> = Min. Cut Diameter    t = Max. Recessing Depth    ap = Dist. from the material surface to the recess

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

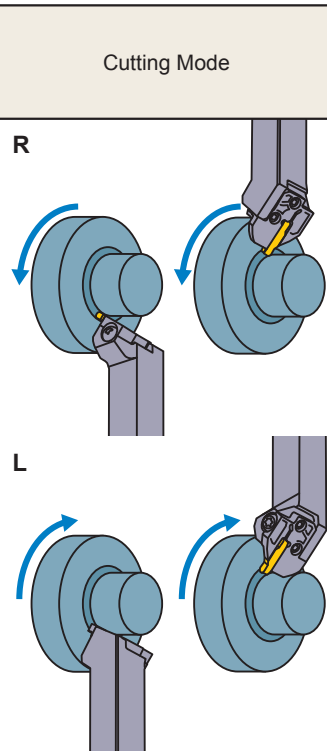
\*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, F<sub>1</sub> and F<sub>2</sub> values may vary.

● : Inventory maintained in Japan.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K50-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY25D
GYHR/L2525M50-M25R/L		TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D

	Dimensions (mm) *2						
	H1	B	L1	L2	H2	F1	F2
	20	20	125	40	20	32	1.6
	20	20	125	40	20	32	1.6
	25	25	150	45	25	35	1.6
	25	25	150	45	25	35	1.6
	20	20	125	40	20	32	1.8
	20	20	125	40	20	32	1.8
	25	25	150	45	25	35	1.8
	25	25	150	45	25	35	1.8
	20	20	125	40	20	32	2.0
	20	20	125	40	20	32	2.0
	25	25	150	45	25	35	2.0
	25	25	150	45	25	35	2.0
	20	20	125	40	20	32	2.4
	20	20	125	40	20	32	2.4
	25	25	150	45	25	35	2.4
	25	25	150	45	25	35	2.4
	20	20	125	40	20	33	2.8
	20	20	125	40	20	33	2.8
	25	25	150	45	25	36	2.8
	25	25	150	45	25	36	2.8
	25	25	150	44	25	36	3.4
	25	25	150	44	25	36	3.4



Select an Insert

Insert Number		
GY2M:○○○○○○○○○N-BM		
For Multifunctional Grooving > P11		
Seat Size	Breaker	BM
	W3	Ball nose
D	2.00mm	●
E	2.50mm	●
F	3.00mm	●
	3.18mm	●
G	4.00mm	●
H	4.75mm	●
	5.00mm	●
J	6.00mm	●
	6.35mm	●

● : Gauge insert shown dimensions

EXTERNAL GROOVING

# GY SERIES (FACE GROOVING)

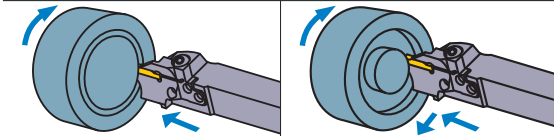
## 4

### 00° type holder

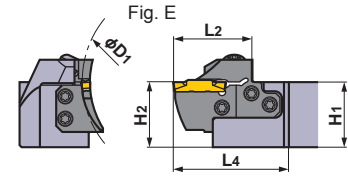
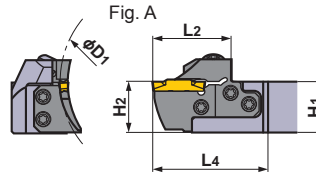
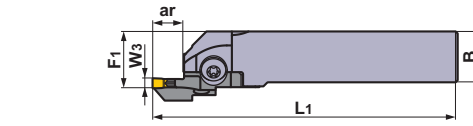
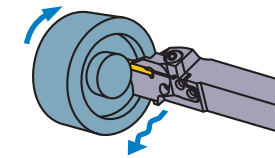
(Note 1) For modular blades and holders, please order separately.

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GS</sup>	Insert	GY2M <sup>MM</sup>



Insert GY2M<sup>BM</sup>



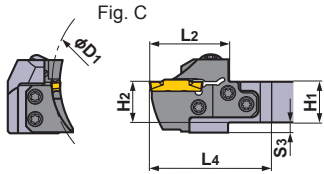
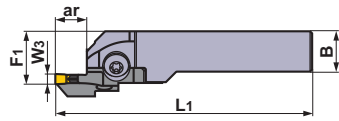
Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
D	2.00	40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-040	●	C
					L	GYHL2020K00-M25L	●	GYM25LD-D12-040	●	C	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-040	●	A
					L	GYHL2525M00-M25L	●	GYM25LD-D12-040	●	A	
		Modular	R		GYHR3225P00-M25R	●	GYM25RD-D12-040	●	E		
		L	GYHL3225P00-M25L		●	GYM25LD-D12-040	●	E			
		Modular	R		GYHR3232P00-M25R	●	GYM25RD-D12-040	●	E		
		L	GYHL3232P00-M25L		●	GYM25LD-D12-040	●	E			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-050	●	C			
		L	GYHL2020K00-M25L	●	GYM25LD-D12-050	●	C				
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-050	●	A			
		L	GYHL2525M00-M25L	●	GYM25LD-D12-050	●	A				
	Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-050	●	E				
	L	GYHL3225P00-M25L	●	GYM25LD-D12-050	●	E					
	Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-050	●	E				
	L	GYHL3232P00-M25L	●	GYM25LD-D12-050	●	E					
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-060	●	C				
	L	GYHL2020K00-M25L	●	GYM25LD-D12-060	●	C					
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-060	●	A				
	L	GYHL2525M00-M25L	●	GYM25LD-D12-060	●	A					
Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-060	●	E					
L	GYHL3225P00-M25L	●	GYM25LD-D12-060	●	E						
Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-060	●	E					
L	GYHL3232P00-M25L	●	GYM25LD-D12-060	●	E						
Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-075	●	C					
L	GYHL2020K00-M25L	●	GYM25LD-D12-075	●	C						
Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-075	●	A					
L	GYHL2525M00-M25L	●	GYM25LD-D12-075	●	A						
Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-075	●	E					
L	GYHL3225P00-M25L	●	GYM25LD-D12-075	●	E						
Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-075	●	E					
L	GYHL3232P00-M25L	●	GYM25LD-D12-075	●	E						

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

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

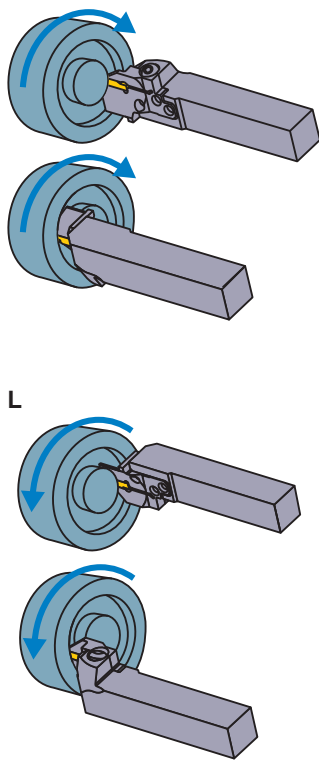


Right hand tool holder shown.

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	



### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
	W3				
D	2.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
	W3				
D	2.00mm	●	●	●	●
	2.24mm	●	●	●	●

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

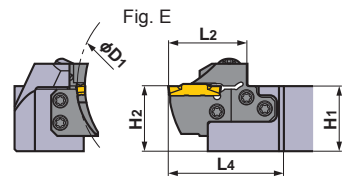
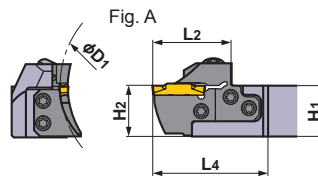
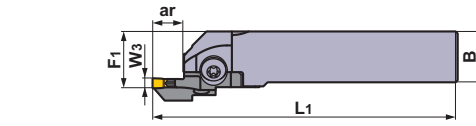
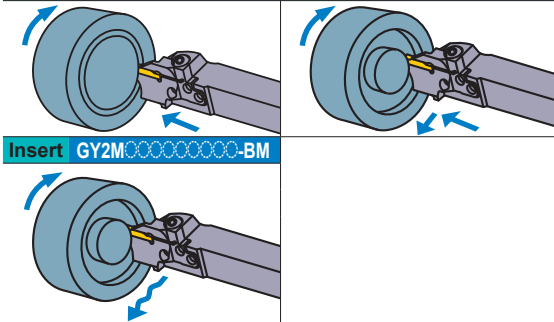
## 4

### 00° type holder

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

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GS</sup>	Insert	GY2M <sup>MM</sup>



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-100	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-100	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-100	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-100	●	A
		Modular	R		GYHR3225P00-M25R	●	GYM25RD-D12-100	●	E		
		Modular	L		GYHL3225P00-M25L	●	GYM25LD-D12-100	●	E		
		Modular	R		GYHR3232P00-M25R	●	GYM25RD-D12-100	●	E		
		Modular	L		GYHL3232P00-M25L	●	GYM25LD-D12-100	●	E		
	135	200	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-135	●	C	
				Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-135	●	C	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-135	●	A	
				Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-135	●	A	
180	250	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-135	●	E		
			Modular	L	GYHL3225P00-M25L	●	GYM25LD-D12-135	●	E		
			Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-135	●	E		
			Modular	L	GYHL3232P00-M25L	●	GYM25LD-D12-135	●	E		
180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-180	●	C		
			Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-180	●	C		
			Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-180	●	A		
			Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-180	●	A		
180	250	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-180	●	E		
			Modular	L	GYHL3225P00-M25L	●	GYM25LD-D12-180	●	E		
			Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-180	●	E		
			Modular	L	GYHL3232P00-M25L	●	GYM25LD-D12-180	●	E		

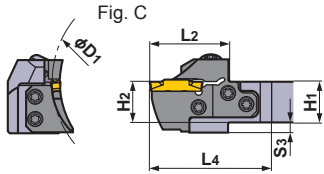
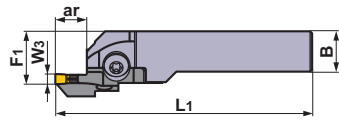
W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

● : Inventory maintained in Japan.



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

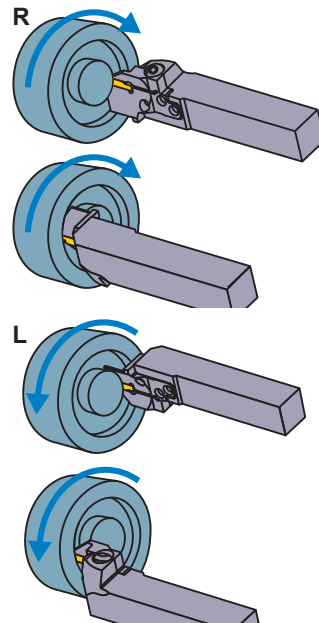


Right hand tool holder shown.

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	



### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
	W3				
D	2.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
	W3				
D	2.00mm	●	●	●	●
	2.24mm	●	●	●	●

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

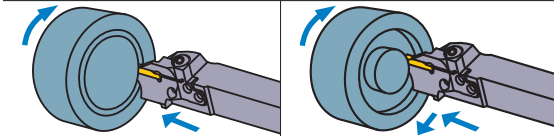
## 4

### 00° type holder

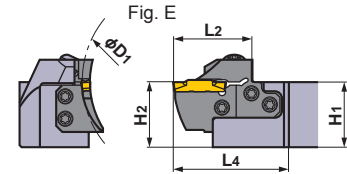
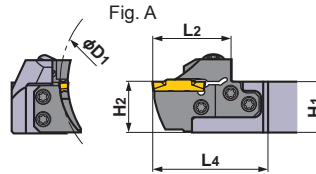
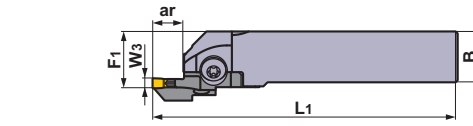
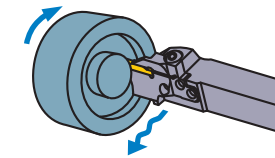
(Note 1) For modular blades and holders, please order separately.

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GS</sup>	Insert	GY2M <sup>MM</sup>



Insert GY2M<sup>BM</sup>



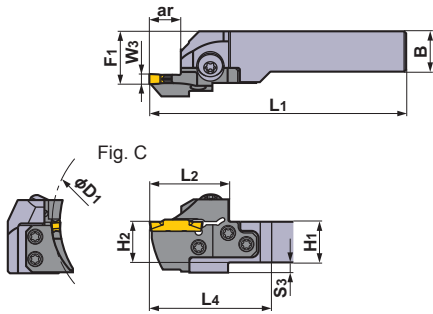
Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-040	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-040	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-040	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-040	●	A
		Modular	R		GYHR3225P00-M25R	●	GYM25RD-E12-040	●	E		
		Modular	L		GYHL3225P00-M25L	●	GYM25LD-E12-040	●	E		
		Modular	R		GYHR3232P00-M25R	●	GYM25RD-E12-040	●	E		
		Modular	L		GYHL3232P00-M25L	●	GYM25LD-E12-040	●	E		
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-050	●	C			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-050	●	C			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-050	●	A			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-050	●	A			
	Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-050	●	E				
	Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-050	●	E				
	Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-050	●	E				
	Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-050	●	E				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-060	●	C				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-060	●	C				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-060	●	A				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-060	●	A				
Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-060	●	E					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-060	●	E					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-060	●	E					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-060	●	E					
Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-075	●	C					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-075	●	C					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-075	●	A					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-075	●	A					
Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-075	●	E					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-075	●	E					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-075	●	E					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-075	●	E					

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

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

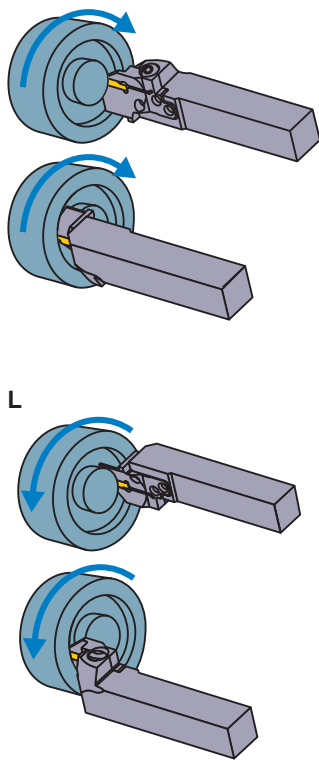


Right hand tool holder shown.

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	



### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		W3			
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
E	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

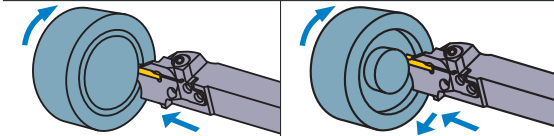
## 4

### 00° type holder

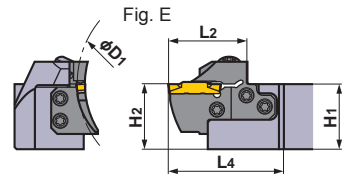
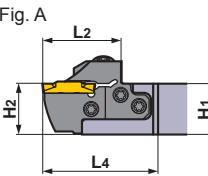
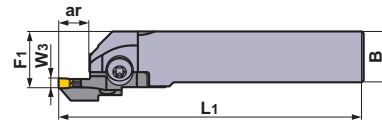
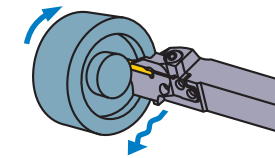
(Note 1) For modular blades and holders, please order separately.

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GS</sup>	Insert	GY2M <sup>MM</sup>



Insert GY2M<sup>BM</sup>



Right hand tool holder shown.

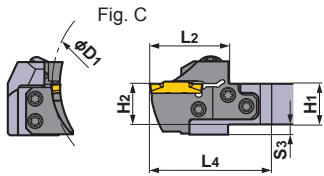
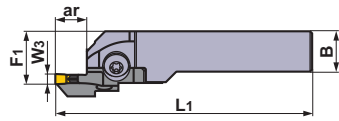
Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-100	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-100	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-100	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-100	●	A
		Modular	R		GYHR3225P00-M25R	●	GYM25RD-E12-100	●	E		
		Modular	L		GYHL3225P00-M25L	●	GYM25LD-E12-100	●	E		
		Modular	R		GYHR3232P00-M25R	●	GYM25RD-E12-100	●	E		
		Modular	L		GYHL3232P00-M25L	●	GYM25LD-E12-100	●	E		
	135	200	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-135	●	C	
				Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-135	●	C	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-135	●	A	
				Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-135	●	A	
	180	250	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-135	●	E	
				Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-135	●	E	
				Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-135	●	E	
				Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-135	●	E	
180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-180	●	C		
			Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-180	●	C		
			Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-180	●	A		
			Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-180	●	A		
180	250	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-180	●	E		
			Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-180	●	E		
			Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-180	●	E		
			Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-180	●	E		

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

● : Inventory maintained in Japan.

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

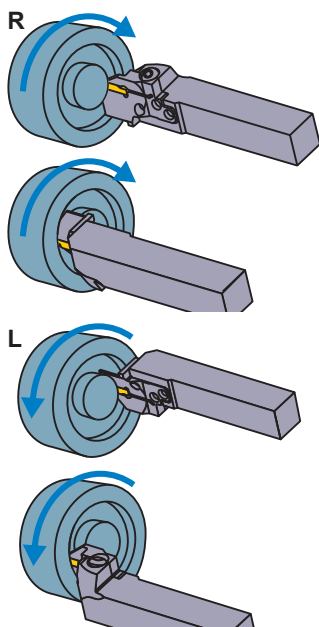


Right hand tool holder shown.

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	



### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		W3			
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
E	2.39mm	●			
	2.50mm	●	●	●	
	2.74mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

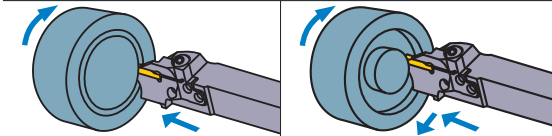
## 4

### 00° type holder

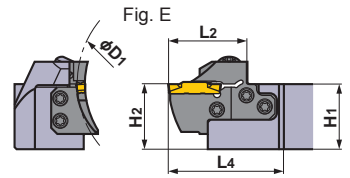
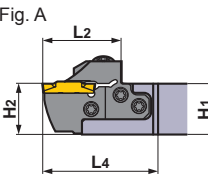
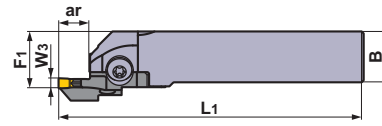
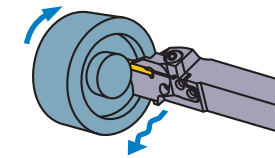
(Note 1) For modular blades and holders, please order separately.

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GS</sup>	Insert	GY2M <sup>MM</sup>



Insert GY2M<sup>BM</sup>



Right hand tool holder shown.

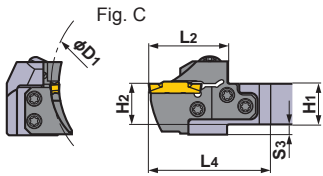
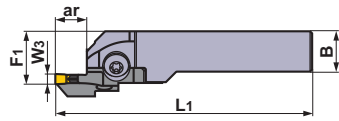
Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	35	40	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-035	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-035	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-035	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-035	●	A
		Modular	R		GYHR3225P00-M25R	●	GYM25RD-F12-035	●	E		
		Modular	L		GYHL3225P00-M25L	●	GYM25LD-F12-035	●	E		
		Modular	R		GYHR3232P00-M25R	●	GYM25RD-F12-035	●	E		
		Modular	L		GYHL3232P00-M25L	●	GYM25LD-F12-035	●	E		
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-040	●	C			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-040	●	C			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-040	●	A			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-040	●	A			
	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-040	●	E				
	Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-040	●	E				
	Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-040	●	E				
	Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-040	●	E				
Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-050	●	C					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-050	●	C					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-050	●	A					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-050	●	A					
Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-050	●	E					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-050	●	E					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-050	●	E					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-050	●	E					

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

● : Inventory maintained in Japan.

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

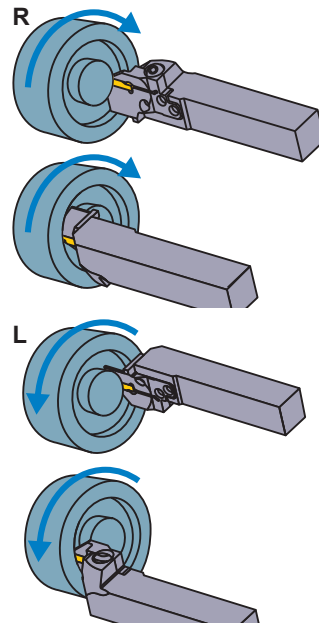


Right hand tool holder shown.

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	



### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		F	W3	●	●
	3.00mm	●	●	●	●
	3.18mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		F	W3		
	3.00mm	●	●	●	●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8			●	
	3.18mm				●
	Re 0.2	●			
	Re 0.4	●			
	3.24mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

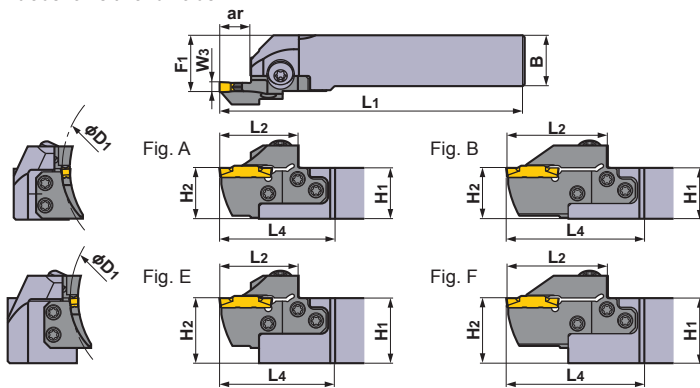
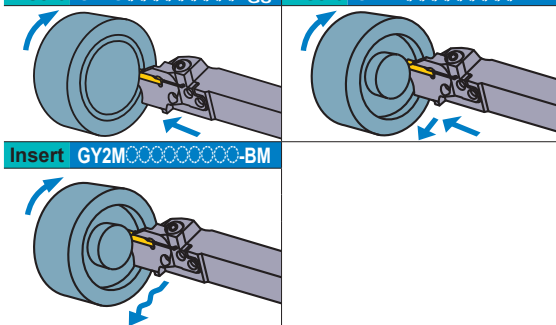
## 4

### 00° type holder

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

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GS</sup>	Insert	GY2M <sup>MM</sup>



Right hand tool holder shown.

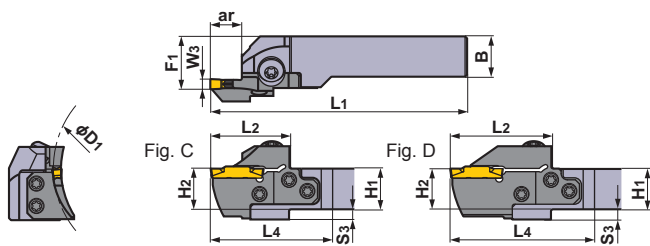
Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	60	75	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-060	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-060	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-060	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-060	●	A
		Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-060	●	E			
		Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-060	●	E			
		Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-060	●	E			
		Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-060	●	E			
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-060	●	D				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-060	●	D				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-060	●	B				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-060	●	B				
	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-060	●	F				
	Modular	L	GYHL3225P00-M25L	●	GYM25LD-F20-060	●	F				
	Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-060	●	F				
	Modular	L	GYHL3232P00-M25L	●	GYM25LD-F20-060	●	F				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-075	●	C				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-075	●	C				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-075	●	A				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-075	●	A				
Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-075	●	E					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-075	●	E					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-075	●	E					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-075	●	E					
Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-075	●	D					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-075	●	D					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-075	●	B					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-075	●	B					
Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-075	●	F					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-F20-075	●	F					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-075	●	F					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-F20-075	●	F					

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.





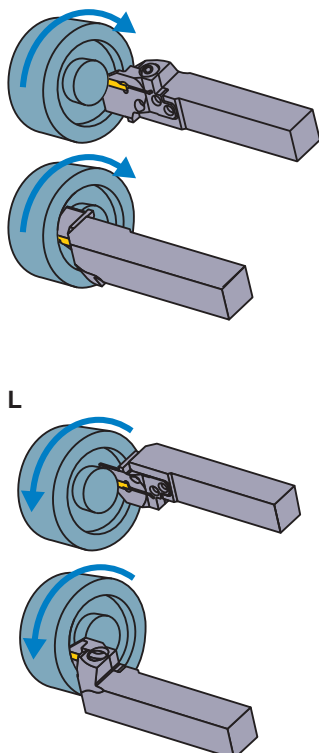
\* Wrench : ① : Clamp Screw, ② : Blade Screw

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	131	45	66	20	26	5	R	
20	20	131	45	66	20	26	5	R	
25	25	156	45	63	25	28	—	R	
25	25	156	45	63	25	28	—	R	
32	25	176	45	63	32	28	—	R	
32	25	176	45	63	32	28	—	R	
32	32	176	45	63	32	35	—	R	
32	32	176	45	63	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	131	45	66	20	26	5	L	
20	20	131	45	66	20	26	5	L	
25	25	156	45	63	25	28	—	L	
25	25	156	45	63	25	28	—	L	
32	25	176	45	63	32	28	—	L	
32	25	176	45	63	32	28	—	L	
32	32	176	45	63	32	35	—	L	
32	32	176	45	63	32	35	—	L	



### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		F	3.00mm	●	●
	3.18mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		F	3.00mm		
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8			●	
	3.18mm				●
	Re 0.2	●			
	Re 0.4	●			
	3.24mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

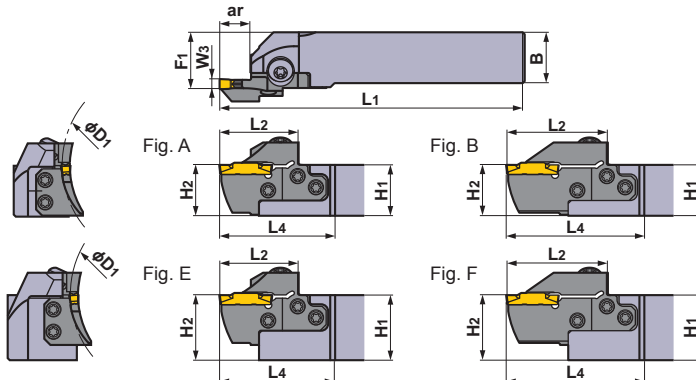
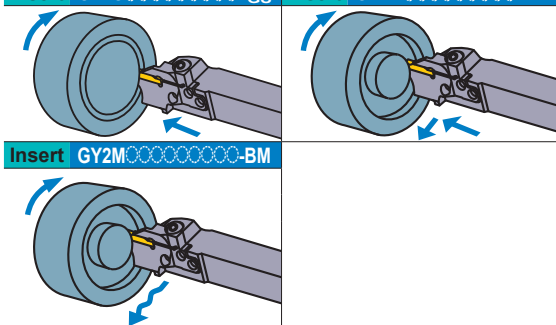
## 4

### 00° type holder

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

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup>	Insert	GY2M <sup>MM</sup>



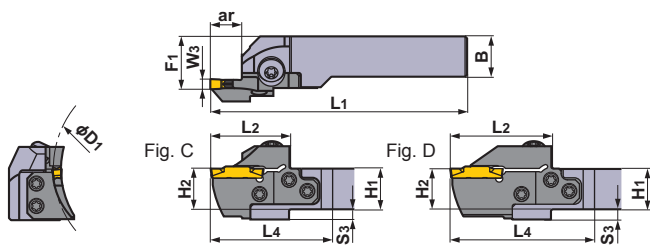
Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-100	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-100	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-100	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-100	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-100	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-100	●	E
		Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-100	●	E			
		Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-100	●	E			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-100	●	D			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-100	●	D			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-100	●	B			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-100	●	B			
	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-100	●	F				
	Modular	L	GYHL3225P00-M25L	●	GYM25LD-F20-100	●	F				
	Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-100	●	F				
	Modular	L	GYHL3232P00-M25L	●	GYM25LD-F20-100	●	F				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-135	●	C				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-135	●	C				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-135	●	A				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-135	●	A				
Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-135	●	E					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-135	●	E					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-135	●	E					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-135	●	E					
Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-135	●	D					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-135	●	D					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-135	●	B					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-135	●	B					
Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-135	●	F					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-F20-135	●	F					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-135	●	F					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-F20-135	●	F					

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

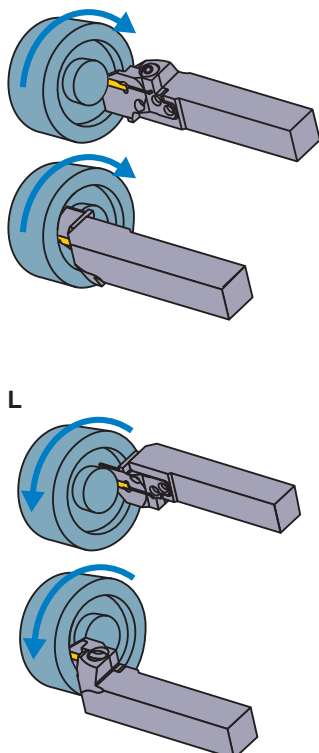


\* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	131	45	66	20	26	5	R	
20	20	131	45	66	20	26	5	R	
25	25	156	45	63	25	28	—	R	
25	25	156	45	63	25	28	—	R	
32	25	176	45	63	32	28	—	R	
32	25	176	45	63	32	28	—	R	
32	32	176	45	63	32	35	—	R	
32	32	176	45	63	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	131	45	66	20	26	5	L	
20	20	131	45	66	20	26	5	L	
25	25	156	45	63	25	28	—	L	
25	25	156	45	63	25	28	—	L	
32	25	176	45	63	32	28	—	L	
32	25	176	45	63	32	28	—	L	
32	32	176	45	63	32	35	—	L	
32	32	176	45	63	32	35	—	L	



Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		F	3.00mm	●	●
	3.18mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		F	3.00mm		
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8			●	
	3.18mm				●
	Re 0.2	●			
	Re 0.4	●			
	3.24mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

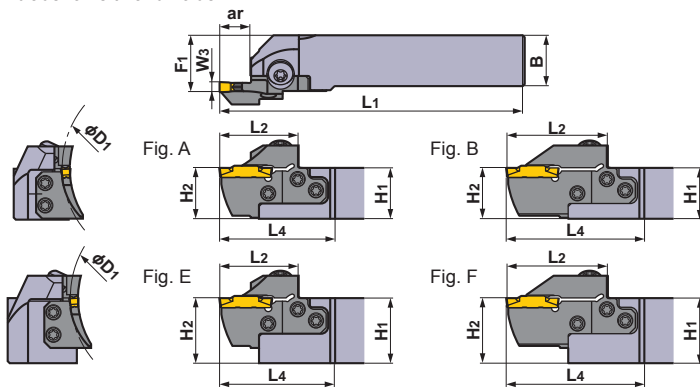
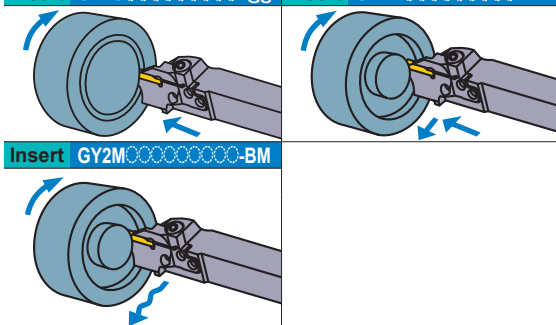
## 4

### 00° type holder

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

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup>	Insert	GY2M <sup>MM</sup>



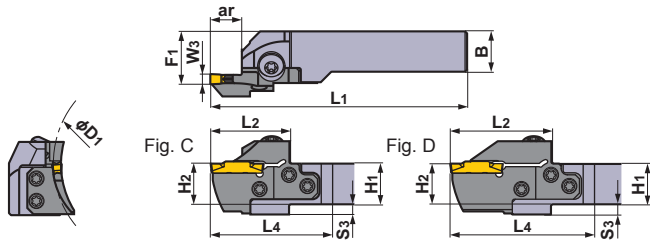
Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-180	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-180	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-180	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-180	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-180	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-180	●	E
		Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-180	●	E			
		Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-180	●	E			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-180	●	D			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-180	●	D			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-180	●	B			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-180	●	B			
	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-180	●	F				
	Modular	L	GYHL3225P00-M25L	●	GYM25LD-F20-180	●	F				
	Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-180	●	F				
	Modular	L	GYHL3232P00-M25L	●	GYM25LD-F20-180	●	F				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-225	●	C				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-225	●	C				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-225	●	A				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-225	●	A				
	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-225	●	E				
	Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-225	●	E				
	Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-225	●	E				
	Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-225	●	E				
Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-225	●	D					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-225	●	D					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-225	●	B					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-225	●	B					
Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-225	●	F					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-F20-225	●	F					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-225	●	F					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-F20-225	●	F					

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.



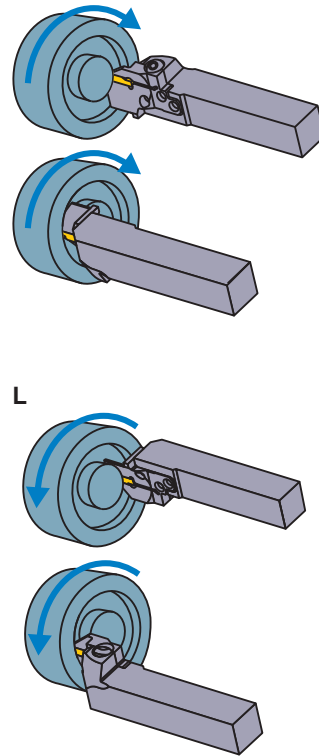
\* Wrench : ① : Clamp Screw, ② : Blade Screw

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	131	45	66	20	26	5	R	
20	20	131	45	66	20	26	5	R	
25	25	156	45	63	25	28	—	R	
25	25	156	45	63	25	28	—	R	
32	25	176	45	63	32	28	—	R	
32	25	176	45	63	32	28	—	R	
32	32	176	45	63	32	35	—	R	
32	32	176	45	63	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	131	45	66	20	26	5	L	
20	20	131	45	66	20	26	5	L	
25	25	156	45	63	25	28	—	L	
25	25	156	45	63	25	28	—	L	
32	25	176	45	63	32	28	—	L	
32	25	176	45	63	32	28	—	L	
32	32	176	45	63	32	35	—	L	
32	32	176	45	63	32	35	—	L	



### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		F	3.00mm	●	●
	3.18mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		F	3.00mm		
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8			●	
	3.18mm				●
	Re 0.2	●			
	Re 0.4	●			
	3.24mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

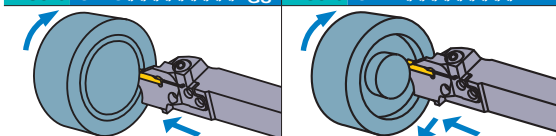
## 4

### 00° type holder

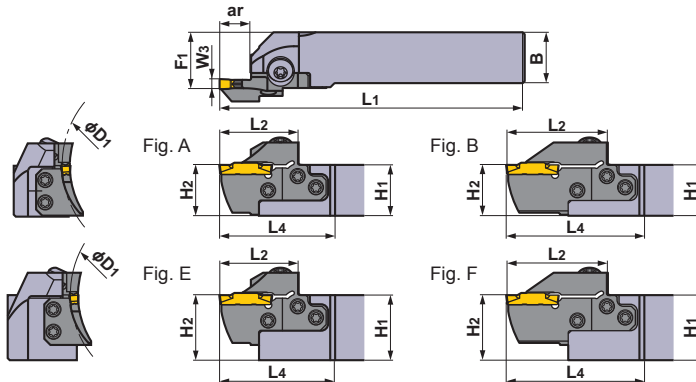
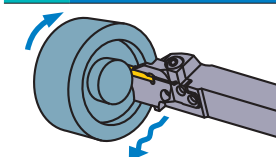
(Note 1) For modular blades and holders, please order separately.

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

Insert	GY2M <sup>GS</sup> <sub>GM</sub>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup> <sub>GS</sub>	Insert	GY2M <sup>MM</sup>



Insert GY2M<sup>BM</sup>



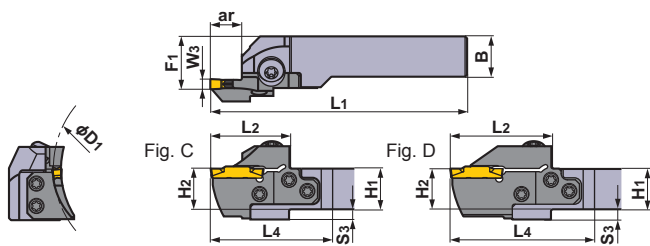
Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	40	50	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-040	●	C
					L	GYHL2020K00-M25L	●	GYM25LD-G14-040	●	C	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-040	●	A
					L	GYHL2525M00-M25L	●	GYM25LD-G14-040	●	A	
		Modular	R		GYHR3225P00-M25R	●	GYM25RD-G14-040	●	E		
		L	GYHL3225P00-M25L		●	GYM25LD-G14-040	●	E			
		Modular	R		GYHR3232P00-M25R	●	GYM25RD-G14-040	●	E		
		L	GYHL3232P00-M25L		●	GYM25LD-G14-040	●	E			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-050	●	C			
		L	GYHL2020K00-M25L	●	GYM25LD-G14-050	●	C				
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-050	●	A			
		L	GYHL2525M00-M25L	●	GYM25LD-G14-050	●	A				
	Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-050	●	E				
	L	GYHL3225P00-M25L	●	GYM25LD-G14-050	●	E					
	Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-050	●	E				
	L	GYHL3232P00-M25L	●	GYM25LD-G14-050	●	E					
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-060	●	C				
	L	GYHL2020K00-M25L	●	GYM25LD-G14-060	●	C					
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-060	●	A				
	L	GYHL2525M00-M25L	●	GYM25LD-G14-060	●	A					
Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-060	●	E					
L	GYHL3225P00-M25L	●	GYM25LD-G14-060	●	E						
Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-060	●	E					
L	GYHL3232P00-M25L	●	GYM25LD-G14-060	●	E						
Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-060	●	D					
L	GYHL2020K00-M25L	●	GYM25LD-G25-060	●	D						
Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-060	●	B					
L	GYHL2525M00-M25L	●	GYM25LD-G25-060	●	B						
Modular	R	GYHR3225P00-M25R	●	GYM25RD-G25-060	●	F					
L	GYHL3225P00-M25L	●	GYM25LD-G25-060	●	F						
Modular	R	GYHR3232P00-M25R	●	GYM25RD-G25-060	●	F					
L	GYHL3232P00-M25L	●	GYM25LD-G25-060	●	F						

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.



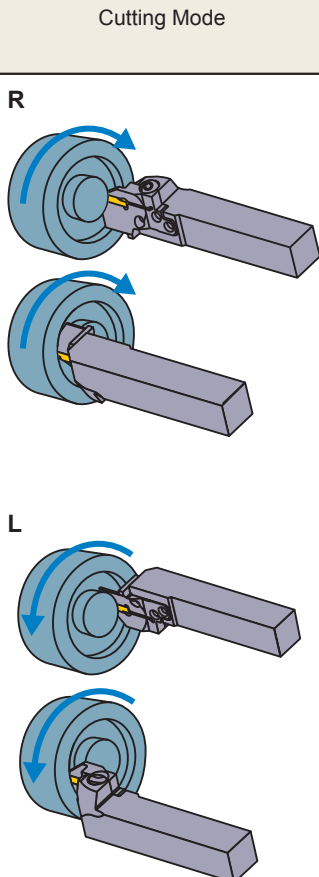
\* Wrench : ① : Clamp Screw, ② : Blade Screw

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	136	50	71	20	26	5	L	
20	20	136	50	71	20	26	5	L	
25	25	161	50	68	25	28	—	L	
25	25	161	50	68	25	28	—	L	
32	25	181	50	68	32	28	—	L	
32	25	181	50	68	32	28	—	L	
32	32	181	50	68	32	35	—	L	
32	32	181	50	68	32	35	—	L	



### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		W3			
G	4.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	Ball nose
		W3			
G	4.00mm				●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8	●		●	
	4.24mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

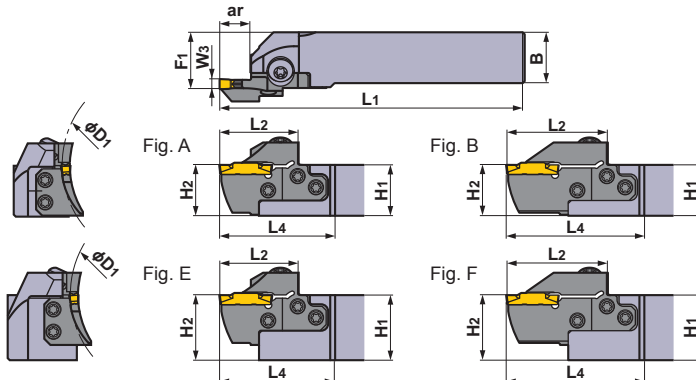
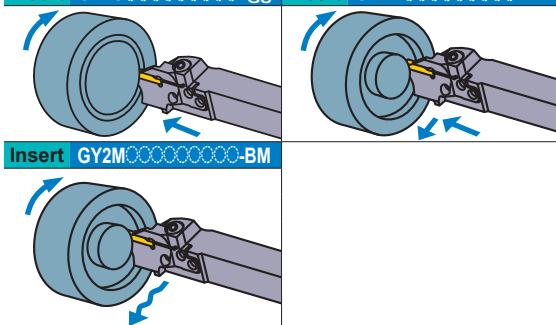
# GY SERIES (FACE GROOVING)

## 4 00° type holder

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

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

Insert	GY2M <sup>GS</sup> <sub>GM</sub>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup> <sub>GS</sub>	Insert	GY2M <sup>MM</sup>



Right hand tool holder shown.

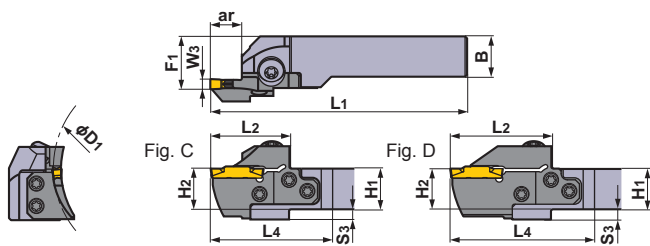
Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	85	125	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-085	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-085	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-085	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-085	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-085	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-G14-085	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-085	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-G14-085	●	E
	25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-085	●	D			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-G25-085	●	D			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-085	●	B			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-G25-085	●	B			
		Modular	R	GYHR3225P00-M25R	●	GYM25RD-G25-085	●	F			
		Modular	L	GYHL3225P00-M25L	●	GYM25LD-G25-085	●	F			
		Modular	R	GYHR3232P00-M25R	●	GYM25RD-G25-085	●	F			
		Modular	L	GYHL3232P00-M25L	●	GYM25LD-G25-085	●	F			
	125	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-125	●	C	
				Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-125	●	C	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-125	●	A	
				Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-125	●	A	
25 *2			Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-125	●	E		
			Modular	L	GYHL3225P00-M25L	●	GYM25LD-G14-125	●	E		
			Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-125	●	E		
			Modular	L	GYHL3232P00-M25L	●	GYM25LD-G14-125	●	E		
Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-125	●	D					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-G25-125	●	D					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-125	●	B					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-G25-125	●	B					
Modular	R	GYHR3225P00-M25R	●	GYM25RD-G25-125	●	F					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-G25-125	●	F					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-G25-125	●	F					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-G25-125	●	F					

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.





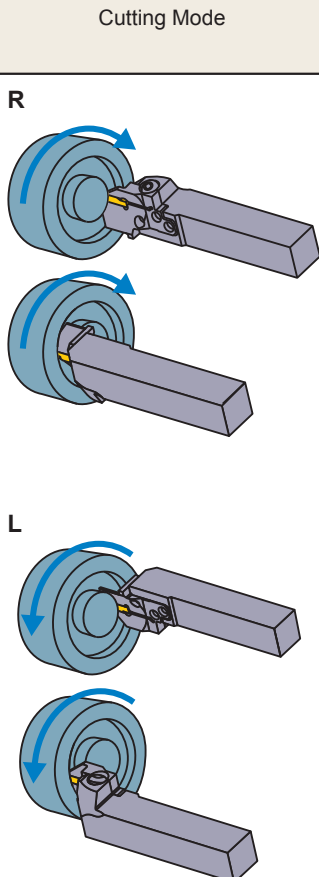
\* Wrench : ① : Clamp Screw, ② : Blade Screw

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	136	50	71	20	26	5	R	
20	20	136	50	71	20	26	5	R	
25	25	161	50	68	25	28	—	R	
25	25	161	50	68	25	28	—	R	
32	25	181	50	68	32	28	—	R	
32	25	181	50	68	32	28	—	R	
32	32	181	50	68	32	35	—	R	
32	32	181	50	68	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	136	50	71	20	26	5	L	
20	20	136	50	71	20	26	5	L	
25	25	161	50	68	25	28	—	L	
25	25	161	50	68	25	28	—	L	
32	25	181	50	68	32	28	—	L	
32	25	181	50	68	32	28	—	L	
32	32	181	50	68	32	35	—	L	
32	32	181	50	68	32	35	—	L	



### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		W3			
G	4.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
G	4.00mm				●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8	●		●	
G	4.24mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

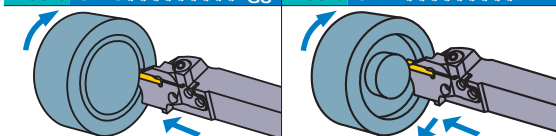
## 4

### 00° type holder

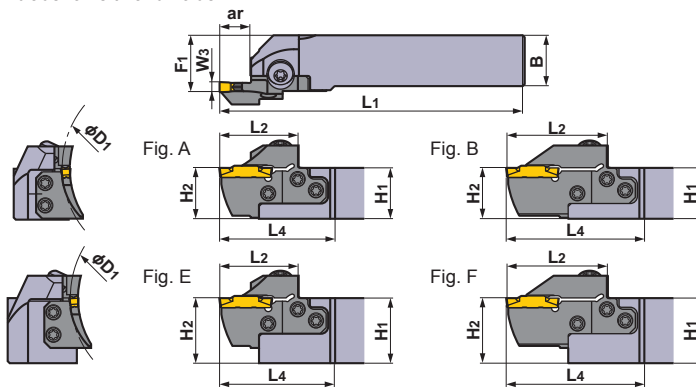
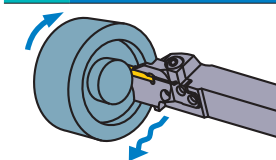
(Note 1) For modular blades and holders, please order separately.

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

Insert	GY2M <sup>GS</sup> <sub>GM</sub>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup> <sub>GS</sub>	Insert	GY2M <sup>MM</sup>



Insert GY2M<sup>BM</sup>



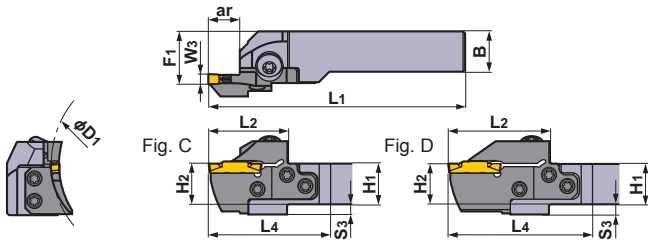
Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
G	4.00	180	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-180	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-180	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-180	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-180	●	A
				Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-180	●	E	
				Modular	L	GYHL3225P00-M25L	●	GYM25LD-G14-180	●	E	
				Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-180	●	E	
				Modular	L	GYHL3232P00-M25L	●	GYM25LD-G14-180	●	E	
	25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-180	●	D			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-G25-180	●	D			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-180	●	B			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-G25-180	●	B			
	4.24	250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-250	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-250	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-250	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-250	●	A
				Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-250	●	E	
				Modular	L	GYHL3225P00-M25L	●	GYM25LD-G14-250	●	E	
				Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-250	●	E	
				Modular	L	GYHL3232P00-M25L	●	GYM25LD-G14-250	●	E	
25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-250	●	D				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-G25-250	●	D				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-250	●	B				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-G25-250	●	B				
Modular	R	GYHR3225P00-M25R	●	GYM25RD-G25-250	●	F					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-G25-250	●	F					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-G25-250	●	F					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-G25-250	●	F					

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

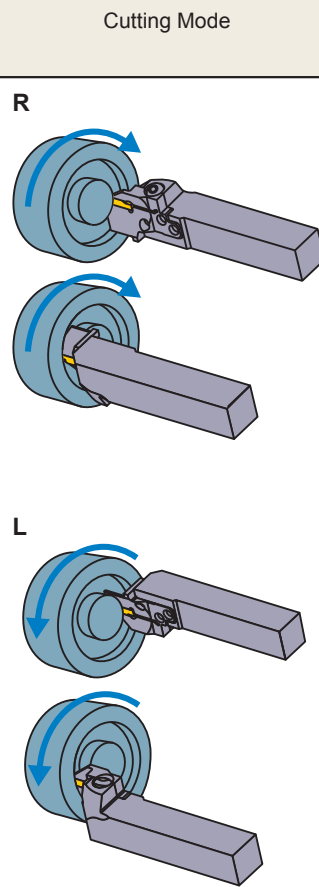


\* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	136	50	71	20	26	5	R	
20	20	136	50	71	20	26	5	R	
25	25	161	50	68	25	28	—	R	
25	25	161	50	68	25	28	—	R	
32	25	181	50	68	32	28	—	R	
32	25	181	50	68	32	28	—	R	
32	32	181	50	68	32	35	—	R	
32	32	181	50	68	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	136	50	71	20	26	5	L	
20	20	136	50	71	20	26	5	L	
25	25	161	50	68	25	28	—	L	
25	25	161	50	68	25	28	—	L	
32	25	181	50	68	32	28	—	L	
32	25	181	50	68	32	28	—	L	
32	32	181	50	68	32	35	—	L	
32	32	181	50	68	32	35	—	L	



Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		W3			
G	4.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
G	4.00mm				●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8	●		●	
	4.24mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

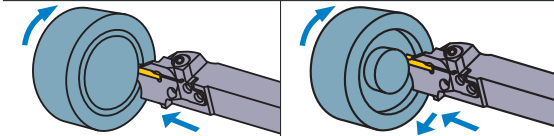
## 4

### 00° type holder

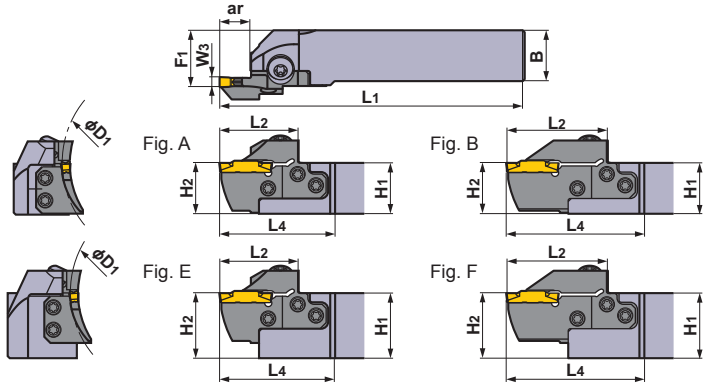
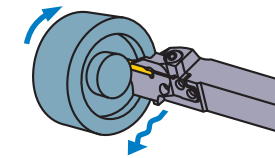
(Note 1) For modular blades and holders, please order separately.

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

Insert	GY2M--GS	Insert	GY2G--MF
Insert	GY2M--GU	Insert	GY2M--MS
Insert	GY1G--GF	Insert	GY2M--MM



Insert GY2M--BM



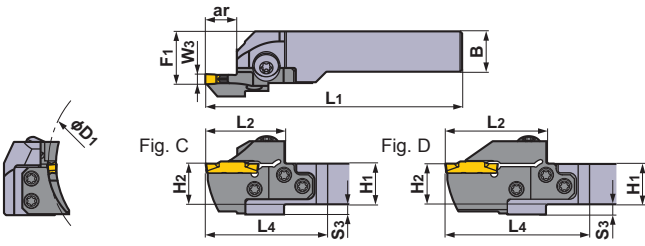
Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	50	60	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-050	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-050	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-050	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-050	●	A
		Modular	R		GYHR3225P00-M25R	●	GYM25RD-H14-050	●	E		
		Modular	L		GYHL3225P00-M25L	●	GYM25LD-H14-050	●	E		
		Modular	R		GYHR3232P00-M25R	●	GYM25RD-H14-050	●	E		
		Modular	L		GYHL3232P00-M25L	●	GYM25LD-H14-050	●	E		
	60	85	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-060	●	C	
				Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-060	●	C	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-060	●	A	
				Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-060	●	A	
			Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-060	●	E		
			Modular	L	GYHL3225P00-M25L	●	GYM25LD-H14-060	●	E		
			Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-060	●	E		
			Modular	L	GYHL3232P00-M25L	●	GYM25LD-H14-060	●	E		
25 *2			Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-060	●	D		
			Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-060	●	D		
			Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-060	●	B		
			Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-060	●	B		
Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-060	●	F					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-H25-060	●	F					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-060	●	F					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-H25-060	●	F					

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.



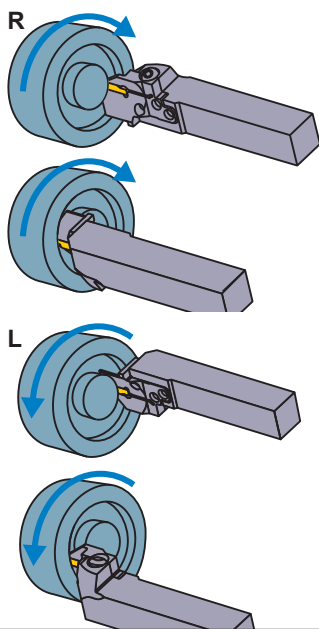
\* Wrench : ① : Clamp Screw, ② : Blade Screw

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	136	50	71	20	26	5	R	
20	20	136	50	71	20	26	5	R	
25	25	161	50	68	25	28	—	R	
25	25	161	50	68	25	28	—	R	
32	25	181	50	68	32	28	—	R	
32	25	181	50	68	32	28	—	R	
32	32	181	50	68	32	35	—	R	
32	32	181	50	68	32	35	—	R	



### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		H	4.75mm	●	●
	5.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		H	4.75mm		
	Re 0.2	●			
	Re 0.4	●			
	Re 0.8	●			
	5.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
	5.24mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

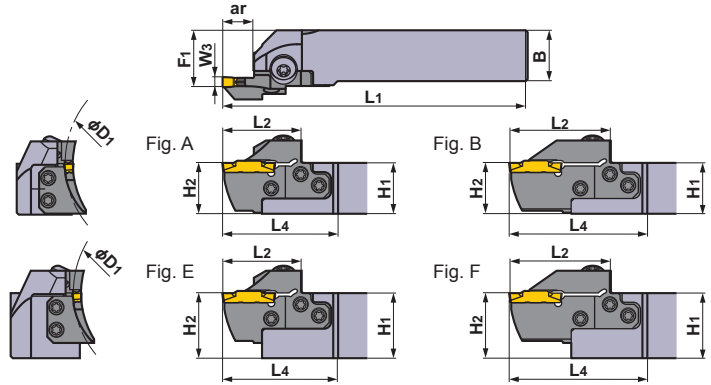
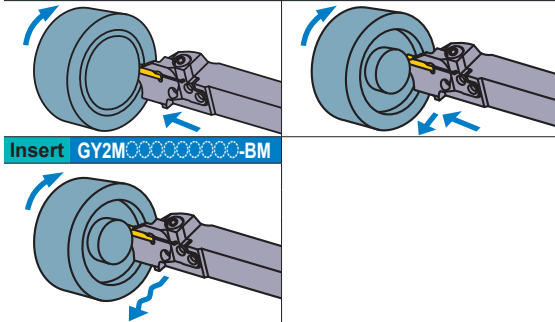
## 4

### 00° type holder

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

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup>	Insert	GY2M <sup>MM</sup>



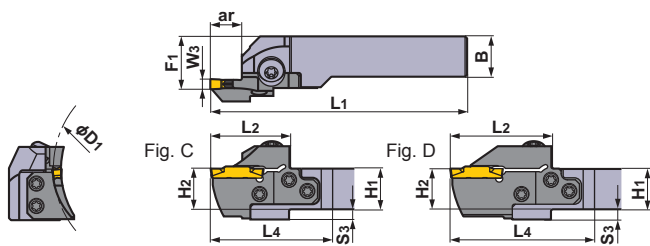
Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	85	125	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-085	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-085	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-085	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-085	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-085	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-H14-085	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-085	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-H14-085	●	E
	25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-085	●	D			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-085	●	D			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-085	●	B			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-085	●	B			
		Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-085	●	F			
		Modular	L	GYHL3225P00-M25L	●	GYM25LD-H25-085	●	F			
		Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-085	●	F			
		Modular	L	GYHL3232P00-M25L	●	GYM25LD-H25-085	●	F			
	125	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-125	●	C	
				Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-125	●	C	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-125	●	A	
				Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-125	●	A	
25 *2			Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-125	●	E		
			Modular	L	GYHL3225P00-M25L	●	GYM25LD-H14-125	●	E		
			Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-125	●	E		
			Modular	L	GYHL3232P00-M25L	●	GYM25LD-H14-125	●	E		
Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-125	●	D					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-125	●	D					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-125	●	B					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-125	●	B					
Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-125	●	F					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-H25-125	●	F					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-125	●	F					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-H25-125	●	F					

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

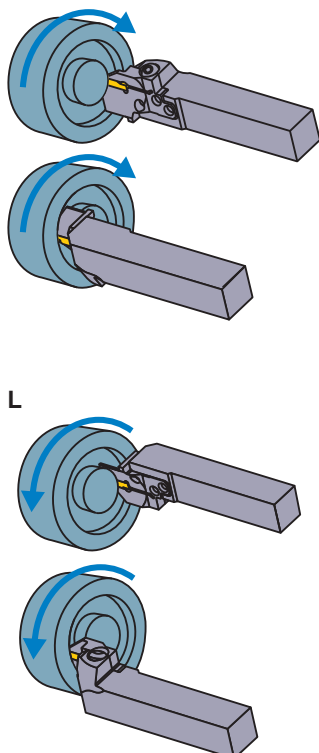


\* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	136	50	71	20	26	5	R	
20	20	136	50	71	20	26	5	R	
25	25	161	50	68	25	28	—	R	
25	25	161	50	68	25	28	—	R	
32	25	181	50	68	32	28	—	R	
32	25	181	50	68	32	28	—	R	
32	32	181	50	68	32	35	—	R	
32	32	181	50	68	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	136	50	71	20	26	5	L	
20	20	136	50	71	20	26	5	L	
25	25	161	50	68	25	28	—	L	
25	25	161	50	68	25	28	—	L	
32	25	181	50	68	32	28	—	L	
32	25	181	50	68	32	28	—	L	
32	32	181	50	68	32	35	—	L	
32	32	181	50	68	32	35	—	L	



Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		H	4.75mm	●	●
	5.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		H	4.75mm		
	Re 0.2	●			
	Re 0.4	●			
	Re 0.8	●			
	5.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
	5.24mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

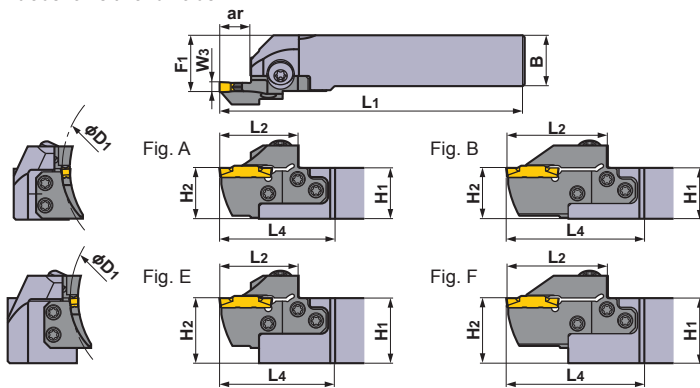
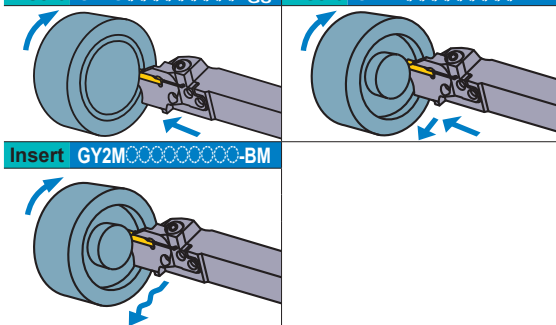
## 4

### 00° type holder

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

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

Insert	GY2M <sup>GS</sup> <sub>GM</sub>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup> <sub>GS</sub>	Insert	GY2M <sup>MM</sup>



Right hand tool holder shown.

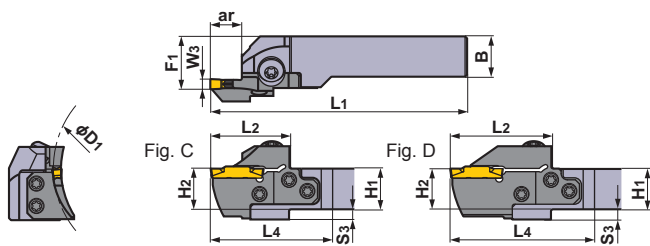
Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	180	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-180	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-180	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-180	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-180	●	A
				Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-180	●	E	
				Modular	L	GYHL3225P00-M25L	●	GYM25LD-H14-180	●	E	
				Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-180	●	E	
				Modular	L	GYHL3232P00-M25L	●	GYM25LD-H14-180	●	E	
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-180	●	D				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-180	●	D				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-180	●	B				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-180	●	B				
	Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-180	●	F				
	Modular	L	GYHL3225P00-M25L	●	GYM25LD-H25-180	●	F				
	Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-180	●	F				
	Modular	L	GYHL3232P00-M25L	●	GYM25LD-H25-180	●	F				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-250	●	C				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-250	●	C				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-250	●	A				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-250	●	A				
Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-250	●	E					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-H14-250	●	E					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-250	●	E					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-H14-250	●	E					
Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-250	●	D					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-250	●	D					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-250	●	B					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-250	●	B					
Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-250	●	F					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-H25-250	●	F					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-250	●	F					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-H25-250	●	F					

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.





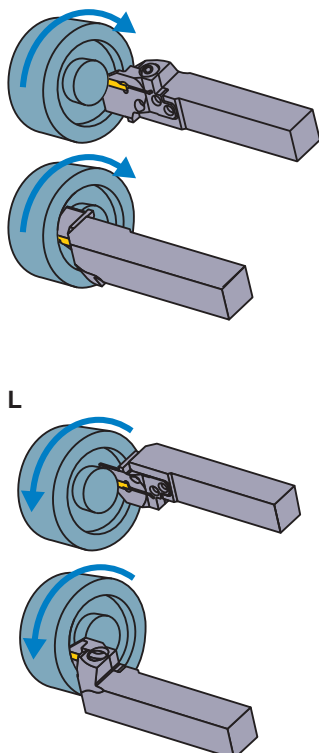
\* Wrench : ① : Clamp Screw, ② : Blade Screw

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	136	50	71	20	26	5	R	
20	20	136	50	71	20	26	5	R	
25	25	161	50	68	25	28	—	R	
25	25	161	50	68	25	28	—	R	
32	25	181	50	68	32	28	—	R	
32	25	181	50	68	32	28	—	R	
32	32	181	50	68	32	35	—	R	
32	32	181	50	68	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	136	50	71	20	26	5	L	
20	20	136	50	71	20	26	5	L	
25	25	161	50	68	25	28	—	L	
25	25	161	50	68	25	28	—	L	
32	25	181	50	68	32	28	—	L	
32	25	181	50	68	32	28	—	L	
32	32	181	50	68	32	35	—	L	
32	32	181	50	68	32	35	—	L	



### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		H	4.75mm	●	●
	5.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		H	4.75mm		
	Re 0.2	●			
	Re 0.4	●			
	Re 0.8	●			
	5.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
	5.24mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

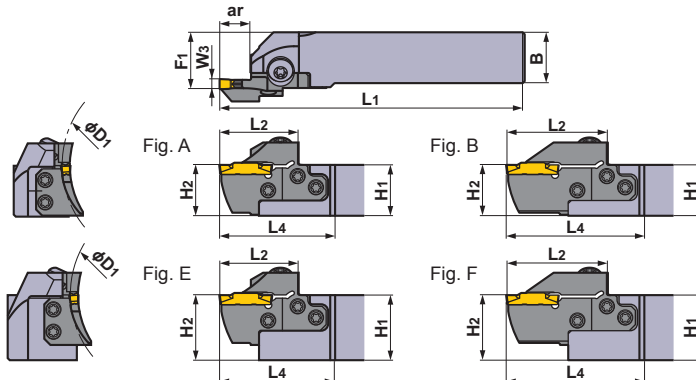
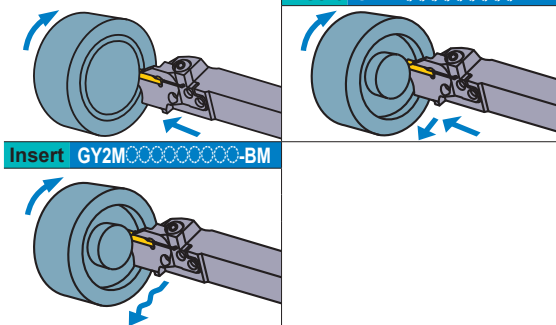
# GY SERIES (FACE GROOVING)

## 4 00° type holder

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

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>GS</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
		Insert	GY2M <sup>MM</sup>



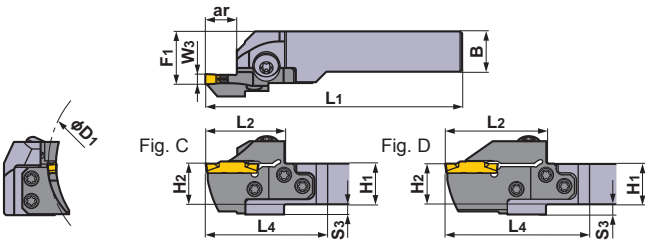
Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
J	6.00 6.31 6.35	50	70	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-050	●	C
					L	GYHL2020K00-M25L	●	GYM25LD-J14-050	●	C	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-050	●	A
					L	GYHL2525M00-M25L	●	GYM25LD-J14-050	●	A	
		Modular	R		GYHR3225P00-M25R	●	GYM25RD-J14-050	●	E		
		L	GYHL3225P00-M25L		●	GYM25LD-J14-050	●	E			
		Modular	R		GYHR3232P00-M25R	●	GYM25RD-J14-050	●	E		
		L	GYHL3232P00-M25L		●	GYM25LD-J14-050	●	E			
		70	110	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-070	●	C
					L	GYHL2020K00-M25L	●	GYM25LD-J14-070	●	C	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-070	●	A
					L	GYHL2525M00-M25L	●	GYM25LD-J14-070	●	A	
	Modular	R	GYHR3225P00-M25R		●	GYM25RD-J14-070	●	E			
	L	GYHL3225P00-M25L	●		GYM25LD-J14-070	●	E				
	Modular	R	GYHR3232P00-M25R		●	GYM25RD-J14-070	●	E			
	L	GYHL3232P00-M25L	●		GYM25LD-J14-070	●	E				
	110	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-110	●	C	
				L	GYHL2020K00-M25L	●	GYM25LD-J14-110	●	C		
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-110	●	A	
				L	GYHL2525M00-M25L	●	GYM25LD-J14-110	●	A		
			Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-110	●	E		
			L	GYHL3225P00-M25L	●	GYM25LD-J14-110	●	E			
			Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-110	●	E		
			L	GYHL3232P00-M25L	●	GYM25LD-J14-110	●	E			
25 *2			Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-110	●	D		
			L	GYHL2020K00-M25L	●	GYM25LD-J25-110	●	D			
			Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-110	●	B		
			L	GYHL2525M00-M25L	●	GYM25LD-J25-110	●	B			
Modular	R	GYHR3225P00-M25R	●	GYM25RD-J25-110	●	F					
L	GYHL3225P00-M25L	●	GYM25LD-J25-110	●	F						
Modular	R	GYHR3232P00-M25R	●	GYM25RD-J25-110	●	F					
L	GYHL3232P00-M25L	●	GYM25LD-J25-110	●	F						

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.



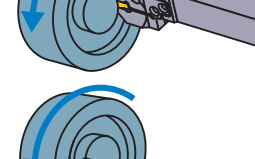
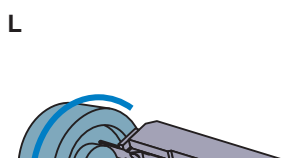
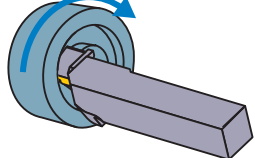
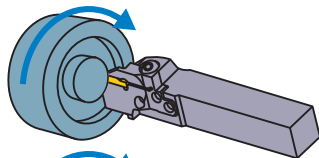
\* Wrench : ① : Clamp Screw, ② : Blade Screw

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		



### Select an Insert

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

For Grooving/Cutting off > P9					
Seat Size	Breaker	GU	GS	GM	GFGS
		W3			
J	6.00mm	●	●	●	
	6.35mm	●	●	●	

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
J	6.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	Re 0.2	●			
	Re 0.4	●			
Re 0.8	●				

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

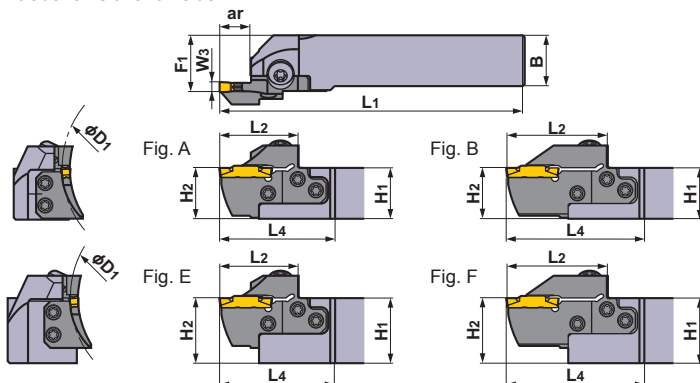
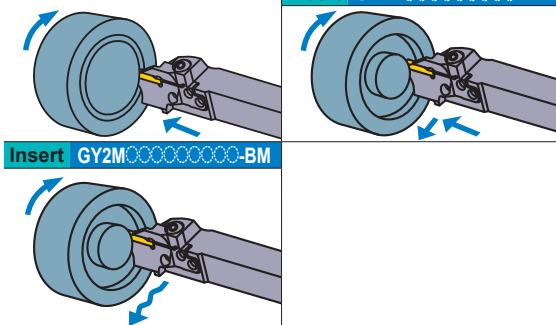
## 4

### 00° type holder

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

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
		Insert	GY2M <sup>MM</sup>



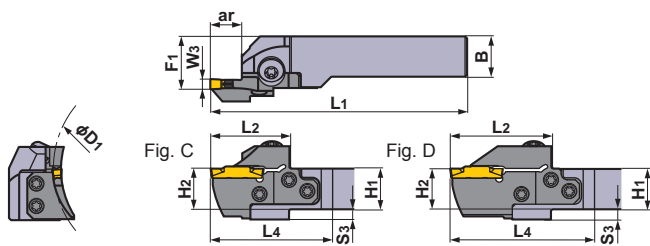
Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
J	6.00 6.31 6.35	170	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-170	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-170	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-170	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-170	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-170	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-J14-170	●	E
		Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-170	●	E			
		Modular	L	GYHL3232P00-M25L	●	GYM25LD-J14-170	●	E			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-170	●	D			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-170	●	D			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-170	●	B			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-170	●	B			
	Modular	R	GYHR3225P00-M25R	●	GYM25RD-J25-170	●	F				
	Modular	L	GYHL3225P00-M25L	●	GYM25LD-J25-170	●	F				
	Modular	R	GYHR3232P00-M25R	●	GYM25RD-J25-170	●	F				
	Modular	L	GYHL3232P00-M25L	●	GYM25LD-J25-170	●	F				
	25 *2	250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-250	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-250	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-250	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-250	●	A
Modular		R	GYHR3225P00-M25R	●	GYM25RD-J14-250	●	E				
Modular		L	GYHL3225P00-M25L	●	GYM25LD-J14-250	●	E				
Modular		R	GYHR3232P00-M25R	●	GYM25RD-J14-250	●	E				
Modular		L	GYHL3232P00-M25L	●	GYM25LD-J14-250	●	E				
25 *2	250	999	25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-250	●	D	
				Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-250	●	D	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-250	●	B	
				Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-250	●	B	
Modular	R	GYHR3225P00-M25R	●	GYM25RD-J25-250	●	F					
Modular	L	GYHL3225P00-M25L	●	GYM25LD-J25-250	●	F					
Modular	R	GYHR3232P00-M25R	●	GYM25RD-J25-250	●	F					
Modular	L	GYHL3232P00-M25L	●	GYM25LD-J25-250	●	F					

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, L<sub>4</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

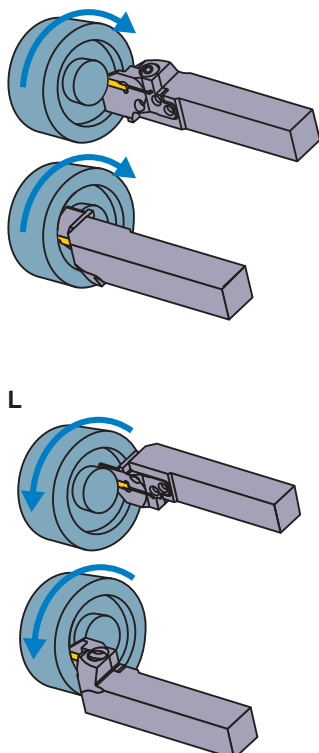


\* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number			
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H1	B	L1	L2	L4	H2	F1	S3		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	136	50	71	20	26	5	R	
20	20	136	50	71	20	26	5	R	
25	25	161	50	68	25	28	—	R	
25	25	161	50	68	25	28	—	R	
32	25	181	50	68	32	28	—	R	
32	25	181	50	68	32	28	—	R	
32	32	181	50	68	32	35	—	R	
32	32	181	50	68	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	136	50	71	20	26	5	L	
20	20	136	50	71	20	26	5	L	
25	25	161	50	68	25	28	—	L	
25	25	161	50	68	25	28	—	L	
32	25	181	50	68	32	28	—	L	
32	25	181	50	68	32	28	—	L	
32	32	181	50	68	32	35	—	L	
32	32	181	50	68	32	35	—	L	



Select an Insert

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

For Grooving/Cutting off > P9					
Seat Size	Breaker	GU	GS	GM	GFGS
		W3			
J	6.00mm	●	●	●	
	6.35mm	●	●	●	

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
J	6.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	Re 0.2	●			
	Re 0.4	●			
Re 0.8	●				

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

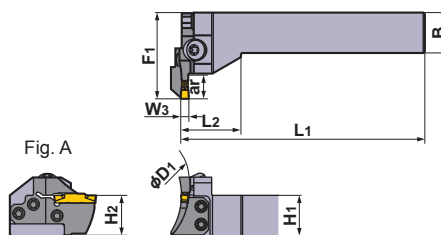
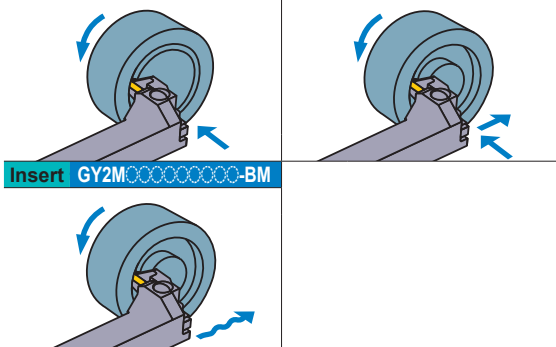
## 5

### 90° type holder

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

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

Insert	GY2M <sup>GS</sup> <sub>GM</sub>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup> <sub>GS</sub>	Insert	GY2M <sup>MM</sup>



Right hand tool holder shown.




Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	40	50	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-D12-040 GYM25RD-D12-040	●	A A
		50	60	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-D12-050 GYM25RD-D12-050	●	A A
		60	75	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-D12-060 GYM25RD-D12-060	●	A A
		75	100	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-D12-075 GYM25RD-D12-075	●	A A
		100	150	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-D12-100 GYM25RD-D12-100	●	A A
		135	200	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-D12-135 GYM25RD-D12-135	●	A A
		180	250	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-D12-180 GYM25RD-D12-180	●	A A
E	2.39 2.50 2.74	40	50	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-E12-040 GYM25RD-E12-040	●	A A
		50	60	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-E12-050 GYM25RD-E12-050	●	A A
		60	75	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-E12-060 GYM25RD-E12-060	●	A A
		75	100	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-E12-075 GYM25RD-E12-075	●	A A
		100	150	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-E12-100 GYM25RD-E12-100	●	A A
		135	200	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-E12-135 GYM25RD-E12-135	●	A A
		180	250	12	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	●	GYM25LD-E12-180 GYM25RD-E12-180	●	A A

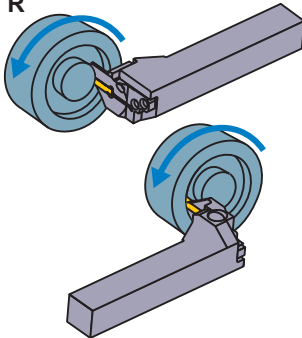
W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, and F<sub>1</sub> values may vary.

● : Inventory maintained in Japan.

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

SPARE PARTS			
Holder Number		 (5 pieces)	
GYHR2525M90-M25L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) *1						Cutting Mode
	H1	B	L1	L2	H2	F1	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	

Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker W <sub>3</sub>	GU	GS	GM	GFGS
		D	2.00mm	●	●
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker W <sub>3</sub>	MF	MS	MM	BM
		D	2.00mm	●	●
2.24mm	●				
E	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

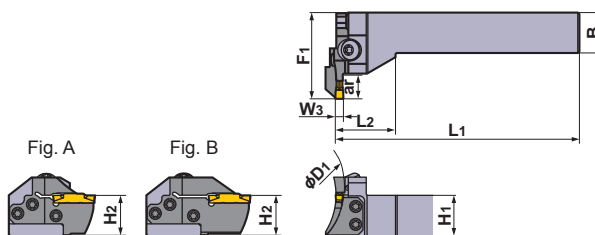
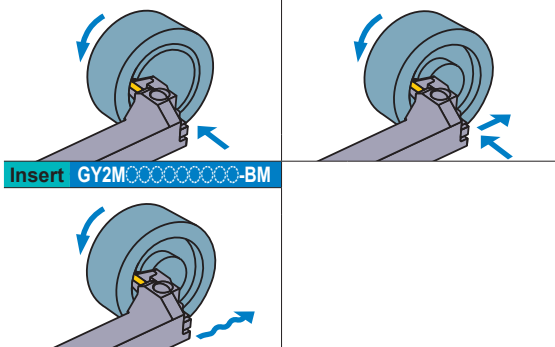
## 5

### 90° type holder

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

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup>	Insert	GY2M <sup>MM</sup>



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	35	40	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-035	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-035	●	A
		40	50	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-040	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-040	●	A
		50	60	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-050	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-050	●	A
		60	75	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-060	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-060	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-060	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-060	●	B
		75	100	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-075	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-075	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-075	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-075	●	B
		100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-100	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-100	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-100	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-100	●	B
		135	200	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-135	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-135	●	A
20 *2	Modular			R	GYHR2525M90-M25L	●	GYM25LD-F20-135	●	B		
				L	GYHL2525M90-M25R	●	GYM25RD-F20-135	●	B		
180	250	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-180	●	A		
				L	GYHL2525M90-M25R	●	GYM25RD-F12-180	●	A		
		20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-180	●	B		
				L	GYHL2525M90-M25R	●	GYM25RD-F20-180	●	B		
225	999	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-225	●	A		
				L	GYHL2525M90-M25R	●	GYM25RD-F12-225	●	A		
				Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-225	●	B	
					L	GYHL2525M90-M25R	●	GYM25RD-F20-225	●	B	

W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.





# GY SERIES (FACE GROOVING)

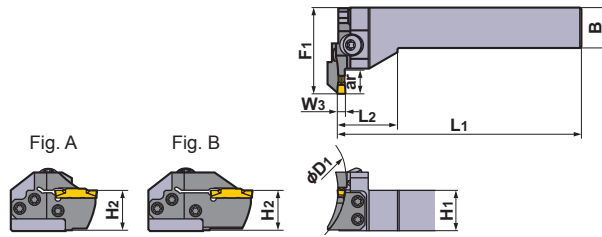
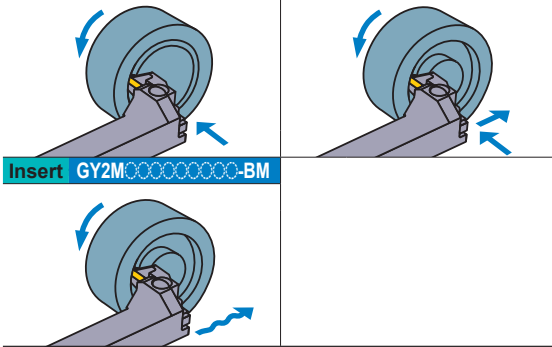
## 5

### 90° type holder

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

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

Insert	GY2M <sup>GS</sup> <sub>GM</sub>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup> <sub>GS</sub>	Insert	GY2M <sup>MM</sup>



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	40	50	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-040	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-040	●	A
		50	60	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-050	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-050	●	A
		60	85	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-060	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-060	●	A
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-060	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-G25-060	●	B
		85	125	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-085	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-085	●	A
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-085	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-G25-085	●	B
		125	200	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-125	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-125	●	A
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-125	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-G25-125	●	B
180	280	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-180	●	A		
				L	GYHL2525M90-M25R	●	GYM25RD-G14-180	●	A		
		25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-180	●	B		
				L	GYHL2525M90-M25R	●	GYM25RD-G25-180	●	B		
250	999	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-250	●	A		
				L	GYHL2525M90-M25R	●	GYM25RD-G14-250	●	A		
		25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-250	●	B		
				L	GYHL2525M90-M25R	●	GYM25RD-G25-250	●	B		




W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

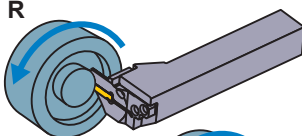
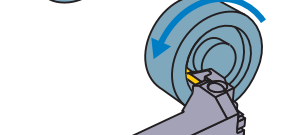
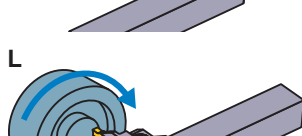
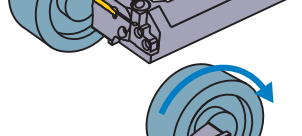






\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

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

## SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
<b>GYHR2525M90-M25L</b>	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
<b>GYHL2525M90-M25R</b>			

	Dimensions (mm) *1						Cutting Mode
	H1	B	L1	L2	H2	F1	
	25	25	150	38	25	53	<b>R</b> 
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	<b>L</b> 
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	

### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
	G	4.00mm	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
	G	4.00mm			
Re 0.2		●	●	●	
Re 0.4		●	●	●	
Re 0.8		●		●	
4.24mm		●			

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

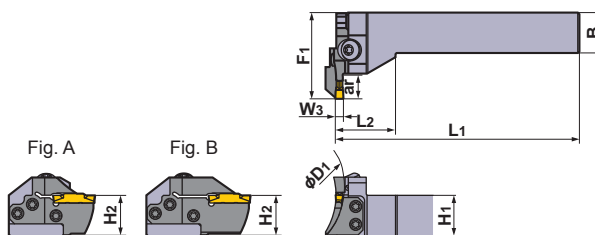
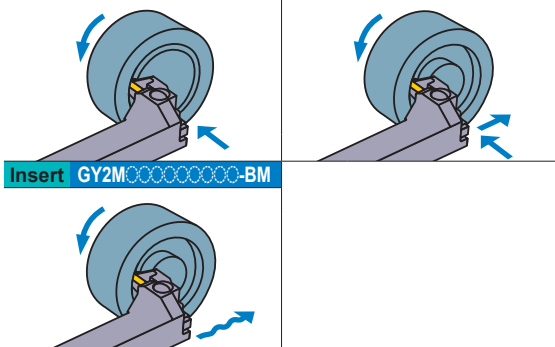
## 5

### 90° type holder

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

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

Insert	GY2M <sup>GS</sup> <sub>GM</sub>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup> <sub>GS</sub>	Insert	GY2M <sup>MM</sup>



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	50	60	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-050	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-H14-050	●	A
		60	85	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-060	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-H14-060	●	A
		60	85	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-060	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-H25-060	●	B
		85	125	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-085	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-H14-085	●	A
		85	125	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-085	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-H25-085	●	B
		125	200	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-125	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-H14-125	●	A
		125	200	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-125	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-H25-125	●	B
		180	280	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-180	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-H14-180	●	A
180	280	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-180	●	B		
				L	GYHL2525M90-M25R	●	GYM25RD-H25-180	●	B		
250	999	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-250	●	A		
				L	GYHL2525M90-M25R	●	GYM25RD-H14-250	●	A		
250	999	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-250	●	B		
				L	GYHL2525M90-M25R	●	GYM25RD-H25-250	●	B		




W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

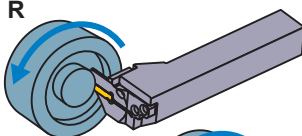
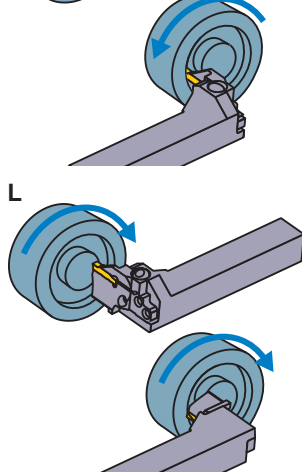
\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

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

## SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
<b>GYHR2525M90-M25L</b>	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
<b>GYHL2525M90-M25R</b>			

	Dimensions (mm) *1						Cutting Mode
	H1	B	L1	L2	H2	F1	
	25	25	150	38	25	53	 
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	

### Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
	H	W3	●	●	●
	4.75mm	●	●	●	●
	5.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
	H	W3			
4.75mm					●
Re 0.2		●			
Re 0.4		●			
Re 0.8		●			
5.00mm					●
Re 0.2		●			
Re 0.4	●	●	●		
Re 0.8	●	●	●		
5.24mm	●				

● : Gauge insert shown dimensions

FACE GROOVING

# GY SERIES (FACE GROOVING)

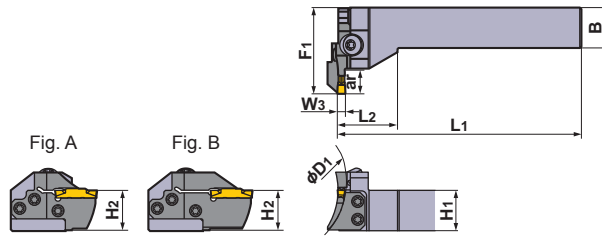
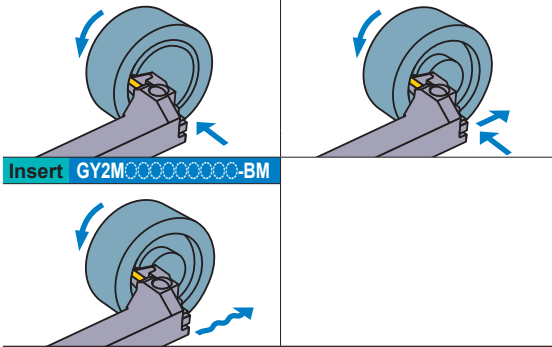
## 5

### 90° type holder

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

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

Insert	GY2M <sup>GS</sup> <sub>GM</sub>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup> <sub>GS</sub>	Insert	GY2M <sup>MM</sup>



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	D <sub>1</sub> (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
J	6.00	50	70	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-050	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-J14-050	●	A
		70	110	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-070	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-J14-070	●	A
		110	200	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-070	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-J25-070	●	B
	170	280	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-110	●	A	
					L	GYHL2525M90-M25R	●	GYM25RD-J14-110	●	A	
	6.31	170	280	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-110	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-J25-110	●	B
		250	999	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-170	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-J14-170	●	A
6.35		250	999	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-170	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-J25-170	●	B
250	999	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-250	●	A		
				L	GYHL2525M90-M25R	●	GYM25RD-J14-250	●	A		
250	999	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-250	●	B		
				L	GYHL2525M90-M25R	●	GYM25RD-J25-250	●	B		




W<sub>3</sub> = Insert Width      D<sub>1</sub> = First Cut Diameter      ar = Max. Groove Depth

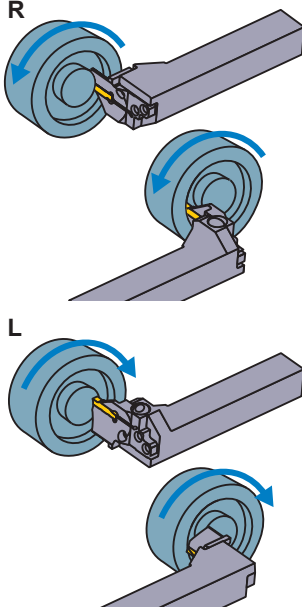
\*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>2</sub>, and F<sub>1</sub> values may vary.

\*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

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

### SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench *
<b>GYHR2525M90-M25L</b>	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
<b>GYHL2525M90-M25R</b>			

	Dimensions (mm) *1						Cutting Mode
	H1	B	L1	L2	H2	F1	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	

### Select an Insert

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

For Grooving/Cutting off > P9					
Seat Size	Breaker	GU	GS	GM	GFGS
	J	6.00mm	●	●	●
	6.35mm	●	●	●	

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
	J	6.00mm			
Re 0.2		●			
Re 0.4		●	●	●	
Re 0.8		●	●	●	
J	6.31mm	●			
	6.35mm				●
	Re 0.2	●			
	Re 0.4	●			
	Re 0.8	●			

● : Gauge insert shown dimensions

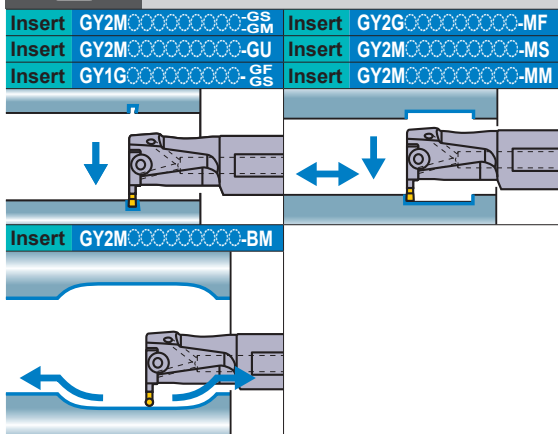
FACE GROOVING

# GY SERIES (INTERNAL GROOVING)

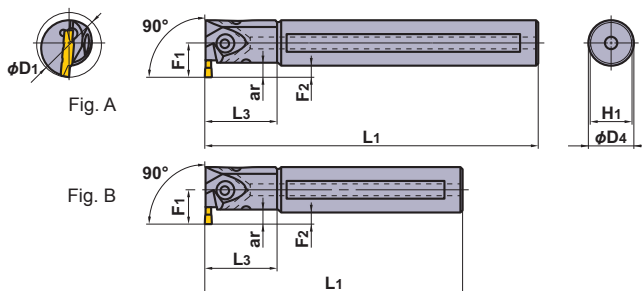
## 6

### 90° type holder

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



#### ● Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	ar (mm) *3	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	6	25	Mono Block	R	<b>GYAR20K90A-D06</b>	●	—	—	B
				Mono Block	L	<b>GYAL20K90A-D06</b>	●	—	—	B
			Mono Block	R	<b>GYAR20Q90A-D06</b>	●	—	—	A	
			Mono Block	L	<b>GYAL20Q90A-D06</b>	●	—	—	A	
		32	Mono Block	R	<b>GYAR25K90B-D06</b>	●	—	—	B	
			Mono Block	L	<b>GYAL25K90B-D06</b>	●	—	—	B	
			Mono Block	R	<b>GYAR25R90B-D06</b>	●	—	—	A	
			Mono Block	L	<b>GYAL25R90B-D06</b>	●	—	—	A	
		4—9.5 *1	40	Modular	R	<b>GYDR32L90C-M20L</b>	●	<b>GYM20LA-D10</b>	●	D
				Modular	L	<b>GYDL32L90C-M20R</b>	●	<b>GYM20RA-D10</b>	●	D
			Modular	R	<b>GYDR32S90C-M20L</b>	●	<b>GYM20LA-D10</b>	●	C	
			Modular	L	<b>GYDL32S90C-M20R</b>	●	<b>GYM20RA-D10</b>	●	C	
		5.5—9.5 *1	50	Modular	R	<b>GYDR40M90D-M20L</b>	●	<b>GYM20LA-D10</b>	●	D
				Modular	L	<b>GYDL40M90D-M20R</b>	●	<b>GYM20RA-D10</b>	●	D
			Modular	R	<b>GYDR40T90D-M20L</b>	●	<b>GYM20LA-D10</b>	●	C	
			Modular	L	<b>GYDL40T90D-M20R</b>	●	<b>GYM20RA-D10</b>	●	C	
		7—11.5 *1	60	Modular	R	<b>GYDR40M90D-M25L</b>	●	<b>GYM25LA-D12</b>	●	D
				Modular	L	<b>GYDL40M90D-M25R</b>	●	<b>GYM25RA-D12</b>	●	D
Modular	R		<b>GYDR40T90D-M25L</b>	●	<b>GYM25LA-D12</b>	●	C			
Modular	L		<b>GYDL40T90D-M25R</b>	●	<b>GYM25RA-D12</b>	●	C			
70	Modular		R	<b>GYDR50P90F-M25L</b>	●	<b>GYM25LA-D12</b>	●	D		
	Modular		L	<b>GYDL50P90F-M25R</b>	●	<b>GYM25RA-D12</b>	●	D		
Modular	R	<b>GYDR50T90F-M25L</b>	●	<b>GYM25LA-D12</b>	●	C				
Modular	L	<b>GYDL50T90F-M25R</b>	●	<b>GYM25RA-D12</b>	●	C				

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Min. Cutting Diameter

\*1 The maximum groove depth varies according to the cutting diameter D<sub>1</sub>. For details, please refer to page 101.

\*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>3</sub>, F<sub>1</sub> and F<sub>2</sub> values may vary.

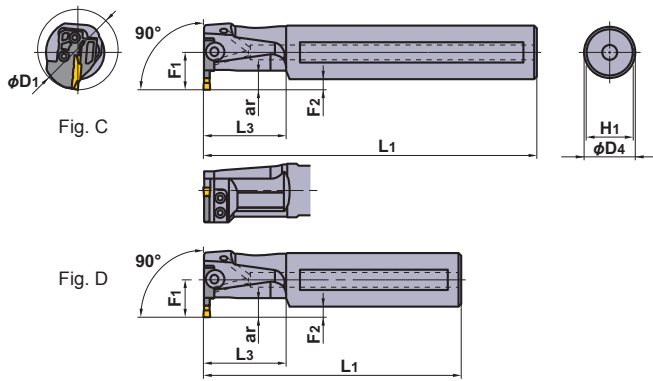
\*3 The maximum groove depth (ar) is a value within the dimension L<sub>3</sub>.

● : Inventory maintained in Japan.



●Modular blade type (Air / coolant through)

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

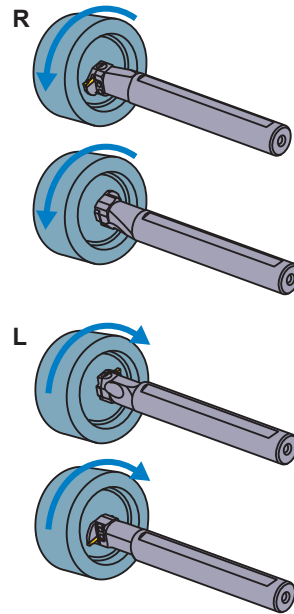


Right hand tool holder shown.

**SPARE PARTS**

Holder Number	Clamp Screw	Blade Screw 4 pcs.	Wrench *
<b>GYAR/L20-90A-06</b>	GY05016S (Clamp Torque : 5.0N·m)	—	①TKY20R
<b>GYAR/L25-90B-06</b>	GY05016S (Clamp Torque : 5.0N·m)	—	①TKY20R
<b>GYDR/L32-90C-M20L/R</b>	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
<b>GYDR/L40-90D-M20L/R</b>	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
<b>GYDR/L40-90D-M25L/R</b>	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
<b>GYDR/L50-90F-M25L/R</b>	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D

	Dimensions (mm) *2						Cutting Mode
	D4	L1	L3	F1	F2	H1	
	20	125	30	14.5	4.5	18	R
	20	125	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	R
	20	180	30	14.5	4.5	18	
	25	125	40	19	6.5	23	R
	25	125	40	19	6.5	23	
	25	200	40	19	6.5	23	R
	25	200	40	19	6.5	23	
	32	140	50	22	6	30	L
	32	140	50	22	6	30	
	32	250	50	22	6	30	L
	32	250	50	22	6	30	
	40	150	60	28	8	37	L
	40	150	60	28	8	37	
	40	300	60	28	8	37	L
	40	300	60	28	8	37	
	40	150	60	28	8	37	L
	40	150	60	28	8	37	
	40	300	60	28	8	37	L
	40	300	60	28	8	37	
	50	170	80	34	9	47	L
	50	170	80	34	9	47	
	50	300	80	34	9	47	L
	50	300	80	34	9	47	



**Select an Insert**

Seat Size	Insert Number
D	GY-0200/0224D-06-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		D	2.00mm	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		D	2.00mm	●	●
	2.24mm	●	●	●	●

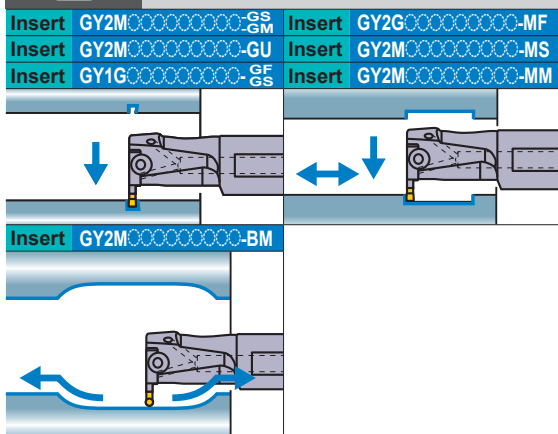
● : Gauge insert shown dimensions

INTERNAL GROOVING

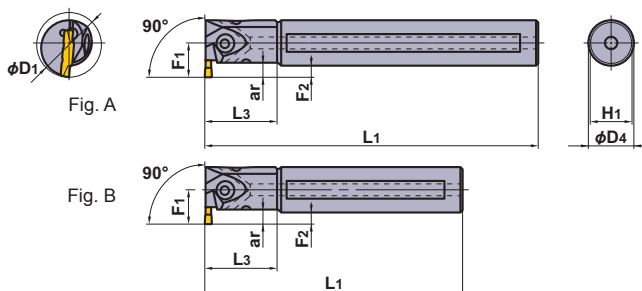
# GY SERIES (INTERNAL GROOVING)

## 6 90° type holder

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



### ● Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	ar (mm) *3	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.			
						Holder	Stock	Modular Blade	Stock				
E	2.39	6	25	Mono Block	R	<b>GYAR20K90A-E06</b>	●	—	—	B			
				Mono Block	L	<b>GYAL20K90A-E06</b>	●	—	—	B			
			Mono Block	R	<b>GYAR20Q90A-E06</b>	●	—	—	A				
			Mono Block	L	<b>GYAL20Q90A-E06</b>	●	—	—	A				
			Mono Block	R	<b>GYAR25K90B-E06</b>	●	—	—	B				
			Mono Block	L	<b>GYAL25K90B-E06</b>	●	—	—	B				
		2.50	4—9.5 *1	40	Modular	R	<b>GYDR32L90C-M20L</b>	●	<b>GYM20LA-E10</b>	●	D		
					Modular	L	<b>GYDL32L90C-M20R</b>	●	<b>GYM20RA-E10</b>	●	D		
				Modular	R	<b>GYDR32S90C-M20L</b>	●	<b>GYM20LA-E10</b>	●	C			
				Modular	L	<b>GYDL32S90C-M20R</b>	●	<b>GYM20RA-E10</b>	●	C			
				2.74	5.5—9.5 *1	50	Modular	R	<b>GYDR40M90D-M20L</b>	●	<b>GYM20LA-E10</b>	●	D
							Modular	L	<b>GYDL40M90D-M20R</b>	●	<b>GYM20RA-E10</b>	●	D
	7—11.5 *1	60	60	Modular	R	<b>GYDR40M90D-M25L</b>	●	<b>GYM25LA-E12</b>	●	D			
				Modular	L	<b>GYDL40M90D-M25R</b>	●	<b>GYM25RA-E12</b>	●	D			
			Modular	R	<b>GYDR40T90D-M25L</b>	●	<b>GYM25LA-E12</b>	●	C				
			Modular	L	<b>GYDL40T90D-M25R</b>	●	<b>GYM25RA-E12</b>	●	C				
			70	70	Modular	R	<b>GYDR50P90F-M25L</b>	●	<b>GYM25LA-E12</b>	●	D		
					Modular	L	<b>GYDL50P90F-M25R</b>	●	<b>GYM25RA-E12</b>	●	D		
					R	<b>GYDR50T90F-M25L</b>	●	<b>GYM25LA-E12</b>	●	C			
					L	<b>GYDL50T90F-M25R</b>	●	<b>GYM25RA-E12</b>	●	C			

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Min. Cutting Diameter

\*1 The maximum groove depth varies according to the cutting diameter D<sub>1</sub>. For details, please refer to page 101.

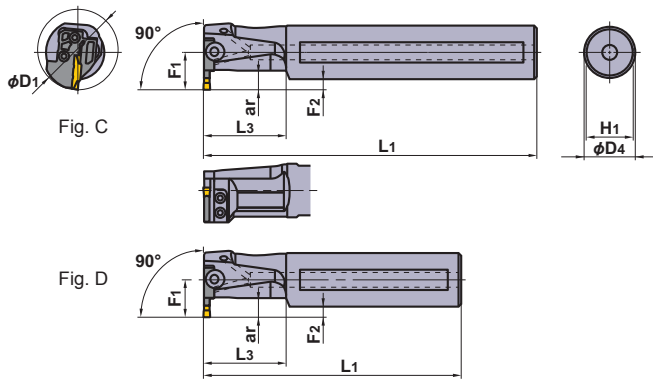
\*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>3</sub>, F<sub>1</sub> and F<sub>2</sub> values may vary.

\*3 The maximum groove depth (ar) is a value within the dimension L<sub>3</sub>.

● : Inventory maintained in Japan.

●Modular blade type (Air / coolant through)

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



Right hand tool holder shown.

**SPARE PARTS**

Holder Number		4 pcs.	
	Clamp Screw	Blade Screw	Wrench *
<b>GYAR/L20-90A-06</b>	GY05016S (Clamp Torque : 5.0N·m)	—	①TKY20R
<b>GYAR/L25-90B-06</b>	—	—	—
<b>GYDR/L32-90C-M20L/R</b>	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
<b>GYDR/L40-90D-M20L/R</b>	—	—	—
<b>GYDR/L40-90D-M25L/R</b>	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
<b>GYDR/L50-90F-M25L/R</b>	—	—	—

	Dimensions (mm) *2						Cutting Mode
	D4	L1	L3	F1	F2	H1	
	20	125	30	14.5	4.5	18	<b>R</b> 
	20	125	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	25	125	40	19	6.5	23	
	25	125	40	19	6.5	23	
	25	200	40	19	6.5	23	
	25	200	40	19	6.5	23	
	32	140	50	22	6	30	<b>L</b> 
	32	140	50	22	6	30	
	32	250	50	22	6	30	
	32	250	50	22	6	30	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	50	170	80	34	9	47	
	50	170	80	34	9	47	
	50	300	80	34	9	47	
	50	300	80	34	9	47	

Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		W3	2.39mm	●	●
E	2.50mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3	2.39mm	●	
E	2.50mm	●	●	●	●
	2.74mm	●			

● : Gauge insert shown dimensions

INTERNAL GROOVING

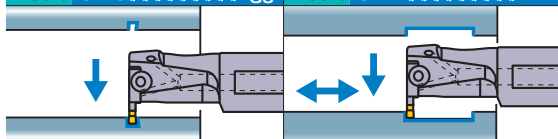
# GY SERIES (INTERNAL GROOVING)

## 6

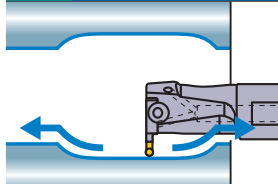
### 90° type holder

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

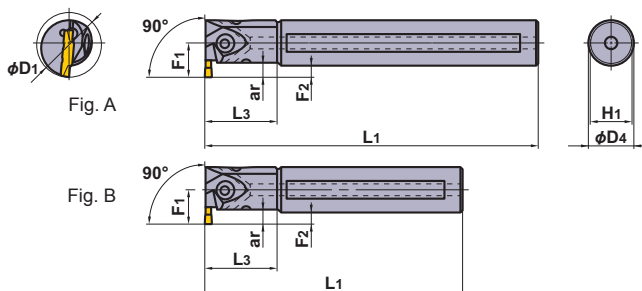
Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GS</sup>	Insert	GY2M <sup>MM</sup>



Insert GY2M<sup>BM</sup>



● Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	ar (mm) *3	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	6	25	Mono Block	R	GYAR20K90A-F06	●	—	—	B
				Mono Block	L	GYAL20K90A-F06	●	—	—	B
			Mono Block	R	GYAR20Q90A-F06	●	—	—	A	
			Mono Block	L	GYAL20Q90A-F06	●	—	—	A	
			Mono Block	R	GYAR25K90B-F06	●	—	—	B	
			Mono Block	L	GYAL25K90B-F06	●	—	—	B	
		4—9.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-F10	●	D
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-F10	●	D
			Modular	R	GYDR32S90C-M20L	●	GYM20LA-F10	●	C	
			Modular	L	GYDL32S90C-M20R	●	GYM20RA-F10	●	C	
			50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-F10	●	D
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-F10	●	D
	7—11.5 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-F10	●	D	
			Modular	L	GYDL40M90D-M25R	●	GYM25RA-F10	●	D	
		Modular	R	GYDR40T90D-M25L	●	GYM25LA-F12	●	C		
		Modular	L	GYDL40T90D-M25R	●	GYM25RA-F12	●	C		
		70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-F12	●	D	
			Modular	L	GYDL50P90F-M25R	●	GYM25RA-F12	●	D	
G	4.00 4.24	7	32	Mono Block	R	GYAR25K90B-G07	●	—	—	B
				Mono Block	L	GYAL25K90B-G07	●	—	—	B
		4.5—11.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-G12	●	D
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-G12	●	D
		6—11.5 *1	50	Modular	R	GYDR32S90C-M20L	●	GYM20LA-G12	●	C
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-G12	●	C
	7.5—13 *1	60	Modular	R	GYDR40M90D-M20L	●	GYM20LA-G12	●	D	
			Modular	L	GYDL40M90D-M20R	●	GYM20RA-G12	●	D	
		70	Modular	R	GYDR40T90D-M20L	●	GYM20LA-G12	●	C	
			Modular	L	GYDL40T90D-M20R	●	GYM20RA-G12	●	C	
		7.5—13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-G14	●	D
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-G14	●	D
70	Modular	R	GYDR40T90D-M25L	●	GYM25LA-G14	●	C			
	Modular	L	GYDL40T90D-M25R	●	GYM25RA-G14	●	C			
7.5—13 *1	70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-G14	●	D		
		Modular	L	GYDL50P90F-M25R	●	GYM25RA-G14	●	D		

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Min. Cutting Diameter

\*1 The maximum groove depth varies according to the cutting diameter D<sub>1</sub>. For details, please refer to page 101.

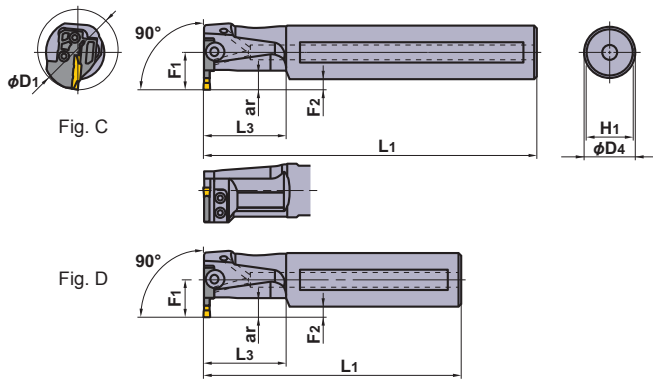
\*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>3</sub>, F<sub>1</sub> and F<sub>2</sub> values may vary.

\*3 The maximum groove depth (ar) is a value within the dimension L<sub>3</sub>.

● : Inventory maintained in Japan.

●Modular blade type (Air / coolant through)

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

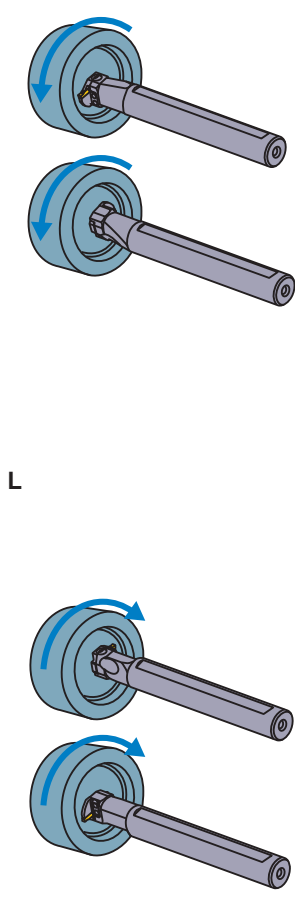


Right hand tool holder shown.

SPARE PARTS

Holder Number	Clamp Screw	Blade Screw 4 pcs.	Wrench *
GYAR/L20○90A-F06	GY05016S (Clamp Torque : 5.0N·m)	—	①TKY20R
GYAR/L25○90B-○○○	—	—	—
GYDR/L32○90C-M20L/R	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
GYDR/L40○90D-M20L/R	—	—	—
GYDR/L40○90D-M25L/R	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
GYDR/L50○90F-M25L/R	—	—	—

	Dimensions (mm) *2						Cutting Mode
	D4	L1	L3	F1	F2	H1	
	20	125	30	14.5	4.5	18	R
	20	125	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	25	125	40	19	6.5	23	
	25	125	40	19	6.5	23	
	25	200	40	19	6.5	23	
	25	200	40	19	6.5	23	
	32	140	50	22	6	30	
	32	140	50	22	6	30	
	32	250	50	22	6	30	
	32	250	50	22	6	30	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	50	170	80	34	9	47	
	50	170	80	34	9	47	
	50	300	80	34	9	47	
	50	300	80	34	9	47	
	25	125	40	19	6.5	23	
	25	125	40	19	6.5	23	
	25	200	40	19	6.5	23	
	25	200	40	19	6.5	23	
	32	140	50	22	6	30	
	32	140	50	22	6	30	
	32	250	50	22	6	30	
	32	250	50	22	6	30	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	50	170	80	34	9	47	
	50	170	80	34	9	47	
	50	300	80	34	9	47	
	50	300	80	34	9	47	



Select an Insert

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

		For Grooving/Cutting off > P9, P10			
Seat Size	Breaker	GU	GS	GM	GFGS
		F	3.00mm	●	●
	3.18mm	●	●	●	●

		For Multifunctional Grooving > P10, P11			
Seat Size	Breaker	MF	MS	MM	BM
		F	3.00mm		
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8			●	
	3.18mm				●
	Re 0.2	●			
	Re 0.4	●			
	3.24mm	●			

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

		For Grooving/Cutting off > P9, P10			
Seat Size	Breaker	GU	GS	GM	GFGS
		G	4.00mm	●	●

		For Multifunctional Grooving > P10, P11			
Seat Size	Breaker	MF	MS	MM	BM
		G	4.00mm		
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8	●		●	
	4.24mm	●			

● : Gauge insert shown dimensions

IDENTIFICATION > P7, P8  
CUTTING CONDITIONS > P101  
INSTRUCTION MANUAL > P103

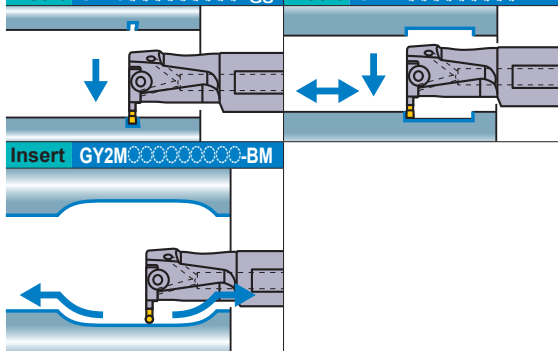
INTERNAL GROOVING

# GY SERIES (INTERNAL GROOVING)

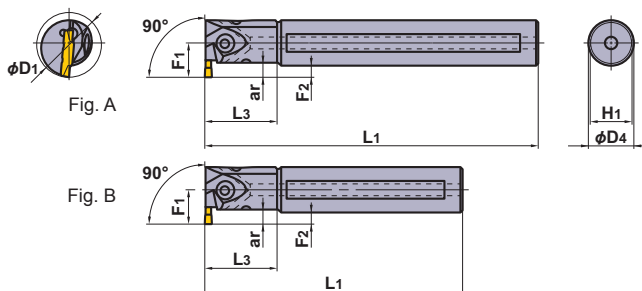
## 6 90° type holder

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

Insert	GY2M <sup>GS</sup>	Insert	GY2G <sup>MF</sup>
Insert	GY2M <sup>GU</sup>	Insert	GY2M <sup>MS</sup>
Insert	GY1G <sup>GF</sup>	Insert	GY2M <sup>MM</sup>



### ● Mono block type (Air / coolant through)



Right hand tool holder shown.

Seat Size	W <sub>3</sub> (mm)	ar (mm) *3	D <sub>1</sub> (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
H	4.75 5.00 5.24	7	32	Mono Block	R	<b>GYAR25K90B-H07</b>	●	—	—	B	
				Mono Block	L	<b>GYAL25K90B-H07</b>	●	—	—	B	
		4.5—11.5 *1	40	Modular	R	<b>GYDR32L90C-M20L</b>	●	<b>GYM20LA-H12</b>	●	D	
				Modular	L	<b>GYDL32L90C-M20R</b>	●	<b>GYM20RA-H12</b>	●	D	
			6—11.5 *1	50	Modular	R	<b>GYDR32S90C-M20L</b>	●	<b>GYM20LA-H12</b>	●	C
					Modular	L	<b>GYDL32S90C-M20R</b>	●	<b>GYM20RA-H12</b>	●	C
	7.5—13 *1	60	Modular	R	<b>GYDR40M90D-M20L</b>	●	<b>GYM20LA-H12</b>	●	D		
			Modular	L	<b>GYDL40M90D-M20R</b>	●	<b>GYM20RA-H12</b>	●	D		
		70	Modular	R	<b>GYDR40T90D-M20L</b>	●	<b>GYM20LA-H12</b>	●	C		
			Modular	L	<b>GYDL40T90D-M20R</b>	●	<b>GYM20RA-H12</b>	●	C		
		6.00 6.31 6.35	7.5—13 *1	60	Modular	R	<b>GYDR40M90D-M25L</b>	●	<b>GYM25LA-H14</b>	●	D
					Modular	L	<b>GYDL40M90D-M25R</b>	●	<b>GYM25RA-H14</b>	●	D
70	Modular		R	<b>GYDR40T90D-M25L</b>	●	<b>GYM25LA-H14</b>	●	C			
	Modular		L	<b>GYDL40T90D-M25R</b>	●	<b>GYM25RA-H14</b>	●	C			

W<sub>3</sub> = Insert Width      ar = Max. Groove Depth      D<sub>1</sub> = Min. Cutting Diameter

\*1 The maximum groove depth varies according to the cutting diameter D<sub>1</sub>. For details, please refer to page 101.

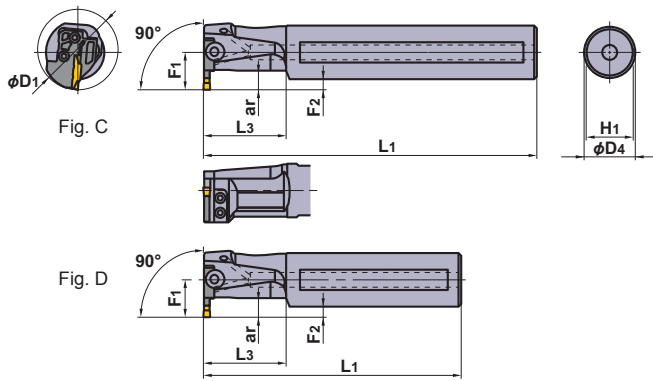
\*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L<sub>1</sub>, L<sub>3</sub>, F<sub>1</sub> and F<sub>2</sub> values may vary.

\*3 The maximum groove depth (ar) is a value within the dimension L<sub>3</sub>.

● : Inventory maintained in Japan.

●Modular blade type (Air / coolant through)

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

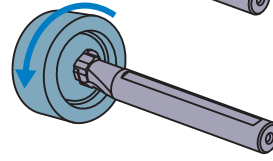
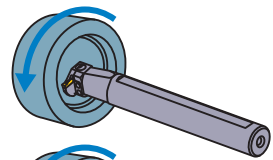


Right hand tool holder shown.

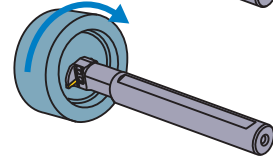
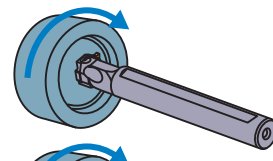
**SPARE PARTS**

Holder Number	Clamp Screw	Blade Screw 4 pcs.	Wrench *
<b>GYAR/L25○90B-○07</b>	GY05016S (Clamp Torque : 5.0N·m)	—	①TKY20R
<b>GYDR/L32○90C-M20L/R</b>	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	①TKY30R ②TKY15D
<b>GYDR/L40○90D-M20L/R</b>	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
<b>GYDR/L40○90D-M25L/R</b>	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D
<b>GYDR/L50○90F-M25L/R</b>	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	①TKY30R ②TKY25D

	Dimensions (mm) *2						Cutting Mode
	D4	L1	L3	F1	F2	H1	
	25	125	40	19	6.5	23	R
	25	125	40	19	6.5	23	
	25	200	40	19	6.5	23	
	25	200	40	19	6.5	23	
	32	140	50	22	6	30	
	32	140	50	22	6	30	
	32	250	50	22	6	30	
	32	250	50	22	6	30	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	50	170	80	34	9	47	
	50	170	80	34	9	47	
	50	300	80	34	9	47	
	50	300	80	34	9	47	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	50	170	80	34	9	47	
	50	170	80	34	9	47	
	50	300	80	34	9	47	
	50	300	80	34	9	47	



L



**Select an Insert**

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		W3			
H	4.75mm	●	●	●	●
	5.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
H	4.75mm				●
	Re 0.2	●			
	Re 0.4	●			
	Re 0.8	●			
	5.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
5.24mm	●				

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
		W3			
J	6.00mm	●	●	●	
	6.35mm	●	●	●	

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
		W3			
J	6.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	Re 0.2	●			
	Re 0.4	●			
Re 0.8	●				

● : Gauge insert shown dimensions

IDENTIFICATION > P7, P8  
CUTTING CONDITIONS > P101  
INSTRUCTION MANUAL > P103

INTERNAL GROOVING

# Grooving system

## RECOMMENDED CUTTING SPEED (m/min) [For External Grooving]

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

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.

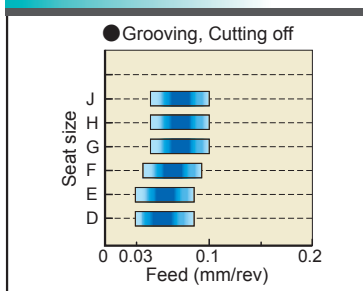
(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

## RECOMMENDED CUTTING CONDITIONS [For External Grooving]

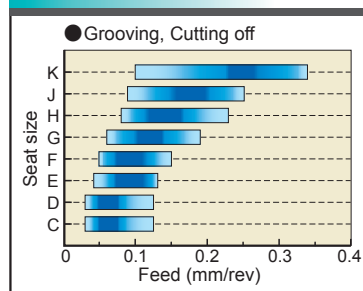
\*Below are the recommended cutting conditions when using the modular type holder GYHR/L2525M00/90-M25R/L with the modular blade GYM25R/LA-○○○○.

### Recommended feed rate and depth of cut

#### GU BREAKER

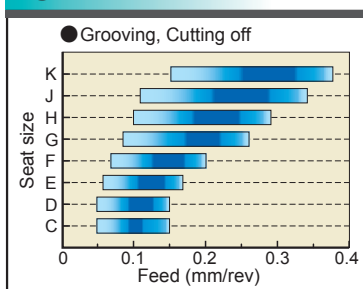


#### GS BREAKER

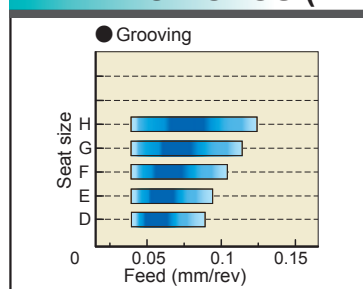


■ : 1st recommended area

#### GM BREAKER



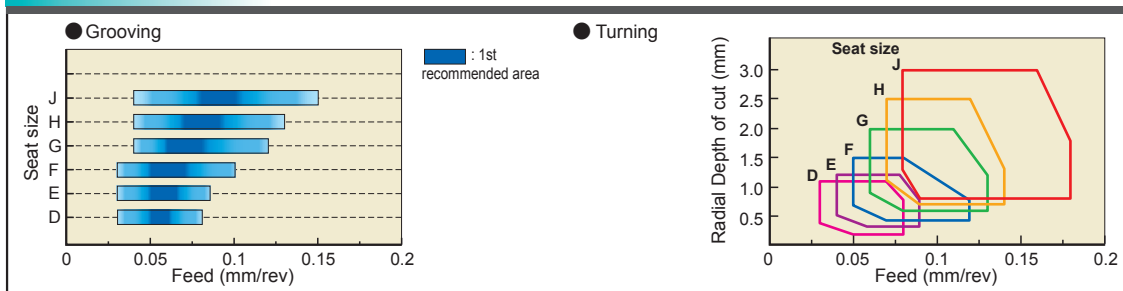
#### FLAT TOP GFGS (CBN)



Seat Size	
Insert Width (mm)	
C	1.50
D	2.00
	2.24
E	2.39
	2.50
	2.74
F	3.00
	3.18
	3.24
G	4.00
	4.24
	4.75
H	5.00
	5.24
J	6.00
	6.31
	6.35
K	8.00

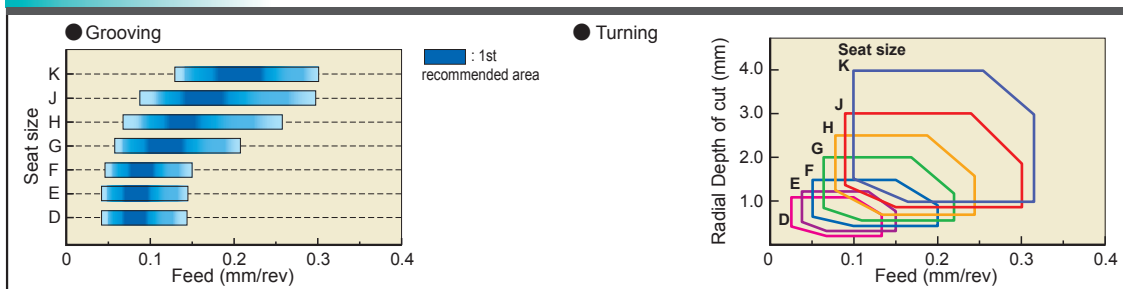


## MF BREAKER

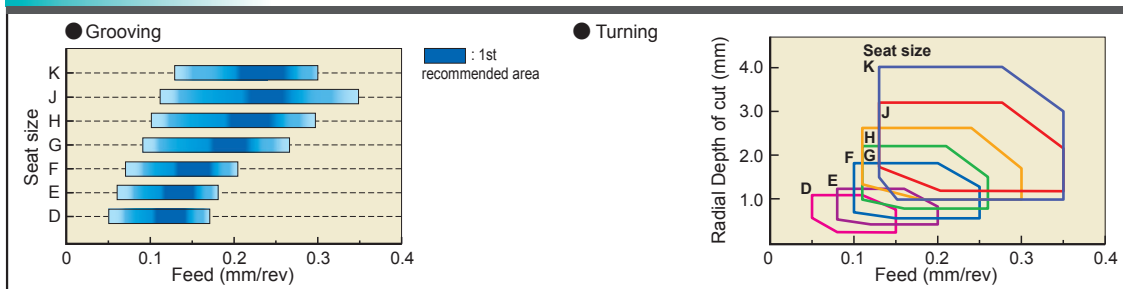


Seat Size	
Insert Width (mm)	
D	2.00
	2.24
E	2.39
	2.50
F	3.00
	3.18
G	3.24
	4.00
H	4.24
	4.75
J	5.00
	5.24
K	6.00
	6.31
K	6.35
	8.00

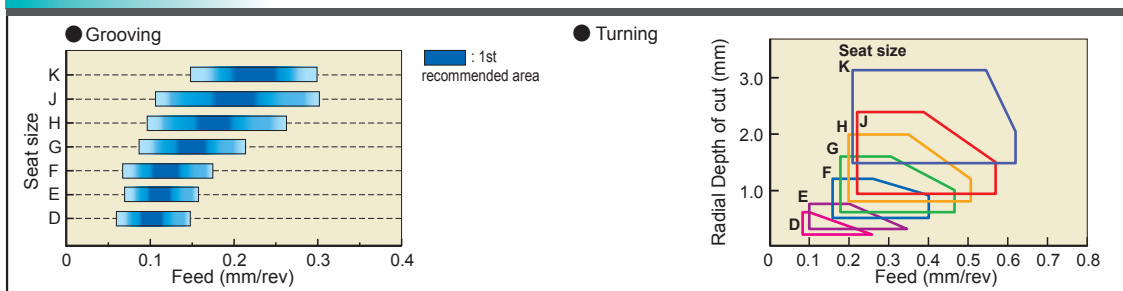
## MS BREAKER



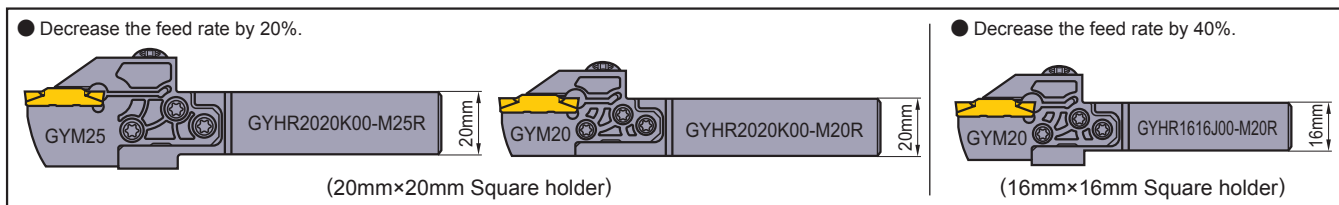
## MM BREAKER



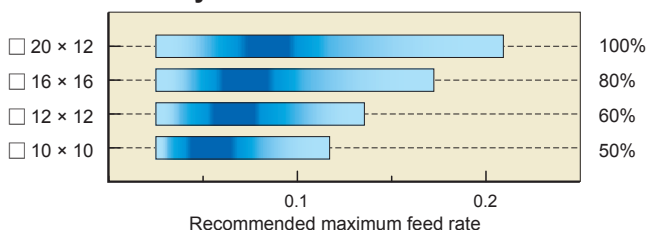
## BM BREAKER



(Note) When using a combination as shown below, decrease the recommended feed rate by 20% and 40% respectively.



### For Swiss style lathes mono block holder

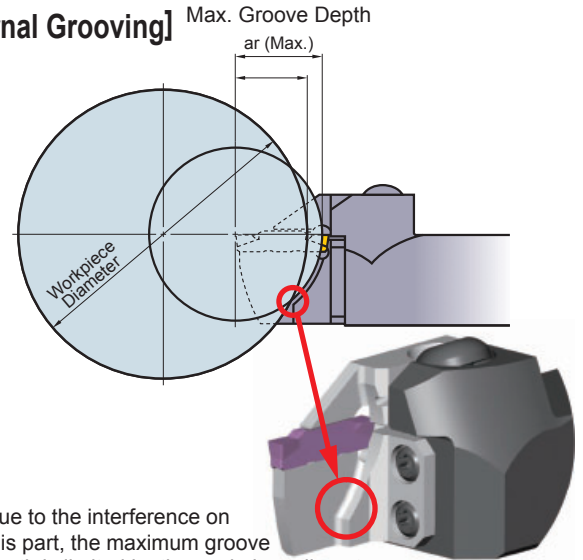
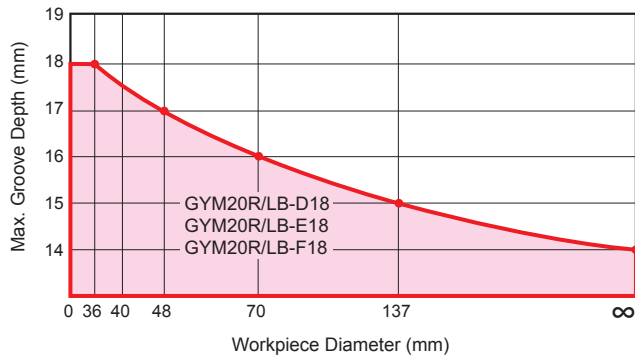


Please refer to the tables above of recommended cutting conditions for external grooving. Apply the percentage ratio shown of each shank size to the values in those tables.

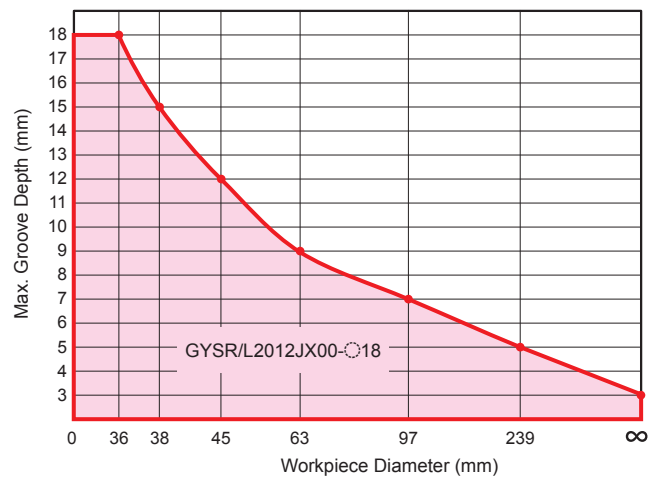
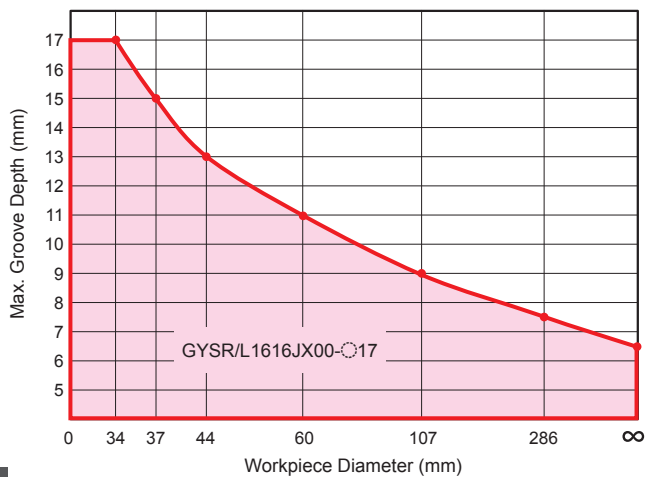
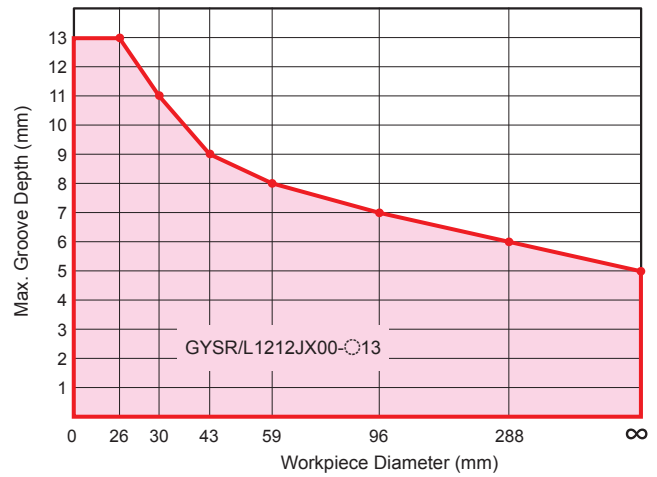
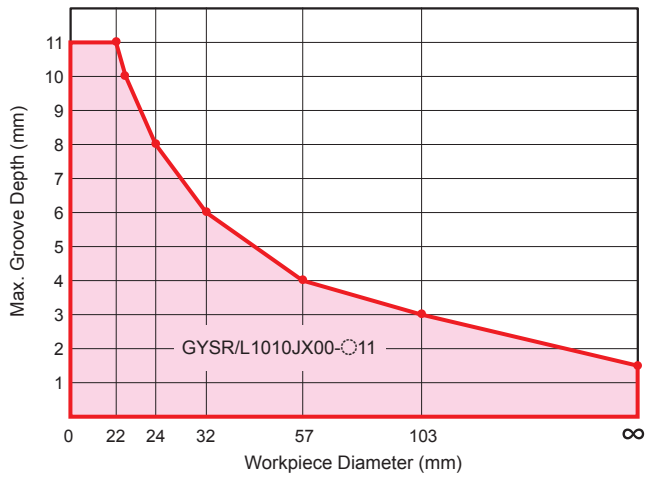
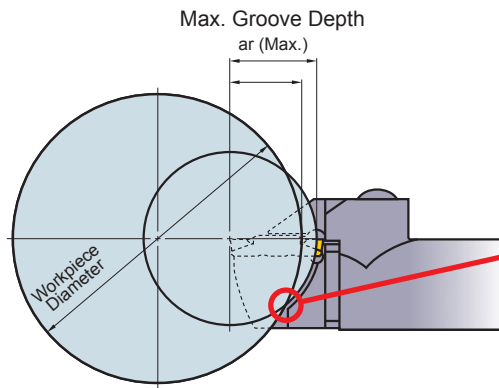
# Grooving system

## LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

- When using the modular blade GYM○○R/LA-○○○  
The maximum groove depth is not limited by the workpiece diameter.
- When using the modular blade GYM○○R/LB-○○○  
The maximum groove depth is limited by the workpiece diameter.



- For Swiss style lathes mono block holder  
The maximum groove depth is limited by the workpiece diameter.

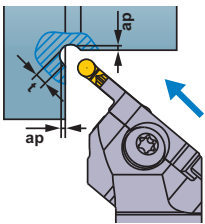


## RECOMMENDED CUTTING SPEED (m/min) [For External Recessing]

Work Material	Hardness	Grade	Cutting Speed (m/min)				
			50	100	150	200	250
P Mild Steel Carbon Steel Alloy Steel Carbon Steel Alloy Steel	≤180HB	VP20RT	80		180		
		VP10RT	90		190		
	180–280HB	VP20RT	60		140		
		VP10RT	70		150		
		MY5015	90		210		
	280–350HB	VP20RT	50		110		
		VP10RT	60		120		
		MY5015	80		160		
M Stainless Steel	≤350HB	VP20RT	50		110		
		VP10RT	60		120		
K Gray Cast Iron Ductile Cast Iron	Tensile Strength ≤350MPa	VP20RT	60		140		
		VP10RT	70		150		
		MY5015	90		210		
	Tensile Strength ≤800MPa	VP20RT	50		110		
		VP10RT	60		120		
		MY5015	80		160		
S Titanium Alloy Heat Resistant Alloy	—	VP20RT	30		60		
		VP10RT	40		70		
	—	VP20RT	30		60		
		VP10RT	40		70		

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.  
 (Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

## DISTANCE FROM THE WORKPIECE TO THE RECESS DEPTH

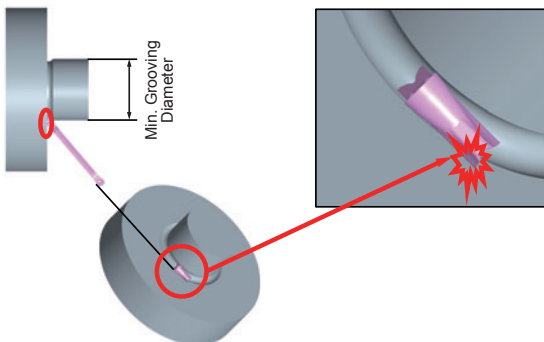


Grooving Width W (mm)	Recessing Depth t (mm)	Distance workpiece to the recess depth ap (mm)
2.00	1.50	0.646
2.50	1.75	0.720
3.00	2.00	0.793
3.18	2.09	0.819
4.00	2.50	0.939
4.75	2.88	1.049
5.00	3.00	1.086
6.00	3.50	1.232
6.35	3.68	1.283

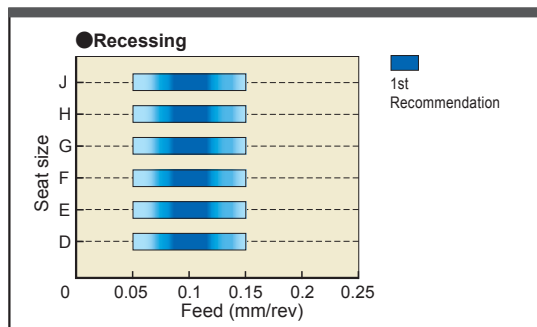
## BM BREAKER

### Minimum grooving diameter

Ensure the tool is suitable for the diameter being machined. Refer to the Min. Grooving Diameter D<sub>1</sub> as shown in the table on the first page to avoid a collision with the workpiece as shown below.



### Recommended feed rate and depth of cut

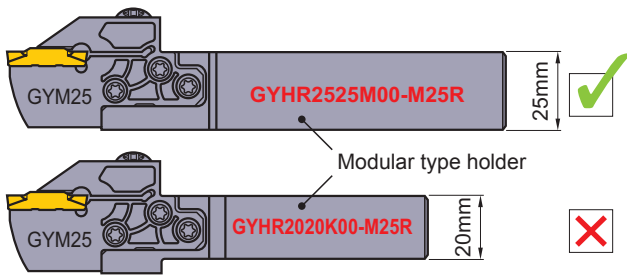


# Grooving system

## TOOL SELECTION

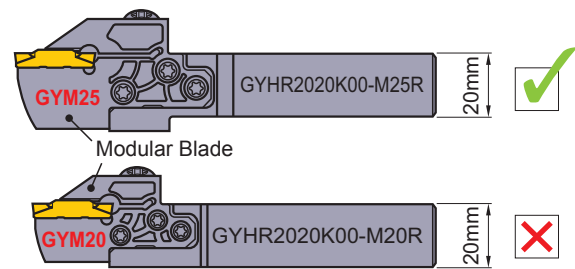
### ● Notes when selecting the tool body

#### Modular type holder



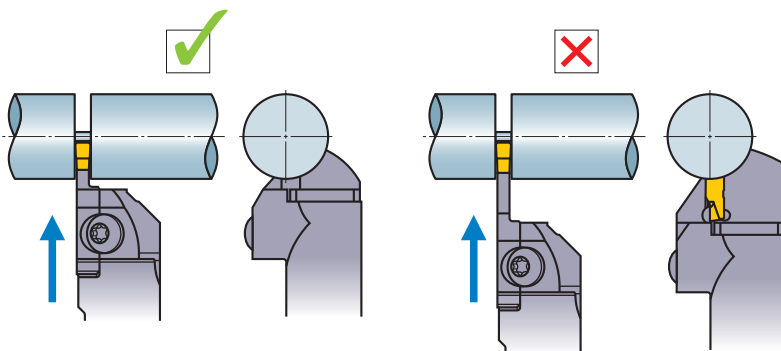
● To ensure sufficient clamping rigidity, select a modular type holder with the largest possible shank size.

#### Modular blade (1)



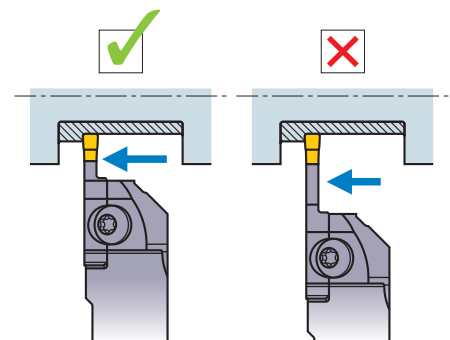
● If there is no restriction for use, select the largest modular blade for the same shank size.

#### Modular blade (2)



● Select the shortest possible blade suitable for the application.

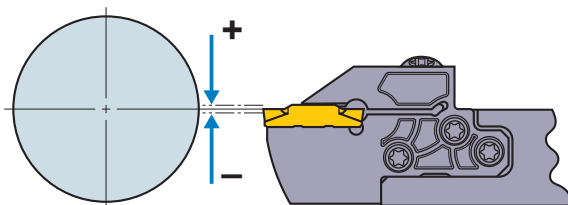
#### Modular blade (3)



● Select the shortest possible blade suitable for the application.

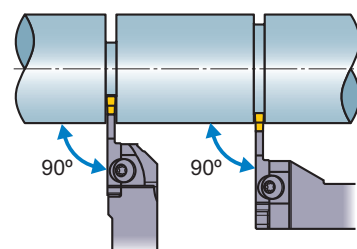
### ● Notes when setting the tool

#### Setting of cutting edge height



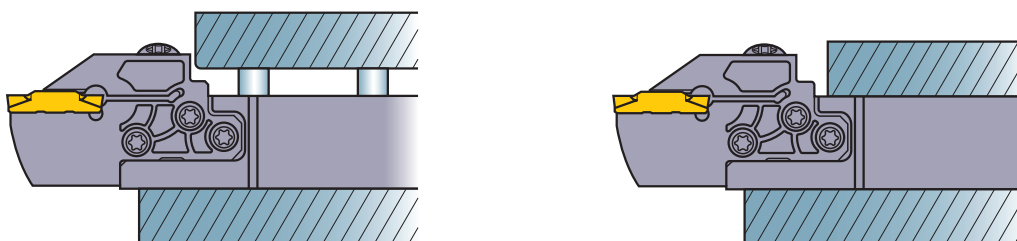
<Grooving/Cross-feed machining>  
Set the cutting edge height to  $\pm 0.1\text{mm}$  parallel to the central axis.  
<Cutting off>  
Set the cutting edge height to  $0\text{--}+0.2\text{mm}$  parallel to the central axis.

#### Tool body setting angle



● Set the insert perpendicular to the central axis.

#### Overhang

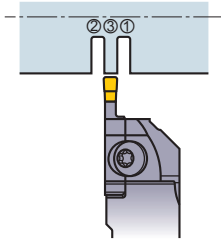


● When setting the tool, ensure that the overhang is as short as possible and avoid the step difference part as above figure shows.

## MACHINING RECOMMENDATIONS

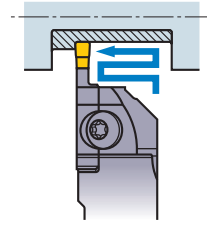
### ● Notes on multi-functional machining (MF,MS,MM and BM breakers)

#### Machining narrow grooves



- It is recommended to carry out plunging in several passes. Following the steps above makes it difficult for chips to elongate. This also improves the accuracy of workpiece wall surface.

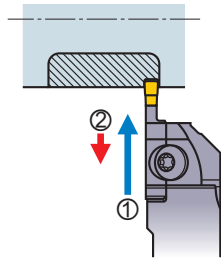
#### Machining wide grooves



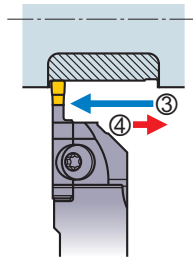
- It is recommended that cross-feed machining is used.

### Machining wide grooves

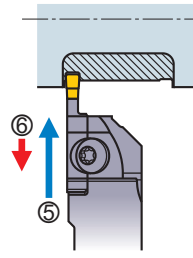
#### ROUGHING



- ① Carry out grooving.
- ② Retract the tool approx 0.1mm.

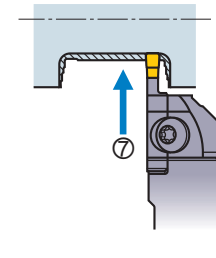


- ③ Carry out cross feed machining.
- ④ Retract the tool approx 0.1mm.

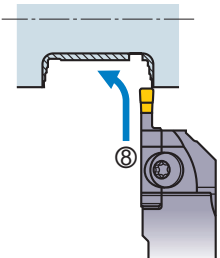


- ⑤ Carry out grooving.
  - ⑥ Retract the tool approx 0.1mm.
- \* Repeat the steps ①-⑥.

#### FINISHING

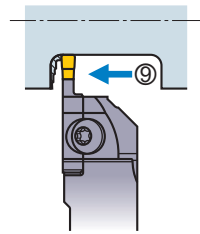


- ⑦ Carry out grooving to the end point of the corner radius.

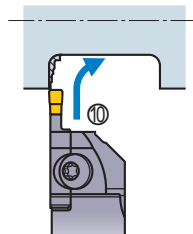


- ⑧ Machining of the wall surface, corner radius and bottom face should be carried out in one process.

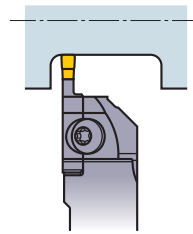
#### FINISHING



- ⑨ Stop at the bottom of the corner radius.

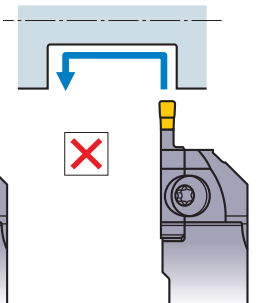
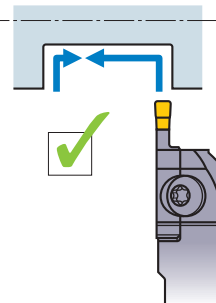


- ⑩ Machine the counter wall to the corner radius in one process.



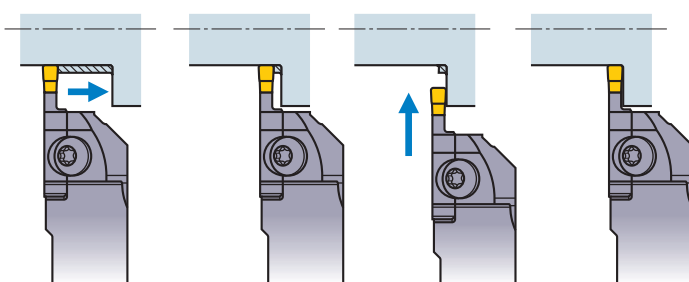
- ⑪ Finish machining.

#### Precautions when finishing walls



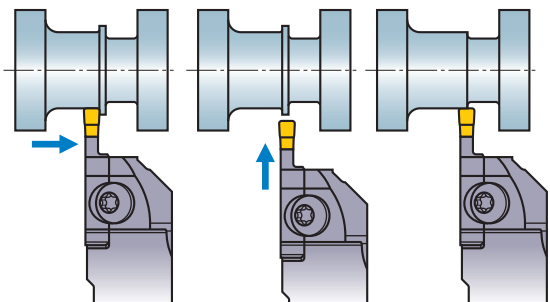
- To produce high accuracy walls using MS or MM breaker insert, do not carry out back turning. Plunging is recommended.

#### Wall machining



- When machining a wall, chip jamming can occur. In this case, stop cross feed machining just before the wall (at a point less than the insert width) then remove the remaining material by plunging.

#### Machining of a ring section



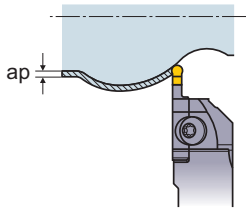
- When a ring remains in a cross feed end process, finish cross feed machining 1-1.5mm short of the end point, then remove the ring by plunging.

# Grooving system

## MACHINING RECOMMENDATIONS

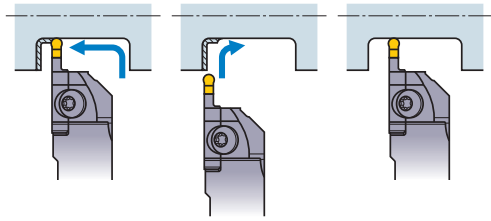
### ● Notes on multi-functional machining (BM breaker)

#### Copying



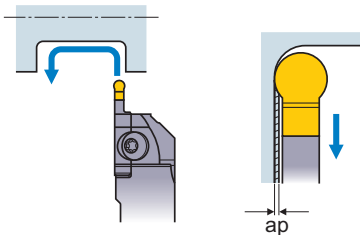
- With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut ( $a_p$ ) to 40% less than the insert width.

#### Roughing



- Use plunging and cross-feed machining. When machining the corner, vibration is likely to occur. To avoid this, reduce the feed by 50%.

#### Finishing



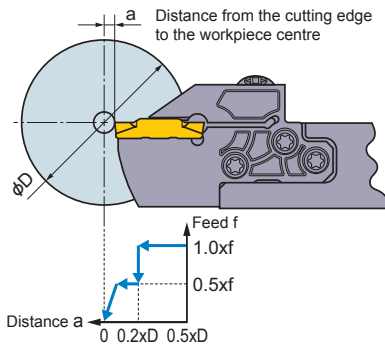
- Carry out finishing in one process. For the depth of cut ( $a_p$ ) when back turning, refer to the table on the right.

Insert	$a_p$ (mm)
GY2M0200D100N-BM	0.05
GY2M0250E125N-BM	0.10
GY2M0300F150N-BM	0.15
GY2M0318F159N-BM	
GY2M0400G200N-BM	0.20
GY2M0475H238N-BM	0.24
GY2M0500H250N-BM	
GY2M0600J150N-BM	0.30
GY2M0635J318N-BM	
GY2M0800K400N-BM	0.40

### ● Notes for cutting off

#### Feed

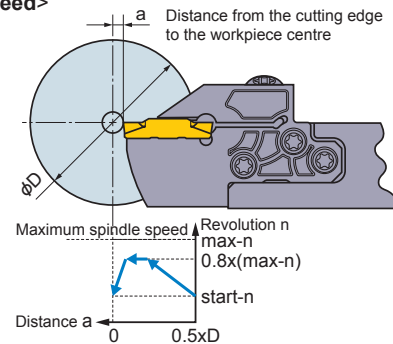
<Feed>



- When the cutting edge approaches the centre, reduce the feed by 50%.
- If necessary, stop the feed prior to reaching the centre of the workpiece to prevent it falling under its own weight.

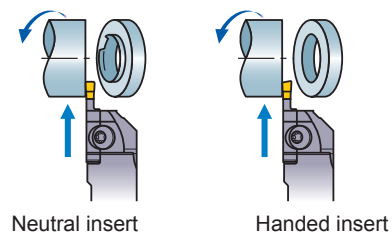
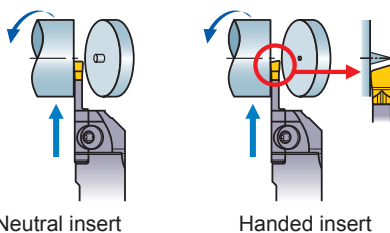
#### Revolution

<Spindle speed>



- When using constant cutting speed during a cutting off cycle, it is recommended to limit the spindle speed to 80% of maximum to ensure stability.
- To prevent the workpiece from being expelled, lower the spindle speed before finishing the grooving operation.

#### Insert



- When there is a centre stub on solid bar work or burrs are formed on pipe material, it is possible to decrease them by using a handed insert. With a handed insert, machining tends to be less stable when compared to using a neutral insert. Pay special attention to avoid fracturing of the cutting edge and decrease the feed when necessary.

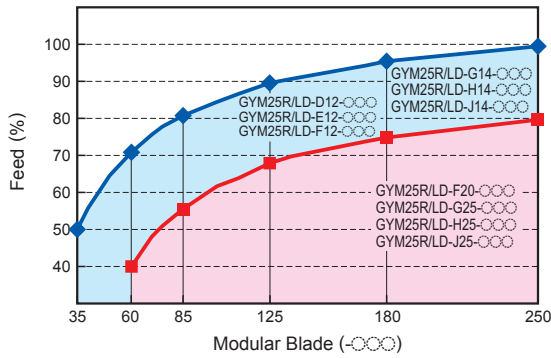
# Memo

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A series of horizontal dashed lines for writing, spanning the width of the page.

# Grooving system

## RELATIONSHIP BETWEEN THE MODULAR BLADE AND FEED PER ROTATION [For Face Grooving]



(Note) Adjust the feed per rotation in the cutting conditions to the percentage shown in the table above.

## RECOMMENDED CUTTING SPEED (m/min) [For Face Grooving]

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

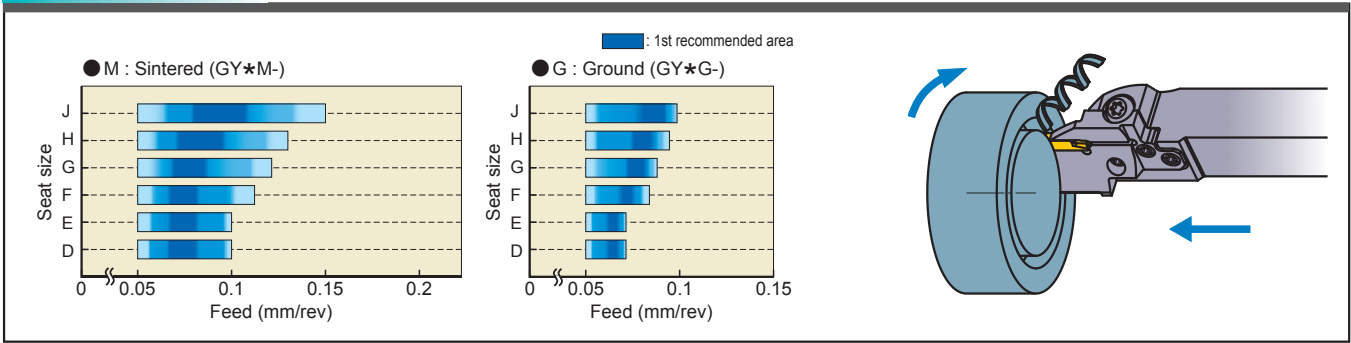
(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.

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

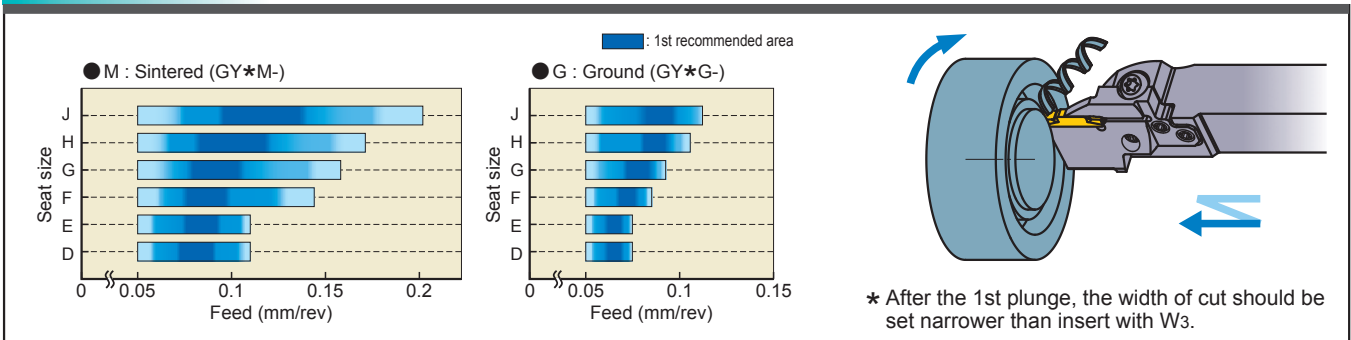


# RECOMMENDED CUTTING CONDITIONS [For Face Grooving]

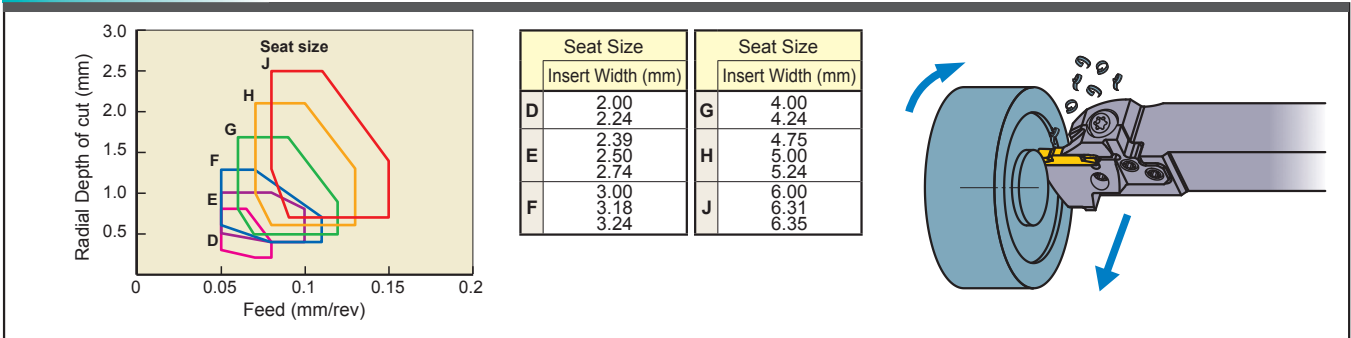
## GROOVING



## PLUNGING



## TRAVERSE MACHINING (MF BREAKER)



## TRAVERSE MACHINING (MM/MS BREAKER)



## TRAVERSE MACHINING (BM BREAKER)

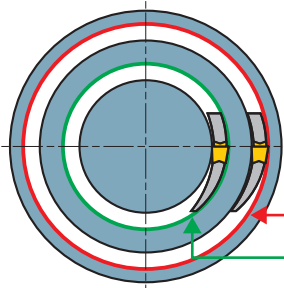


# Grooving system

## TOOL SELECTION

### ● Notes when selecting the tool body

#### Modular blade (1)

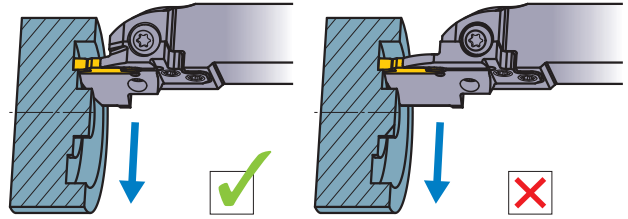


- Select a modular blade for face grooving, so that the cutting diameter at the first pass is within the range of D1 minimum and D1 maximum that are described in the table of dimensions.

φD1 (Max.)

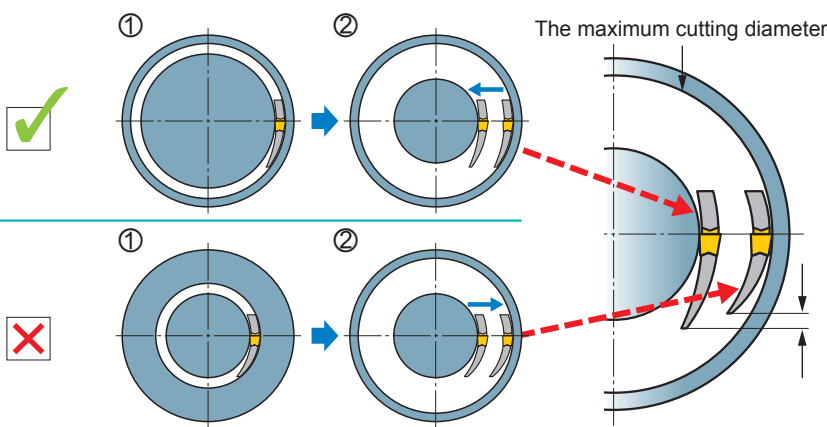
φD1 (Min.)

#### Modular blade (2)



- Select the shortest possible blade suitable for the application.

#### Modular blade (3)

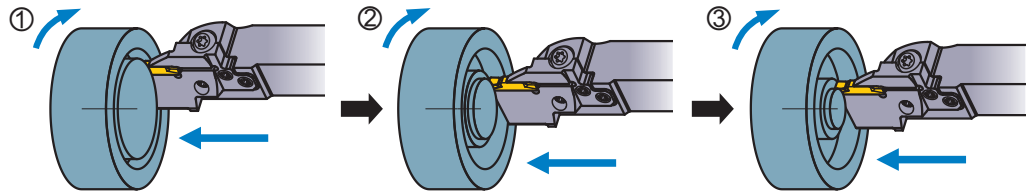


- Select the largest size blade within the maximum cutting diameter of the workpiece.
- Machine from the outer diameter towards the centre.

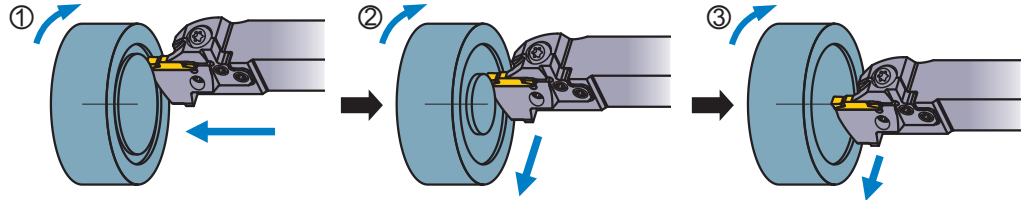
- Increased machining stability and rigidity is possible if a modular blade with the largest possible back metal is used.

- At first machine the maximum cutting diameter, there is no restriction in the cutting diameter on the remaining process.

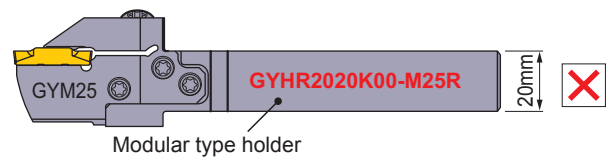
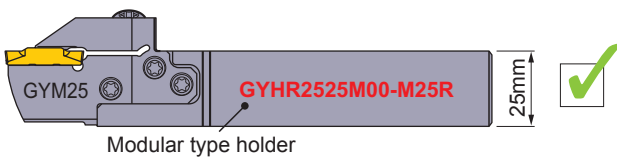
- When plunging in several passes.



- When combining plunging and infeed machining.



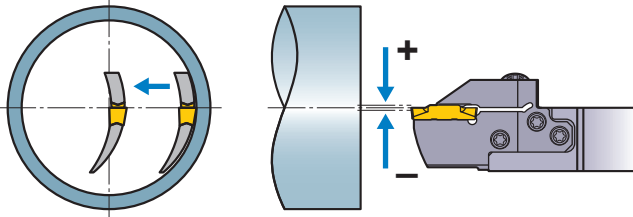
#### Modular type holder



- To ensure sufficient clamping rigidity, select a modular type holder with the largest possible shank size.

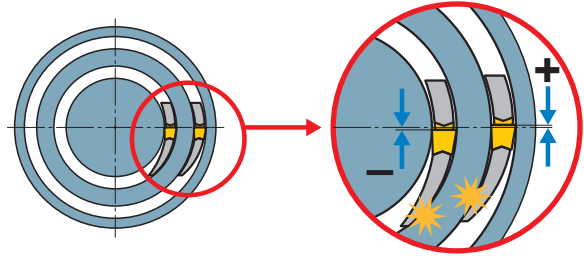
## ● Notes when setting the tool

### Setting the cutting edge height



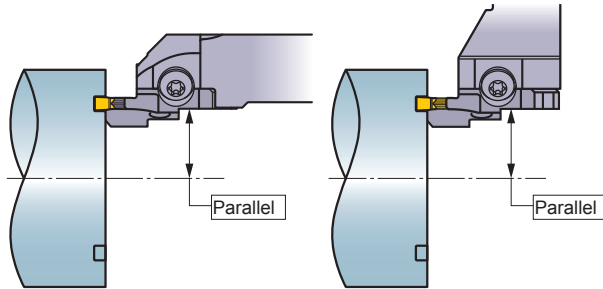
- Set the cutting edge height to  $\pm 0.1\text{mm}$  parallel to the central axis.
- Cutting edge centre height check should be done by traverse machining towards the centre with a very small depth of cut and ensure that an even surface and no material remains at the centre point afterwards.

### When interfering the wall of groove and the Modular blade



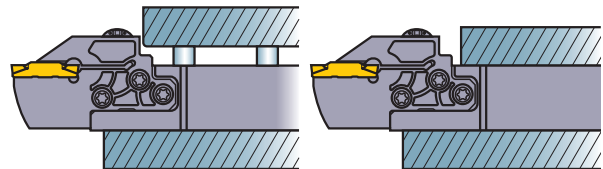
- If interference occurs even when the correct blade is used, the cutting edge height could be incorrect.
  - { When interference occurs on the inner side of the blade, the cutting edge height is set too high.
  - { When interference occurs on the outer side of the blade, the cutting edge height is set too low.

### Setting the tool



- Set the insert parallel to the central axis.

### Tool overhang



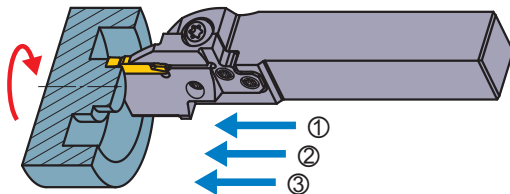
- When setting the tool, ensure that the overhang is as short as possible and avoid the step difference part as above figure shows.

## MACHINING RECOMMENDATIONS

## ● Notes when face grooving

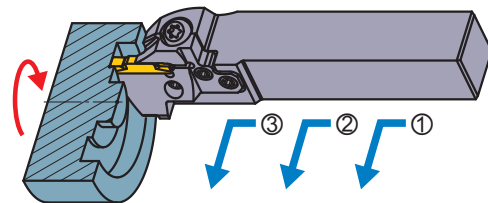
- Always machine from the outer diameter towards the centre.

### Machining narrow grooves



- Plunging in several passes is recommended.

### Machining wide grooves



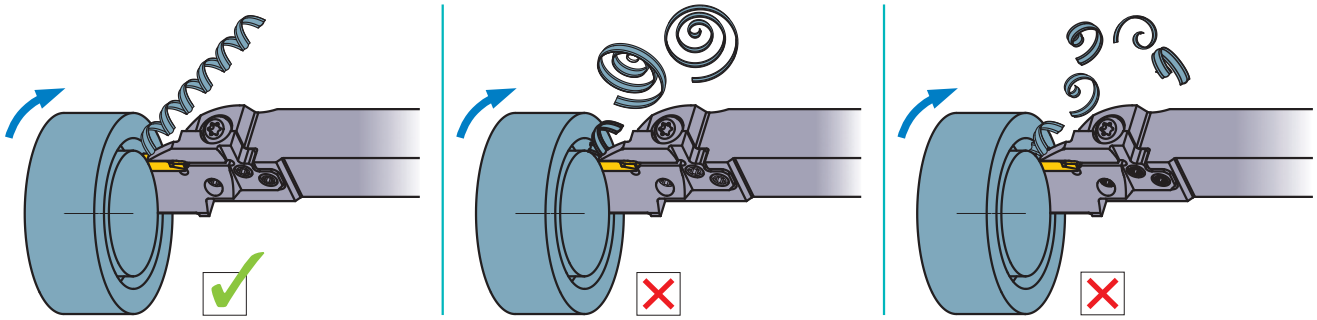
- Cross feed machining is recommended.

# Grooving system

## MACHINING RECOMMENDATIONS

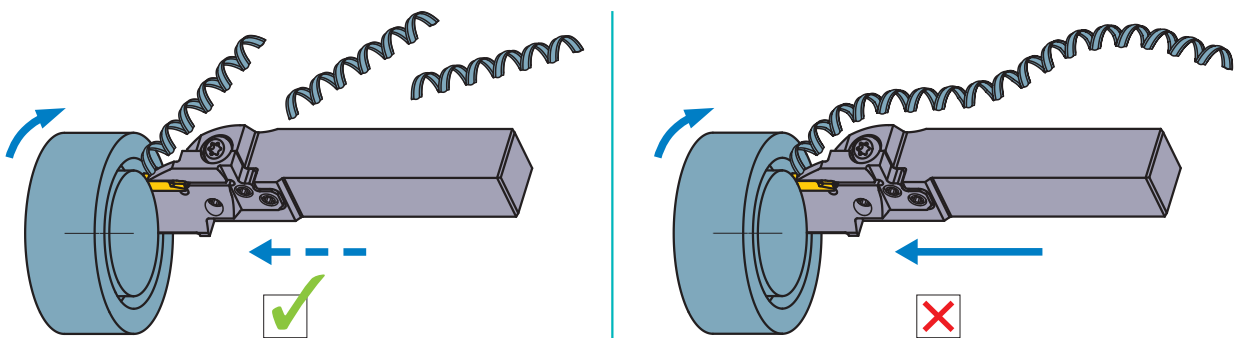
### ● Notes when face grooving (2)

#### Notes on the first pass (1)



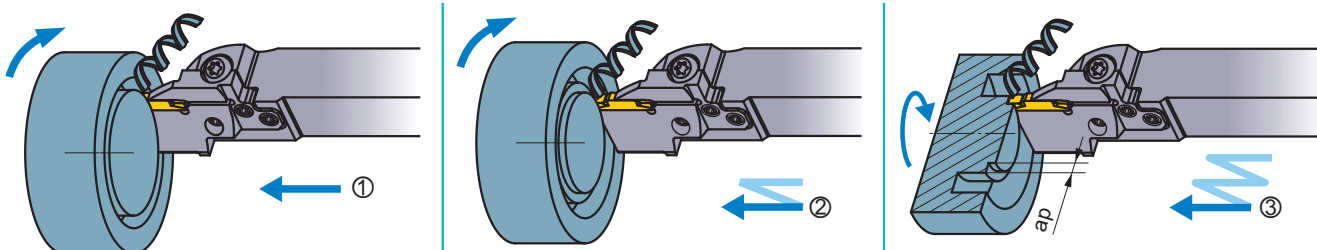
- During the first face grooving pass it is difficult to disperse broken chips and can lead to problems such as a chipped insert. Maintain longer chips that disperse easily by decreasing the feed per rotation.

#### Notes on the first pass (2)



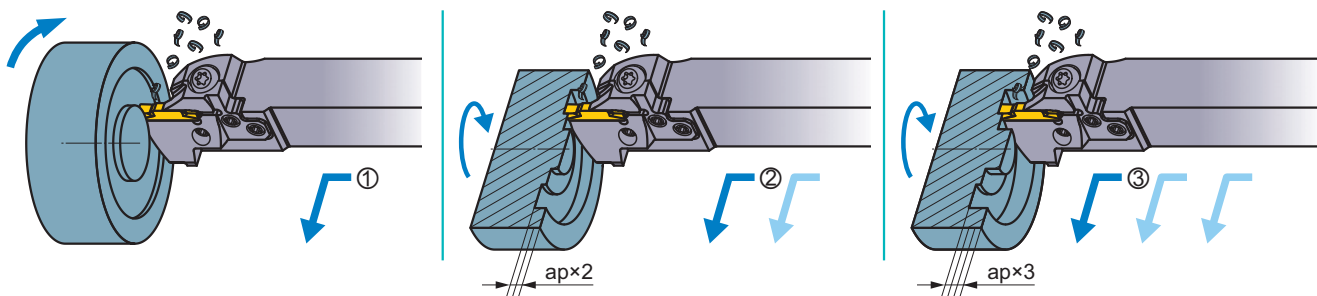
- When chips become too long, use peck feed to break them into a suitable length.

#### Notes when wide face grooving by plunging in several passes



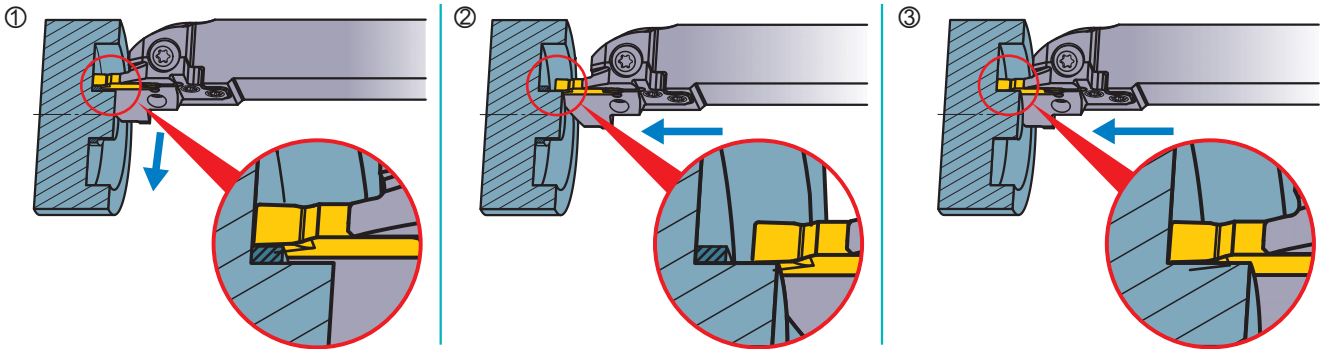
- When machining a face groove in several passes, machine from the outer diameter towards the centre so that space for discharging chips is created to prevent insert damage caused by chip jamming.
- Plunging width of cut is recommended to be set at 60 - 80% of the insert width. This enhances the effect of the chipbreaker by enlarging the width of the groove to improve chip dispersal.

#### Notes when wide face grooving by combination of plunging and traverse machining (1)



- When face groove machining by using plunge feed and traverse machining, always machine from the outer diameter towards the centre to disperse chips outward to avoid chip jamming problems.
- Set the depth of cut within 40% of the insert width.

## Notes when wide face grooving by combination of plunging and traverse machining (2)



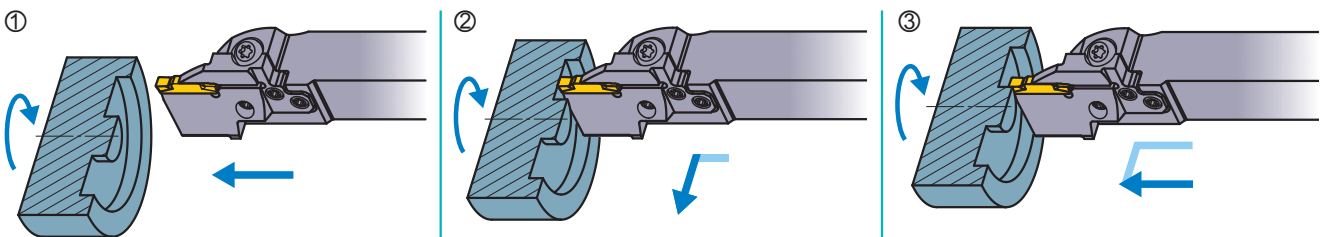
- When infeed machining at the bottom of a deep groove, chips may interfere on the cutting edge near the centre wall. In such cases, stop infeed machining just before the centre wall (at a point less than the insert width) then remove the remaining material by plunging.

## Notes when copying (BM Breaker)



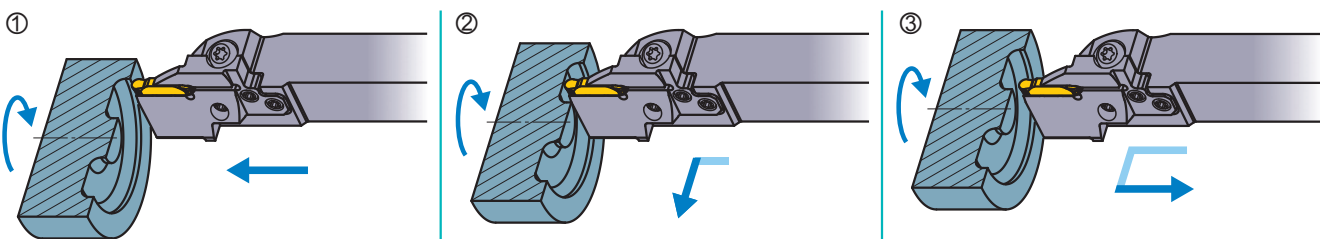
- With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (ap) to 30% less than the insert width.

## Finishing (1)

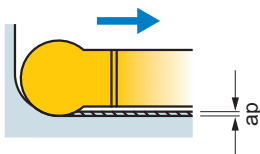


- When finish cutting, machine continuously from the outer wall to the bottom of the groove, then finally plunge cut the centre wall.

## Finishing (2) (BM Breaker)



- Carry out finishing in one process. For the depth of cut (ap) when back turning, refer to the table on the right.



Insert	ap (mm)
GY2M0200D100N-BM	0.10
GY2M0250E125N-BM	
GY2M0300F150N-BM	
GY2M0318F159N-BM	0.15
GY2M0400G200N-BM	
GY2M0475H238N-BM	0.20
GY2M0500H250N-BM	
GY2M0600J150N-BM	0.25
GY2M0635J318N-BM	

# Grooving system

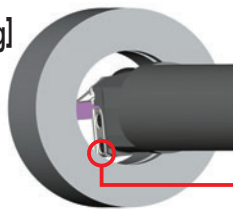
## LIMITATION OF THE MAXIMUM GROOVE DEPTH [For Internal Grooving]

### •When using the mono block type

The maximum groove depth is not limited by the cutting diameter.

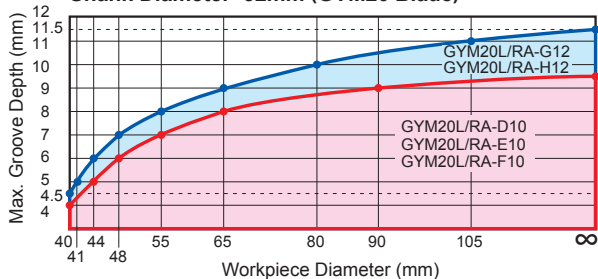
### •When using the modular blade type

The maximum groove depth is limited by the cutting diameter.

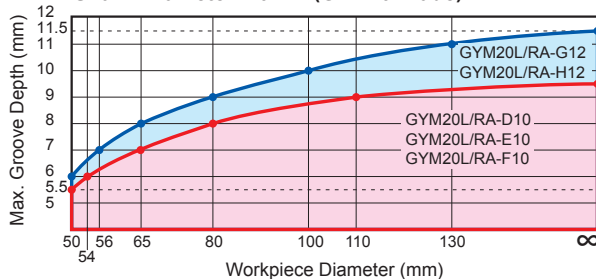


Due to interference of this part, the maximum groove depth is limited by the cutting diameter.

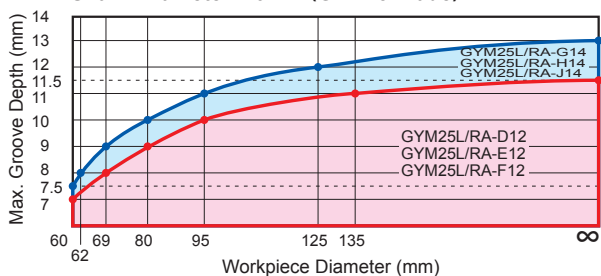
#### •Shank Diameter=32mm (GYM20 Blade)



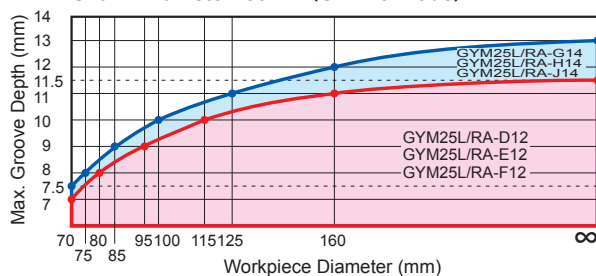
#### •Shank Diameter=40mm (GYM20 Blade)



#### •Shank Diameter=40mm (GYM25 Blade)



#### •Shank Diameter=50mm (GYM25 Blade)



## RECOMMENDED CUTTING SPEED (m/min) [For Internal Grooving]

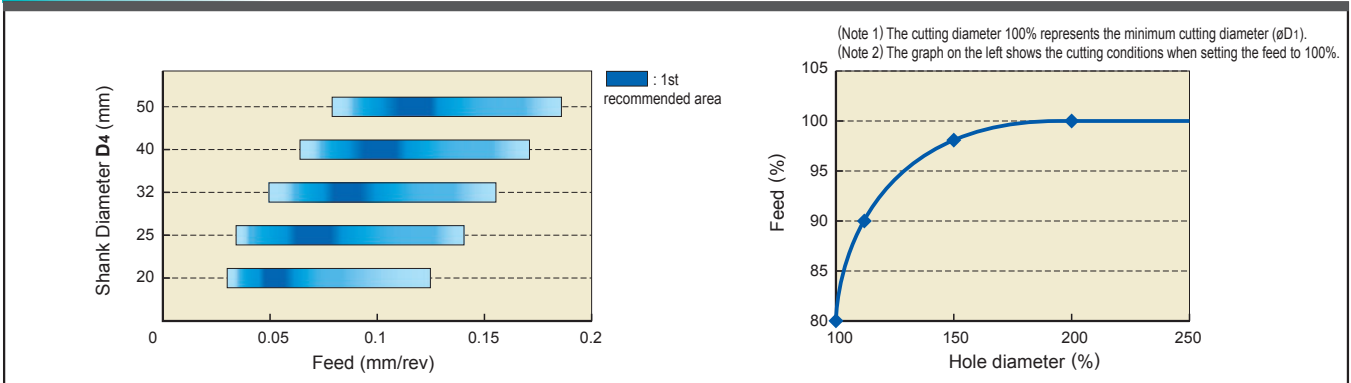
Work Material	Hardness	Grade	Cutting Speed (m/min)							
			50	100	150	200	250	300		
P Mild Steel	≤160HB	VP20RT		80		180				
		VP10RT		90		190				
		NX2525		70		170				
	Carbon Steel Alloy Steel	160–280HB	VP20RT		60		140			
			VP10RT		70		150			
			MY5015		90		210			
		280HB≤	NX2525		55		135			
			VP20RT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

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.

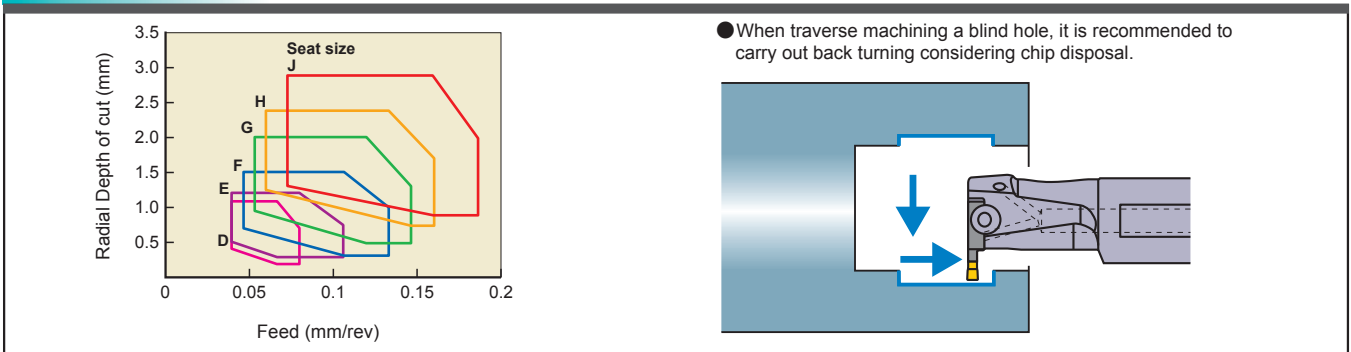
(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

# RECOMMENDED CUTTING CONDITIONS [For Internal Grooving]

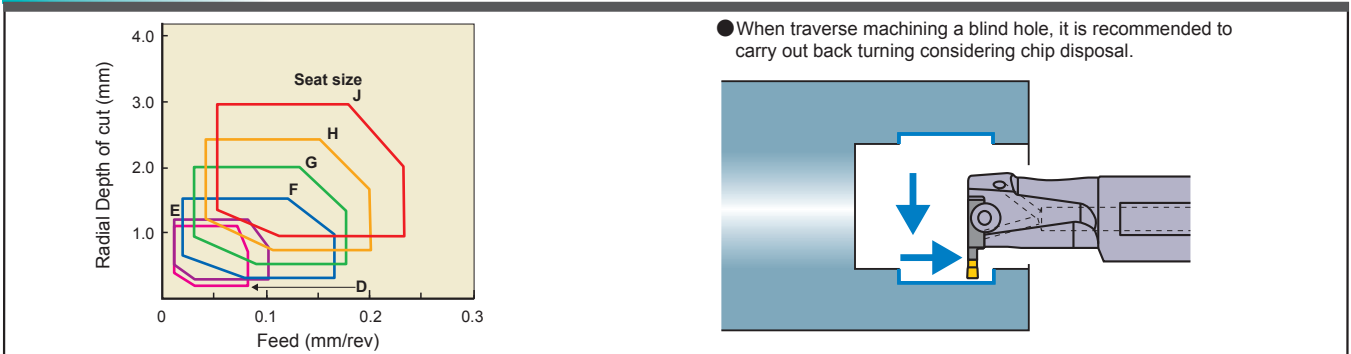
## GROOVING



## TRAVERSE MACHINING (MF BREAKER)

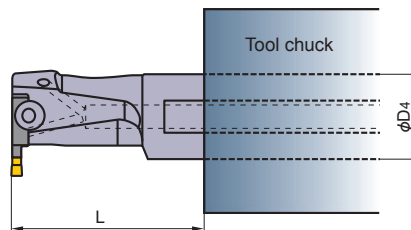


## TRAVERSE MACHINING (MM/MS BREAKER)



(Note) The above cutting conditions are for when using the tool overhang (L) 1.6-2.0 times larger than the shank diameter ( $\phi D_4$ ). (L/D=1.6-2.0)  
 When using L/D larger than 2.0, reduce the cutting conditions.

Seat Size	
	Insert Width (mm)
D	2.00
	2.24
E	2.39
	2.50
F	3.00
	3.18
G	4.00
	4.24
H	4.75
	5.00
J	6.00
	6.31
	6.35



# Grooving system

## TOOL SELECTION

### ● Notes when selecting the tool body

#### Holder

● When the overhang is the same, select a holder with the largest possible shank size to ensure sufficient clamping rigidity.

#### Modular blade (1)

**GYM20R/LA-○○○○**

GYM20R/LA-D10  
GYM20R/LA-E10  
GYM20R/LA-F10  
GYM20R/LA-G12  
GYM20R/LA-H12

**GYM25R/LA-○○○○**

GYM25R/LA-D12  
GYM25R/LA-E12  
GYM25R/LA-F12  
GYM25R/LA-G14  
GYM25R/LA-H14  
GYM25R/LA-J14

● For a  $\varnothing 40$  shank holder, if there is no restriction for use, select a holder suitable for GYM25 blade.

#### Modular blade (2)

● For an internal holder, select a modular blade listed above.

### ● Notes when setting the tool

#### Overhang

● The maximum groove depth is limited to the dimension L3. When machining with longer overhangs, refer to the dimension F2 of the tool used.

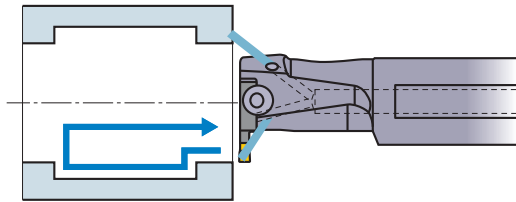


## MACHINING RECOMMENDATIONS

### ● Notes on multi-function machining (MF, MS, MM and BM breakers)

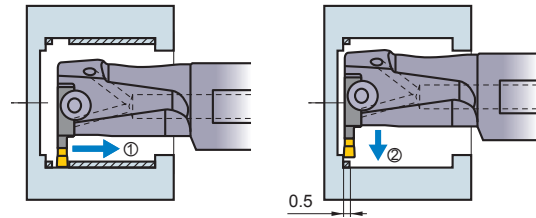
For internal grooving, the machining methods for external grooving (P92–P93) can be used, but please note the following precautions.

#### Coolant



- Supply large amounts of coolant for effective chip disposal during cutting. Maintain supply until the tool has been retracted completely for improved chip disposal.

#### Machining blind holes

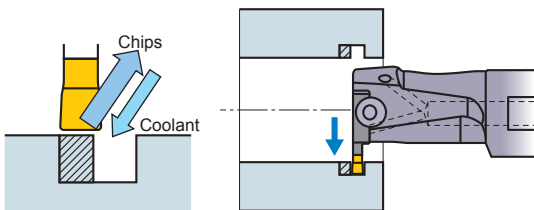


- As continuous chips tend to elongate at the back of the bore, the above operation is recommended. The recommended width of cut for ② is 0.5mm.

## Machining Wide Grooves

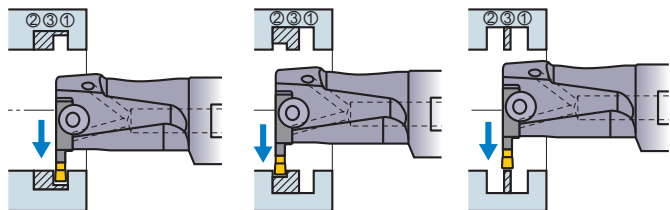
### Grooving

- When the cutting edge width is  $x 2 \geq$  groove width



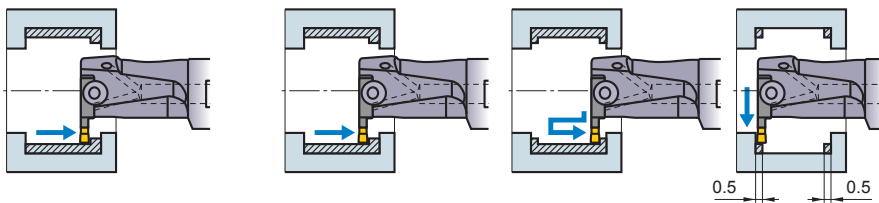
- When the depth of cut is shallower than the cutting edge width, continuous chips are usually produced. When plunging in several passes, it is recommended to carry out machining in the steps above. This ensures that coolant reaches the cutting edge and chips are easily discharged.

- When the cutting edge width is  $x 2 <$  groove width



- When the groove depth is larger than the cutting edge width, carry out plunging in the steps above to break up chips efficiently.

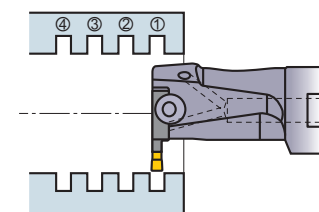
### Turning



- When chip breaking and disposal are especially important, cross-feed machining is recommended.

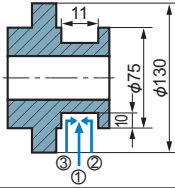
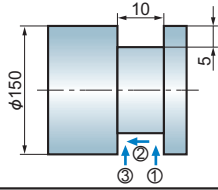
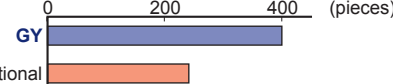
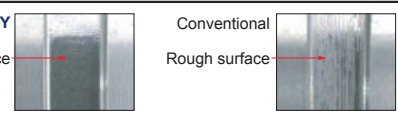
- Wide face grooving when the corner R of the work piece is equal to the corner R of the insert, machine as shown above. (When corner R of the work piece is larger than corner R of the insert, refer to the description of external wide grooving.)
- If the groove depth exceeds a given level, chips may elongate at the wall. In such a case, increase the feed and carry out machining as shown above.

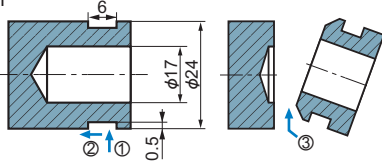
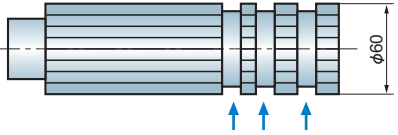

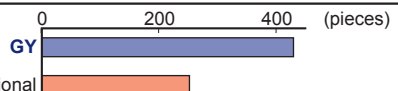
### Machining instruction

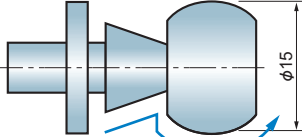
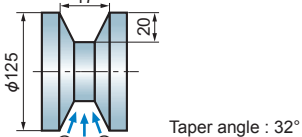
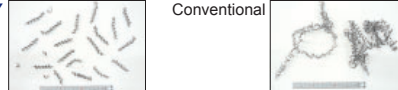


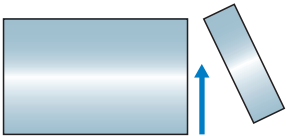
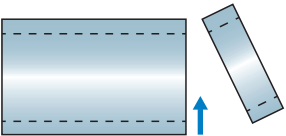
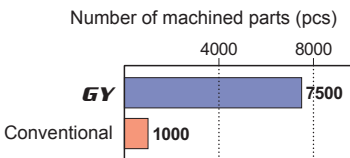
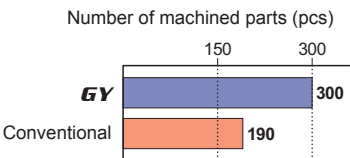
- It is recommended to carry out grooving from the front end of the workpiece. This reduces workpiece deflection.

## Application Examples for External Grooving

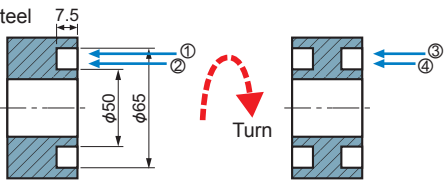
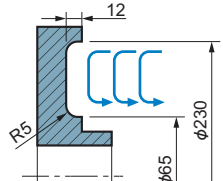
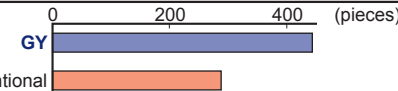
Holder	<b>GYHL2525M00-M25L</b>	<b>GYHL3232P00-M25L</b>	
Modular Blade	<b>GYM25LA-H14</b>	<b>GYM25LA-F12</b>	
Insert	<b>GY2M0500H080N-MS</b>	<b>GY2M0300F020N-MS</b>	
Insert Grade	<b>VP10RT</b>	<b>NX2525</b>	
Workpiece	Alloy steel 	Carbon steel 	
Component	Automotive transmission gear	Hydraulic piston	
Cutting Conditions	Cutting Speed (m/min)	180	210
	Feed (mm/rev)	0.15	①②③: 0.05
	Radial Depth of Cut (mm)	10	①③:5 ②: Machining allowance 0.15
	Axial Depth of Cut (mm)	①(Grooving): 5 ②③(Plunging): 3	①③: Machining allowance 0.25 ②:10
	Coolant	Wet	Wet
Results	 <p>GY gave 1.6 times longer tool life. Additionally, the sharper edge geometry resulted in lower cutting forces and prevented the workpiece being drawn out of the chuck.</p>	 <p>GY tools achieved a smooth shiny surface finish compared to the dull conventional tool finish.</p>	

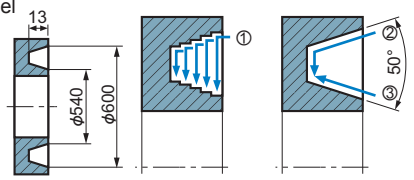
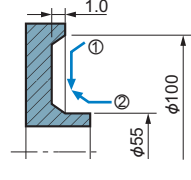
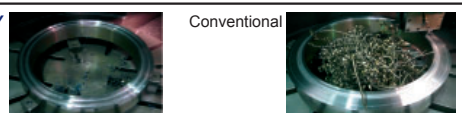
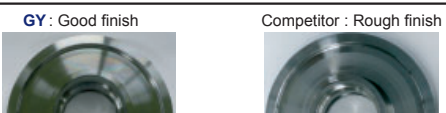
Holder	<b>GYHR2020K00-M20R</b>	<b>GYHR2525M00-M25R</b>	
Modular Blade	<b>GYM20RB-F18</b>	<b>GYM25RA-F06</b>	
Insert	<b>GY2M0300F020N-MS</b>	<b>GY1G0300F020N-GFGS</b>	
Insert Grade	<b>VP20RT</b>	<b>MB8025</b>	
Workpiece	Alloy steel 	Hardened steel 	
Component	Machine parts	Truck transmission main shaft	
Cutting Conditions	Cutting Speed (m/min)	130	129
	Feed (mm/rev)	①③: 0.1 ②: 0.15	0.1
	Radial Depth of Cut (mm)	①②: 0.5 ③: 3.5	1.3 (Machining allowance 0.15)
	Axial Depth of Cut (mm)	①③: 3	3 (Machining allowance 0.15)
	Coolant	Wet	Wet
Results	<p>GY reduces cycle times and tool changes due to the ability to both groove and turn. Improved chip disposal compared to conventional products.</p>  <p>● Chip geometry</p>	 <p>GY achieved 1.5 times longer tool life than a conventional product.</p>	

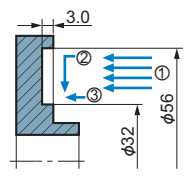
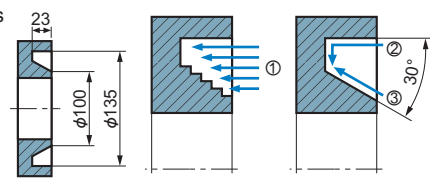
Holder	<b>GYHR2020K00-M25R</b>	<b>GYHR2525M00-M25R</b>	
Modular Blade	<b>GYM25RA-G08</b>	<b>GYM25RA-J25</b>	
Insert	<b>GY2M0400G200N-BM</b>	<b>GY2M0600H040N-MS</b>	
Insert Grade	<b>VP10RT</b>	<b>MY5015</b>	
Workpiece	Carbon steel 	Cast iron  <p>Taper angle : 32°</p>	
Component	Ball stud for ball joint	Pulley	
Cutting Conditions	Cutting Speed (m/min)	150	300
	Feed (mm/rev)	0.2	①②③:0.15
	Radial Depth of Cut (mm)	Machining allowance 0.25–0.45	①②③:20
	Axial Depth of Cut (mm)	Machining allowance 0.25–0.45	①:6 ②③:5.5
	Coolant	Wet	Wet
Results	 <p>GY produced smaller consistent chips compared to longer uncontrolled chips when using conventional tools.</p>	<p>When machining cast iron, the highly rigid design allows stable cutting without vibration and negated the conventional problem of the insert becoming chipped.</p>	

Holder	<b>NEW</b> GYSL1212JX00-D13	<b>NEW</b> GYSR1212JX-C13
Insert	GY2M0200D020N-GM (VP20RT)	GY2M0150C010N-GS (VP20RT)
Workpiece	SUS316 Cutting off 	Inconel ® 625 Cutting off 
Component	Medical component	Washer (Pipe Material)
Cutting Speed (m/min)	61	30.5
Feed (mm/rev)	0.031 → 0.038	0.025
Results	<p>Number of machined parts (pcs)</p>  <p>During a surface finishing test, GY achieved 7 times longer tool life and a high degree of efficiency due to high feed rate.</p>	<p>Number of machined parts (pcs)</p>  <p>Extended tool life was achieved because GY displayed only normal wear, but conventional products suffered from fracturing.</p>

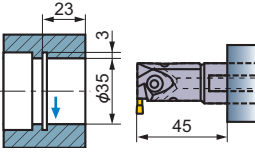
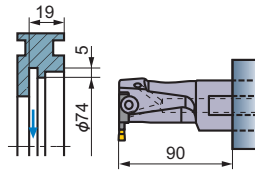
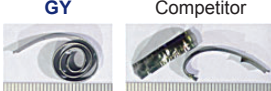
## Application Examples for Face Grooving

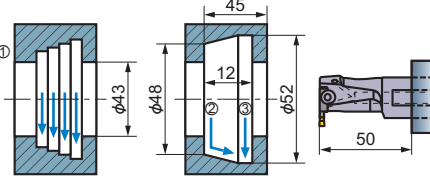
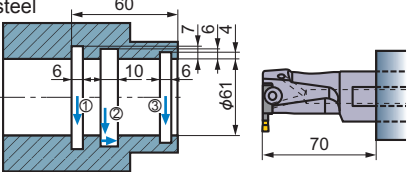
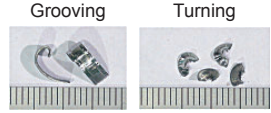
Holder	<b>GYHR2525M00-M25R</b>	<b>GYHR2525M00-M25R</b>
Modular Blade	<b>GYM25RD-G14-060</b>	<b>GYM25RD-H14-180</b>
Insert	<b>GY2M0400G040N-MM</b>	<b>GY2M0500H250N-BM</b>
Insert Grade	<b>VP10RT</b>	<b>MY5015</b>
Workpiece	Carbon steel 	Carbon steel 
Component	Construction equipment parts	Automotive flywheel
Cutting Conditions	Cutting Speed (m/min)	150
	Feed (mm/rev)	①③:0.10 ②④:0.12
	Radial Depth of Cut (mm)	①③:4.0 ②④:3.5
	Axial Depth of Cut (mm)	7.5
	Coolant	Wet
Results	 GY achieved 1.5 times greater tool life compared to conventional products and with less machining noise.	The rigid design allowed an increase in cutting conditions compared to conventional tools. The grade MY5015 also reduced tool costs with double tool life over conventional grades.

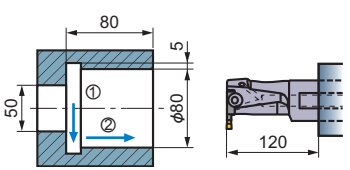
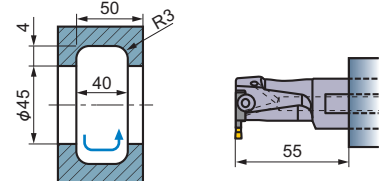
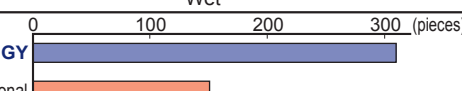
Holder	<b>GYHL3232P00-M25L</b>	<b>GYHL2525M00-M25L</b>
Modular Blade	<b>GYM25LD-J14-250</b>	<b>GYM25LD-H14-085</b>
Insert	<b>GY2M0600J040N-MM</b>	<b>GY2M0500H080N-MM</b>
Insert Grade	<b>VP20RT</b>	<b>MY5015</b>
Workpiece	Carbon steel 	Alloy steel 
Component	Windturbine parts	Automotive parts
Cutting Conditions	Cutting Speed (m/min)	①: 100 ②③: 150
	Feed (mm/rev)	①: 0.1 ②③: 0.08
	Radial Depth of Cut (mm)	①: - ②③: Machining allowance 0.5
	Axial Depth of Cut (mm)	①:2.5 ②③:-
	Coolant	Wet
Results	 The ability to traverse instead of just plunging produced better chip control.	 MY5015 grade produced an improved surface finish over a longer period than conventional tools that only gave a dull finish.

Holder	<b>GYHR2020K00-M25R</b>	<b>GYHL2525M00-M25L</b>
Modular Blade	<b>GYM25RD-F12-050</b>	<b>GYM25LD-H25-125</b>
Insert	<b>GY2M0300F020N-MS</b>	<b>GY2M0500H040N-MS</b>
Insert Grade	<b>NX2525</b>	<b>VP20RT</b>
Workpiece	Alloy steel 	Stainless steel 
Component	Automotive clutch parts	Plant pipe nut
Cutting Conditions	Cutting Speed (m/min)	120
	Feed (mm/rev)	①:0.15 ②③:0.12
	Radial Depth of Cut (mm)	①:3.0 ②③: Machining allowance 0.2
	Axial Depth of Cut (mm)	①:2.8 ②③: Machining allowance 0.2
	Coolant	Wet
Results	Cermet grades were used traditionally to give good surface finishes.  Conventional operations ① and ② needed to be stopped frequently due to bad chip control because conventional grades were produced without chip breakers.	Conventional groove machining produced inconsistent diameters in operation 1 due to tool deflection.  With higher rigidity, GY gave consistent, high precision results for finishing operations ② and ③.

## Application Examples for Internal Grooving

Holder	<b>GYAL25R90B-E06</b>	<b>GYDR50P90F-M25L</b>
Modular Blade	-	<b>GYM25LA-G14</b>
Insert	<b>GY2M0239E020N-GM</b>	<b>GY2M0400G020N-GS</b>
Insert Grade	<b>VP20RT</b>	<b>VP20RT</b>
Workpiece	Carbon steel 	Alloy steel 
Component	Machine parts	Transmission gear
Cutting Conditions	Cutting Speed (m/min)	120
	Feed (mm/rev)	0.12
	Radial Depth of Cut (mm)	3
	Axial Depth of Cut (mm)	2.39
	Coolant	Wet
Results	In comparison with conventional products, GY showed excellent chip breaking. Additionally, low cutting resistance enabled stable machining even at high feeds.	With GY, chips were not burnt due to lower cutting resistance, resulting in longer tool life. Additionally, GY showed excellent chip disposal. 

Holder	<b>GYDL32L90C-M20R</b>	<b>GYDR40T90D-M25L</b>
Modular Blade	<b>GYM20RA-F10</b>	<b>GYM25LA-J14</b>
Insert	<b>GY2M0300F020N-MS</b>	<b>GY2M0600J040N-MS</b>
Insert Grade	<b>VP20RT</b>	<b>VP20RT</b>
Workpiece	Stainless steel 	Carbon steel 
Component	Machine parts	Cylinder
Cutting Conditions	Cutting Speed (m/min)	80
	Feed (mm/rev)	①③:0.10 ②:0.12
	Radial Depth of Cut (mm)	①:2.0-4.3 ②③: Machining allowance 0.2
	Axial Depth of Cut (mm)	①:2.4-3.0 ②③: Machining allowance 0.2
	Coolant	Wet
Results	A highly efficient disposal rate allowed stability even when machining stainless steel.  The ability to traverse cut meant the same tools could be used for different size components which led to tool cost reductions.	GY could carry out machining higher feeds, resulting in a reduction in cycle time. Additionally, GY showed good chip disposal for both grooving and cross-feed machining. 

Holder	<b>GYDL50T90F-M25R</b>	<b>GYDR32L90C-M20L</b>
Modular Blade	<b>GYM25RA-F12</b>	<b>GYM20LA-H12</b>
Insert	<b>GY2M0300F040N-MM</b>	<b>GY2M0500H250N-BM</b>
Insert Grade	<b>MY5015</b>	<b>NX2525</b>
Workpiece	Cast iron 	Alloy steel 
Component	Machine parts	Bearing
Cutting Conditions	Cutting Speed (m/min)	200
	Feed (mm/rev)	①:0.12 ②:0.15
	Radial Depth of Cut (mm)	①:5 ②:0.5
	Axial Depth of Cut (mm)	①:3 ②:-
	Coolant	Wet
Results	 <p>GY achieved double tool life, improved surface finish and vibration free machining.</p>	Traditional machining methods left a blend mark between passes. By using a BM type breaker the blend marks were eliminated and the surface finish was improved.

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## Modular Blades Selection Chart (For Internal Grooving)

Modular Type Holder		Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)			Order Number	Hand (R/L)	
GYDR50P90F-M25L	R	90°	D	GYM25LA-D12	L	79,80
			E	GYM25LA-E12	L	81,82
			F	GYM25LA-F12	L	83,84
			G	GYM25LA-G14	L	
			H	GYM25LA-H14	L	85,86
GYDL50P90F-M25R	L	90°	J	GYM25LA-J14	L	
			D	GYM25RA-D12	R	79,80
			E	GYM25RA-E12	R	81,82
			F	GYM25RA-F12	R	83,84
			G	GYM25RA-G14	R	
GYDR50T90F-M25L	R	90°	H	GYM25RA-H14	R	85,86
			J	GYM25RA-J14	R	
			D	GYM25LA-D12	L	79,80
			E	GYM25LA-E12	L	81,82
			F	GYM25LA-F12	L	83,84
GYDL50T90F-M25R	L	90°	G	GYM25LA-G14	L	
			H	GYM25LA-H14	L	85,86
			J	GYM25LA-J14	L	
			D	GYM25RA-D12	R	79,80
			E	GYM25RA-E12	R	81,82

Modular Type Holder		Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)			Order Number	Hand (R/L)	
GYDR32L90C-M20L	R	90°	D	GYM20LA-D10	L	79,80
			E	GYM20LA-E10	L	81,82
			F	GYM20LA-F10	L	83,84
			G	GYM20LA-G12	L	
			H	GYM20LA-H12	L	85,86
GYDL32L90C-M20R	L	90°	D	GYM20RA-D10	R	79,80
			E	GYM20RA-E10	R	81,82
			F	GYM20RA-F10	R	83,84
			G	GYM20RA-G12	R	
			H	GYM20RA-H12	R	85,86
GYDR32S90C-M20L	R	90°	D	GYM20LA-D10	L	79,80
			E	GYM20LA-E10	L	81,82
			F	GYM20LA-F10	L	83,84
			G	GYM20LA-G12	L	
			H	GYM20LA-H12	L	85,86
GYDL32S90C-M20R	L	90°	D	GYM20RA-D10	R	79,80
			E	GYM20RA-E10	R	81,82
			F	GYM20RA-F10	R	83,84
			G	GYM20RA-G12	R	
			H	GYM20RA-H12	R	85,86
GYDR40M90D-M20L	R	90°	D	GYM20LA-D10	L	79,80
			E	GYM20LA-E10	L	81,82
			F	GYM20LA-F10	L	83,84
			G	GYM20LA-G12	L	
			H	GYM20LA-H12	L	85,86
GYDL40M90D-M20R	L	90°	D	GYM20RA-D10	R	79,80
			E	GYM20RA-E10	R	81,82
			F	GYM20RA-F10	R	83,84
			G	GYM20RA-G12	R	
			H	GYM20RA-H12	R	85,86
GYDR40M90D-M25L	R	90°	D	GYM25LA-D12	L	79,80
			E	GYM25LA-E12	L	81,82
			F	GYM25LA-F12	L	83,84
			G	GYM25LA-G14	L	
			H	GYM25LA-H14	L	85,86
GYDL40M90D-M25R	L	90°	J	GYM25LA-J14	L	
			D	GYM25RA-D12	R	79,80
			E	GYM25RA-E12	R	81,82
			F	GYM25RA-F12	R	83,84
			G	GYM25RA-G14	R	
GYDR40T90D-M20L	R	90°	H	GYM25RA-H14	R	85,86
			J	GYM25RA-J14	R	
			D	GYM20LA-D10	L	79,80
			E	GYM20LA-E10	L	81,82
			F	GYM20LA-F10	L	83,84
GYDL40T90D-M20R	L	90°	G	GYM20LA-G12	L	
			H	GYM20LA-H12	L	85,86
			D	GYM20RA-D10	R	79,80
			E	GYM20RA-E10	R	81,82
			F	GYM20RA-F10	R	83,84
GYDR40T90D-M25L	R	90°	G	GYM20RA-G12	R	
			H	GYM20RA-H12	R	85,86
			J	GYM25LA-J14	L	
			D	GYM25RA-D12	R	79,80
			E	GYM25RA-E12	R	81,82
GYDL40T90D-M25R	L	90°	F	GYM25RA-F12	R	83,84
			G	GYM25RA-G14	R	
			H	GYM25RA-H14	R	85,86
			J	GYM25RA-J14	R	
			D	GYM25RA-D12	R	79,80



# QUICK INDEX

## Modular Blades Selection Chart (For External and Face Grooving)

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHL3232P00-M25L	L	Face	00°	H	GYM25LD-H14-050	L	59,60
					GYM25LD-H14-060	L	
					GYM25LD-H14-085	L	61,62
					GYM25LD-H14-125	L	
					GYM25LD-H14-180	L	63,64
					GYM25LD-H14-250	L	
					GYM25LD-H25-060	L	59,60
					GYM25LD-H25-085	L	61,62
					GYM25LD-H25-180	L	63,64
					GYM25LD-H25-250	L	
				J	GYM25LD-J14-050	L	65,66
					GYM25LD-J14-070	L	
					GYM25LD-J14-110	L	67,68
					GYM25LD-J14-170	L	
					GYM25LD-J14-250	L	65,66
					GYM25LD-J25-070	L	67,68
					GYM25LD-J25-110	L	
					GYM25LD-J25-170	L	
					GYM25LD-J25-250	L	

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page			
Order Number	Hand (R/L)				Order Number	Hand (R/L)				
GYHL3232P00-M25L	L	Face	00°	D	GYM25LA-D06	L	15,16			
					GYM25LA-D12	L				
					GYM25LA-D20	L				
					E	GYM25LA-E06	L	17,18		
						GYM25LA-E12	L			
						GYM25LA-E20	L			
					F	GYM25LA-F06	L	19,20		
						GYM25LA-F12	L			
						GYM25LA-F20	L			
					G	GYM25LA-G08	L	21,22		
						GYM25LA-G14	L			
						GYM25LA-G25	L			
					H	GYM25LA-H08	L	23,24		
						GYM25LA-H14	L			
						GYM25LA-H25	L			
					J	GYM25LA-J08	L	25,26		
						GYM25LA-J14	L			
					Ext.	00°	D	GYM25LD-D12-040	L	37,38
								GYM25LD-D12-050	L	
								GYM25LD-D12-060	L	
								GYM25LD-D12-075	L	39,40
								GYM25LD-D12-100	L	
								GYM25LD-D12-135	L	
								GYM25LD-D12-180	L	
				E				GYM25LD-E12-040	L	41,42
								GYM25LD-E12-050	L	
								GYM25LD-E12-060	L	
								GYM25LD-E12-075	L	43,44
								GYM25LD-E12-100	L	
							GYM25LD-E12-135	L		
				F			GYM25LD-F12-035	L	45,46	
							GYM25LD-F12-040	L		
							GYM25LD-F12-050	L		
							GYM25LD-F12-060	L	47,48	
							GYM25LD-F12-075	L	49,50	
							GYM25LD-F12-100	L		
							GYM25LD-F12-135	L		
							GYM25LD-F12-180	L	51,52	
							GYM25LD-F12-225	L	47,48	
							GYM25LD-F20-060	L		
							GYM25LD-F20-075	L		
					GYM25LD-F20-100	L	49,50			
				GYM25LD-F20-135	L	51,52				
				GYM25LD-F20-180	L					
				GYM25LD-F20-225	L					
				G	GYM25LD-G14-040	L	53,54			
					GYM25LD-G14-050	L				
					GYM25LD-G14-060	L				
					GYM25LD-G14-085	L	55,56			
					GYM25LD-G14-125	L	57,58			
					GYM25LD-G14-180	L				
					GYM25LD-G14-250	L				
GYM25LD-G25-060	L	53,54								
GYM25LD-G25-085	L	55,56								
GYM25LD-G25-125	L	57,58								
GYM25LD-G25-180	L									
GYM25LD-G25-250	L									

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page	
Order Number	Hand (R/L)				Order Number	Hand (R/L)		
GYHR3232P00-M25R	R	Face	00°	E	GYM25RD-E12-040	R	41,42	
					GYM25RD-E12-050	R		
					GYM25RD-E12-060	R		
					GYM25RD-E12-075	R		
					GYM25RD-E12-100	R		
					GYM25RD-E12-135	R		
				GYM25RD-E12-180	R	43,44		
				F	GYM25RD-F12-035		R	45,46
					GYM25RD-F12-040		R	
					GYM25RD-F12-050		R	
					GYM25RD-F12-060		R	
					GYM25RD-F12-075		R	
					GYM25RD-F12-100	R		
				F	GYM25RD-F12-135	R	49,50	
					GYM25RD-F12-180	R		
					GYM25RD-F12-225	R		
					GYM25RD-F20-060	R		47,48
					GYM25RD-F20-075	R		
					GYM25RD-F20-100	R		
				GYM25RD-F20-135	R			
				GYM25RD-F20-180	R			
				GYM25RD-F20-225	R	51,52		
				G	GYM25RD-G14-040		R	53,54
					GYM25RD-G14-050		R	
					GYM25RD-G14-060		R	
					GYM25RD-G14-085		R	
					GYM25RD-G14-125		R	
					GYM25RD-G14-180	R		
				G	GYM25RD-G14-250	R	57,58	
					GYM25RD-G25-060	R		53,54
					GYM25RD-G25-085	R		
					GYM25RD-G25-125	R		
					GYM25RD-G25-180	R		
					GYM25RD-G25-250	R		
				H	GYM25RD-H14-050	R	59,60	
					GYM25RD-H14-060	R		
					GYM25RD-H14-085	R		
					GYM25RD-H14-125	R		
					GYM25RD-H14-180	R		
					GYM25RD-H14-250	R		
				H	GYM25RD-H25-060	R	59,60	
					GYM25RD-H25-085	R		
GYM25RD-H25-125	R							
GYM25RD-H25-180	R							
GYM25RD-H25-250	R							
J	GYM25RD-J14-050	R	65,66					
	GYM25RD-J14-070	R						
	GYM25RD-J14-110	R						
	GYM25RD-J14-170	R						
	GYM25RD-J14-250	R						
	GYM25RD-J25-070	R		65,66				
GYM25RD-J25-110	R							
GYM25RD-J25-170	R							
GYM25RD-J25-250	R							

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHL3225P00-M25L	L	Face	00°	G	GYM25LD-G14-040	L	53,54
					GYM25LD-G14-050	L	
					GYM25LD-G14-060	L	
					GYM25LD-G14-085	L	
					GYM25LD-G14-125	L	
					GYM25LD-G14-180	L	
					GYM25LD-G14-250	L	
					GYM25LD-G25-060	L	
					GYM25LD-G25-085	L	
					GYM25LD-G25-125	L	
					GYM25LD-G25-180	L	
					GYM25LD-G25-250	L	
				H	GYM25LD-H14-050	L	59,60
					GYM25LD-H14-060	L	
					GYM25LD-H14-085	L	
					GYM25LD-H14-125	L	
					GYM25LD-H14-180	L	
					GYM25LD-H14-250	L	
					GYM25LD-H25-060	L	
					GYM25LD-H25-085	L	
					GYM25LD-H25-125	L	
					GYM25LD-H25-180	L	
					GYM25LD-H25-250	L	
					J	GYM25LD-J14-050	
GYM25LD-J14-070	L						
GYM25LD-J14-110	L						
GYM25LD-J14-170	L						
GYM25LD-J14-250	L						
GYM25LD-J25-070	L						
GYM25LD-J25-110	L	65,66					
GYM25LD-J25-170	L						
GYM25LD-J25-250	L						
D	GYM25RA-D06		R	15,16			
	GYM25RA-D12		R				
	GYM25RA-D20		R				
E	GYM25RA-E06	R	17,18				
	GYM25RA-E12	R					
F	GYM25RA-E20	R	19,20				
	GYM25RA-F06	R					
F	GYM25RA-F12	R	19,20				
	GYM25RA-F20	R					
G	GYM25RA-G08	R	21,22				
	GYM25RA-G14	R					
	GYM25RA-G25	R					
H	GYM25RA-H08	R	23,24				
	GYM25RA-H14	R					
	GYM25RA-H25	R					
J	GYM25RA-J08	R	25,26				
	GYM25RA-J14	R					
	GYM25RA-J25	R					
D	GYM25RD-D12-040	R	37,38				
	GYM25RD-D12-050	R					
	GYM25RD-D12-060	R					
	GYM25RD-D12-075	R					
	GYM25RD-D12-100	R					
	GYM25RD-D12-135	R					
D	GYM25RD-D12-180	R	39,40				

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## Modular Blades Selection Chart (For External and Face Grooving)

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page						
Order Number	Hand (R/L)				Order Number	Hand (R/L)							
GYHR3225P00-M25R	R	Face	00°	J	GYM25RD-J14-050	R	65,66						
					GYM25RD-J14-070	R							
					GYM25RD-J14-110	R							
					GYM25RD-J14-170	R		67,68					
					GYM25RD-J14-250	R							
					GYM25RD-J25-070	R		65,66					
					GYM25RD-J25-110	R							
					GYM25RD-J25-170	R		67,68					
					GYM25RD-J25-250	R							
					GYHL3225P00-M25L	L		Ext.	00°	D	GYM25LA-D06	L	15,16
											GYM25LA-D12	L	
											GYM25LA-D20	L	
										E	GYM25LA-E06	L	17,18
											GYM25LA-E12	L	
GYM25LA-E20	L												
F	GYM25LA-F06	L	19,20										
	GYM25LA-F12	L											
G	GYM25LA-F20	L	21,22										
	GYM25LA-G08	L											
H	GYM25LA-G14	L	23,24										
	GYM25LA-G25	L											
J	GYM25LA-H08	L	25,26										
	GYM25LA-H14	L											
GYHL3225P00-M25L	L	Face	00°	D	GYM25LD-D12-040	L	37,38						
					GYM25LD-D12-050	L							
					GYM25LD-D12-060	L							
					GYM25LD-D12-075	L							
					GYM25LD-D12-100	L		39,40					
					GYM25LD-D12-135	L							
				E	GYM25LD-D12-180	L	41,42						
					GYM25LD-E12-040	L							
					GYM25LD-E12-050	L							
					GYM25LD-E12-060	L							
					GYM25LD-E12-075	L							
					GYM25LD-E12-100	L		43,44					
				F	GYM25LD-E12-135	L	45,46						
					GYM25LD-E12-180	L							
					GYM25LD-F12-035	L		47,48					
					GYM25LD-F12-040	L							
					GYM25LD-F12-050	L							
					GYM25LD-F12-060	L							
				GYM25LD-F12-075	L	49,50							
				G	GYM25LD-F12-100	L	51,52						
					GYM25LD-F12-135	L							
					GYM25LD-F12-180	L							
					GYM25LD-F20-060	L		47,48					
					GYM25LD-F20-075	L							
GYM25LD-F20-100	L	49,50											
H	GYM25LD-F20-135	L	51,52										
	GYM25LD-F20-180	L											
	GYM25LD-F20-225	L											
	GYM25LD-F20-225	L											
	GYM25LD-F20-225	L											
	GYM25LD-F20-225	L											

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page	
Order Number	Hand (R/L)				Order Number	Hand (R/L)		
GYHR3225P00-M25R	R	Face	00°	J	GYM25RA-J08	R	25,26	
					GYM25RA-J14	R		
					GYM25RA-J25	R		
				D	GYM25RD-D12-040	R	37,38	
					GYM25RD-D12-050	R		
					GYM25RD-D12-060	R		
					GYM25RD-D12-075	R		
					GYM25RD-D12-100	R		39,40
					GYM25RD-D12-135	R		
				E	GYM25RD-D12-180	R	41,42	
					GYM25RD-E12-040	R		
					GYM25RD-E12-050	R		
					GYM25RD-E12-060	R		
					GYM25RD-E12-075	R		
					GYM25RD-E12-100	R		43,44
				F	GYM25RD-E12-135	R	45,46	
					GYM25RD-E12-180	R		
					GYM25RD-F12-035	R		47,48
					GYM25RD-F12-040	R		
					GYM25RD-F12-060	R		
					GYM25RD-F12-075	R		
				G	GYM25RD-F12-100	R	51,52	
					GYM25RD-F12-135	R		
					GYM25RD-F12-180	R		
					GYM25RD-F12-225	R		47,48
					GYM25RD-F20-060	R		
					GYM25RD-F20-075	R		49,50
				H	GYM25RD-F20-100	R	51,52	
					GYM25RD-F20-135	R		
					GYM25RD-F20-180	R		
					GYM25RD-F20-225	R		
					GYM25RD-G14-040	R		53,54
					GYM25RD-G14-050	R		
				G	GYM25RD-G14-060	R	55,56	
					GYM25RD-G14-085	R		
					GYM25RD-G14-125	R		
					GYM25RD-G14-180	R		
					GYM25RD-G14-250	R		
					GYM25RD-G25-060	R		53,54
				H	GYM25RD-G25-085	R	55,56	
					GYM25RD-G25-125	R		
					GYM25RD-G25-180	R		
					GYM25RD-G25-250	R		
					GYM25RD-H14-050	R		57,58
					GYM25RD-H14-060	R		
				H	GYM25RD-H14-085	R	59,60	
					GYM25RD-H14-125	R		
					GYM25RD-H14-180	R		
					GYM25RD-H14-250	R		
					GYM25RD-H25-060	R		61,62
					GYM25RD-H25-085	R		
				H	GYM25RD-H25-125	R	63,64	
					GYM25RD-H25-180	R		
					GYM25RD-H25-250	R		
GYM25RD-H25-250	R							
GYM25RD-H25-250	R							
GYM25RD-H25-250	R							

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Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page	
Order Number	Hand (R/L)				Order Number	Hand (R/L)		
GYHL2525M90-M25R	L	Face	90°	F	GYM25RD-F12-035	R	71,72	
					GYM25RD-F12-040	R		
					GYM25RD-F12-050	R		
					GYM25RD-F12-060	R		
					GYM25RD-F12-075	R		
					GYM25RD-F12-100	R		
					GYM25RD-F12-135	R		
					GYM25RD-F12-180	R		
					GYM25RD-F12-225	R		
					GYM25RD-F20-060	R		
					GYM25RD-F20-075	R		
					GYM25RD-F20-100	R		
					GYM25RD-F20-135	R		
					GYM25RD-F20-180	R		
				GYM25RD-F20-225	R			
				G	GYM25RD-G14-040	R		73,74
					GYM25RD-G14-050	R		
					GYM25RD-G14-060	R		
					GYM25RD-G14-085	R		
					GYM25RD-G14-125	R		
					GYM25RD-G14-180	R		
					GYM25RD-G14-250	R		
					GYM25RD-G25-060	R		
					GYM25RD-G25-085	R		
					GYM25RD-G25-125	R		
				H	GYM25RD-H14-050	R		75,76
					GYM25RD-H14-060	R		
					GYM25RD-H14-085	R		
					GYM25RD-H14-125	R		
					GYM25RD-H14-180	R		
					GYM25RD-H14-250	R		
					GYM25RD-H25-060	R		
					GYM25RD-H25-085	R		
					GYM25RD-H25-125	R		
					GYM25RD-H25-180	R		
				J	GYM25RD-J14-050	R		77,78
					GYM25RD-J14-070	R		
					GYM25RD-J14-110	R		
					GYM25RD-J14-170	R		
					GYM25RD-J14-250	R		
					GYM25RD-J25-070	R		
					GYM25RD-J25-110	R		
GYM25RD-J25-170	R							
D	GYM25RA-D06	R	15,16					
	GYM25RA-D12	R						
	GYM25RA-D20	R						
	E	GYM25RA-E06		R	17,18			
		GYM25RA-E12		R				
GYM25RA-E20		R						
F	GYM25RA-F06	R	19,20					
	GYM25RA-F12	R						
	GYM25RA-F20	R						
G	GYM25RA-G08	R	21,22					
	GYM25RA-G14	R						
	GYM25RA-G25	R						
H	GYM25RA-H08	R	23,24					
	GYM25RA-H14	R						
	GYM25RA-H25	R						

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page	
Order Number	Hand (R/L)				Order Number	Hand (R/L)		
GYHR2525M90-M25L	R	Face	90°	H	GYM25LD-H14-050	L	75,76	
					GYM25LD-H14-060	L		
					GYM25LD-H14-085	L		
					GYM25LD-H14-125	L		
					GYM25LD-H14-180	L		
					GYM25LD-H14-250	L		
					GYM25LD-H25-060	L		
				J	GYM25LD-H25-085	L		77,78
					GYM25LD-H25-125	L		
					GYM25LD-H25-180	L		
					GYM25LD-H25-250	L		
					GYM25LD-J14-050	L		
					GYM25LD-J14-070	L		
					GYM25LD-J14-110	L		
D	GYM25LD-J14-170	L	77,78					
	GYM25LD-J14-250	L						
	GYM25LD-J25-070	L						
	GYM25LD-J25-110	L						
	GYM25LD-J25-170	L						
	GYM25LD-J25-250	L						
	E	GYM25RA-D06		R	29,30			
		GYM25RA-D12		R				
		GYM25RA-D20		R				
	F	GYM25RA-E06		R	29,30			
GYM25RA-E12		R						
G	GYM25RA-E20	R	31,32					
	GYM25RA-F06	R						
H	GYM25RA-F12	R	31,32					
	GYM25RA-F20	R						
J	GYM25RA-G08	R	31,32					
	GYM25RA-G14	R						
	GYM25RA-G25	R						
D	GYM25RA-H08	R	33,34					
	GYM25RA-H14	R						
	GYM25RA-H25	R						
E	GYM25RA-J08	R	33,34					
	GYM25RA-J14	R						
	GYM25RA-J25	R						
GYHL2525M90-M25R	L	Ext.	90°	D	GYM25RD-D12-040	R	69,70	
					GYM25RD-D12-050	R		
					GYM25RD-D12-060	R		
					GYM25RD-D12-075	R		
					GYM25RD-D12-100	R		
				E	GYM25RD-D12-135	R		69,70
					GYM25RD-D12-180	R		
					GYM25RD-E12-040	R		
					GYM25RD-E12-050	R		
					GYM25RD-E12-060	R		
F	GYM25RD-E12-075	R	69,70					
	GYM25RD-E12-100	R						
	GYM25RD-E12-135	R						
	GYM25RD-E12-180	R						

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## Modular Blades Selection Chart (For External and Face Grooving)

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page				
Order Number	Hand (R/L)				Order Number	Hand (R/L)					
GYHR2525M90-M25L	R	Ext.	90°	D	GYM25LA-D06	L	29,30				
					GYM25LA-D12	L					
					GYM25LA-D20	L					
				E	GYM25LA-E06	L	29,30				
					GYM25LA-E12	L					
					GYM25LA-E20	L					
				F	GYM25LA-F06	L	31,32				
					GYM25LA-F12	L					
					GYM25LA-F20	L					
				G	GYM25LA-G08	L	31,32				
					GYM25LA-G14	L					
					GYM25LA-G25	L					
				H	GYM25LA-H08	L	33,34				
					GYM25LA-H14	L					
					GYM25LA-H25	L					
				J	GYM25LA-J08	L	33,34				
					GYM25LA-J14	L					
					GYM25LA-J25	L					
				GYHR2525M90-M25L	R	Face	90°	D	GYM25LD-D12-040	L	69,70
									GYM25LD-D12-050	L	
									GYM25LD-D12-060	L	
									GYM25LD-D12-075	L	
									GYM25LD-D12-100	L	
									GYM25LD-D12-135	L	
GYM25LD-D12-180	L										
E	GYM25LD-E12-040	L	69,70								
	GYM25LD-E12-050	L									
	GYM25LD-E12-060	L									
	GYM25LD-E12-075	L									
	GYM25LD-E12-100	L									
	GYM25LD-E12-135	L									
F	GYM25LD-F12-035	L	71,72								
	GYM25LD-F12-040	L									
	GYM25LD-F12-050	L									
	GYM25LD-F12-060	L									
	GYM25LD-F12-075	L									
	GYM25LD-F12-100	L									
	GYM25LD-F12-135	L									
	GYM25LD-F12-180	L									
	GYM25LD-F12-225	L									
	GYM25LD-F20-060	L									
	GYM25LD-F20-075	L									
	GYM25LD-F20-100	L									
	GYM25LD-F20-135	L									
	GYM25LD-F20-180	L									
GYM25LD-F20-225	L										
G	GYM25LD-G14-040	L	73,74								
	GYM25LD-G14-050	L									
	GYM25LD-G14-060	L									
	GYM25LD-G14-085	L									
	GYM25LD-G14-125	L									
	GYM25LD-G14-180	L									
	GYM25LD-G14-250	L									
	GYM25LD-G25-060	L									
	GYM25LD-G25-085	L									
	GYM25LD-G25-125	L									
	GYM25LD-G25-180	L									
	GYM25LD-G25-250	L									

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHL2525M00-M25L	L	Face	00°	F	GYM25LD-F12-035	L	45,46
					GYM25LD-F12-040	L	
					GYM25LD-F12-050	L	
					GYM25LD-F12-060	L	
					GYM25LD-F12-075	L	
					GYM25LD-F12-100	L	
					GYM25LD-F12-135	L	
					GYM25LD-F12-180	L	
					GYM25LD-F12-225	L	
					GYM25LD-F20-060	L	
					GYM25LD-F20-075	L	
					GYM25LD-F20-100	L	
				G	GYM25LD-G14-040	L	55,56
					GYM25LD-G14-050	L	
					GYM25LD-G14-060	L	
					GYM25LD-G14-085	L	
					GYM25LD-G14-125	L	
					GYM25LD-G14-180	L	
					GYM25LD-G14-250	L	
					GYM25LD-G25-060	L	
					GYM25LD-G25-085	L	
					GYM25LD-G25-125	L	
					GYM25LD-G25-180	L	
					GYM25LD-G25-250	L	
				H	GYM25LD-H14-050	L	59,60
					GYM25LD-H14-060	L	
					GYM25LD-H14-085	L	
					GYM25LD-H14-125	L	
					GYM25LD-H14-180	L	
					GYM25LD-H14-250	L	
					GYM25LD-H25-060	L	
					GYM25LD-H25-085	L	
					GYM25LD-H25-125	L	
					GYM25LD-H25-180	L	
					GYM25LD-H25-250	L	
					J	GYM25LD-J14-050	
GYM25LD-J14-070	L						
GYM25LD-J14-110	L						
GYM25LD-J14-170	L						
GYM25LD-J14-250	L						
GYM25LD-J25-070	L						
GYM25LD-J25-110	L						
GYM25LD-J25-170	L						
GYM25LD-J25-250	L						
GYHR2525M50-M25L	R	Ext.	Recessing	D	GYM25LC-D005	L	35,36
				E	GYM25LC-E005	L	
				F	GYM25LC-F005	L	
				G	GYM25LC-G005	L	
				H	GYM25LC-H005	L	
				J	GYM25LC-J005	L	
GYHL2525M50-M25R	L	Ext.	Recessing	D	GYM25RC-D005	R	35,36
				E	GYM25RC-E005	R	
				F	GYM25RC-F005	R	
				G	GYM25RC-G005	R	
				H	GYM25RC-H005	R	
				J	GYM25RC-J005	R	

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Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page	
Order Number	Hand (R/L)				Order Number	Hand (R/L)		
GYHR2525M00-M25R	R	Face	00°	H	GYM25RD-H14-050	R	59,60	
					GYM25RD-H14-060	R		
					GYM25RD-H14-085	R		
					GYM25RD-H14-125	R		
					GYM25RD-H14-180	R		
					GYM25RD-H14-250	R		
					GYM25RD-H25-060	R		
					GYM25RD-H25-085	R		
					GYM25RD-H25-125	R		
				J	GYM25RD-H25-180	R	63,64	
					GYM25RD-H25-250	R		
					GYM25RD-J14-050	R		
					GYM25RD-J14-070	R		
					GYM25RD-J14-110	R		
					GYM25RD-J14-170	R		
					GYM25RD-J14-250	R		
					GYM25RD-J25-070	R		
					GYM25RD-J25-110	R		
J	GYM25RD-J25-170	R	67,68					
	GYM25RD-J25-250	R						
GYHL2525M00-M25L	L	Ext.	00°	D	GYM25LA-D06	L	15,16	
					GYM25LA-D12	L		
					GYM25LA-D20	L		
				E	GYM25LA-E06	L	17,18	
					GYM25LA-E12	L		
					GYM25LA-E20	L		
				F	GYM25LA-F06	L	19,20	
					GYM25LA-F12	L		
					GYM25LA-F20	L		
				G	GYM25LA-G08	L	21,22	
					GYM25LA-G14	L		
					GYM25LA-G25	L		
				H	GYM25LA-H08	L	23,24	
					GYM25LA-H14	L		
					GYM25LA-H25	L		
				J	GYM25LA-J08	L	25,26	
					GYM25LA-J14	L		
					GYM25LA-J25	L		
D	Face	00°	D	GYM25LD-D12-040	L	37,38		
				GYM25LD-D12-050	L			
				GYM25LD-D12-060	L			
				GYM25LD-D12-075	L			
				GYM25LD-D12-100	L			
				GYM25LD-D12-135	L			
				GYM25LD-D12-180	L			
				E	GYM25LD-E12-040		L	41,42
					GYM25LD-E12-050		L	
GYM25LD-E12-060	L							
E	GYM25LD-E12-075	L	43,44					
	GYM25LD-E12-100	L						
	GYM25LD-E12-135	L						
E	GYM25LD-E12-180	L	43,44					

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page					
Order Number	Hand (R/L)				Order Number	Hand (R/L)						
GYHR2525M00-M25R	R	Ext.	00°	D	GYM25RA-D06	R	15,16					
					GYM25RA-D12	R						
					GYM25RA-D20	R						
					GYM25RA-E06	R						
					GYM25RA-E12	R						
					GYM25RA-E20	R						
				F	GYM25RA-F06	R	19,20					
					GYM25RA-F12	R						
					GYM25RA-F20	R						
				G	GYM25RA-G08	R	21,22					
					GYM25RA-G14	R						
				H	GYM25RA-G25	R	23,24					
					GYM25RA-H08	R						
				H	GYM25RA-H14	R	23,24					
					GYM25RA-H25	R						
				J	GYM25RA-J08	R	25,26					
					GYM25RA-J14	R						
				J	GYM25RA-J25	R	25,26					
				D	Face	00°	D	GYM25RD-D12-040	R	37,38		
								GYM25RD-D12-050	R			
								GYM25RD-D12-060	R			
								GYM25RD-D12-075	R			
								GYM25RD-D12-100	R			
								GYM25RD-D12-135	R			
								GYM25RD-D12-180	R			
								E	GYM25RD-E12-040		R	39,40
									GYM25RD-E12-050		R	
									GYM25RD-E12-060		R	
								E	GYM25RD-E12-075		R	41,42
GYM25RD-E12-100	R											
GYM25RD-E12-135	R											
E	GYM25RD-E12-180	R	43,44									
F	Face	00°	F	GYM25RD-F12-035	R	45,46						
				GYM25RD-F12-040	R							
				GYM25RD-F12-050	R							
				GYM25RD-F12-060	R							
				GYM25RD-F12-075	R							
				GYM25RD-F12-100	R							
				GYM25RD-F12-135	R							
				GYM25RD-F12-180	R							
				G	GYM25RD-F20-060		R	47,48				
					GYM25RD-F20-075		R					
					GYM25RD-F20-100		R					
				G	GYM25RD-F20-135		R	49,50				
GYM25RD-F20-180	R											
GYM25RD-F20-225	R											
G	GYM25RD-G14-040	R	51,52									
	GYM25RD-G14-050	R										
	GYM25RD-G14-060	R										
G	GYM25RD-G14-085	R	53,54									
	GYM25RD-G14-125	R										
	GYM25RD-G14-180	R										
G	GYM25RD-G14-250	R	55,56									
	GYM25RD-G25-060	R										
	GYM25RD-G25-085	R										
G	GYM25RD-G25-125	R	55,56									
	GYM25RD-G25-180	R										
	GYM25RD-G25-250	R										

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## Modular Blades Selection Chart (For External and Face Grooving)

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page	
Order Number	Hand (R/L)				Order Number	Hand (R/L)		
GYHL2020K00-M25L	L	Face	00°	H	GYM25LD-H14-050	L	59,60	
					GYM25LD-H14-060	L		
					GYM25LD-H14-085	L		
					GYM25LD-H14-125	L		
					GYM25LD-H14-180	L		
					GYM25LD-H14-250	L		
					GYM25LD-H25-060	L		
					GYM25LD-H25-085	L		
					GYM25LD-H25-125	L		
				J	GYM25LD-H25-180	L	63,64	
					GYM25LD-H25-250	L		
					GYM25LD-J14-050	L		
					GYM25LD-J14-070	L		
					GYM25LD-J14-110	L		
					GYM25LD-J14-170	L		
					GYM25LD-J14-250	L		
					GYM25LD-J25-070	L		
					GYM25LD-J25-110	L		
D	GYM25LD-J25-170	L	67,68					
	GYM25LD-J25-250	L						
GYHR2020K50-M20L	R	Ext. Recessing		D	GYM20LC-D005	L	35,36	
					E	GYM20LC-E005		L
					F	GYM20LC-F005		L
					G	GYM20LC-G005		L
					H	GYM20LC-H005		L
GYHL2020K50-M20R	L	Ext. Recessing		D	GYM20RC-D005	R	35,36	
					E	GYM20RC-E005		R
					F	GYM20RC-F005		R
					G	GYM20RC-G005		R
					H	GYM20RC-H005		R
GYHR2020K90-M20L	R	Ext.	90°	D	GYM20LA-D06	L	29,30	
					GYM20LA-D10	L		
					GYM20LB-D18	L		
				E	GYM20LA-E06	L	31,32	
					GYM20LA-E10	L		
					GYM20LB-E18	L		
				F	GYM20LA-F06	L	33,34	
					GYM20LA-F10	L		
					GYM20LB-F18	L		
GYHL2020K90-M20R	L	Ext.	90°	D	GYM20RA-D06	R	29,30	
					GYM20RA-D10	R		
					GYM20RB-D18	R		
				E	GYM20RA-E06	R	31,32	
					GYM20RA-E10	R		
					GYM20RB-E18	R		
				F	GYM20RA-F06	R	33,34	
					GYM20RA-F10	R		
					GYM20RB-F18	R		
G	GYM20RA-G12	R	33,34					
	GYM20RA-H12	R						

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page		
Order Number	Hand (R/L)				Order Number	Hand (R/L)			
GYHL2020K00-M25L	L	Ext.	00°	D	GYM25LA-D06	L	15,16		
					GYM25LA-D12	L			
					GYM25LA-D20	L			
					E	GYM25LA-E06		L	17,18
						GYM25LA-E12		L	
						GYM25LA-E20		L	
					F	GYM25LA-F06		L	19,20
						GYM25LA-F12		L	
						GYM25LA-F20		L	
					G	GYM25LA-G08		L	21,22
						GYM25LA-G14		L	
					H	GYM25LA-G25		L	23,24
				GYM25LA-H08		L			
				GYM25LA-H14		L			
				J	GYM25LA-H25	L	25,26		
					GYM25LA-J08	L			
					GYM25LA-J14	L			
				D	GYM25LA-J25	L	37,38		
					GYM25LD-D12-040	L			
					GYM25LD-D12-050	L			
					GYM25LD-D12-060	L			
					GYM25LD-D12-075	L			
					E	GYM25LD-D12-100		L	39,40
						GYM25LD-D12-135		L	
						GYM25LD-D12-180		L	
					E	GYM25LD-E12-040		L	41,42
						GYM25LD-E12-050		L	
GYM25LD-E12-060	L								
GYM25LD-E12-075	L								
GYM25LD-E12-100	L								
GYM25LD-E12-135	L								
F	GYM25LD-E12-180	L	43,44						
	GYM25LD-F12-035	L							
	GYM25LD-F12-040	L							
F	GYM25LD-F12-050	L	45,46						
	GYM25LD-F12-060	L							
	GYM25LD-F12-075	L							
	GYM25LD-F12-100	L							
	GYM25LD-F12-135	L							
	G	GYM25LD-F12-180		L	47,48				
		GYM25LD-F12-225		L					
		GYM25LD-F20-060		L					
	G	GYM25LD-F20-075		L	49,50				
		GYM25LD-F20-100		L					
		GYM25LD-F20-135		L					
	G	GYM25LD-F20-180		L	51,52				
GYM25LD-F20-225		L							
GYM25LD-G14-040		L							
GYM25LD-G14-050		L							
GYM25LD-G14-060		L							
G		GYM25LD-G14-085	L	53,54					
		GYM25LD-G14-125	L						
		GYM25LD-G14-180	L						
G		GYM25LD-G14-250	L	55,56					
		GYM25LD-G25-060	L						
		GYM25LD-G25-085	L						
G		GYM25LD-G25-125	L	57,58					
	GYM25LD-G25-180	L							
	GYM25LD-G25-250	L							

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# Modular Blades Selection Chart (For External and Face Grooving)

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page	
Order Number	Hand (R/L)				Order Number	Hand (R/L)		
GYHR2020K00-M25R	R	Face	00°	D	GYM25RD-D12-040	R	37,38	
					GYM25RD-D12-050	R		
					GYM25RD-D12-060	R		
					GYM25RD-D12-075	R		
				E	GYM25RD-D12-100	R	39,40	
					GYM25RD-D12-135	R		
					GYM25RD-D12-180	R		
					GYM25RD-E12-040	R		41,42
					GYM25RD-E12-050	R		
					GYM25RD-E12-060	R		
				GYM25RD-E12-075	R			
				GYM25RD-E12-100	R	43,44		
				GYM25RD-E12-135	R			
				GYM25RD-E12-180	R			
				F	GYM25RD-F12-035		R	45,46
					GYM25RD-F12-040	R		
					GYM25RD-F12-050	R	47,48	
					GYM25RD-F12-060	R		
					GYM25RD-F12-075	R		
					GYM25RD-F20-060	R		
					GYM25RD-F20-075	R		
					GYM25RD-F12-100	R		49,50
					GYM25RD-F12-135	R		
					GYM25RD-F20-100	R		
				GYM25RD-F20-135	R			
				G	GYM25RD-F12-180	R	51,52	
					GYM25RD-F12-225	R		
					GYM25RD-F20-180	R	53,54	
					GYM25RD-F20-225	R		
					GYM25RD-G14-040	R		
					GYM25RD-G14-050	R		
					GYM25RD-G14-060	R		
					GYM25RD-G25-060	R		
					GYM25RD-G14-085	R		55,56
					GYM25RD-G14-125	R		
				GYM25RD-G25-085	R			
				GYM25RD-G25-125	R			
				H	GYM25RD-G14-180	R	57,58	
					GYM25RD-G14-250	R		
					GYM25RD-G25-180	R	59,60	
					GYM25RD-G25-250	R		
					GYM25RD-H14-050	R		
					GYM25RD-H14-060	R		
					GYM25RD-H25-060	R		
					GYM25RD-H14-085	R		61,62
					GYM25RD-H14-125	R		
					GYM25RD-H25-085	R		
				GYM25RD-H25-125	R			
J	GYM25RD-H14-180	R	63,64					
	GYM25RD-H14-250	R						
	GYM25RD-H25-180	R	65,66					
	GYM25RD-H25-250	R						
	GYM25RD-J14-050	R						
	GYM25RD-J14-070	R						
	GYM25RD-J14-110	R						
	GYM25RD-J25-070	R						
	GYM25RD-J25-110	R						
	GYM25RD-J14-170	R		67,68				
GYM25RD-J14-250	R							
GYM25RD-J25-170	R							
GYM25RD-J25-250	R							

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page	
Order Number	Hand (R/L)				Order Number	Hand (R/L)		
GYHR1616J00-M20R	R	Ext.	00°	D	GYM20RA-D06	R	15,16	
					GYM20RA-D10	R		
					GYM20RB-D18	R		
					GYM20RA-E06	R		17,18
					GYM20RA-E10	R		
					GYM20RB-E18	R		
				E	GYM20RA-F06	R	19,20	
					GYM20RA-F10	R		
					GYM20RB-F18	R		
					GYM20RA-G12	R		21,22
					GYM20RA-H12	R		23,24
					GYHL1616J00-M20L	L		Ext.
GYM20LA-D10	L							
GYM20LB-D18	L							
E	GYM20LA-E06	L	17,18					
	GYM20LA-E10	L						
	GYM20LB-E18	L						
F	GYM20LA-F06	L	19,20					
	GYM20LA-F10	L						
	GYM20LB-F18	L						
	GYM20LA-G12	L		21,22				
	GYM20LA-H12	L		23,24				
	GYHR2020K00-M20R	R		Ext.			00°	
GYM20RA-D10			R					
GYM20RB-D18			R					
GYM20RA-E06			R		17,18			
GYM20RA-E10			R					
GYM20RB-E18			R					
E			GYM20RA-F06		R	19,20		
			GYM20RA-F10		R			
			GYM20RB-F18		R			
			GYM20RA-G12		R			21,22
			GYM20RA-H12		R			23,24
			GYHL2020K00-M20L		L			Ext.
GYM20LA-D10	L							
GYM20LB-D18	L							
E	GYM20LA-E06	L		17,18				
	GYM20LA-E10	L						
	GYM20LB-E18	L						
F	GYM20LA-F06	L		19,20				
	GYM20LA-F10	L						
	GYM20LB-F18	L						
	GYM20LA-G12	L				21,22		
	GYM20LA-H12	L				23,24		
	GYHR2020K00-M25R	R				Ext.	00°	
GYM25RA-D12			R					
GYM25RA-D20			R					
GYM25RA-E06			R	17,18				
GYM25RA-E12			R					
GYM25RA-E20			R					
E			GYM25RA-F06	R	19,20			
			GYM25RA-F12	R				
			GYM25RA-F20	R				
			GYM25RA-G08	R				21,22
			GYM25RA-G14	R				
			F	GYM25RA-G25				R
GYM25RA-H08	R							
GYM25RA-H14	R							
GYM25RA-H25	R							
GYM25RA-J08	R	25,26						
GYM25RA-J14	R							
G	GYM25RA-J25	R						
	GYM25RA-J25	R						

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## Modular Blades Selection Chart (For External and Internal Grooving)

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page
	Order Number	Hand (R/L)	Order Number	Hand (R/L)			
J	GYM25RA-J08	R	GYHR2020K00-M25R	R	Ext.	00°	25,26
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R			
			GYHL2525M90-M25R	L			
	GYM25LA-J08	L	GYHL2020K00-M25L	L	Ext.	00°	25,26
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L			
	GYM25RA-J14	R	GYHR2020K00-M25R	R	Ext.	00°	25,26
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R	Int.	90°	85,86
			GYHL2525M90-M25R	L			
			GYDL40M90D-M25R	L			
			GYDL40T90D-M25R	L			
	GYM25LA-J14	L	GYHL2020K00-M25L	L	Ext.	00°	25,26
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L	Int.	90°	85,86
			GYHR2525M90-M25L	R			
			GYDR40M90D-M25L	R			
			GYDR40T90D-M25L	R			
	GYM25RA-J25	R	GYHR2020K00-M25R	R	Ext.	00°	25,26
GYHR2525M00-M25R			R				
GYHR3225P00-M25R			R				
GYHR3232P00-M25R			R				
GYHL2525M90-M25R			L				
GYM25LA-J25	L	GYHL2020K00-M25L	L	Ext.	00°	25,26	
		GYHL2525M00-M25L	L				
		GYHL3225P00-M25L	L				
		GYHL3232P00-M25L	L				
		GYHR2525M90-M25L	R				

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page	
	Order Number	Hand (R/L)	Order Number	Hand (R/L)				
H	GYM20RA-H12	R	GYHR1616J00-M20R	R	Ext.	00°	23,24	
			GYHR2020K00-M20R	R				
			GYHL2020K90-M20R	L		Int.	90°	85,86
			GYDL32L90C-M20R	L				
			GYDL32S90C-M20R	L				
			GYDL40M90D-M20R	L				
	GYM20LA-H12	L	GYHL1616J00-M20L	L	Ext.	00°	23,24	
			GYHL2020K00-M20L	L				
			GYHR2020K90-M20L	R	Int.	90°	85,86	
			GYDR32L90C-M20L	R				
			GYDR32S90C-M20L	R				
			GYDR40M90D-M20L	R				
	GYM25RA-H08	R	GYHR2020K00-M25R	R	Ext.	00°	23,24	
			GYHR2525M00-M25R	R				
			GYHR3225P00-M25R	R				
			GYHR3232P00-M25R	R				
			GYHL2525M90-M25R	L				
	GYM25LA-H08	L	GYHL2020K00-M25L	L	Ext.	00°	23,24	
			GYHL2525M00-M25L	L				
			GYHL3225P00-M25L	L				
			GYHL3232P00-M25L	L				
			GYHR2525M90-M25L	R				
	GYM25RA-H14	R	GYHR2020K00-M25R	R	Ext.	00°	23,24	
			GYHR2525M00-M25R	R				
GYHR3225P00-M25R			R					
GYHR3232P00-M25R			R	Int.	90°	85,86		
GYHL2525M90-M25R			L					
GYDL40M90D-M25R			L					
GYDL40T90D-M25R			L					
GYM25LA-H14	L	GYHL2020K00-M25L	L	Ext.	00°	23,24		
		GYHL2525M00-M25L	L					
		GYHL3225P00-M25L	L					
		GYHL3232P00-M25L	L	Int.	90°	85,86		
		GYHR2525M90-M25L	R					
		GYDR40M90D-M25L	R					
		GYDR40T90D-M25L	R					
GYM25RA-H25	R	GYHR2020K00-M25R	R	Ext.	00°	23,24		
		GYHR2525M00-M25R	R					
		GYHR3225P00-M25R	R					
		GYHR3232P00-M25R	R					
		GYHL2525M90-M25R	L					
GYM25LA-H25	L	GYHL2020K00-M25L	L	Ext.	00°	23,24		
		GYHL2525M00-M25L	L					
		GYHL3225P00-M25L	L					
		GYHL3232P00-M25L	L					
		GYHR2525M90-M25L	R					

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page
	Order Number	Hand (R/L)	Order Number	Hand (R/L)			
G	GYM20RA-G12	R	GYHR1616J00-M20R	R	Ext.	00°	21,22
			GYHR2020K00-M20R	R		90°	31,32
			GYHL2020K90-M20R	L		Int.	90°
			GYDL32L90C-M20R	L			
			GYDL32S90C-M20R	L			
			GYDL40M90D-M20R	L			
	GYDL40T90D-M20R	L					
	GYM20LA-G12	L	GYHL1616J00-M20L	L	Ext.	00°	21,22
			GYHL2020K00-M20L	L		90°	31,32
			GYHR2020K90-M20L	R		Int.	90°
			GYDR32L90C-M20L	R			
			GYDR32S90C-M20L	R			
			GYDR40M90D-M20L	R			
	GYDR40T90D-M20L	R					
	GYM25RA-G08	R	GYHR2020K00-M25R	R	Ext.	00°	21,22
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R		90°	31,32
			GYHR3232P00-M25R	R			
	GYM25LA-G08	L	GYHL2020K00-M25L	L	Ext.	00°	21,22
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L		90°	31,32
			GYHL3232P00-M25L	L			
	GYM25RA-G14	R	GYHR2020K00-M25R	R	Ext.	00°	21,22
			GYHR2525M00-M25R	R			
GYHR3225P00-M25R			R	90°		31,32	
GYHR3232P00-M25R			R				
GYDL40M90D-M25R			L	Int.	90°	83,84	
GYDL40T90D-M25R			L				
GYDL50P90F-M25R	L						
GYM25LA-G14	L	GYHL2020K00-M25L	L	Ext.	00°	21,22	
		GYHL2525M00-M25L	L				
		GYHL3225P00-M25L	L		90°	31,32	
		GYHL3232P00-M25L	L				
		GYHR2525M90-M25L	R	Int.	90°	83,84	
		GYDR40M90D-M25L	R				
GYDR40T90D-M25L	R						
GYM25RA-G25	R	GYHR2020K00-M25R	R	Ext.	00°	21,22	
		GYHR2525M00-M25R	R				
		GYHR3225P00-M25R	R		90°	31,32	
		GYHR3232P00-M25R	R				
GYM25LA-G25	L	GYHL2020K00-M25L	L	Ext.	00°	21,22	
		GYHL2525M00-M25L	L				
		GYHL3225P00-M25L	L		90°	31,32	
		GYHL3232P00-M25L	L				

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page		
	Order Number	Hand (R/L)	Order Number	Hand (R/L)					
F	GYM20RA-F06	R	GYHR1616J00-M20R	R	Ext.	00°	19,20		
			GYHR2020K00-M20R	R		90°	31,32		
			GYHL2020K90-M20R	L		Int.	90°	83,84	
	GYM20LA-F06	L	GYHL1616J00-M20L	L					
	GYHL2020K00-M20L		L						
	GYHR2020K90-M20L		R						
	GYM20RA-F10	R	GYHR1616J00-M20R	R	Ext.	00°	19,20		
			GYHR2020K00-M20R	R		90°	31,32		
			GYHL2020K90-M20R	L		Int.	90°	83,84	
			GYDL32L90C-M20R	L					
			GYDL32S90C-M20R	L					
			GYDL40M90D-M20R	L					
	GYDL40T90D-M20R	L							
	GYM20LA-F10	L	GYHL1616J00-M20L	L	Ext.	00°	19,20		
			GYHL2020K00-M20L	L					
			GYHR2020K90-M20L	R		90°	31,32		
			GYDR32L90C-M20L	R					
	GYDR32S90C-M20L	R	Int.	90°	83,84				
	GYDR40M90D-M20L	R							
	GYDR40T90D-M20L	R							
	GYM20RB-F18	R	GYHR1616J00-M20R	R	Ext.	00°	19,20		
			GYHR2020K00-M20R	R		90°	31,32		
			GYHL2020K90-M20R	L		Int.	90°	83,84	
	GYM20LB-F18	L	GYHL1616J00-M20L	L	Ext.				00°
GYHL2020K00-M20L			L	90°					31,32
GYHR2020K90-M20L			R	Int.		90°	83,84		
GYM25RA-F06	R	GYHR2020K00-M25R	R		Ext.			00°	19,20
		GYHR2525M00-M25R	R						
		GYHR3225P00-M25R	R	90°		31,32			
		GYHR3232P00-M25R	R						
GYM25LA-F06	L	GYHL2020K00-M25L	L	Ext.	00°	19,20			
		GYHL2525M00-M25L	L						
		GYHL3225P00-M25L	L		90°	31,32			
		GYHL3232P00-M25L	L						
GYM25RA-F12	R	GYHR2020K00-M25R	R	Ext.	00°	19,20			
		GYHR2525M00-M25R	R		90°	31,32			
		GYHR3225P00-M25R	R		Int.	90°	83,84		
		GYHR3232P00-M25R	R						
		GYHL2525M90-M25R	L						
		GYDL40M90D-M25R	L						
GYDL40T90D-M25R	L								
GYM25LA-F12	L	GYHL2020K00-M25L	L	Ext.	00°	19,20			
		GYHL2525M00-M25L	L		90°	31,32			
		GYHL3225P00-M25L	L		Int.	90°	83,84		
		GYHR2525M90-M25L	R						
		GYDR40M90D-M25L	R						
		GYDR40T90D-M25L	R						
GYM25RA-F20	R	GYHR2020K00-M25R	R	Ext.	00°	19,20			
		GYHR2525M00-M25R	R						
		GYHR3225P00-M25R	R		90°	31,32			
		GYHR3232P00-M25R	R						
GYM25LA-F20	L	GYHL2020K00-M25L	L	Ext.	00°	19,20			
		GYHL2525M00-M25L	L						
		GYHL3225P00-M25L	L		90°	31,32			
		GYHL3232P00-M25L	L						

# QUICK INDEX

## Modular Blades Selection Chart (For External and Internal Grooving)

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page
	Order Number	Hand (R/L)	Order Number	Hand (R/L)			
E	GYM20RA-E06	R	GYHR1616J00-M20R	R	Ext.	00°	17,18
			GYHR2020K00-M20R	R		90°	29,30
			GYHL2020K90-M20R	L			
	GYM20LA-E06	L	GYHL1616J00-M20L	L	Ext.	00°	17,18
			GYHL2020K00-M20L	L		90°	29,30
			GYHR2020K90-M20L	R			
	GYM20RA-E10	R	GYHR1616J00-M20R	R	Ext.	00°	17,18
			GYHR2020K00-M20R	R		90°	29,30
			GYHL2020K90-M20R	L			
			GYDL32L90C-M20R	L	Int.	90°	81,82
			GYDL32S90C-M20R	L			
			GYDL40M90D-M20R	L			
	GYM20LA-E10	L	GYHL1616J00-M20L	L	Ext.	00°	17,18
			GYHL2020K00-M20L	L		90°	29,30
			GYHR2020K90-M20L	R			
			GYDR32L90C-M20L	R	Int.	90°	81,82
			GYDR32S90C-M20L	R			
			GYDR40M90D-M20L	R			
	GYM20RB-E18	R	GYHR1616J00-M20R	R	Ext.	00°	17,18
			GYHR2020K00-M20R	R		90°	29,30
GYM20LB-E18	L	GYHL1616J00-M20L	L	Ext.	00°	17,18	
		GYHL2020K00-M20L	L		90°	29,30	
GYM25RA-E06	R	GYHR2020K00-M25R	R	Ext.	00°	17,18	
		GYHR2525M00-M25R	R				
		GYHR3225P00-M25R	R				
		GYHR3232P00-M25R	R				
		GYHL2525M90-M25R	L		90°	29,30	
GYM25LA-E06	L	GYHL2020K00-M25L	L	Ext.	00°	17,18	
		GYHL2525M00-M25L	L				
		GYHL3225P00-M25L	L				
		GYHL3232P00-M25L	L				
		GYHR2525M90-M25L	R		90°	29,30	
GYM25RA-E12	R	GYHR2020K00-M25R	R	Ext.	00°	17,18	
		GYHR2525M00-M25R	R				
		GYHR3225P00-M25R	R				
		GYHR3232P00-M25R	R				
		GYHL2525M90-M25R	L		90°	29,30	
		GYDL40M90D-M25R	L	Int.	90°	81,82	
		GYDL40T90D-M25R	L				
		GYDL50P90F-M25R	L				
		GYDL50T90F-M25R	L				
GYM25LA-E12	L	GYHL2020K00-M25L	L	Ext.	00°	17,18	
		GYHL2525M00-M25L	L				
		GYHL3225P00-M25L	L				
		GYHL3232P00-M25L	L				
		GYHR2525M90-M25L	R		90°	29,30	
		GYDR40M90D-M25L	R	Int.	90°	81,82	
		GYDR40T90D-M25L	R				
		GYDR50P90F-M25L	R				
GYDR50T90F-M25L	R						
GYM25RA-E20	R	GYHR2020K00-M25R	R	Ext.	00°	17,18	
		GYHR2525M00-M25R	R				
		GYHR3225P00-M25R	R				
		GYHL2525M90-M25R	L		90°	29,30	
GYM25LA-E20	L	GYHL2020K00-M25L	L	Ext.	00°	17,18	
		GYHL2525M00-M25L	L				
		GYHL3225P00-M25L	L				
		GYHR2525M90-M25L	R		90°	29,30	

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page
	Order Number	Hand (R/L)	Order Number	Hand (R/L)			
D	GYM20RA-D06	R	GYHR1616J00-M20R	R	Ext.	00°	15,16
			GYHR2020K00-M20R	R		90°	29,30
			GYHL2020K90-M20R	L			
	GYM20LA-D06	L	GYHL1616J00-M20L	L	Ext.	00°	15,16
			GYHL2020K00-M20L	L		90°	29,30
			GYHR2020K90-M20L	R			
	GYM20RA-D10	R	GYHR1616J00-M20R	R	Ext.	00°	15,16
			GYHR2020K00-M20R	R		90°	29,30
			GYHL2020K90-M20R	L			
			GYDL32L90C-M20R	L	Int.	90°	79,80
			GYDL32S90C-M20R	L			
			GYDL40M90D-M20R	L			
	GYM20LA-D10	L	GYHL1616J00-M20L	L	Ext.	00°	15,16
			GYHL2020K00-M20L	L		90°	29,30
			GYHR2020K90-M20L	R			
			GYDR32L90C-M20L	R	Int.	90°	79,80
			GYDR32S90C-M20L	R			
			GYDR40M90D-M20L	R			
	GYM20RB-D18	R	GYHR1616J00-M20R	R	Ext.	00°	15,16
			GYHR2020K00-M20R	R		90°	29,30
GYM20LB-D18	L	GYHL1616J00-M20L	L	Ext.	00°	15,16	
		GYHL2020K00-M20L	L		90°	29,30	
GYM25RA-D06	R	GYHR2020K00-M25R	R	Ext.	00°	15,16	
		GYHR2525M00-M25R	R				
		GYHR3225P00-M25R	R				
		GYHL2525M90-M25R	L		90°	29,30	
GYM25LA-D06	L	GYHL2020K00-M25L	L	Ext.	00°	15,16	
		GYHL2525M00-M25L	L				
		GYHL3225P00-M25L	L				
		GYHR2525M90-M25L	R		90°	29,30	
GYM25RA-D12	R	GYHR2020K00-M25R	R	Ext.	00°	15,16	
		GYHR2525M00-M25R	R				
		GYHR3225P00-M25R	R				
		GYHR3232P00-M25R	R				
		GYHL2525M90-M25R	L		90°	29,30	
		GYDL40T90D-M20R	L	Int.	90°	79,80	
		GYDL40M90D-M25R	L				
		GYDL40T90D-M25R	L				
		GYDL50P90F-M25R	L				
		GYDL50T90F-M25R	L				
GYM25LA-D12	L	GYHL2020K00-M25L	L	Ext.	00°	15,16	
		GYHL2525M00-M25L	L				
		GYHL3225P00-M25L	L				
		GYHL3232P00-M25L	L				
		GYHR2525M90-M25L	R		90°	29,30	
		GYDR40T90D-M20L	R	Int.	90°	79,80	
		GYDR40M90D-M25L	R				
		GYDR40T90D-M25L	R				
GYDR50P90F-M25L	R						
GYM25RA-D20	R	GYHR2020K00-M25R	R	Ext.	00°	15,16	
		GYHR2525M00-M25R	R				
		GYHR3225P00-M25R	R				
		GYHR3232P00-M25R	R				
		GYHL2525M90-M25R	L		90°	29,30	
GYM25LA-D20	L	GYHL2020K00-M25L	L	Ext.	00°	15,16	
		GYHL2525M00-M25L	L				
		GYHL3225P00-M25L	L				
		GYHL3232P00-M25L	L				
		GYHR2525M90-M25L	R		90°	29,30	

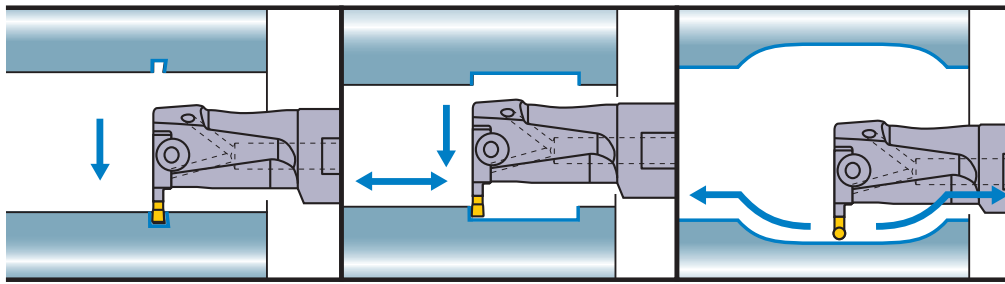
# Memo

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A series of horizontal dashed lines for writing, spanning the width of the page.

# QUICK INDEX (INTERNAL GROOVING)

## 90° L type holder



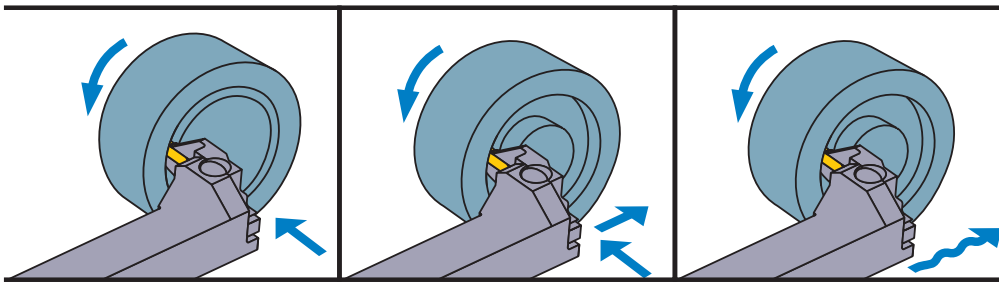
Insert Width $W_3$ (mm)	Min. Cut Diameter $D_1$ (mm)	Max. Groove Depth $a_r$ (mm)	Page
2.00 2.24	25	6.0	P79,80
	32		
	40	4.0-9.5 *1	
	50	5.5-9.5 *1	
	60	7.0-11.5 *1	
70			
2.39 2.50 2.74	25	6.0	P81,82
	32		
	40	4.0-9.5 *1	
	50	5.5-9.5 *1	
	60	7.0-11.5 *1	
70			
3.00 3.18 3.24	25	6.0	P83,84
	32		
	40	4.0-9.5 *1	
	50	5.5-9.5 *1	
	60	7.0-11.5 *1	
70			
4.00 4.24	32	7.0	P83,84
	40	4.5-11.5 *1	
	50	6.0-11.5 *1	
	60	7.5-13.0 *1	
70			
4.75 5.00 5.24	32	7.0	P85,86
	40	4.5-11.5 *1	
	50	6.0-11.5 *1	
	60	7.5-13.0 *1	
70			
6.00 6.31	60	7.5-13.0 *1	
	70		

\*1 The maximum groove depth varies according to the cutting diameter  $D_1$ . For details, please refer to page 101.

QUICK  
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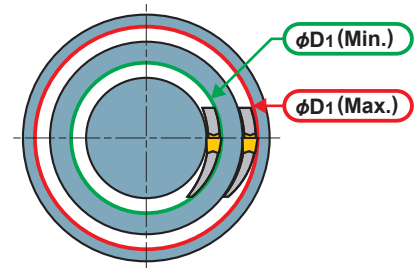
# QUICK INDEX (FACE GROOVING)

## 90° L type holder



### Notes when selecting a modular blade (1)

- Select a modular blade for face grooving, so that the cutting diameter at the first pass is within the range of D1 minimum and D1 maximum that are described in the table of dimensions.



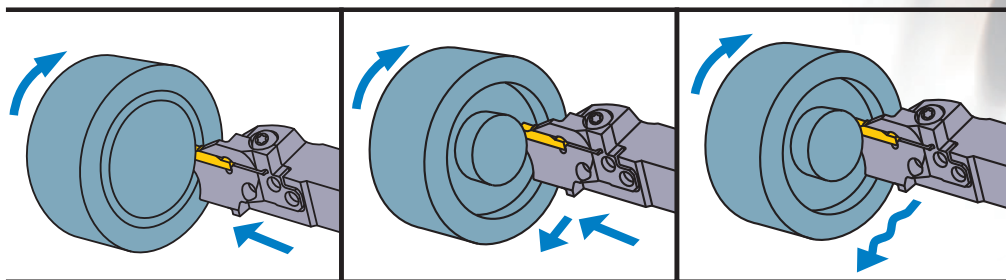
### How to choose a modular blade by insert width and diameter

Insert Width W <sub>3</sub> (mm)	Cutting Diameter at the First Pass $\phi D_1$ (mm)									
	$\phi 40$	$\phi 50$	$\phi 60$	$\phi 70$	$\phi 80$	$\phi 90$	$\phi 100$	$\phi 150$	$\phi 200$	$\phi 300$ .....
2.00 2.24		$\phi 40-50$ P69,70	$\phi 50-60$ P69,70	$\phi 60-75$ P69,70		$\phi 75-100$ P69,70		$\phi 100-150$ P69,70		$\phi 180-250$ P69,70
2.39 2.50 2.74								$\phi 135-200$ P69,70		
3.00 3.18 3.24	$\phi 35-40$ P71,72	$\phi 40-50$ P71,72	$\phi 50-60$ P71,72	$\phi 60-75$ P71,72		$\phi 75-100$ P71,72		$\phi 100-150$ P71,72	$\phi 180-250$ P71,72	
								$\phi 135-200$ P71,72		$\phi 225-999$ P71,72
4.00 4.24		$\phi 40-50$ P73,74	$\phi 50-60$ P73,74	$\phi 60-85$ P73,74		$\phi 85-125$ P73,74		$\phi 125-200$ P73,74		$\phi 250-999$ P73,74
									$\phi 180-280$ P73,74	
4.75 5.00 5.24			$\phi 50-60$ P75,76	$\phi 60-85$ P75,76		$\phi 85-125$ P75,76		$\phi 125-200$ P75,76		$\phi 250-999$ P75,76
									$\phi 180-280$ P75,76	
6.00 6.31 6.35			$\phi 50-70$ P77,78		$\phi 70-110$ P77,78		$\phi 110-200$ P77,78			$\phi 250-999$ P77,78
									$\phi 170-280$ P77,78	

All face grooving holders are modular types.  
The blades can only be used for face grooving.  
Compatible with 00° type face grooving holder.

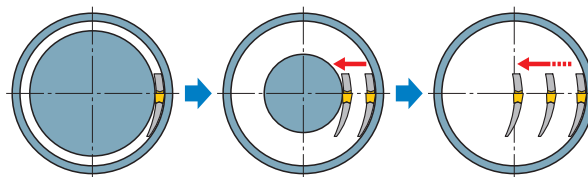
# QUICK INDEX (FACE GROOVING)

## 00° type holder



### Notes when selecting a modular blade (2)

- When machining wide face grooves, select a modular blade suitable for the maximum diameter and machine from the outer diameter towards the centre.
- When machining toward the centre, there is no restriction on the cutting diameter.
- For details, please refer to page 97.



### How to choose a modular blade by insert width and diameter

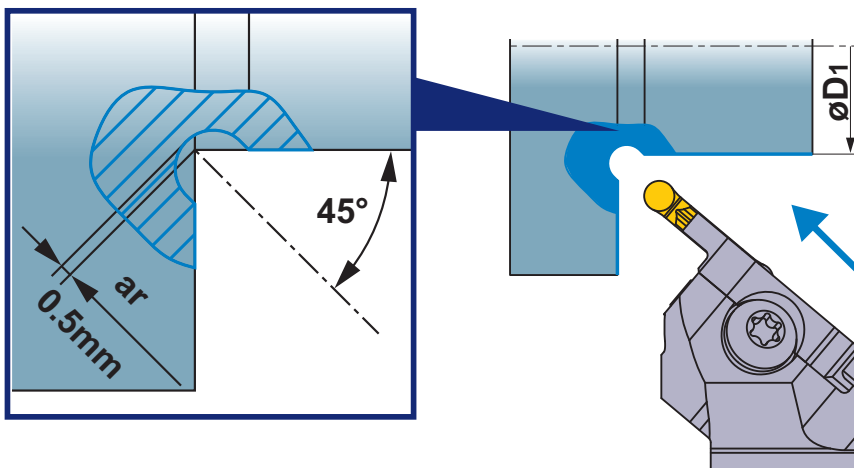
Insert Width W <sub>3</sub> (mm)	Cutting Diameter at the First Pass $\phi D_1$ (mm)									
	$\phi 40$	$\phi 50$	$\phi 60$	$\phi 70$	$\phi 80$	$\phi 90$	$\phi 100$	$\phi 150$	$\phi 200$	$\phi 300 \dots$
2.00 2.24		$\phi 40-50$ P37,38	$\phi 50-60$ P37,38	$\phi 60-75$ P37,38	$\phi 75-100$ P37,38		$\phi 100-150$ P39,40		$\phi 180-250$ P39,40	
								$\phi 135-200$ P39,40		
2.39 2.50 2.74		$\phi 40-50$ P41,42	$\phi 50-60$ P41,42	$\phi 60-75$ P41,42	$\phi 75-100$ P41,42		$\phi 100-150$ P43,44		$\phi 180-250$ P43,44	
								$\phi 135-200$ P43,44		
3.00 3.18 3.24	$\phi 35-40$ P45,46	$\phi 40-50$ P45,46	$\phi 50-60$ P45,46	$\phi 60-75$ P47,48	$\phi 75-100$ P47,48		$\phi 100-150$ P49,50		$\phi 180-250$ P51,52	
								$\phi 135-200$ P49,50		$\phi 225-999$ P51,52
4.00 4.24		$\phi 40-50$ P53,54	$\phi 50-60$ P53,54	$\phi 60-85$ P53,54		$\phi 85-125$ P55,56	$\phi 125-200$ P55,56			$\phi 250-999$ P57,58
								$\phi 180-280$ P57,58		
4.75 5.00 5.24			$\phi 50-60$ P59,60	$\phi 60-85$ P59,60		$\phi 85-125$ P61,62	$\phi 125-200$ P61,62			$\phi 250-999$ P63,64
								$\phi 180-280$ P63,64		
6.00 6.31 6.35			$\phi 50-70$ P65,66		$\phi 70-110$ P65,66		$\phi 110-200$ P65,66			$\phi 250-999$ P67,68
								$\phi 170-280$ P67,68		

QUICK INDEX

All face grooving holders are modular types.  
The blades can only be used for face grooving.  
Compatible with 90° L type face grooving holder.

# QUICK INDEX (EXTERNAL RECESSING)

## Recessing type holder

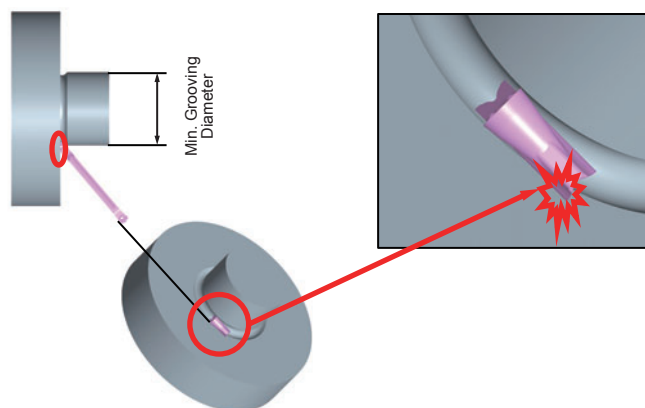


Min. Cut Diameter $D_1$ (mm)	Insert Width $W_3$ (mm)	Max. Groove Depth $ar$ (mm)	Page
30	2.00	0.5	P35,36
	2.50		
	3.00		
	3.18		
20	4.00	0.5	P35,36
	5.00		
	6.00 6.35		

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

### Minimum grooving diameter

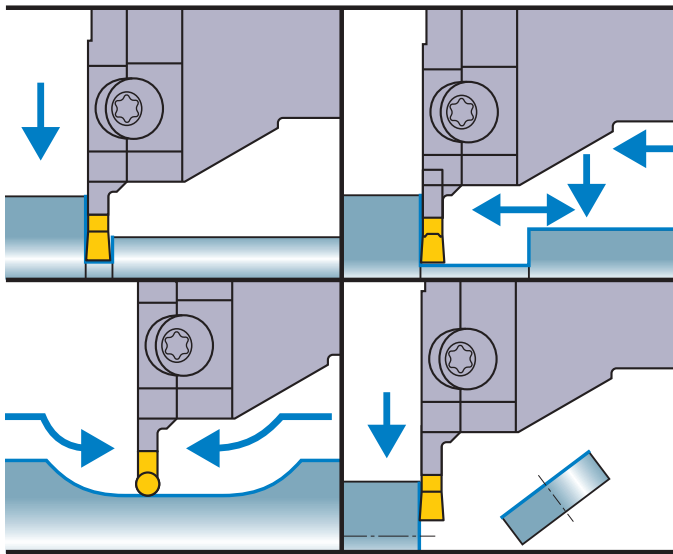
Ensure the tool is suitable for the diameter being machined. Refer to the Min. Grooving Diameter  $D_1$  as shown in the table on the first page to avoid a collision with the workpiece as shown below.





# QUICK INDEX (EXTERNAL GROOVING)

## 90° L type holder



Insert Width $W_3$ (mm)	Max. Groove Depth $a_r$ (mm)	Max. Cut Off Diameter $D_1$ (mm)	Page	
2.00 2.24	6	12	<b>P29,30</b>	
	10	20		
	12	24		
	18 *3	36		
	20 *1	40 *2		
2.39 2.50 2.74	6	12		
	10	20		
	12	24		
	18 *3	36		
	20 *1	40 *2		
3.00 3.18 3.24	6	12	<b>P31,32</b>	
	10	20		
	12	24		
	18 *3	36		
	20 *1	40 *2		
4.00 4.24	8	16		<b>P33,34</b>
	12	24		
	14	28		
	25 *1	50 *2		
4.75 5.00 5.24	8	16		
	12	24		
	14	28		
	25 *1	50 *2		
6.00 6.31 6.35	8	16		
	14	28		
	25 *1	50 *2		

\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

\*2 The maximum cut off diameter  $D_1$  varies according to the insert used. The cut off diameter is double the maximum groove depth ( $a_r$ ) of inserts on pages 9 to 11.

\*3 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

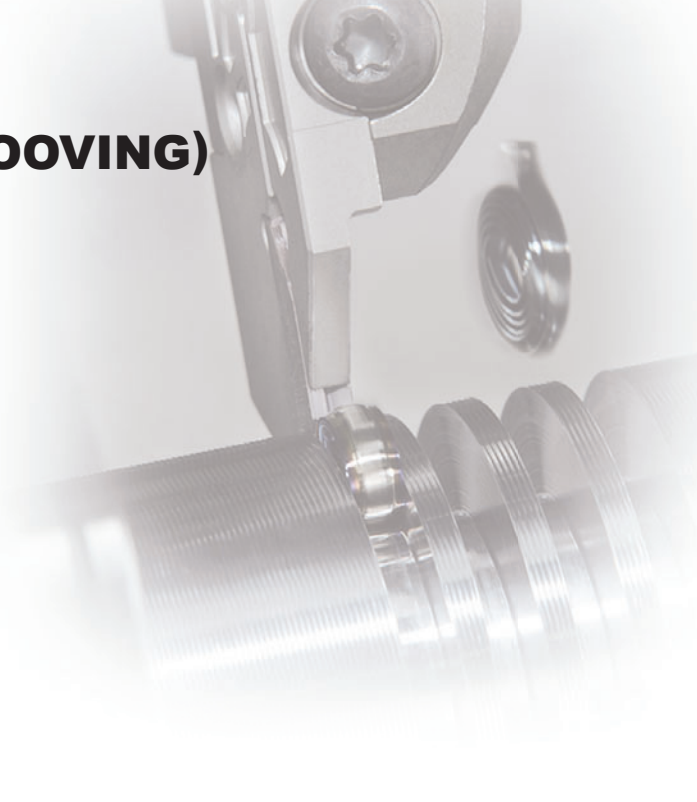
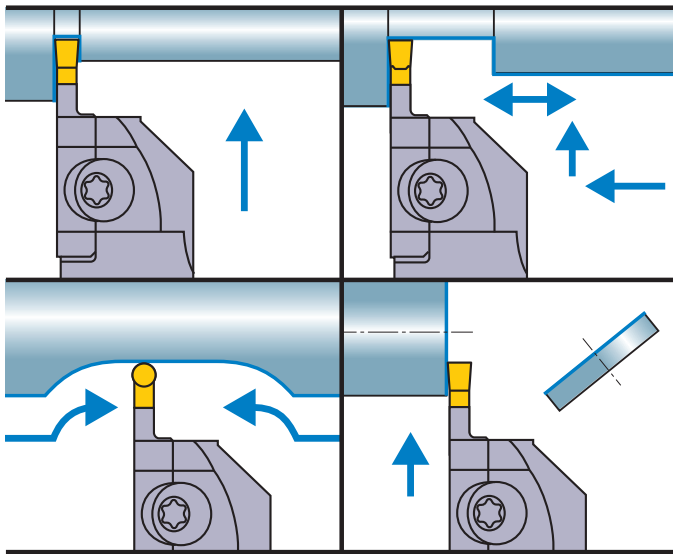
The modular blade is compatible with 00° type and Internal holders. >Q9

QUICK  
INDEX

In the reverse  
page order

# QUICK INDEX (EXTERNAL GROOVING)

00° type holder



Insert Width $W_3$ (mm)	Max. Groove Depth $ar$ (mm)	Max. Cut Off Diameter $D_1$ (mm)	Page
2.00 2.24	6	12	<b>P15,16</b>
	10	20	
	12	24	
	18 *3	36	
	20 *1	40 *2	
2.39 2.50 2.74	6	12	<b>P17,18</b>
	10	20	
	12	24	
	18 *3	36	
	20 *1	40 *2	
3.00 3.18 3.24	6	12	<b>P19,20</b>
	10	20	
	12	24	
	18 *3	36	
	20 *1	40 *2	
4.00 4.24	8	16	<b>P21,22</b>
	12	24	
	14	28	
	25 *1	50 *2	
4.75 5.00 5.24	8	16	<b>P23,24</b>
	12	24	
	14	28	
	25 *1	50 *2	
6.00 6.31 6.35	8	16	<b>P25,26</b>
	14	28	
	25 *1	50 *2	
8.00	25 *1	50 *2	<b>P27,28</b>

\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

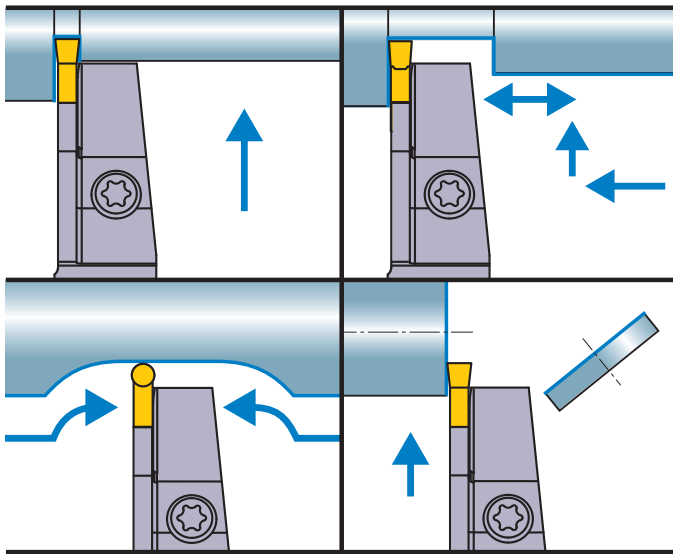
\*2 The maximum cut off diameter  $D_1$  varies according to the insert used. The cut off diameter is double the maximum groove depth ( $ar$ ) of inserts on pages 9 to 11.

\*3 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

The modular blade is compatible with 90° L type and Internal holders. >Q9

# QUICK INDEX (EXTERNAL GROOVING for Swiss style lathes)

00° type holder



Max. Groove Depth <b>ar</b> (mm) *3	Max. Cut Off Diameter <b>D1</b> (mm)	Holder		Insert Width <b>W3</b> (mm)	Page
		<b>H1</b>	<b>B</b>		
11	22	10	10	1.50 2.00 2.24 2.39 2.50 3.00 3.18 3.24	P13,14
13	26	12	12		
17 *1	34 *2	16	16		
18 *1	36 *2	20	12		

\*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

\*2 The maximum cut off diameter **D1** varies according to the insert used. The cut off diameter is double the maximum groove depth (**ar**) of inserts on pages 9 to 11.

\*3 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

## Grooving System

# GY Series QUICK INDEX

## Side B

### QUICK INDEX .....Q1

\* Side B page begins from this side.

**Q2** EXTERNAL GROOVING  
00° type holder

**Q3** EXTERNAL GROOVING  
90° L type holder

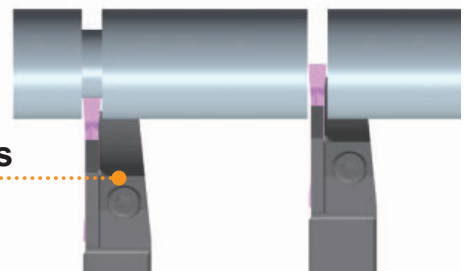
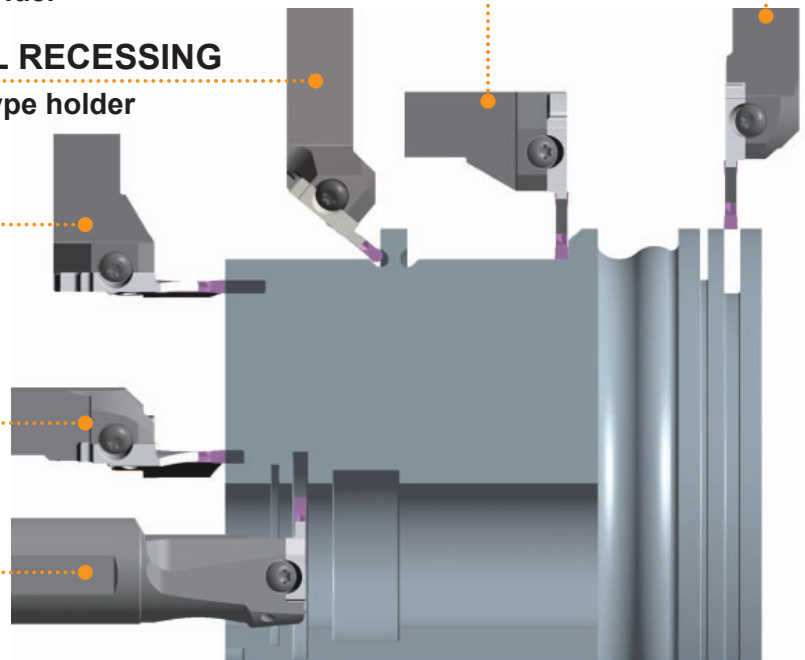
**Q4** EXTERNAL RECESSING  
Recessing type holder

**Q6** FACE GROOVING  
90° L type holder

**Q5** FACE GROOVING  
00° type holder

**Q7** INTERNAL GROOVING  
90° L type holder

**Q1** EXTERNAL GROOVING for Swiss style lathes  
00° type holder



#### For Your Safety

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

## MITSUBISHI MATERIALS CORPORATION

### MITSUBISHI MATERIALS CORPORATION

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