GY GROOVING SERIES

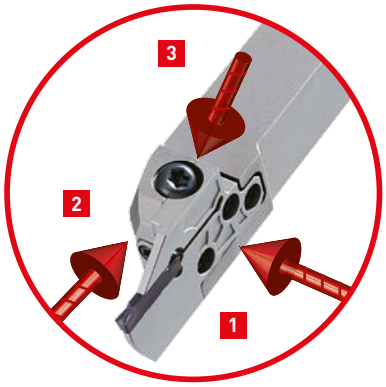
A WIDE SELECTION OF HOLDERS AND INSERTS AVAILABLE FOR DIVERSE GROOVING APPLICATIONS

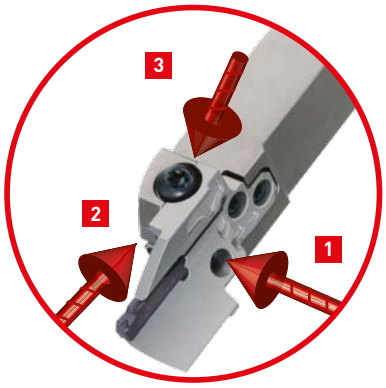
DIA EDGE

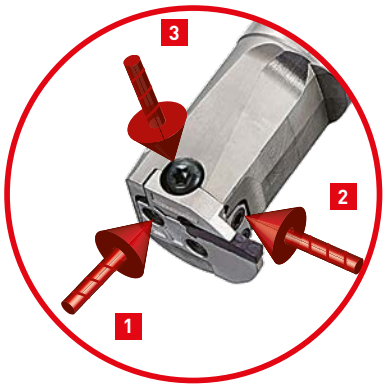
MITSUBISHI MATERIALS

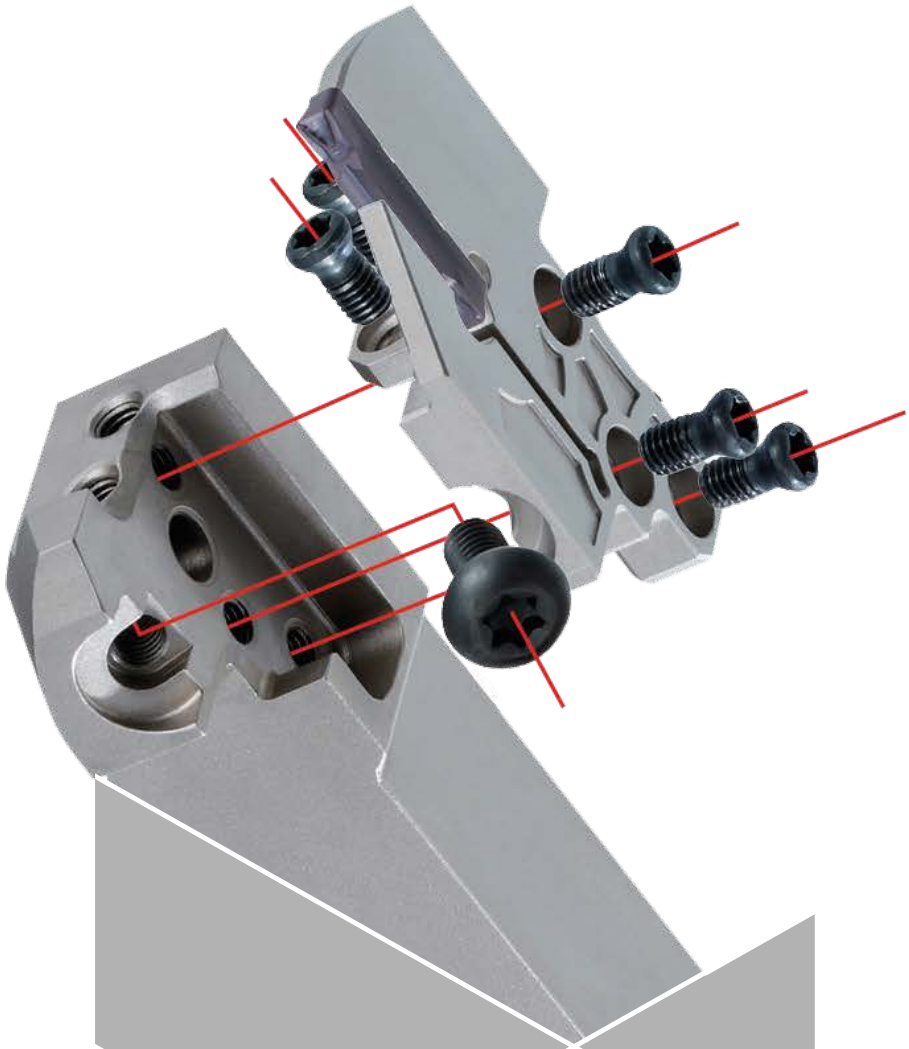
INDEX

TRIFORCE SYSTEM FOR INCREASED STABILITY AND PERFORMANCE!









Mitsubishi Materials has developed an original and unique, modular blade system.

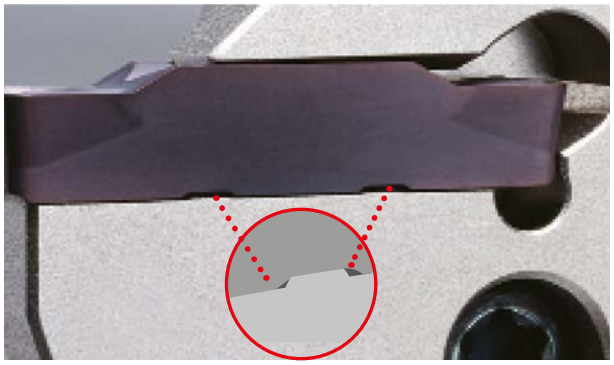
The TRIFORCE grooving system ensures the blade is securely fixed in 3 directions (side, front and top) giving high rigidity for a stable grooving performance.

GY GROOVING SERIES

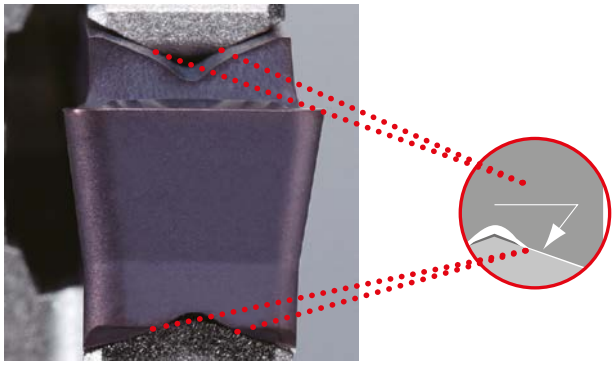
ORIGINAL INSERT DESIGN LEADING THE WAY TO NEW GROOVING APPLICATIONS

HIGHLY RELIABLE INSERT CLAMPING

Safety keys prevent insert movement.

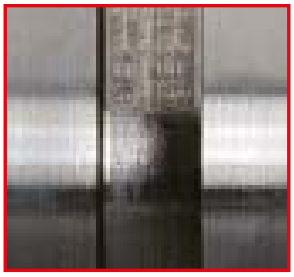


The convex geometry ensures high precision clamping.

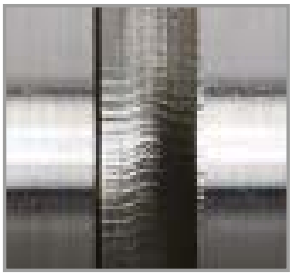


COMPARISON OF FINISHED SURFACE

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



GY

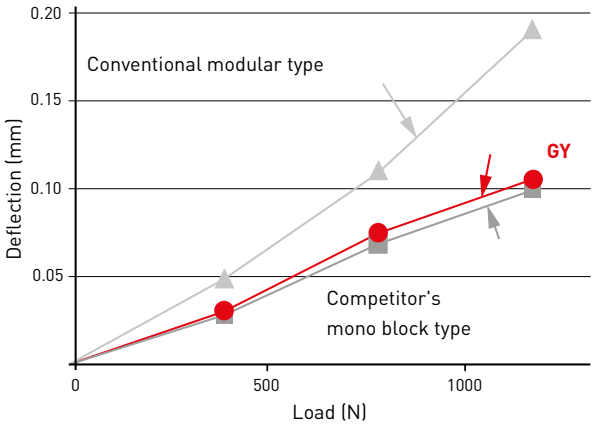


Conventional modular type

Material	SCM440
Insert width (mm)	5
Vc (m/min)	150
f (mm/rev.)	0.2
ap (mm)	23

RIGIDITY COMPARISON

The grooving system provides rigidity comparable to a monoblock type grooving tool.



Tool body for 5 mm width insert

GY GROOVING SERIES

A WIDE SELECTION OF INSERTS

CUTTING OFF


GU Chipbreaker
(For mild steel)


GS Chipbreaker
(Low feeds)


GM Chipbreaker
(Medium feeds)


R/L05-GM Breaker
(Medium feeds)


R08-GS Breaker
(Low feeds)


R15-GS Breaker
(Low feeds)


GL Breaker
(For aluminium alloys)

GROOVING


GU Chipbreaker
(For mild steel)


GS Chipbreaker
(Low feeds)


GM Chipbreaker
(Medium feeds)


GFGS
(For hardened materials)


GL Breaker
(For aluminium alloys)

FOR MULTIFUNCTIONAL GROOVING


MF Chipbreaker
(G class)


MS Chipbreaker
(Low feeds)


MM Chipbreaker
(Medium feeds)

COPYING / RECESSING



BM Chipbreaker
(Medium feeds)

Breaker	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	NEW MP9015	NEW MP9025
GU Breaker			✓	✓		✓			
GS Breaker	✓	✓	✓	✓		✓			
GM Breaker			✓	✓	✓	✓		✓	✓
GL Breaker	✓								
MF Breaker	✓		✓	✓		✓			
MS Breaker			✓	✓	✓	✓			
MM Breaker			✓	✓	✓	✓		✓	✓
BM Breaker			✓	✓	✓	✓		✓	✓
Blank Insert	✓	✓				✓			
GFGS Honing (PCBN)							✓		

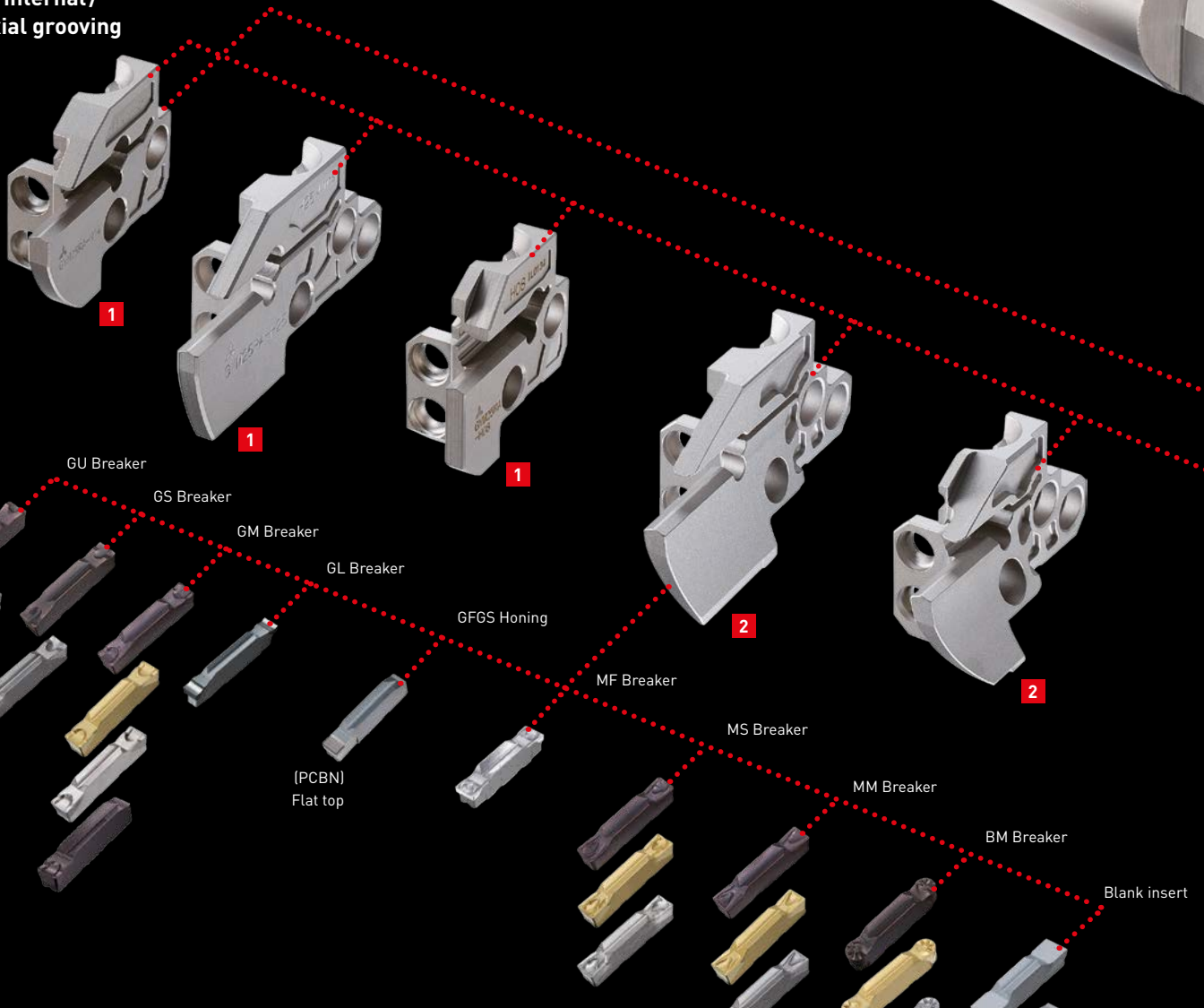
GY GROOVING SERIES

CORRESPONDING BLADES TO A VARIETY OF MODULAR HOLDERS WITH DIFFERENT SHANK SIZES

MODULAR HOLDER FOR INTERNAL GROOVING

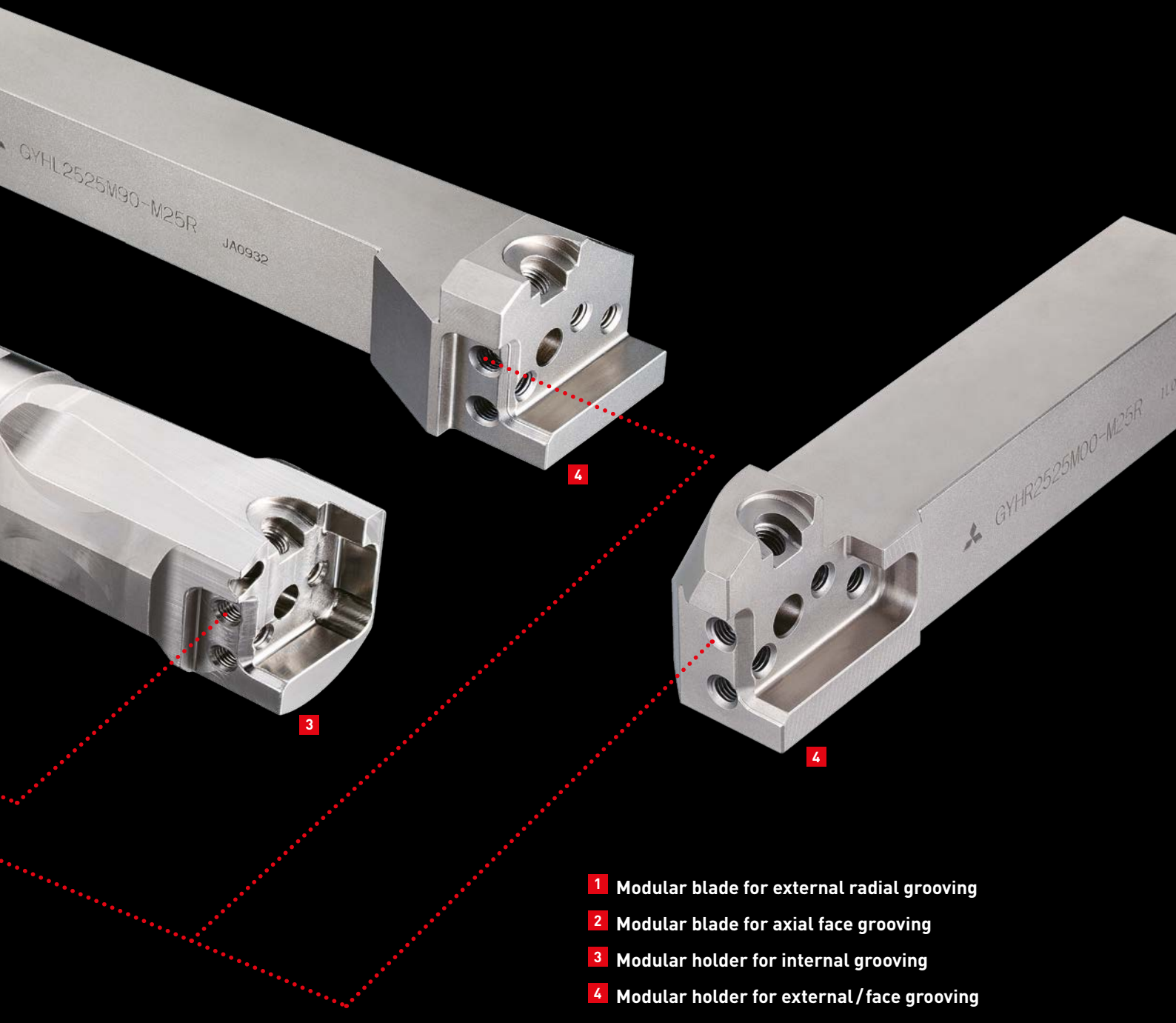
Easy to use modular blade system allows flexible tool management but maintains an overall strength comparable to a monoblock type holder.

Modular blade for external / internal / radial / axial grooving



MODULAR HOLDER FOR EXTERNAL/FACE GROOVING

A wide variety of products with assorted combinations to consolidate necessary tools for diverse grooving applications.



1. Modular blade for external radial grooving
2. Modular blade for axial face grooving
3. Modular holder for internal grooving
4. Modular holder for external/face grooving

A WIDE VARIETY OF PRODUCTS WITH ASSORTED COMBINATIONS TO CONSOLIDATE NECESSARY TOOLS FOR DIVERSE GROOVING APPLICATIONS.

GY GROOVING 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.

NEW
⌀ 10 mm
⌀ 12 mm
⌀ 16 mm
⌀ 20 mm

⌀ 20 mm
⌀ 25 mm
⌀ 25 x 32 mm
⌀ 32 mm

⌀ 16 mm

⌀ 20 mm

⌀ 25 mm

⌀ 25 x 32 mm
⌀ 32 mm

Monoblock type

Modular type

Various depths of groove possible with a single tool using different modular blades.

External grooving

Face grooving

Various sizes of face grooves from a wide array of modular blades.

INTERNAL HOLDERS

A wide range of holders available from minimum diameter of Ø25 mm.

Monoblock type

Min.cutting diameter Ø25, Ø32

Modular type

Min.cutting diameter Ø40, Ø50, Ø60, Ø70

Short shank types are stock standard.

Monoblock type

Short

Standard

Modular type

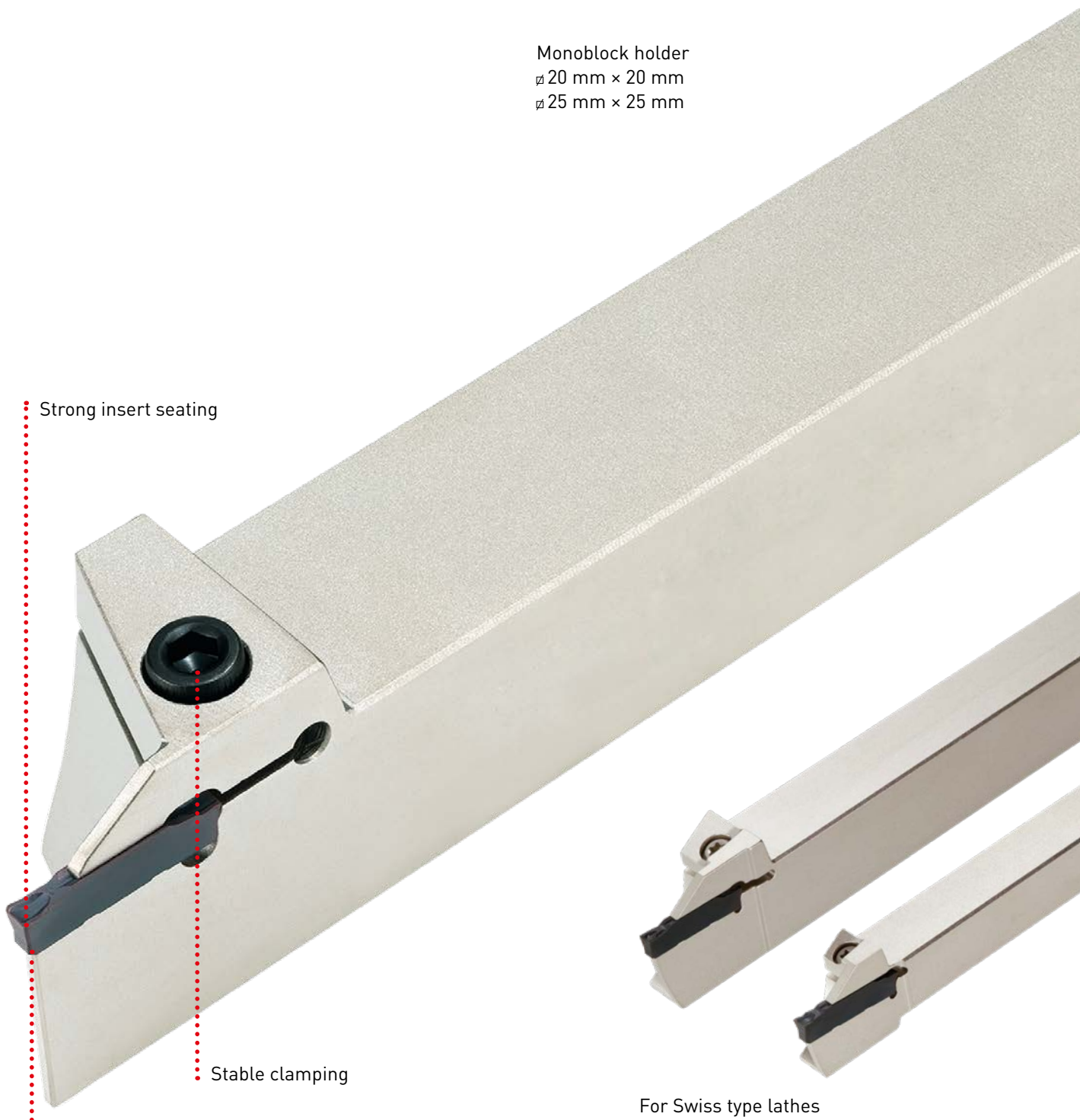
Short

Standard

GY GROOVING SERIES

MONOBLOCK HOLDERS FOR EXTERNAL GROOVING AND FOR SWISS TYPE LATHE MACHINES

Monoblock holder
⧄ 20 mm × 20 mm
⧄ 25 mm × 25 mm



Strong insert seating

Stable clamping

For Swiss type lathes

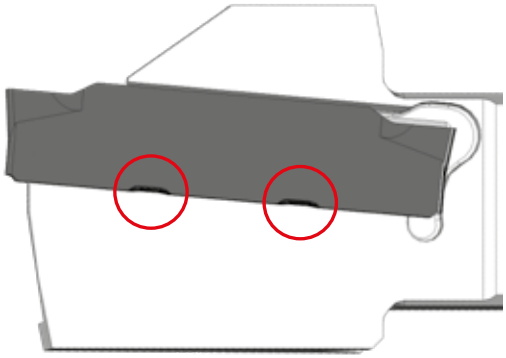
2 corner insert
Insert width 2.0 – 8.0 mm

GY GROOVING SERIES

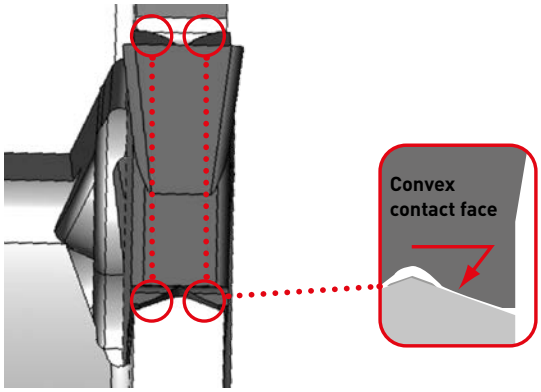
INNOVATIVE CLAMPING SYSTEM FOR SWISS TYPE LATHES ENSURES RELIABLE GROOVING

HIGHLY RELIABLE INSERT CLAMP

The safety key locks the insert and prevents movement.



The convex geometry ensures high precision clamping.

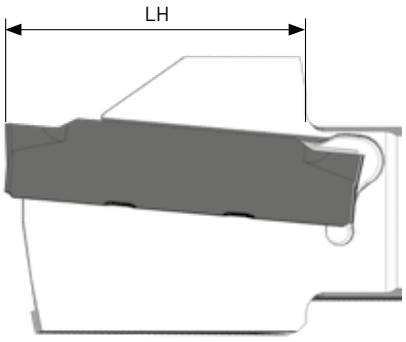


MONOBLOCK HOLDER FOR SWISS TYPE AUTOMATIC LATHES

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

OVERHANG LENGTH COMPATIBLE WITH SWISS TYPE AUTOMATIC LATHES

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

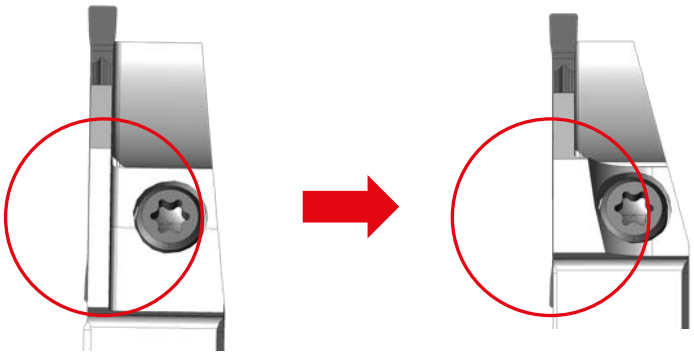


GY GROOVING SERIES

FEATURES OF THE HIGH-RIGIDITY HOLDER FOR SWISS TYPE LATHES

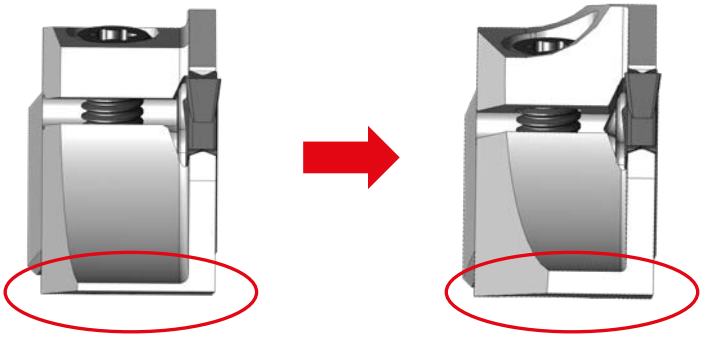
STRONG CLAMP BRIDGE

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



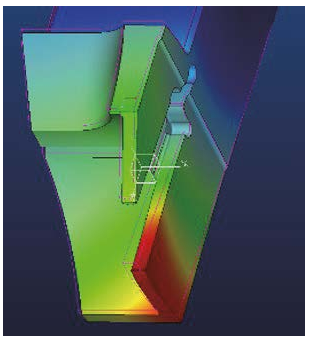
THICKER TOOL BASE

Tool deflection caused by cutting resistance is greatly reduced.



Analysis by simulation
Deflection measurement: 0.044 mm

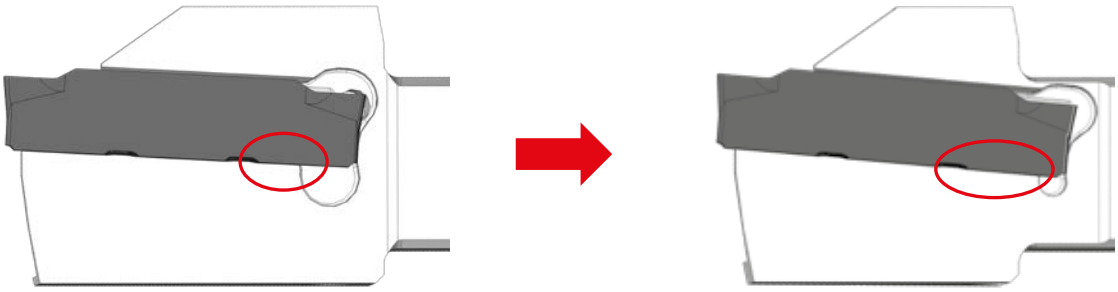
Analysis by simulation
Deflection measurement: 0.013 mm



Analysis by simulation

STRENGTHENING OF THE INSERT CLAMP

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



GY GROOVING SERIES

NEW LINE-UP

LOW RESISTANCE/ LOW FEED BREAKER

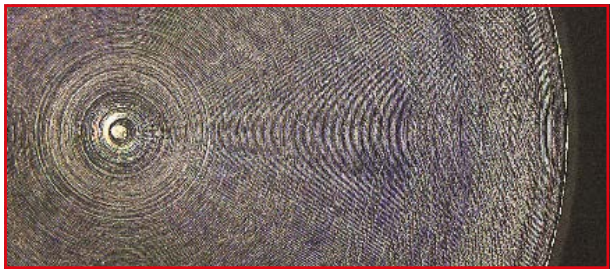
GS Breaker for lead angle 8° and 15°

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

CUTTING PERFORMANCE

SUS304 Comparison of cutting off and remaining material

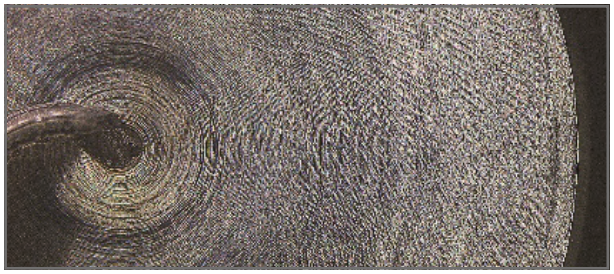
Complete cutting off



GY
GS breaker

Remaining pip in the centre: Ø 0.49 mm, Rz: 0.009 mm

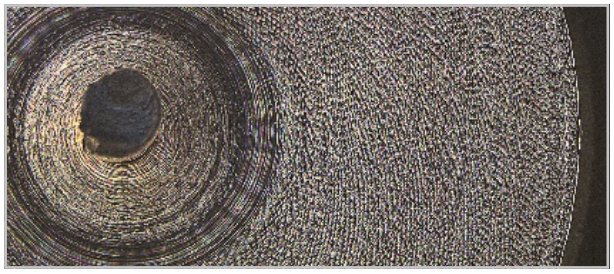
Not completely cut off



Conventional A

Remaining pip in the centre: Ø 0.58 mm, Rz: 0.043 mm

Not completely cut off



Conventional B

Remaining pip in the centre: Ø 1.42 mm, Rz: 0.015 mm

Material	SUS304 Ø16mm
Tool	CW = 2 mm Lead Angle 15°
Vc (m/min)	100
f (mm/rev)	0.03
Cutting mode	Wet cutting

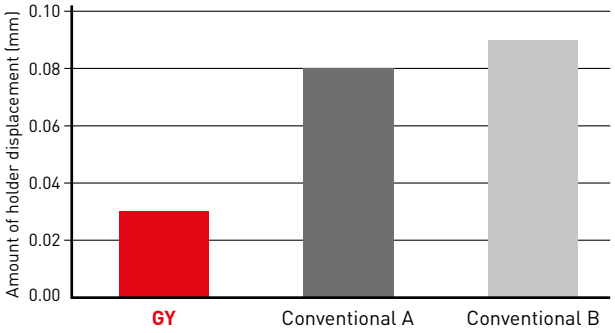
GY GROOVING SERIES

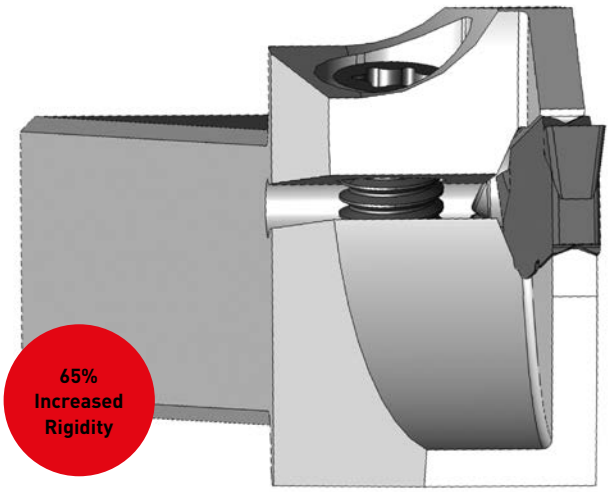
CUTTING PERFORMANCE FOR SWISS TYPE LATHES

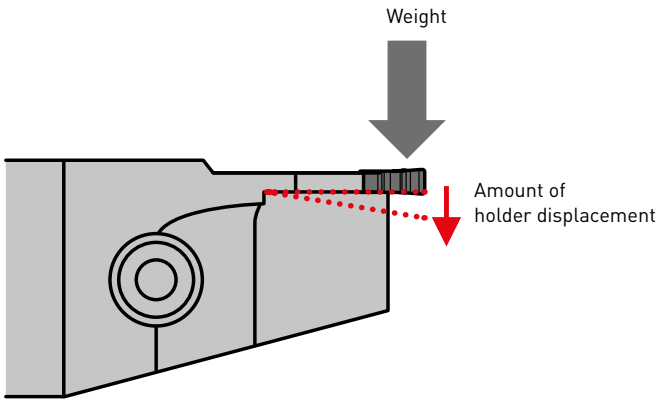
TOOL HOLDER DEFLECTION COMPARISON

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

GY holder







GY GROOVING SERIES

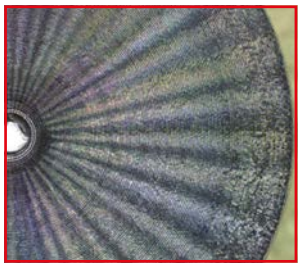
CUTTING PERFORMANCE FOR SWISS TYPE LATHES

SURFACE FINISH COMPARISON WHEN CUTTING OFF: 1.4301 X5CRNI18-9

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

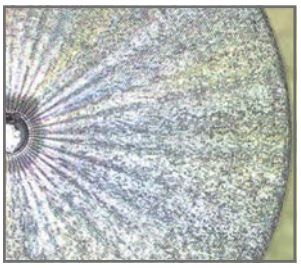
GY Holder

Rz 1.8 µm



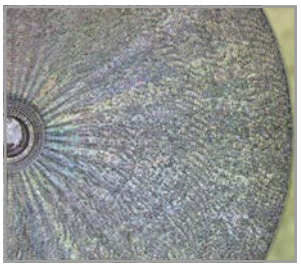
GY

Rz 5.6 µm



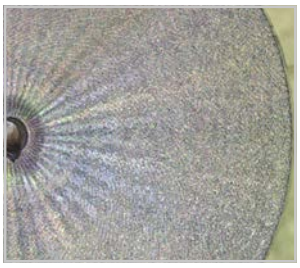
Conventional A

Rz 4.1 µm



Conventional B

Rz 5.7 µm



Conventional C

Material	1.4301 Ø25mm
Tool	CW = 2 mm RE = 0.2 mm 16 x 16
Vc (m/min)	120
f (mm/rev)	0.10
Cutting mode	Wet cutting

Excellent surface finish

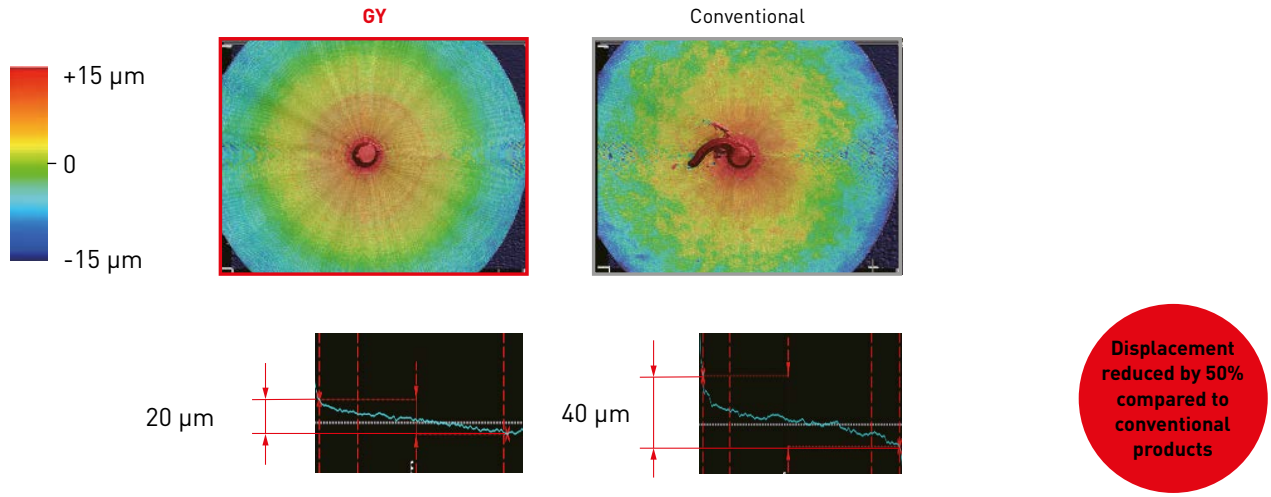
GY GROOVING SERIES

CUTTING PERFORMANCE FOR SWISS TYPE LATHES

COMPARISON OF THE ACCURACY OF THE WORKPIECE WHEN CUTTING OFF: 1.4301 X5CRNI18-9

GY Holder

Height difference colour



Displacement reduced by 50% compared to conventional products

Material	1.4301 Ø25mm
Tool	CW = 2 mm RE = 0.2 mm 16 x 16
Vc (m/min)	120
f (mm/rev)	0.10
Cutting mode	Wet cutting

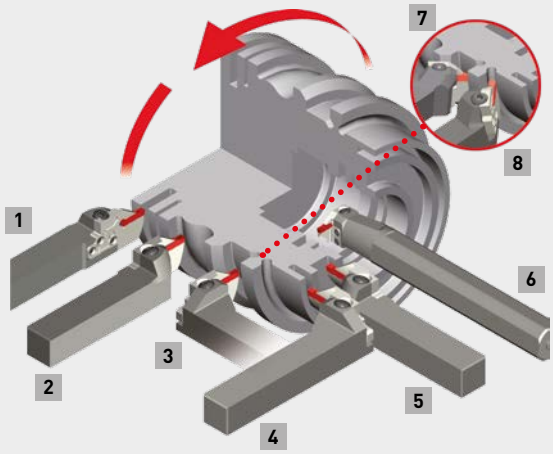
GY GROOVING SERIES

STEP 1 – SELECT AN APPLICATION

SELECT THE APPLICATION AND THE DIRECTION OF THE WORKPIECE ROTATION, THEN FOLLOW THE NEXT STEPS

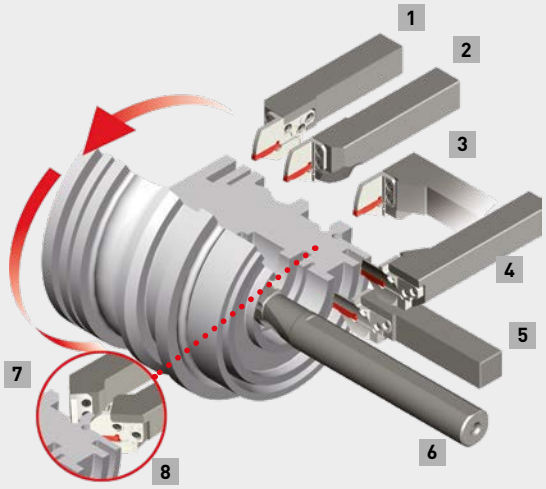
CLOCKWISE

Normal use



No.	Type	Angle	Hand	Page
1	External	0°	L	37
2	External	0°	R	37
3	External	90°	L	44
4	Face	90°	R	62

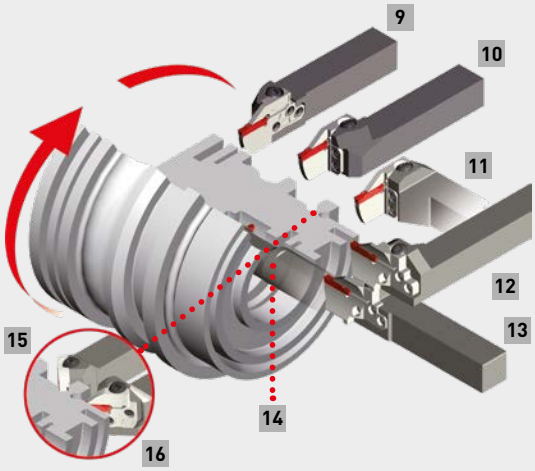
Reverse holder use



No.	Type	Angle	Hand	Page
5	Face	0°	L	47
6	Internal	90°	R	64
7	Recessing	50°	L	46
8	Recessing	50°	R	46

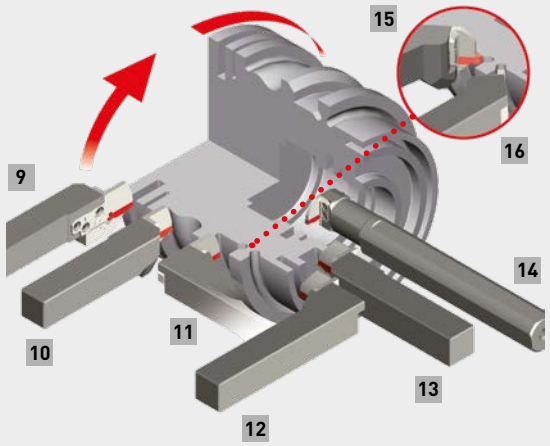
COUNTER CLOCKWISE

Normal use



No.	Type	Angle	Hand	Page
9	External	0°	R	37
10	External	0°	L	37
11	External	90°	R	44
12	Face	90°	L	62

Reverse holder use



No.	Type	Angle	Hand	Page
13	Face	0°	R	47
14	Internal	90°	L	64
15	Recessing	50°	R	46
16	Recessing	50°	L	46

1. Rotational direction of the workpiece is stated as if viewed from behind the spindle headstock.

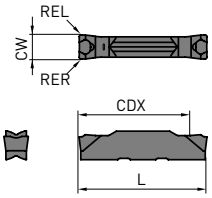
GY GROOVING SERIES

STEP 2 – SELECT AN INSERT

1 Select an insert suitable for the machining application, then select the corresponding seat size.
Seat size refers to the seat width of the modular blade.

INSERTS

Order number	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	MB8025	Seat size	CW	Tolerance	RE R/L	CDX	L	Geometry
FOR GROOVING / CUTTING OFF														
GY2M0200D020N-GU			●	●		●		D	2.00	±0.03	0.2	19.7	20.70	GU (For gummy steel)
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	



STEP 3 – SELECT A MODULAR HOLDER & A MODULAR BLADE

1 Proceed to the tool holder page in STEP 1, then go to the column of the seat size selected in STEP 2.

2 Select the hand of the tool holder.

3 Select a modular holder suitable for the machine used.

4 Select the maximum groove depth.

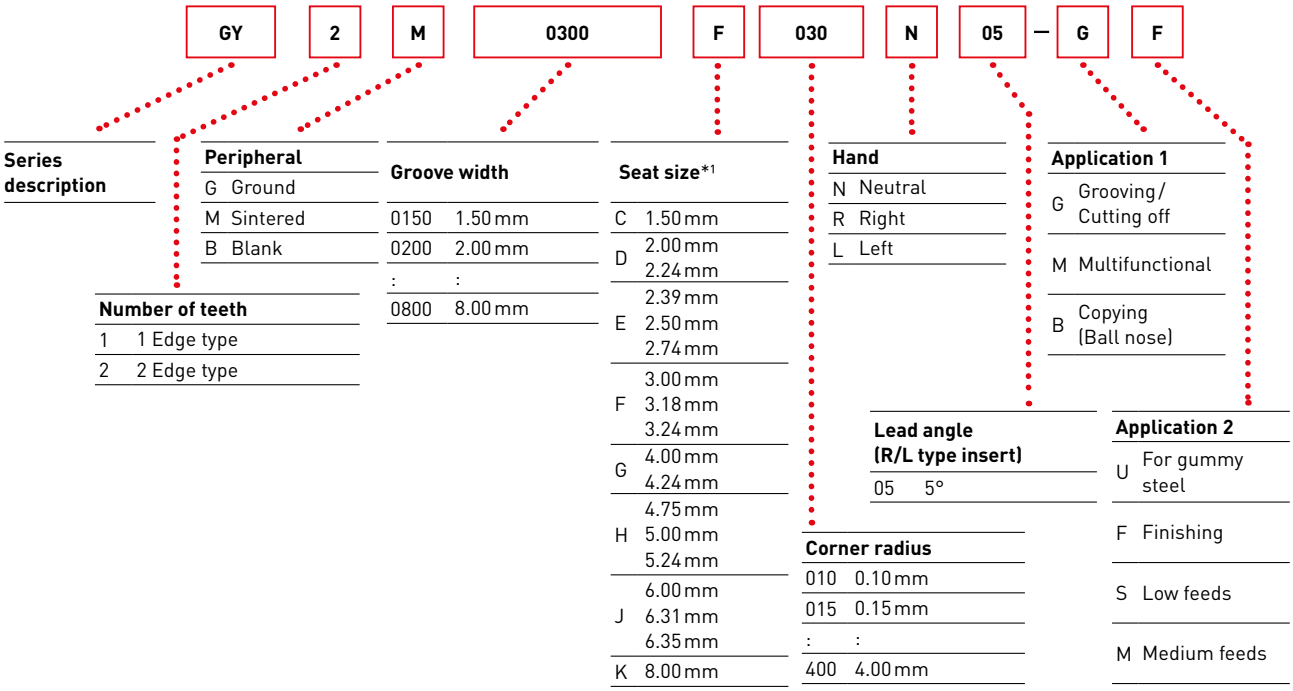
5 Select a modular blade that corresponds to 4 .
When selecting a modular blade for face grooving note if the cutting diameter range is suitable.

3 Order number Holder	Stock	5 Order number Modular blade	Stock	1 Seat size	CW	4 CDX	CUTDIA	2 Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
GYHR1616J00-M20R	●	GYM20RA-D06	●					R	16	16	104	28	44	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-D06	●					L	16	16	104	28	44	16	20	4	3
GYQR2020K00-D06	●	–						R	20	20	125	36	–	20	20.15	–	7
GYQL2020K00-D06	●	–						L	20	20	125	36	–	20	20.15	–	7
GYHR2020K00-M20R	●	GYM20RA-D06	●					R	20	20	119	28	43	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-D06	●					L	20	20	119	28	43	20	23	–	1
GYHR2020K00-M25R	●	GYM25RA-D06	●					R	20	20	117	31	52	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-D06	●					L	20	20	117	31	52	20	26	5	3
GYQR2525M00-D06	●	–		D	2.00 2.24	6	12	R	25	25	150	36	–	25	25.15	–	7

IDENTIFICATION

INSERT / BLADE / TOOL BLOCK

INSERT



Series description

Peripheral

G	Ground
M	Sintered
B	Blank

Number of teeth

1	1 Edge type
2	2 Edge type

Groove width

0150	1.50 mm
0200	2.00 mm
:	:
0800	8.00 mm

Seat size[*1]

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

Corner radius

010	0.10 mm
015	0.15 mm
:	:
400	4.00 mm

Hand

N	Neutral
R	Right
L	Left

Lead angle (R/L type insert)

05	5°

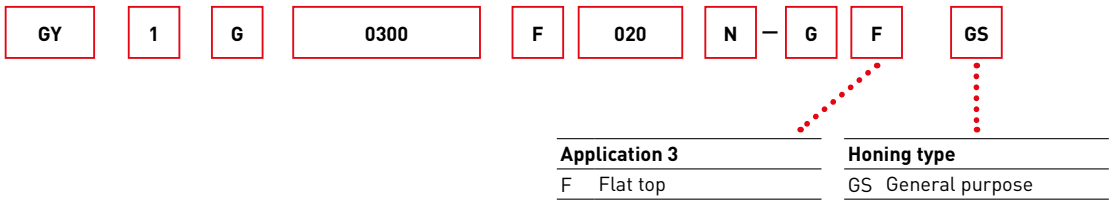
Application 1

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

Application 2

U	For gummy steel
F	Finishing
S	Low feeds
M	Medium feeds

PCBN INSERT



Application 3

F	Flat top

Honing type

GS	General purpose

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

IDENTIFICATION

INSERT / BLADE / TOOL BLOCK

MODULAR BLADE

External / Internal / Recessing

GY	M25	R	A	–	F	12

Series description

Modular blade size

M20	
M25	

Hand

R	Right
L	Left

Modular blade type

A	Standard type
B	Reinforced type
C	External recessing
D	Face grooving

Seat size[*1]

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

Max. groove depth[*2]

005	0.5 mm
06	6 mm
:	:
25	25 mm

Face grooving

GY	M25	R	D	–	F	12	050

Min. groove diameter

035	35 mm
040	40 mm
:	:
250	250 mm

Note : Dimension symbols conforming to ISO13399.

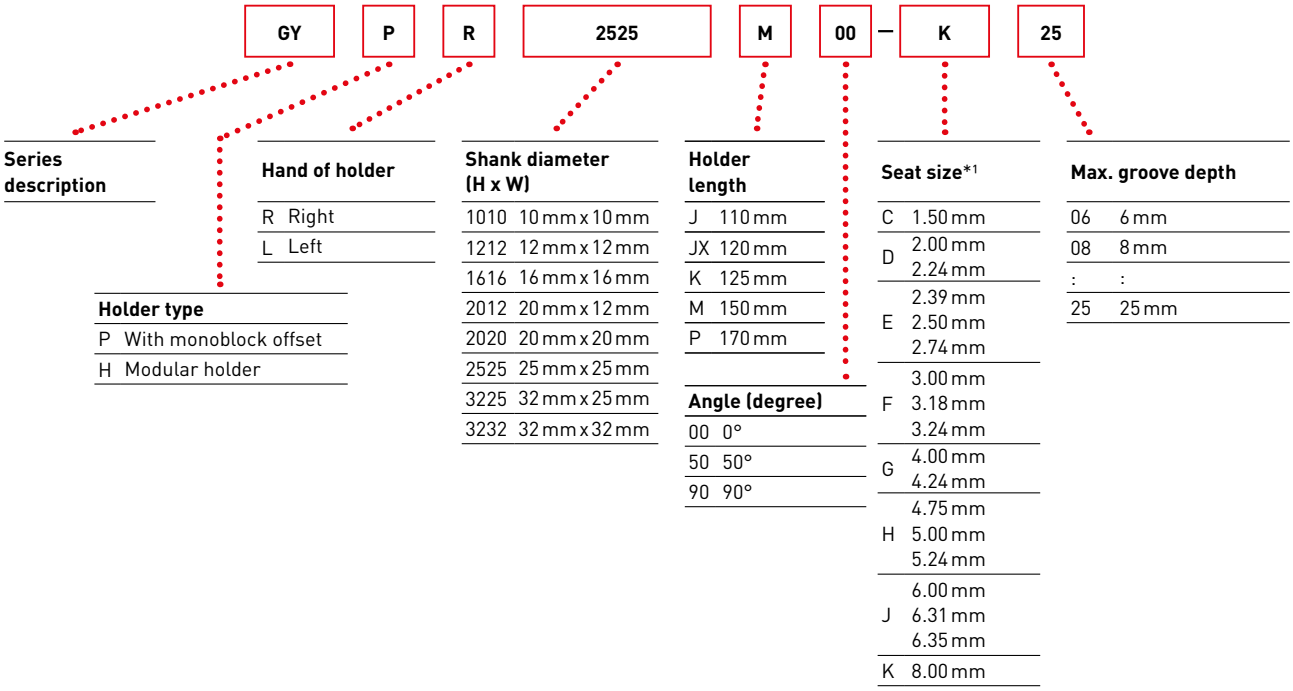
*1 Select a seat size with the same symbol as that of the insert.
*2 The maximum groove depth is a value when used for external grooving and changes according to the insert used.
*3 For internal grooving, refer to the maximum groove depth (CDX) on pages 90 – 92.
*4 GYM20R/LA-◌10, GYM20R/LA-◌12, GYM25R/LA-◌12 and GYM25R/LA-◌14 can be used for both external and internal grooving.

IDENTIFICATION

INSERT / BLADE / TOOL BLOCK

EXTERNAL / FACE GROOVING / RECESSING

Monoblock holder



Series description

Holder type	
P	With monoblock offset
H	Modular holder

Hand of holder	
R	Right
L	Left

Shank diameter (H x W)	
1010	10 mm x 10 mm
1212	12 mm x 12 mm
1616	16 mm x 16 mm
2012	20 mm x 12 mm
2020	20 mm x 20 mm
2525	25 mm x 25 mm
3225	32 mm x 25 mm
3232	32 mm x 32 mm

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

Angle (degree)	
00	0°
50	50°
90	90°

Seat size*1	
C	1.50 mm
D	2.00 mm 2.24 mm
E	2.39 mm 2.50 mm 2.74 mm
F	3.00 mm 3.18 mm 3.24 mm
G	4.00 mm 4.24 mm
H	4.75 mm 5.00 mm 5.24 mm
J	6.00 mm 6.31 mm 6.35 mm
K	8.00 mm

Max. groove depth	
06	6 mm
08	8 mm
:	:
25	25 mm

Modular holder

Modular blade size
M20
M25

Hand of modular blade	
R	Right
L	Left

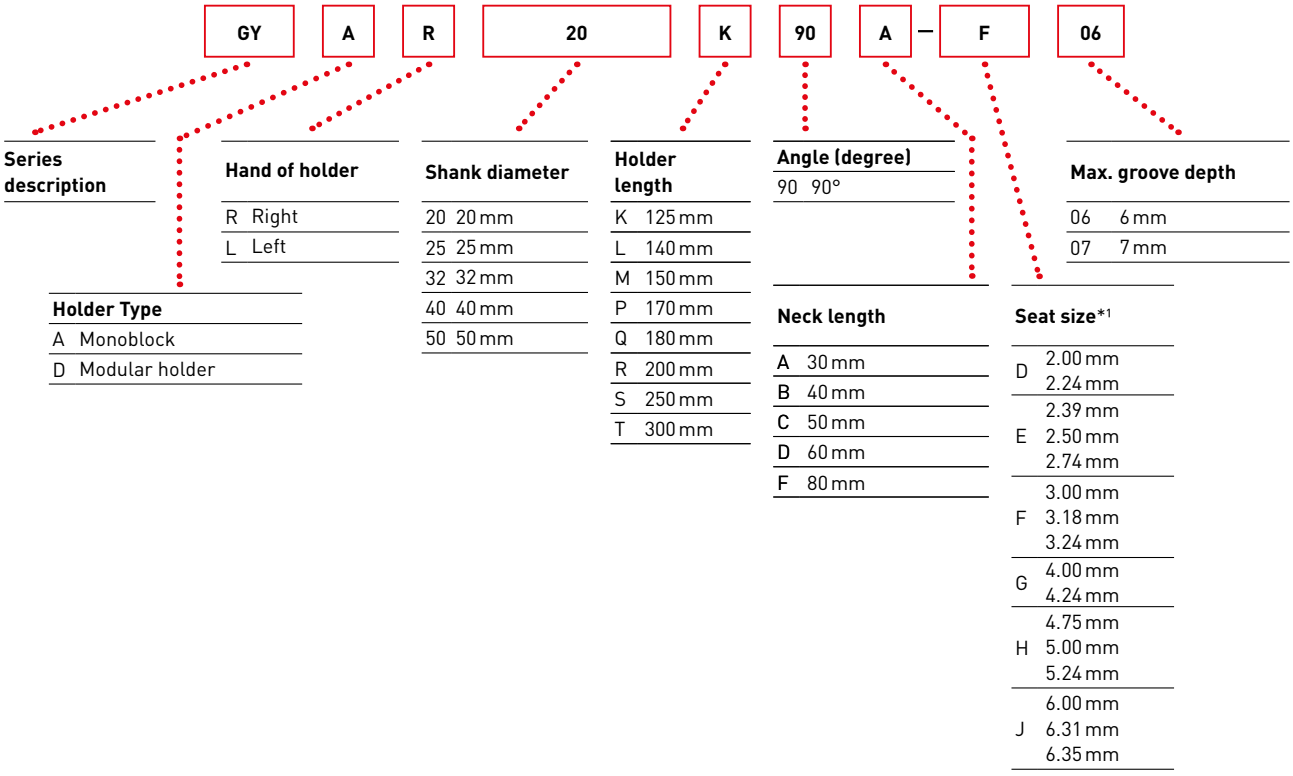
*1 Select a seat size with the same symbol as that of the insert.

IDENTIFICATION

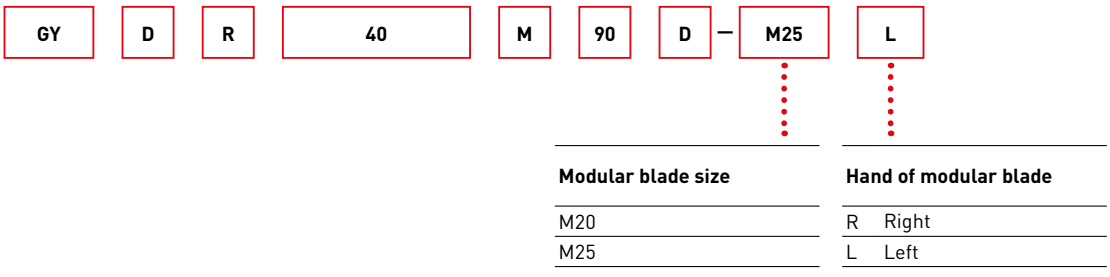
INSERT / BLADE / TOOL BLOCK

INTERNAL

Monoblock holder



Modular holder

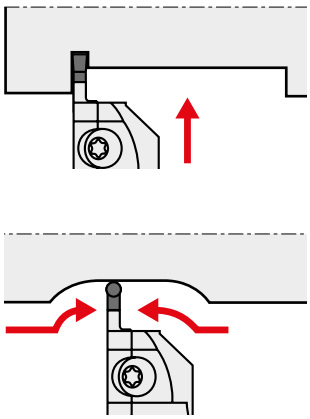


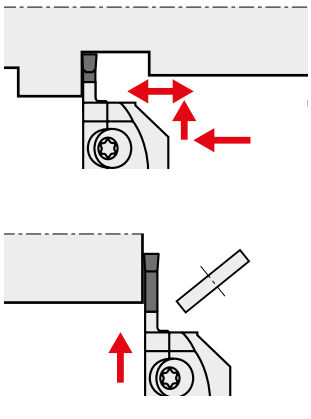
*1 Select a seat size with the same symbol as that of the insert.

GY GROOVING SERIES

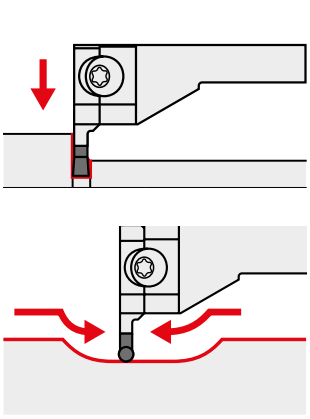
EXTERNAL GROOVING

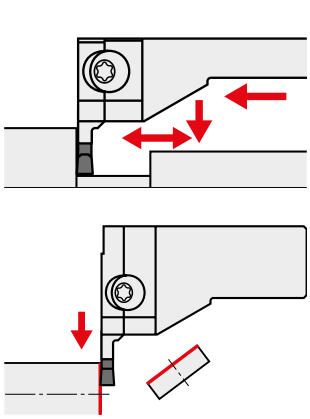
00° TYPE HOLDER





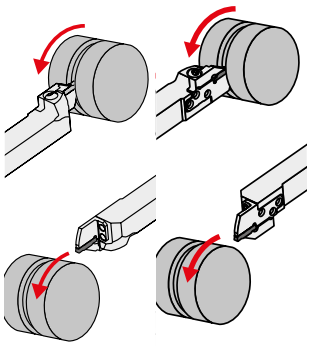
90° TYPE HOLDER



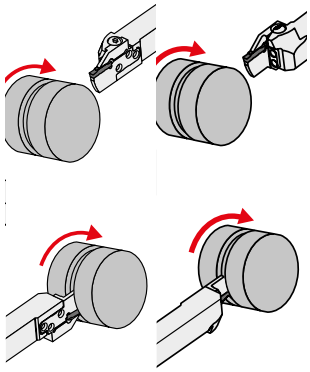


CUTTING MODE

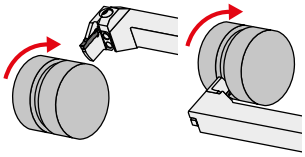
Clockwise



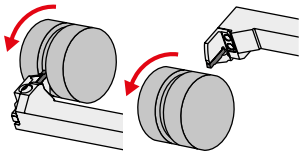
Anticlockwise



Anticlockwise

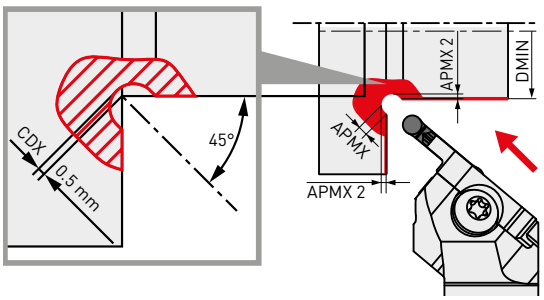


Clockwise



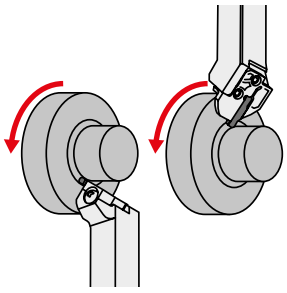
EXTERNAL RECESSING

50° TYPE HOLDER

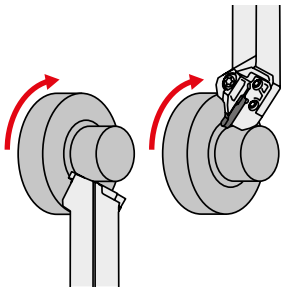


CUTTING MODE

Clockwise



Anticlockwise

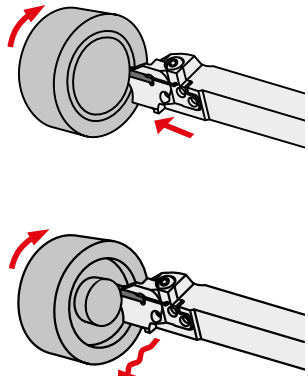


1. Rotational direction of the workpiece is stated as if viewed from behind the spindle headstock.

GY GROOVING SERIES

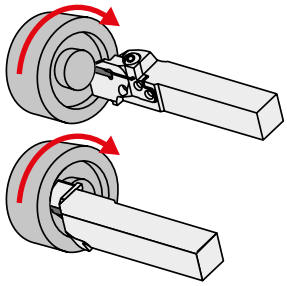
FACE GROOVING

00° TYPE HOLDER

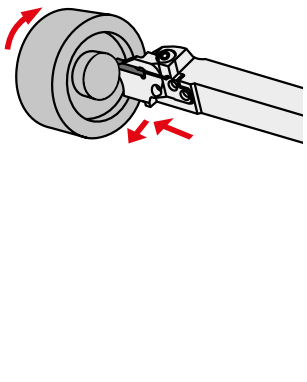


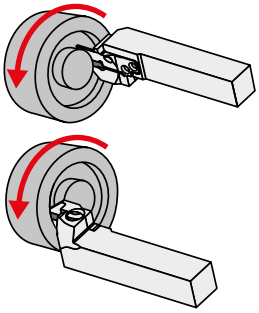
CUTTING MODE

Anticlockwise

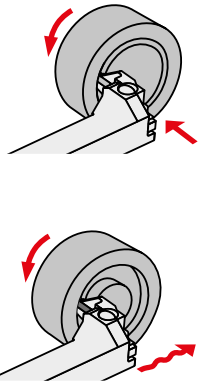


Clockwise



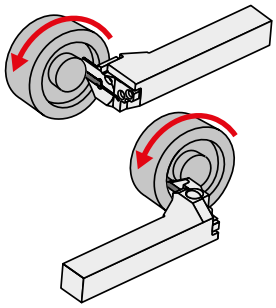


90° TYPE HOLDER

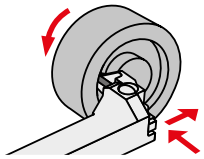


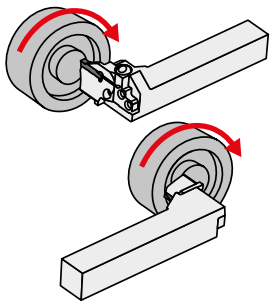
CUTTING MODE

Clockwise



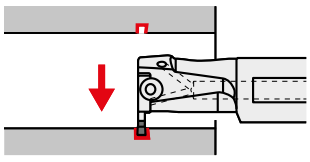
Anticlockwise

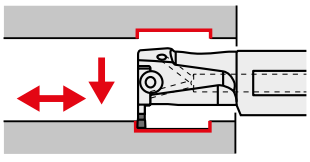


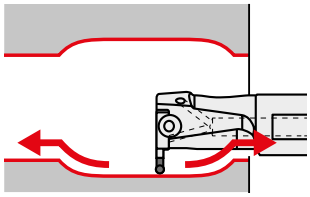


GROOVING

90° TYPE HOLDER

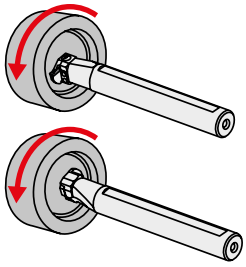




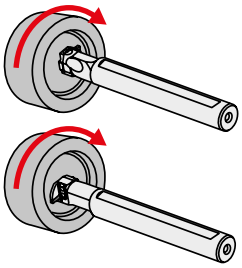


CUTTING MODE

Clockwise



Anticlockwise

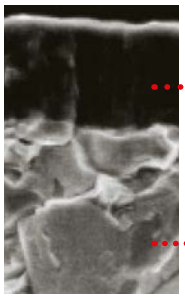


1. Rotational direction of the workpiece is stated as if viewed from behind the spindle headstock.

INSERT GRADES

P		M		K		S		H		N	
NX2525	●							BC8110	●	RT9010	●
MY5015	●			MY5015	●	VP10RT RT9010 MP9015	●		●		●
VP10RT	●	VP10RT	●	VP10RT	●	VP20RT RT9020 MP9025	●				
VP20RT	✱	VP20RT	✱	VP20RT	✱		✱				

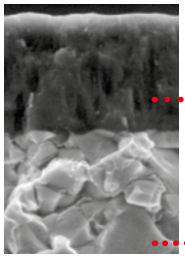
VP20RT (1st Recommendation)



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)

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)

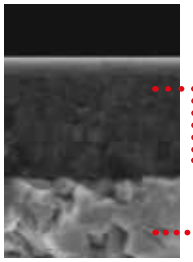
RT9010

First recommended grade for titanium alloys.

BC8110

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

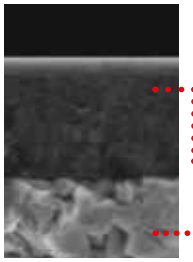
MP9015



PVD coated grade with a cemented carbide substrate. First recommendation for general applications at HRSA materials

- High Al-rich (Al,Ti)N Single layer coating technology
- Special cemented carbide substrate

MP9025



PVD coated grade with a tough cemented carbide substrate. It provides cutting edge stability for unstable applications at HRSA materials

- High Al-rich (Al,Ti)N Single layer coating technology
- Special cemented carbide substrate

MY5015

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

- CVD coating
- Carbide substrate

NX2525

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

BLANK INSERTS FOR CUSTOM GRINDING

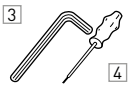
1 Edge type　　2 Edge type

RT9010/RT9020

BLANK INSERT

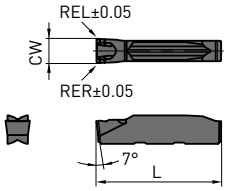
First recommendation for blanks inserts is RT9020 due to the tougher carbide substrate that is suitable for a wider range of applications.
RT9010 has a harder substrate than RT9020 and is ideal for longer tool life on stable cutting applications.
Both grades are recommended to have a coating applied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

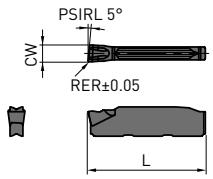
SPARE PARTS

Holder		 5 pcs.	
	Clamp screw	**Blade screw**	**Wrench**
GYQR/L□□□-□□□	1 HSC05030 (Clamp torque: 7.0N·m)	—	HKY40R
GYHR/L□□□-M20R/L	2 GY06013M (Clamp torque: 6.0N·m)	TS407 (Clamp torque: 3.5N·m)	3 TKY30R 4 TKY15D
GYHR/L□□□-M25R/L		TS55 (Clamp torque: 5.0N·m)	3 TKY30R 4 TKY25D
GYPR/L□□□00-K25		—	3 TKY30R
GYSR/L1010JX00	3 CS350990T	—	3 TKY10R
GYSR/L1212JX00			
GYSR/L1616JX00	3 TS4SBL	—	3 TKY15R
GYSR/L1915K00			
GYSR/L2012JX00	3 CS350990T	—	3 TKY10R
GYSR/L2020K00	3 HSC05018	—	3 HKY40R
GYSR/L2525K00			

INSERTS (SINGLE END)

Order number	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	MP9015	MP9025	Seat size	CW	Tolerance	RER/L	L	Geometry
GROOVING / CUTTING OFF															
GY1M0200D020N-GM			●	●	●			●	●	D	2.00	±0.03	0.2	20.70	GM Breaker (Medium feeds)
GY1M0250E020N-GM			●	●	★			●	●	E	2.50	±0.03	0.2	20.70	
GY1M0300F030N-GM			●	●	●			●	●	F	3.00	±0.03	0.3	20.70	
GY1M0400G030N-GM			●	●	●			●	●	G	4.00	±0.04	0.3	25.65	
GY1M0500H040N-GM			●	●	●			●	●	H	5.00	±0.04	0.4	25.65	
CUTTING OFF															
GY1M0200D020R05-GM			●	●						D	2.00	±0.03	0.2	20.80	R/L05-GM Breaker
GY1M0200D020L05-GM			★	●						D	2.00	±0.03	0.2	20.80	
GY1M0300F030R05-GM			●	●						F	3.00	±0.03	0.3	20.85	
GY1M0300F030L05-GM			●	●						F	3.00	±0.03	0.3	20.85	



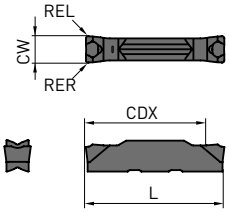


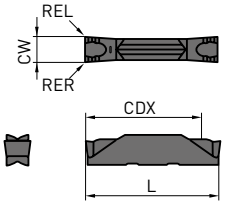
Left hand insert shown.

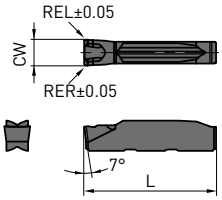
● : Inventory maintained. ★ : Inventory maintained in Japan.

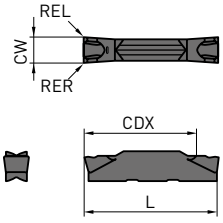
INSERTS

Order number	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	MP9015	MP9025	Seat size	CW	Tolerance	RE R/L	CDX	L	Geometry
GROOVING / CUTTING OFF																
GY2M0200D020N-GU			●	●		●				D	2.00	±0.03	0.2	19.7	20.70	GU (For gummy steel)
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	
GY2M0120B010N-GS			●	●						B	1.20	±0.03	0.1	12.2	14.70	GS (Low feeds)
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	
GY2M0635J030N-GS			●	●		●				J	6.35	±0.04	0.3	24.1	25.65	
GY2M0800K030N-GS			●	●						K	8.00	±0.04	0.3	29.1	30.50	
GY1M0200D020N-GM			●	●		●		●	●	D	2.00	±0.03	0.2	–	20.70	GM (Medium feeds)
GY1M0250E020N-GM			●	●		★		●	●	E	2.50	±0.03	0.2	–	20.70	
GY1M0300F030N-GM			●	●		●		●	●	F	3.00	±0.03	0.3	–	20.70	
GY1M0400G030N-GM			●	●		●		●	●	G	4.00	±0.04	0.3	–	25.65	
GY1M0500H040N-GM			●	●		●		●	●	H	5.00	±0.04	0.4	–	25.65	
GY2M0150C020N-GM			●	●		●		●	●	C	1.50	±0.03	0.2	13.9	14.70	GM (Medium feeds)
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	
GY2M0600J040N-GM			●	●	●	●		●	●	J	6.00	±0.04	0.4	24.3	25.65	
GY2M0635J040N-GM			●	●	●	●		●	●	J	6.35	±0.04	0.4	24.3	25.65	
GY2M0800K050N-GM			●	●	●			●	●	K	8.00	±0.04	0.5	29.3	30.50	





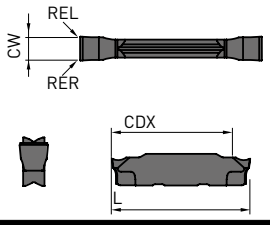


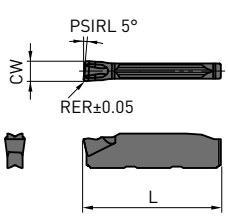


● : Inventory maintained. ★ : Inventory maintained in Japan.

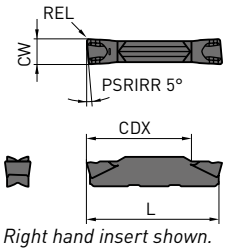
INSERTS

Order number	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	MP9015	MP9025	Seat size	CW	Tolerance	RE R/L	CDX	L	Geometry
GROOVING / CUTTING OFF																
GY2G0200D005N-GL	●									D	2.00	±0.02	0.05	19.5	21.05	GL Breaker (For aluminium alloys)
GY2G0250E005N-GL	●									E	2.50	±0.02	0.05	19.1	21.05	
GY2G0300F005N-GL	●									F	3.00	±0.02	0.05	18.9	21.05	
CUTTING OFF																
GY1M0200D020R05-GM			●	●						D	2.00	±0.03	0.2	–	20.80	R/L05-GM Breaker
GY1M0200D020L05-GM			★	●						D	2.00	±0.03	0.2	–	20.80	
GY1M0300F030R05-GM			●	●						F	3.00	±0.03	0.3	–	20.85	
GY1M0300F030L05-GM			●	●						F	3.00	±0.03	0.3	–	20.85	
GY2M0200D020R05-GM			●	●						D	2.00	±0.03	0.2	19.5	20.80	R/L05-GM Breaker
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	
GY2M0120B010R05-GS			★	★						B	1.20	±0.03	0.1	12.22	14.70	R/L05-GS Breaker (Low feeds)
GY2G0150C010R08-GS			●	●						C	1.50	±0.02	0.1	13.17	15.20	R08-GS Breaker (Low feeds)
GY2G0200D020R08-GS			●	●						D	2.00	±0.03	0.2	18.85	21.30	
GY2G0250E020R08-GS			●	●						E	2.50	±0.03	0.2	19.04	21.50	
GY2G0300F020R08-GS			●	●						F	3.00	±0.03	0.2	18.62	21.50	
GY2G0150C003R15-GS			●	●						C	1.50	±0.02	0.03	13.17	15.20	R15-GS Breaker (Low feeds)
GY2G0150C010R15-GS			●	●						C	1.50	±0.02	0.1	13.17	15.20	
GY2G0200D003R15-GS			●	●						D	2.00	±0.03	0.03	18.85	21.30	
GY2G0200D010R15-GS			●	●						D	2.00	±0.03	0.1	18.85	21.30	
GY2G0250E003R15-GS			●	●						E	2.50	±0.03	0.03	19.04	21.50	
GY2G0250E020R15-GS			●	●						E	2.50	±0.03	0.2	19.04	21.50	
GY2G0300F003R15-GS			●	●						F	3.00	±0.03	0.03	18.62	21.50	
GY2G0300F020R15-GS			●	●						F	3.00	±0.03	0.2	18.62	21.50	





Left hand insert shown.



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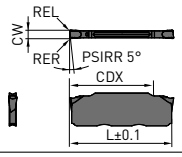

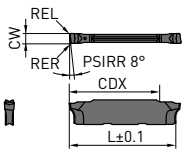

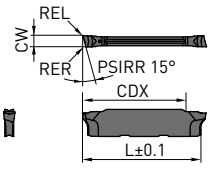

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INSERTS

Order number	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	MP9015	MP9025	Seat size	CW	Tolerance	RE R/L	CDX	L	LE	Geometry
GROOVING																	
GY1G0200D020N-GFGS							●			D	2.00	±0.03	0.2	—	20.70	2.7	(For hardened material)
GY1G0239E020N-GFGS							●			E	2.39	±0.03	0.2	—	20.70	2.7	
GY1G0250E020N-GFGS							●			E	2.50	±0.03	0.2	—	20.70	2.7	
GY1G0300F020N-GFGS							●			F	3.00	±0.03	0.2	—	20.70	2.7	
GY1G0318F020N-GFGS							●			F	3.18	±0.03	0.2	—	20.70	2.7	
GY1G0400G020N-GFGS							●			G	4.00	±0.03	0.2	—	25.65	2.7	
GY1G0475H020N-GFGS							●			H	4.75	±0.03	0.2	—	25.65	2.7	
GY1G0500H020N-GFGS							●			H	5.00	±0.03	0.2	—	25.65	2.7	
GY1G0600J020N-GFGS							●			J	6.00	±0.03	0.2	—	25.65	2.7	
MULTIFUNCTIONAL GROOVING																	
GY2G0200D020N-MF	●		●	●		●				D	2.00	±0.02	0.2	19.5	21.05	—	MF (Finishing)
GY2G0224D015N-MF*1	●		●	●		●				D	2.24	±0.02	0.15	19.8	21.05	—	
GY2G0239E020N-MF	★		★	★		★				E	2.39	±0.02	0.2	19.2	21.05	—	
GY2G0250E020N-MF	●		●	●		●				E	2.50	±0.02	0.2	19.4	21.05	—	
GY2G0274E020N-MF*1	●		●	●		●				E	2.74	±0.02	0.2	19.7	21.05	—	
GY2G0300F020N-MF	●		●	●		●				F	3.00	±0.02	0.2	19.5	21.05	—	
GY2G0300F040N-MF	●		●	●		●				F	3.00	±0.02	0.4	19.3	21.05	—	
GY2G0318F020N-MF	★		★	★		★				F	3.18	±0.02	0.2	19.5	21.05	—	
GY2G0318F040N-MF	★		★	★		★				F	3.18	±0.02	0.4	19.3	21.05	—	
GY2G0324F020N-MF*1	●		●	●		●				F	3.24	±0.02	0.2	19.5	21.05	—	
GY2G0400G020N-MF	●		●	●		●				G	4.00	±0.02	0.2	24.9	25.95	—	
GY2G0400G040N-MF	●		●	●		●				G	4.00	±0.02	0.4	24.7	25.95	—	
GY2G0400G080N-MF	●		●	●		●				G	4.00	±0.02	0.8	24.3	25.95	—	
GY2G0424G020N-MF*1	●		●	●		●				G	4.24	±0.02	0.2	24.9	25.95	—	
GY2G0475H020N-MF	★		★	★		★				H	4.75	±0.02	0.2	24.4	25.95	—	
GY2G0475H040N-MF	★		★	★		★				H	4.75	±0.02	0.4	24.2	25.95	—	
GY2G0475H080N-MF	★		★	★		★				H	4.75	±0.02	0.8	23.8	25.95	—	
GY2G0500H020N-MF	●		●	●		●				H	5.00	±0.02	0.2	24.4	25.95	—	
GY2G0500H040N-MF	●		●	●		●				H	5.00	±0.02	0.4	24.2	25.95	—	
GY2G0500H080N-MF	●		●	●		●				H	5.00	±0.02	0.8	23.8	25.95	—	
GY2G0524H020N-MF*1	●		●	●		●				H	5.24	±0.02	0.2	24.4	25.95	—	
GY2G0600J020N-MF	●		●	●		●				J	6.00	±0.02	0.2	24.4	25.95	—	
GY2G0600J040N-MF	●		●	●		●				J	6.00	±0.02	0.4	24.2	25.95	—	
GY2G0600J080N-MF	●		●	●		●				J	6.00	±0.02	0.8	23.8	25.95	—	
GY2G0631J020N-MF*1	●		●	●		●				J	6.31	±0.02	0.2	24.4	25.95	—	
GY2G0635J020N-MF	★		★	★		★				J	6.35	±0.02	0.2	24.4	25.95	—	
GY2G0635J040N-MF	★		★	★		★				J	6.35	±0.02	0.4	24.2	25.95	—	
GY2G0635J080N-MF	★		★	★		★				J	6.35	±0.02	0.8	23.8	25.95	—	
GY2M0200D020N-MS			●	●	●	●				D	2.00	±0.03	0.2	19.1	20.70	—	MS (Low feeds)
GY2M0250E020N-MS			●	●	●	●				E	2.50	±0.03	0.2	19.1	20.70	—	
GY2M0300F020N-MS			●	●	●	●				F	3.00	±0.03	0.2	19.2	20.70	—	
GY2M0300F040N-MS			●	●	●	●				F	3.00	±0.03	0.4	18.9	20.70	—	
GY2M0400G020N-MS			●	●	●	●				G	4.00	±0.04	0.2	24.2	25.65	—	
GY2M0400G040N-MS			●	●	●	●				G	4.00	±0.04	0.4	23.9	25.65	—	
GY2M0500H040N-MS			●	●	●	●				H	5.00	±0.04	0.4	23.9	25.65	—	
GY2M0500H080N-MS			●	●	●	●				H	5.00	±0.04	0.8	23.5	25.65	—	
GY2M0600J040N-MS			●	●	●	●				J	6.00	±0.04	0.4	23.9	25.65	—	
GY2M0600J080N-MS			●	●	●	●				J	6.00	±0.04	0.8	23.5	25.65	—	
GY2M0800K080N-MS			●	●	●					K	8.00	±0.04	0.8	28.5	30.50	—	

*1 Groove width corresponding to the circlip.

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INSERTS

Order number	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	MP9015	MP9025	Seat size	CW	Tolerance	RE R/L	CDX	L	Geometry
MULTIFUNCTIONAL GROOVING																
GY2M0200D020N-MM			●	●	●	●		●	●	D	2.00	±0.03	0.2	19.1	20.70	MM Breaker (Medium feeds)
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	
GY2M0800K120N-MM			●	●	●			●	●	K	8.00	±0.04	1.2	28.1	30.50	
COPYING / FOR RECESSING																
GY2M0200D100N-BM			●	●	●	●		●	●	D	2.00	±0.03	1.00	19.5	20.90	BM Breaker
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	
GY2M0800K400N-BM			●	●	●			●	●	K	8.00	±0.04	4.00	26.5	30.80	
BLANK																
GY2B0220D020N	●	●				●				D	2.20	±0.10	0.2	—	21.05	Flat top
GY2B0250D020N	●	●				●				D	2.55	±0.10	0.2	—	21.28	
GY2B0270E020N	●	●				●				E	2.70	±0.10	0.2	—	21.05	
GY2B0300E020N	●	●				●				E	3.05	±0.10	0.2	—	21.28	
GY2B0340F020N	●	●				●				F	3.40	±0.10	0.2	—	21.05	
GY2B0360F020N	●	●				●				F	3.65	±0.10	0.2	—	21.28	
GY2B0420G020N	●	●				●				G	4.20	±0.10	0.2	—	26.00	2 Edge type
GY2B0460G020N	●	●				●				G	4.65	±0.10	0.2	—	26.18	
GY2B0520H020N	●	●				●				H	5.20	±0.10	0.2	—	26.00	
GY2B0560H020N	●	●				●				H	5.65	±0.10	0.2	—	26.18	
GY2B0655J020N	●	●				●				J	6.55	±0.10	0.2	—	26.00	
GY2B0680J020N	●	●				●				J	6.85	±0.10	0.2	—	26.18	
GY2B0880K020N	●	●				●				K	8.85	±0.10	0.2	—	30.88	
GY1B0220D020N	●	●				●				D	2.20	±0.10	0.2	—	21.07	1 Edge type
GY1B0270E020N	●	●				●				E	2.70	±0.10	0.2	—	21.10	
GY1B0340F020N	●	●				●				F	3.40	±0.10	0.2	—	21.00	
GY1B0420G020N	●	●				●				G	4.20	±0.10	0.2	—	25.86	
GY1B0520H020N	●	●				●				H	5.20	±0.10	0.2	—	25.90	
GY1B0655J020N	●	●				●				J	6.55	±0.10	0.2	—	25.90	

*2 Blank inserts to be ground by the customer.

● : Inventory maintained. ★ : Inventory maintained in Japan.

GY GROOVING SERIES

EXTERNAL FOR SWISS TYPE LATHES

INSERT SELECTION

Seat size	Insert type
B	GY○○0120B○○○○–Breaker shown below
C	GY○○0150C○○○○–Breaker shown below
D	GY○○0200/0224D○○○○–Breaker shown below
E	GY○○0239/0250/0274E○○○○–Breaker shown below
F	GY○○0300/0318/0324F○○○○–Breaker shown below

For multifunctional grooving breaker

Seat size	CW	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying)
					Ball shape
D	2.00	●	●	●	●
	2.24	●			
E	2.39	●			
	2.50	●	●	●	●
	2.74	●			
F	3.00				●
	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18				●
	RE 0.2	●			
	RE 0.4	●			
	3.24	●			

For cutting off breaker

Seat size	CW	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
		R	R	R	R/L
B	1.20	★			
C	1.50		●	●	
D	2.00		●	●	
E	2.39		●	●	●
	2.50				
F	3.00		●	●	●
	3.18		●	●	●

For grooving/cutting off breaker

Seat size	CW	GU (For gummy steel)	GS (Low)	GM (Medium)	GL (Aluminium)	GFGS (Hardened steel)
		Neutral	Neutral	Neutral	Neutral	Neutral
B	1.20		●			
C	1.50		●	●		
D	2.00	●	●	●	●	●
E	2.39	●	●	●		●
	2.50	●	●	●	●	●
F	3.00	●	●	●	●	●
	3.18	●	●	●		●

CORRECT USE OF GY SERIES GS BREAKER

First recommendation

Reduction of cutting resistance

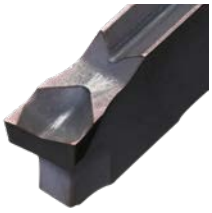
Lead angle PSIRR = 0° ⇄ **Lead angle PSIRR = 8°**

Reduction of burrs and core residue

Lead angle PSIRR = 8° ⇄ **Lead angle PSIRR = 15°**

Improved fracture resistance

Improved fracture resistance

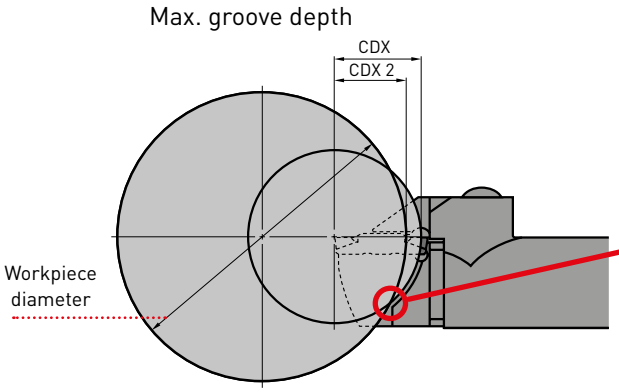


● : Inventory maintained. ★ : Inventory maintained in Japan.

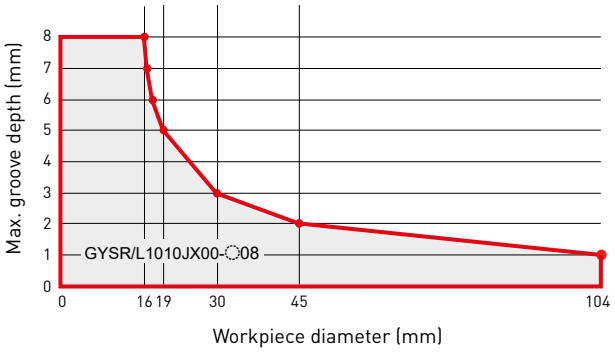
GY GROOVING SERIES

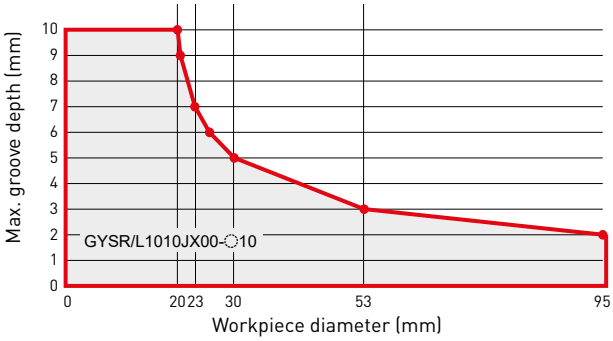
LIMITATION OF THE MAXIMUM GROOVE DEPTH FOR EXTERNAL SWISS TYPE LATHES

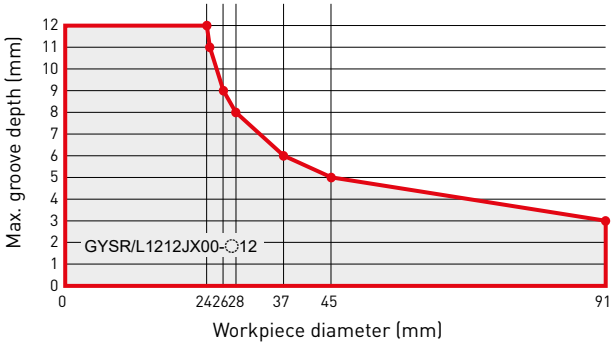
In the case of monoblock type holder for Swiss type lathes.
The maximum groove depth is limited by the workpiece diameter.

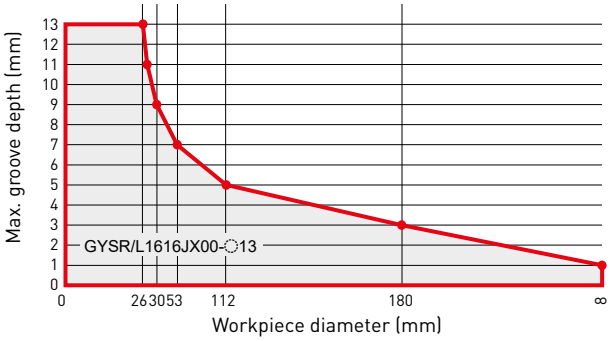


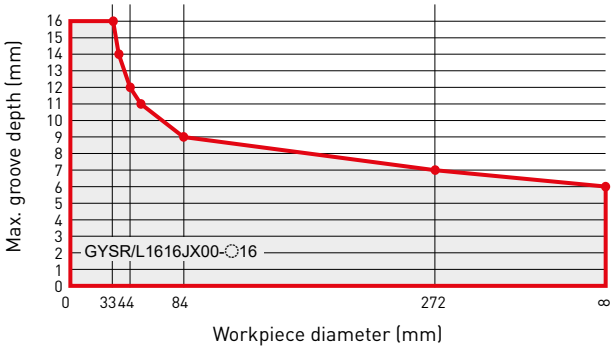
Due to interference, the maximum groove depth is limited by the workpiece diameter.









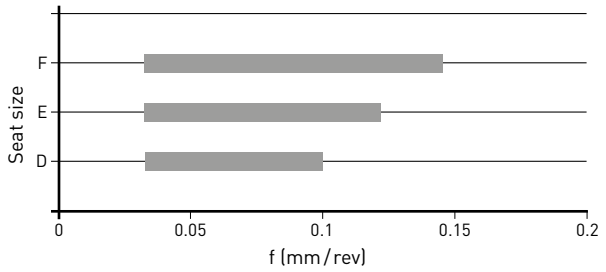


GY GROOVING SERIES

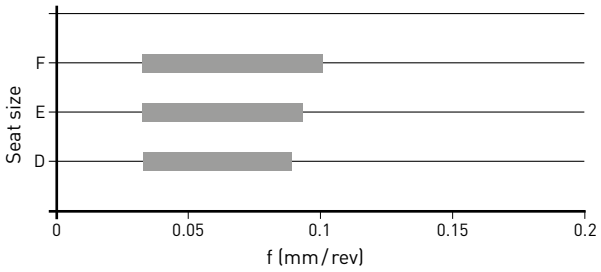
CUTTING OFF
FEED PER REVOLUTION

GROOVING, CUTTING OFF

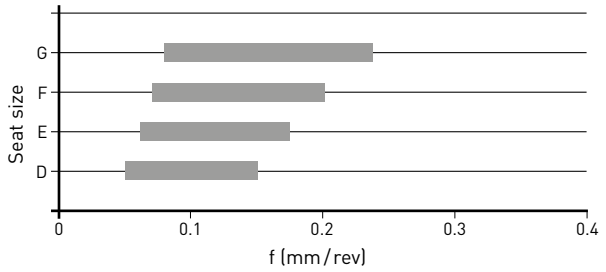
R05-GS Breaker



R08-GS Breaker



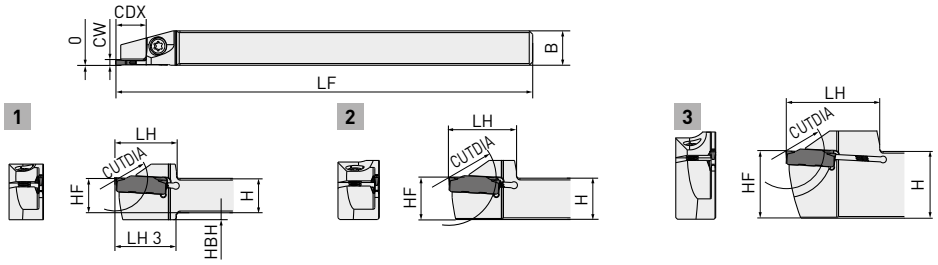
R/L05-GM Breaker



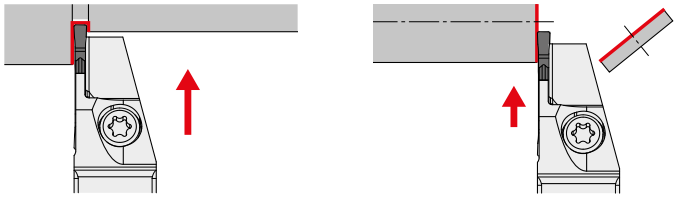
Chipbreaker	PSIPR	Hand	f (mm/rev)			
			Seat size D	Seat size E	Seat size F	Seat size G
R05-GS	5°	R	0.03–0.10	0.03–0.12	0.03–0.14	—
R08-GS	8°	R	0.03–0.08	0.03–0.09	0.03–0.10	—
R05-GM	5°	R/L	0.05–0.15	0.06–0.17	0.07–0.20	0.08–0.23

GY GROOVING SERIES

EXTERNAL FOR SWISS TYPE LATHES



Right hand tool holder shown.



	Order number	Seat size	CW	CDX*2	CUTDIA	Hand	Stock	H	B	LF	LH	LH3	HF*1	HBH	Fig.
	GYSR1010JX00-B08	B	1.20	8	16	R	●	10	10	120	17.5	17.5	10	2	1
	GYSL1010JX00-B08					L	●	10	10	120	17.5	17.5	10	2	1
	GYSR1212JX00-B08					R	●	12	12	120	19.5	—	12	—	2
	GYSL1212JX00-B08					L	●	12	12	120	19.5	—	12	—	2
	GYSR1212JX00-B12			12	24	R	●	12	12	120	19.5	19.5	12	2	1
	GYSL1212JX00-B12					L	●	12	12	120	19.5	19.5	12	2	1
	GYSR1616JX00-B08			8	16	R	●	16	16	120	25.0	—	16	—	2
	GYSL1616JX00-B08					L	●	16	16	120	25.0	—	16	—	2
	GYSR1616JX00-B13			13	26	R	●	16	16	120	25.0	—	16	—	2
	GYSL1616JX00-B13					L	●	16	16	120	25.0	—	16	—	2
NEW	GYSR1010JX00-C08	C	1.50	8	16	R	●	10	10	120	17.5	17.5	10	2	1
NEW	GYSL1010JX00-C08					L	●	10	10	120	17.5	17.5	10	2	1
NEW	GYSR1212JX00-C08					R	●	12	12	120	19.5	—	12	—	2
NEW	GYSL1212JX00-C08					L	●	12	12	120	19.5	—	12	—	2
NEW	GYSR1212JX00-C12			12	24	R	●	12	12	120	19.5	19.5	12	2	1
NEW	GYSL1212JX00-C12					L	●	12	12	120	19.5	19.5	12	2	1
NEW	GYSR1616JX00-C13			13	26	R	●	16	16	120	25.0	—	16	—	2
NEW	GYSL1616JX00-C13					L	●	16	16	120	25.0	—	16	—	2
NEW	GYSR2012JX00-C13					R	★	20	12	120	28.0	—	20	—	3
NEW	GYSL2012JX00-C13					L	★	20	12	120	28.0	—	20	—	3
NEW	GYSR1010JX00-D10	D	2.00	10	20	R	★	10	10	120	17.5	17.5	10	2	1
NEW	GYSL1010JX00-D10					L	★	10	10	120	17.5	17.5	10	2	1
NEW	GYSR1212JX00-D12			12	24	R	●	12	12	120	19.5	19.5	12	2	1
NEW	GYSL1212JX00-D12					L	●	12	12	120	19.5	19.5	12	2	1
NEW	GYSR1616JX00-D13			13	26	R	●	16	16	120	25	—	16	—	2
NEW	GYSL1616JX00-D13					L	●	16	16	120	25	—	16	—	2
NEW	GYSR1616JX00-D16			16	32	R	★	16	16	120	28	—	16	—	2
NEW	GYSL1616JX00-D16					L	●	16	16	120	28	—	16	—	2

● : Inventory maintained. ★ : Inventory maintained in Japan.

EXTERNAL FOR SWISS TYPE LATHES

	Order number	Seat size	CW	CDX*2	CUTDIA	Hand	Stock	H	B	LF	LH	LH3	HF*1	HBH	Fig.
NEW	GYSR1915K00-D17	D	2.24	17	34	R	★	19.05	15.875	125	28	—	19.05	—	3
NEW	GYSL1915K00-D17					L	★	19.05	15.875	125	28	—	19.05	—	3
NEW	GYSR2012JX00-D17					R	★	20	12	120	28	—	20	—	3
NEW	GYSL2012JX00-D17					L	★	20	12	120	28	—	20	—	3
NEW	GYSR2020K00-D17					R	★	20	20	125	35	—	20	—	2
NEW	GYSL2020K00-D17					L	★	20	20	125	35	—	20	—	2
NEW	GYSR2525M00-D17					R	★	25	25	150	40	—	25	—	2
NEW	GYSL2525M00-D17					L	★	25	25	150	40	—	25	—	2
NEW	GYSR1010JX00-E10	E	2.39	10	20	R	★	10	10	120	17.5	17.5	10	2	1
NEW	GYSL1010JX00-E10					L	★	10	10	120	17.5	17.5	10	2	1
NEW	GYSR1212JX00-E12			12	24	R	★	12	12	120	19.5	19.5	12	2	1
NEW	GYSL1212JX00-E12					L	★	12	12	120	19.5	19.5	12	2	1
NEW	GYSR1616JX00-E13			13	26	R	★	16	16	120	25	—	16	—	2
NEW	GYSL1616JX00-E13					L	★	16	16	120	25	—	16	—	2
NEW	GYSR1616JX00-E16			16	32	R	★	16	16	120	28	—	16	—	2
NEW	GYSL1616JX00-E16		2.50	16	32	L	★	16	16	120	28	—	16	—	2
NEW	GYSR1915K00-E17			17	34	R	★	19.05	15.875	125	28	—	19.05	—	3
NEW	GYSL1915K00-E17		2.74	17	34	L	★	19.05	15.875	125	28	—	19.05	—	3
NEW	GYSR2012JX00-E17					R	★	20	12	120	28	—	20	—	3
NEW	GYSL2012JX00-E17					L	★	20	12	120	28	—	20	—	3
NEW	GYSR2020K00-E17					R	★	20	20	125	35	—	20	—	2
NEW	GYSL2020K00-E17					L	★	20	20	125	35	—	20	—	2
NEW	GYSR2525M00-E17					R	★	25	25	150	40	—	25	—	2
NEW	GYSL2525M00-E17					L	★	25	25	150	40	—	25	—	2
NEW	GYSR1212JX00-F12	F	3.00	12	24	R	★	12	12	120	19.5	19.5	12	2	1
NEW	GYSL1212JX00-F12					L	●	12	12	120	19.5	19.5	12	2	1
NEW	GYSR1616JX00-F13			13	26	R	★	16	16	120	25	—	16	—	2
NEW	GYSL1616JX00-F13					L	★	16	16	120	25	—	16	—	2
NEW	GYSR1616JX00-F16		3.18	16	32	R	●	16	16	120	28	—	16	—	2
NEW	GYSL1616JX00-F16					L	★	16	16	120	28	—	16	—	2
NEW	GYSR1915K00-F17		3.24	17	34	R	★	19.05	15.875	125	28	—	19.05	—	3
NEW	GYSL1915K00-F17					L	★	19.05	15.875	125	28	—	19.05	—	3
NEW	GYSR2012JX00-F17					R	★	20	12	120	28	—	20	—	3
NEW	GYSL2012JX00-F17					L	★	20	12	120	28	—	20	—	3

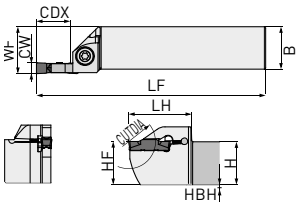
*1 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.
*2 The maximum groove depth is limited by the workpiece diameter.
1. Cutting mode will be shown on page 22.

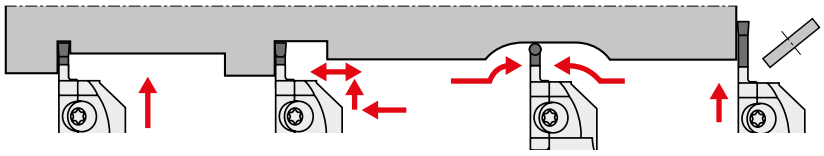
68 Vc

● : Inventory maintained. ★ : Inventory maintained in Japan.

MONOBLOCK

EXTERNAL GROOVING





Right hand tool holder shown.

Order number	Seat size	CW	CDX	CUTDIA	Hand	Stock	H	B	LF	LH	HF	WF	HBH
GYQR2020K00-D06	D	2.00 2.24	6	12	R	●	20	20	125	36	20	20.15	—
GYQL2020K00-D06					L	●	20	20	125	36	20	20.15	—
GYQR2525M00-D06					R	●	25	25	150	36	25	25.15	—
GYQL2525M00-D06					L	●	25	25	150	36	25	25.15	—
GYQR2020K00-D18			18	36	R	●	20	20	125	39	20	20.10	—
GYQL2020K00-D18					L	●	20	20	125	39	20	20.10	—
GYQR2525M00-D20			20	40	R	●	25	25	150	41	25	25.15	—
GYQL2525M00-D20					L	●	25	25	150	41	25	25.15	—
GYQR2020K00-F06	F	3.00 3.18 3.24	6	12	R	●	20	20	125	36	20	20.30	—
GYQL2020K00-F06					L	●	20	20	125	36	20	20.30	—
GYQR2525M00-F06					R	●	25	25	150	36	25	25.30	—
GYQL2525M00-F06					L	●	25	25	150	36	25	25.30	—
GYQR2020K00-F18			18	36	R	●	20	20	125	39	20	20.25	—
GYQL2020K00-F18					L	●	20	20	125	39	20	20.25	—
GYQR2525M00-F20			20	40	R	●	25	25	150	41	25	25.25	—
GYQL2525M00-F20					L	●	25	25	150	41	25	25.25	—
GYQR2020K00-G08	G	4.00 4.24	8	16	R	●	20	20	125	41	20	20.35	—
GYQL2020K00-G08					L	●	20	20	125	41	20	20.35	—
GYQR2525M00-G08					R	●	25	25	150	41	25	25.35	—
GYQL2525M00-G08					L	●	25	25	150	41	25	25.35	—
GYQR2020K00-G25			25	50	R	●	20	20	125	46	20	20.35	4
GYQL2020K00-G25					L	●	20	20	125	46	20	20.35	4
GYQR2525M00-G25					R	●	25	25	150	46	25	25.35	—
GYQL2525M00-G25					L	●	25	25	150	46	25	25.35	—
GYQR2020K00-H08	H	4.75 5.00 5.24	8	6	R	●	20	20	125	41	20	20.35	—
GYQL2020K00-H08					L	●	20	20	125	41	20	20.35	—
GYQR2525M00-H08					R	●	25	25	150	41	25	25.35	—
GYQL2525M00-H08					L	●	25	25	150	41	25	25.35	—
GYQR2020K00-H25			25	50	R	●	20	20	125	46	20	20.35	4
GYQL2020K00-H25					L	●	20	20	125	46	20	20.35	4
GYQR2525M00-H25					R	●	25	25	150	46	25	25.35	—
GYQL2525M00-H25					L	●	25	25	150	46	25	25.35	—
GYQR2020K00-J08	J	6.00 6.31 6.35	8	16	R	●	20	20	125	41	20	20.35	—
GYQL2020K00-J08					L	●	20	20	125	41	20	20.35	—
GYQR2525M00-J08					R	●	25	25	150	41	25	25.35	—
GYQL2525M00-J08					L	●	25	25	150	41	25	25.35	—
GYQR2020K00-J25			25	50	R	●	20	20	125	46	20	20.35	4
GYQL2020K00-J25					L	●	20	20	125	46	20	20.35	4
GYQR2525M00-J25					R	●	25	25	150	46	25	25.35	—
GYQL2525M00-J25					L	●	25	25	150	46	25	25.35	—

*1 The maximum groove depth varies according to the insert used.
Please refer to the maximum groove depth (CDX) of inserts on pages 27 – 30.
*2 The maximum cut off diameter CUTDIA varies according to the insert used.
The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.

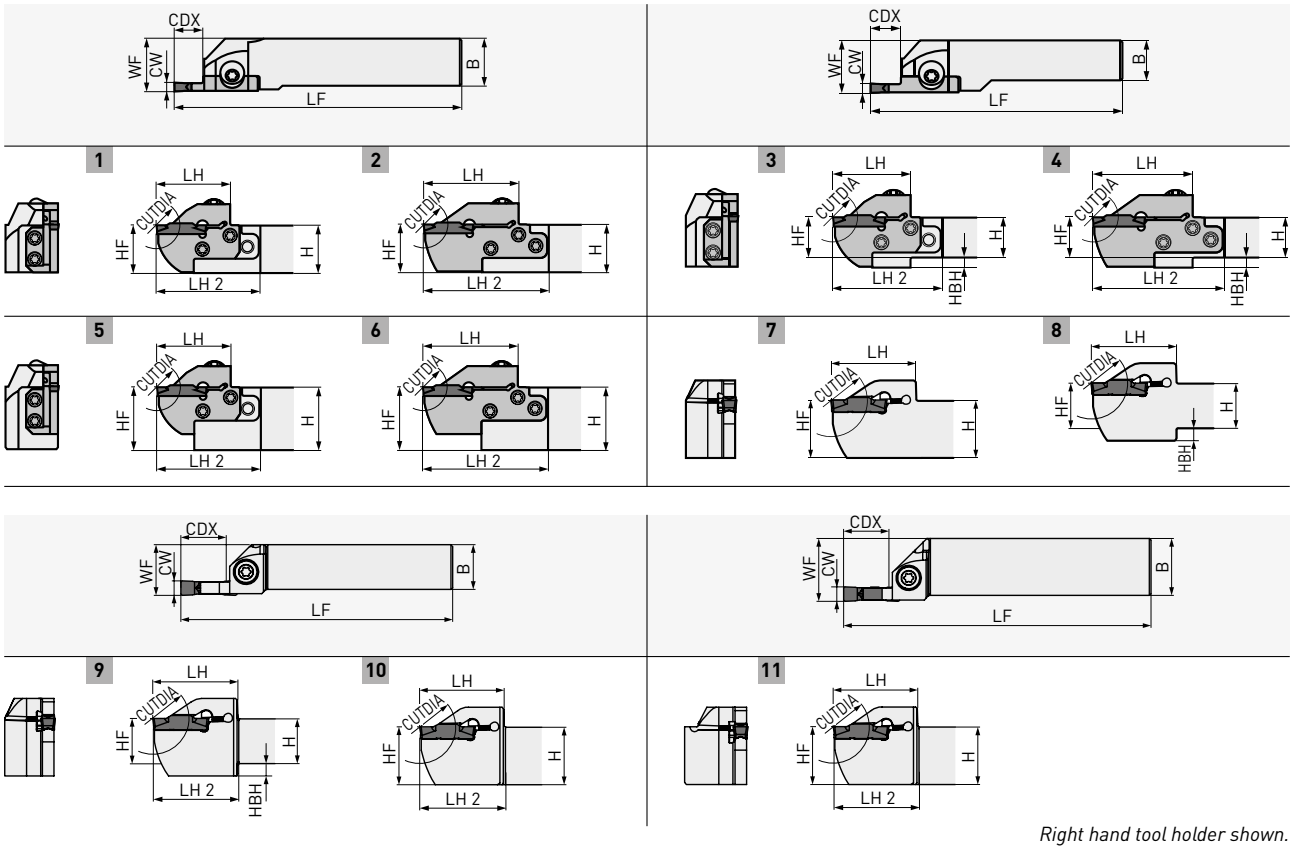
1. Identification: page 18
2. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

GY GROOVING SERIES

EXTERNAL GROOVING

00° TYPE HOLDER



Right hand tool holder shown.

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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
GYHR1616J00-M20R	●	GYM20RA-D06	●	D	2.00 2.24	6	12	R	16	16	104	28	44	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-D06	●					L	16	16	104	28	44	16	20	4	3
GYQR2020K00-D06	●	–						R	20	20	125	36	–	20	20.15	–	7
GYQL2020K00-D06	●	–						L	20	20	125	36	–	20	20.15	–	7
GYHR2020K00-M20R	●	GYM20RA-D06	●					R	20	20	119	28	43	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-D06	●					L	20	20	119	28	43	20	23	–	1
GYHR2020K00-M25R	●	GYM25RA-D06	●					R	20	20	117	31	52	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-D06	●					L	20	20	117	31	52	20	26	5	3
GYQR2525M00-D06	●	–						R	25	25	150	36	–	25	25.15	–	7
GYQL2525M00-D06	●	–						L	25	25	150	36	–	25	25.15	–	7
GYHR2525M00-M25R	●	GYM25RA-D06	●					R	25	25	142	31	49	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-D06	●					L	25	25	142	31	49	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-D06	●					R	32	25	162	31	49	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-D06	●					L	32	25	162	31	49	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-D06	●					R	32	32	162	31	49	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-D06	●					L	32	32	162	31	49	32	35	–	5

● : Inventory maintained. ★ : Inventory maintained in Japan.

EXTERNAL GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
GYHR1616J00-M20R	●	GYM20RA-D10	●	D	2.00 2.24	10	20	R	16	16	110	34	50	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-D10	●					L	16	16	110	34	50	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-D10	●					R	20	20	125	34	49	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-D10	●					L	20	20	125	34	49	20	23	–	1
GYHR2020K00-M25R	●	GYM25RA-D12	●	D	2.00 2.24	12	24	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-D12	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-D12	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-D12	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-D12	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-D12	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-D12	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-D12	●					L	32	32	170	39	57	32	35	–	5
GYHR1616J00-M20R	●	GYM20RB-D18	●	D	2.00 2.24	18*4	36	R	16	16	116	40	56	16	20	4	4
GYHL1616J00-M20L	●	GYM20LB-D18	●					L	16	16	116	40	56	16	20	4	4
GYQR2020K00-D18	●	–						R	20	20	125	39	–	20	20.10	–	7
GYQL2020K00-D18	●	–						L	20	20	125	39	–	20	20.10	–	7
GYHR2020K00-M20R	●	GYM20RB-D18	●					R	20	20	131	40	55	20	23	–	2
GYHL2020K00-M20L	●	GYM20LB-D18	●					L	20	20	131	40	55	20	23	–	2
GYHR2020K00-M25R	●	GYM25RA-D20	●	D	2.00 2.24	20*1	40*2	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-D20	●					L	20	20	131	45	66	20	26	5	4
GYQR2525M00-D20	●	–						R	25	25	150	41	–	25	25.15	–	7
GYQL2525M00-D20	●	–						L	25	25	150	41	–	25	25.15	–	7
GYHR2525M00-M25R	●	GYM25RA-D20	●					R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-D20	●					L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-D20	●					R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-D20	●					L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-D20	●					R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-D20	●					L	32	32	176	45	63	32	35	–	6
GYHR1616J00-M20R	●	GYM20RA-E06	●	E	2.39 2.50 2.74	6	12	R	16	16	104	28	44	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-E06	●					L	16	16	104	28	44	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-E06	●					R	20	20	119	28	43	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-E06	●					L	20	20	119	28	43	20	23	–	1
GYHR2020K00-M25R	●	GYM25RA-E06	●					R	20	20	117	31	52	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-E06	●					L	20	20	117	31	52	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-E06	●					R	25	25	142	31	49	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-E06	●					L	25	25	142	31	49	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-E06	●					R	32	25	162	31	49	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-E06	●					L	32	25	162	31	49	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-E06	●					R	32	32	162	31	49	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-E06	●					L	32	32	162	31	49	32	35	–	5
GYHR1616J00-M20R	●	GYM20RA-E10	●	E	2.39 2.50 2.74	10	20	R	16	16	110	34	50	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-E10	●					L	16	16	110	34	50	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-E10	●					R	20	20	125	34	49	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-E10	●					L	20	20	125	34	49	20	23	–	1

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 72 – 76.
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.
*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 74.

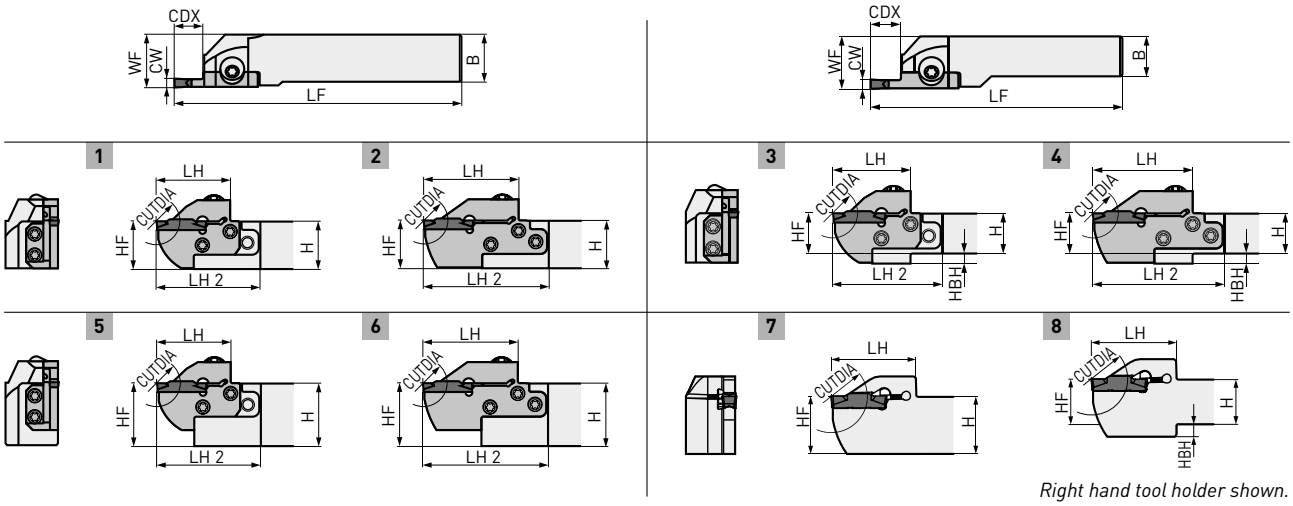
1. Identification: page 18
2. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

GY GROOVING SERIES

EXTERNAL GROOVING

00° TYPE HOLDER



Right hand tool holder shown.

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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RA-E12	●	E	2.39 2.50 2.74	12	24	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-E12	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-E12	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-E12	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-E12	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-E12	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-E12	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-E12	●					L	32	32	170	39	57	32	35	–	5
GYHR1616J00-M20R	●	GYM20RB-E18	●	E	2.39 2.50 2.74	18*4	36	R	16	16	116	40	56	16	20	4	4
GYHL1616J00-M20L	●	GYM20LB-E18	●					L	16	16	116	40	56	16	20	4	4
GYHR2020K00-M20R	●	GYM20RB-E18	●					R	20	20	131	40	55	20	23	–	2
GYHL2020K00-M20L	●	GYM20LB-E18	●					L	20	20	131	40	55	20	23	–	2
GYHR2020K00-M25R	●	GYM25RA-E20	●	E	2.39 2.50 2.74	20*1	40*2	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-E20	●					L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RA-E20	●					R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-E20	●					L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-E20	●					R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-E20	●					L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-E20	●					R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-E20	●					L	32	32	176	45	63	32	35	–	6
GYHR1616J00-M20R	●	GYM20RA-F06	●	F	3.00 3.18 3.24	6	12	R	16	16	104	28	44	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-F06	●					L	16	16	104	28	44	16	20	4	3
GYQR2020K00-F06	●	–						R	20	20	125	36	–	20	20.30	–	7
GYQL2020K00-F06	●	–						L	20	20	125	36	–	20	20.30	–	7
GYHR2020K00-M20R	●	GYM20RA-F06	●					R	20	20	119	28	43	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-F06	●					L	20	20	119	28	43	20	23	–	1
GYHR2020K00-M25R	●	GYM25RA-F06	●					R	20	20	117	31	52	20	26	5	3

● : Inventory maintained. ★ : Inventory maintained in Japan.

EXTERNAL GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
GYHL2020K00-M25L	●	GYM25LA-F06	●	F	3.00 3.18 3.24	6	12	L	20	20	117	31	52	20	26	5	3
GYQR2525M00-F06	●	–						R	25	25	150	36	–	25	25.30	–	7
GYQL2525M00-F06	●	–						L	25	25	150	36	–	25	25.30	–	7
GYHR2525M00-M25R	●	GYM25RA-F06	●					R	25	25	142	31	49	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-F06	●					L	25	25	142	31	49	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-F06	●					R	32	25	162	31	49	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-F06	●					L	32	25	162	31	49	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-F06	●					R	32	32	162	31	49	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-F06	●					L	32	32	162	31	49	32	35	–	5
GYHR1616J00-M20R	●	GYM20RA-F10	●	F	3.00 3.18 3.24	10	20	R	16	16	110	34	50	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-F10	●					L	16	16	110	34	50	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-F10	●					R	20	20	125	34	49	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-F10	●					L	20	20	125	34	49	20	23	–	1
GYHR2020K00-M25R	●	GYM25RA-F12	●	F	3.00 3.18 3.24	12	24	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-F12	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-F12	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-F12	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-F12	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-F12	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-F12	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-F12	●					L	32	32	170	39	57	32	35	–	5
GYHR1616J00-M20R	●	GYM20RB-F18	●	F	3.00 3.18 3.24	18*4	36	R	16	16	116	40	56	16	20	4	4
GYHL1616J00-M20L	●	GYM20LB-F18	●					L	16	16	116	40	56	16	20	4	4
GYQR2020K00-F18	●	–						R	20	20	125	39	–	20	20.25	–	7
GYQL2020K00-F18	●	–						L	20	20	125	39	–	20	20.25	–	7
GYHR2020K00-M20R	●	GYM20RB-F18	●					R	20	20	131	40	55	20	23	–	2
GYHL2020K00-M20L	●	GYM20LB-F18	●					L	20	20	131	40	55	20	23	–	2
GYHR2020K00-M25R	●	GYM25RA-F20	●	F	3.00 3.18 3.24	20*1	40*2	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-F20	●					L	20	20	131	45	66	20	26	5	4
GYQR2525M00-F20	●	–						R	25	25	150	41	–	25	25.25	–	7
GYQL2525M00-F20	●	–						L	25	25	150	41	–	25	25.25	–	7
GYHR2525M00-M25R	●	GYM25RA-F20	●					R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-F20	●					L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-F20	●					R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-F20	●					L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-F20	●					R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-F20	●					L	32	32	176	45	63	32	35	–	6
GYQR2020K00-G08	●	–		G	4.00 4.24	8	16	R	20	20	125	41	–	20	20.35	–	7
GYQL2020K00-G08	●	–						L	20	20	125	41	–	20	20.35	–	7
GYHR2020K00-M25R	●	GYM25RA-G08	●					R	20	20	119	33	54	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-G08	●					L	20	20	119	33	54	20	26	5	3
GYQR2525M00-G08	●	–						R	25	25	150	41	–	25	25.35	–	7
GYQL2525M00-G08	●	–						L	25	25	150	41	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-G08	●					R	25	25	144	33	51	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-G08	●					L	25	25	144	33	51	25	28	–	1

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.
*2 The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.
*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 74.

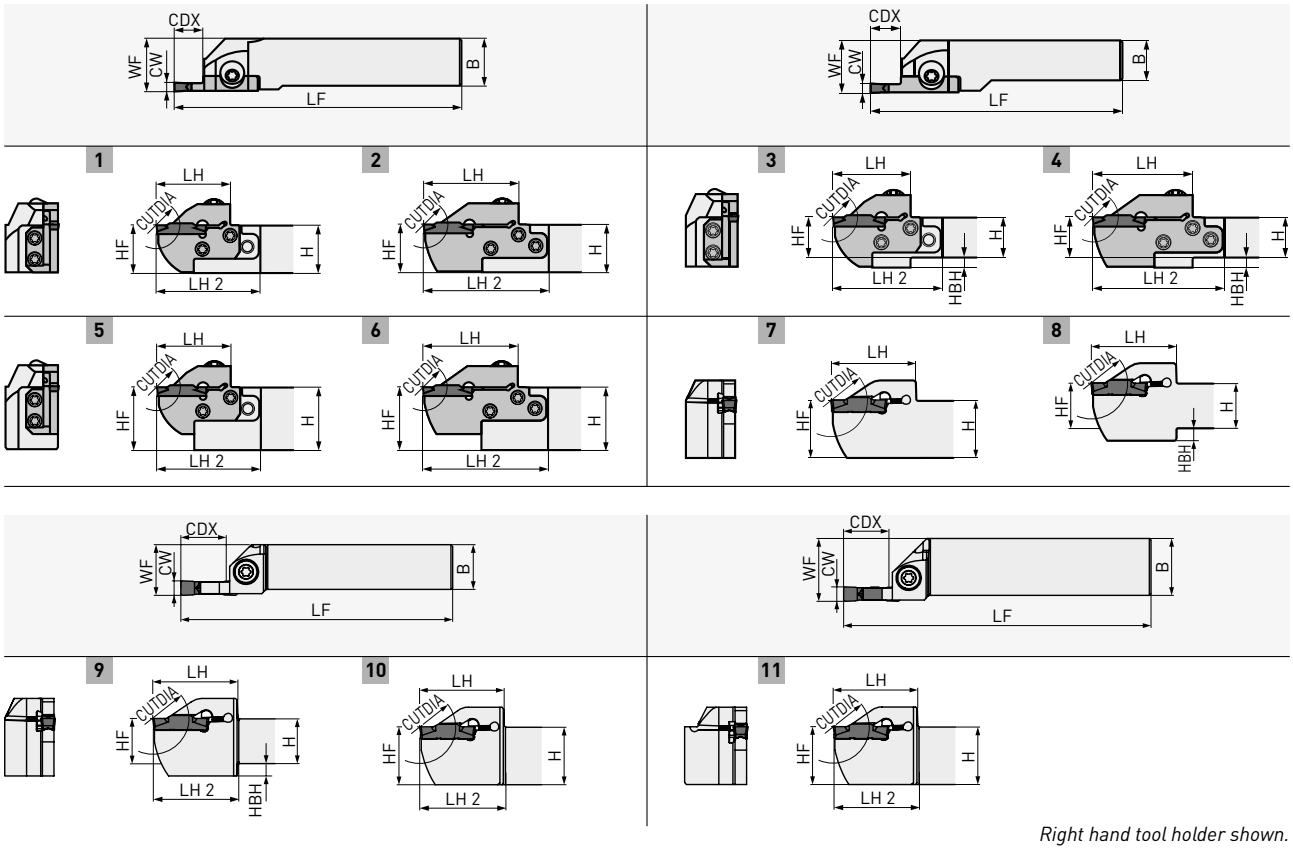
1. Identification: page 18
2. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

GY GROOVING SERIES

EXTERNAL GROOVING

00° TYPE HOLDER



Right hand tool holder shown.

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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
GYHR3225P00-M25R	●	GYM25RA-G08	●	G	4.00 4.24	8	16	R	32	25	164	33	51	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-G08	●					L	32	25	164	33	51	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-G08	●					R	32	32	164	33	51	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-G08	●					L	32	32	164	33	51	32	35	–	5
GYHR1616J00-M20R	●	GYM20RA-G12	●	G	4.00 4.24	12	24	R	16	16	110	34	50	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-G12	●					L	16	16	110	34	50	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-G12	●					R	20	20	125	34	49	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-G12	●					L	20	20	125	34	49	20	23	–	1
GYHR2020K00-M25R	●	GYM25RA-G14	●	G	4.00 4.24	14	28	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-G14	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-G14	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-G14	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-G14	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-G14	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-G14	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-G14	●					L	32	32	170	39	57	32	35	–	5

● : Inventory maintained. ★ : Inventory maintained in Japan.

EXTERNAL GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
GYQR2020K00-G25	●	–		G	4.00 4.24	25*1	50*2	R	20	20	125	46	–	20	20.35	4	8
GYQL2020K00-G25	●	–						L	20	20	125	46	–	20	20.35	4	8
GYHR2020K00-M25R	●	GYM25RA-G25	●					R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-G25	●					L	20	20	136	50	71	20	26	5	4
GYQR2525M00-G25	●	–						R	25	25	150	46	–	25	25.35	–	7
GYQL2525M00-G25	●	–						L	25	25	150	46	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-G25	●					R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-G25	●					L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-G25	●					R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-G25	●					L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-G25	●					R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-G25	●					L	32	32	181	50	68	32	35	–	6
GYQR2020K00-H08	●	–		H	4.75 5.00 5.24	8	16	R	20	20	125	41	–	20	20.35	–	7
GYQL2020K00-H08	●	–						L	20	20	125	41	–	20	20.35	–	7
GYHR2020K00-M25R	●	GYM25RA-H08	●					R	20	20	119	33	54	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-H08	●					L	20	20	119	33	54	20	26	5	3
GYQR2525M00-H08	●	–						R	25	25	150	41	–	25	25.35	–	7
GYQL2525M00-H08	●	–						L	25	25	150	41	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-H08	●					R	25	25	144	33	51	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-H08	●					L	25	25	144	33	51	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-H08	●					R	32	25	164	33	51	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-H08	●					L	32	25	164	33	51	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-H08	●					R	32	32	164	33	51	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-H08	●					L	32	32	164	33	51	32	35	–	5
GYHR1616J00-M20R	●	GYM20RA-H12	●	H	4.75 5.00 5.24	12	24	R	16	16	110	34	50	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-H12	●					L	16	16	110	34	50	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-H12	●					R	20	20	125	34	49	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-H12	●					L	20	20	125	34	49	20	23	–	1
GYHR2020K00-M25R	●	GYM25RA-H14	●	H	4.75 5.00 5.24	14	28	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-H14	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-H14	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-H14	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-H14	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-H14	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-H14	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-H14	●					L	32	32	170	39	57	32	35	–	5
GYQR2020K00-H25	●	–		H	4.75 5.00 5.24	25*1	50*2	R	20	20	125	46	–	20	20.35	4	8
GYQL2020K00-H25	●	–						L	20	20	125	46	–	20	20.35	4	8
GYHR2020K00-M25R	●	GYM25RA-H25	●					R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-H25	●					L	20	20	136	50	71	20	26	5	4
GYQR2525M00-H25	●	–						R	25	25	150	46	–	25	25.35	–	7
GYQL2525M00-H25	●	–						L	25	25	150	46	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-H25	●					R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-H25	●					L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-H25	●					R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-H25	●					L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-H25	●					R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-H25	●					L	32	32	181	50	68	32	35	–	6

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.

*2 The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.

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

1. Identification: page 18
2. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

EXTERNAL GROOVING – 00° TYPE HOLDER

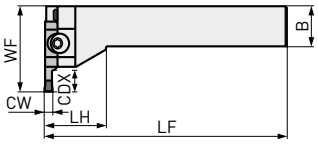
Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
GYQR2020K00-J08	●	–		J	6.00 6.31 6.35	8	16	R	20	20	125	41	–	20	20.35	–	7
GYQL2020K00-J08	●	–						L	20	20	125	41	–	20	20.35	–	7
GYHR2020K00-M25R	●	GYM25RA-J08	●					R	20	20	119	33	54	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-J08	●					L	20	20	119	33	54	20	26	5	3
GYQR2525M00-J08	●	–						R	25	25	150	41	–	25	25.35	–	7
GYQL2525M00-J08	●	–						L	25	25	150	41	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-J08	●					R	25	25	144	33	51	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-J08	●					L	25	25	144	33	51	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-J08	●					R	32	25	164	33	51	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-J08	●					L	32	25	164	33	51	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-J08	●					R	32	32	164	33	51	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-J08	●					L	32	32	164	33	51	32	35	–	5
GYHR2020K00-M25R	●	GYM25RA-J14	●	J	6.00 6.31 6.35	14	28	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-J14	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-J14	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-J14	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-J14	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-J14	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-J14	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-J14	●					L	32	32	170	39	57	32	35	–	5
GYQR2020K00-J25	●	–		J	6.00 6.31 6.35	25*1	50*2	R	20	20	125	46	–	20	20.35	4	8
GYQL2020K00-J25	●	–						L	20	20	125	46	–	20	20.35	4	8
GYHR2020K00-M25R	●	GYM25RA-J25	●					R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-J25	●					L	20	20	136	50	71	20	26	5	4
GYQR2525M00-J25	●	–						R	25	25	150	46	–	25	25.35	–	7
GYQL2525M00-J25	●	–						L	25	25	150	46	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-J25	●					R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-J25	●					L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-J25	●					R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-J25	●					L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-J25	●					R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-J25	●					L	32	32	181	50	68	32	35	–	6
GYPR2525M00-K25	●	–		K	8.00	25*1	50*2	R	25	25	150	47	48	25	28	7	9
GYPL2525M00-K25	●	–						L	25	25	150	47	48	25	28	7	9
GYPR3225P00-K25	●	–						R	32	25	170	47	48	32	28	–	10
GYPL3225P00-K25	●	–						L	32	25	170	47	48	32	28	–	10
GYPR3232P00-K25	●	–						R	32	32	170	47	48	32	35	–	11
GYPL3232P00-K25	●	–						L	32	32	170	47	48	32	35	–	11

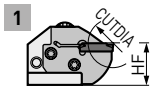
● : Inventory maintained. ★ : Inventory maintained in Japan.

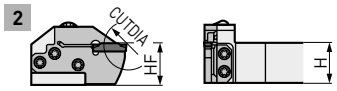
GY GROOVING SERIES

EXTERNAL GROOVING

90° TYPE HOLDER







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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	HF	WF*3	Fig.
GYHR2020K90-M20L	●	GYM20LA-D06	●	D	2.00 2.24	6	12	R	20	20	125	35	20	39	1
GYHL2020K90-M20R	●	GYM20RA-D06	●					L	20	20	125	35	20	39	1
GYHR2525M90-M25L	●	GYM25LA-D06	●					R	25	25	150	38	25	45	1
GYHL2525M90-M25R	●	GYM25RA-D06	●					L	25	25	150	38	25	45	1
GYHR2020K90-M20L	●	GYM20LA-D10	●			10	20	R	20	20	125	35	20	45	1
GYHL2020K90-M20R	●	GYM20RA-D10	●					L	20	20	125	35	20	45	1
GYHR2525M90-M25L	●	GYM25LA-D12	●			12	24	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-D12	●					L	25	25	150	38	25	53	1
GYHR2020K90-M20L	●	GYM20LB-D18	●			18*4	36	R	20	20	125	35	20	51	2
GYHL2020K90-M20R	●	GYM20RB-D18	●					L	20	20	125	35	20	51	2
GYHR2525M90-M25L	●	GYM25LA-D20	●			20*1	40*2	R	25	25	150	38	25	59	2
GYHL2525M90-M25R	●	GYM25RA-D20	●					L	25	25	150	38	25	59	2
GYHR2020K90-M20L	●	GYM20LA-E06	●	E	2.39 2.50 2.74	6	12	R	20	20	125	35	20	39	1
GYHL2020K90-M20R	●	GYM20RA-E06	●					L	20	20	125	35	20	39	1
GYHR2525M90-M25L	●	GYM25LA-E06	●					R	25	25	150	38	25	45	1
GYHL2525M90-M25R	●	GYM25RA-E06	●					L	25	25	150	38	25	45	1
GYHR2020K90-M20L	●	GYM20LA-E10	●			10	20	R	20	20	125	35	20	45	1
GYHL2020K90-M20R	●	GYM20RA-E10	●					L	20	20	125	35	20	45	1
GYHR2525M90-M25L	●	GYM25LA-E12	●			12	24	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-E12	●					L	25	25	150	38	25	53	1
GYHR2020K90-M20L	●	GYM20LB-E18	●			18*4	36	R	20	20	125	35	20	51	2
GYHL2020K90-M20R	●	GYM20RB-E18	●					L	20	20	125	35	20	51	2
GYHR2525M90-M25L	●	GYM25LA-E20	●			20*1	40*2	R	25	25	150	38	25	59	2
GYHL2525M90-M25R	●	GYM25RA-E20	●					L	25	25	150	38	25	59	2
GYHR2020K90-M20L	●	GYM20LA-F06	●	F	3.00 3.18 3.24	6	12	R	20	20	125	35	20	39	1
GYHL2020K90-M20R	●	GYM20RA-F06	●					L	20	20	125	35	20	39	1
GYHR2525M90-M25L	●	GYM25LA-F06	●					R	25	25	150	38	25	45	1
GYHL2525M90-M25R	●	GYM25RA-F06	●					L	25	25	150	38	25	45	1

● : Inventory maintained. ★ : Inventory maintained in Japan.

EXTERNAL GROOVING – 90° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	HF	WF*3	Fig.
GYHR2020K90-M20L	●	GYM20LA-F10	●	F	3.00 3.18 3.24	10	20	R	20	20	125	35	20	45	1
GYHL2020K90-M20R	●	GYM20RA-F10	●					L	20	20	125	35	20	45	1
GYHR2525M90-M25L	●	GYM25LA-F12	●			12	24	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-F12	●					L	25	25	150	38	25	53	1
GYHR2020K90-M20L	●	GYM20LB-F18	●	F	3.00 3.18 3.24	18*4	36	R	20	20	125	35	20	51	2
GYHL2020K90-M20R	●	GYM20RB-F18	●					L	20	20	125	35	20	51	2
GYHR2525M90-M25L	●	GYM25LA-F20	●			20*1	40*2	R	25	25	150	38	25	59	2
GYHL2525M90-M25R	●	GYM25RA-F20	●					L	25	25	150	38	25	59	2
GYHR2525M90-M25L	●	GYM25LA-G08	●	G	4.00 4.24	8	16	R	25	25	150	38	25	47	1
GYHL2525M90-M25R	●	GYM25RA-G08	●					L	25	25	150	38	25	47	1
GYHR2020K90-M20L	●	GYM20LA-G12	●			12	24	R	20	20	125	35	20	45	1
GYHL2020K90-M20R	●	GYM20RA-G12	●					L	20	20	125	35	20	45	1
GYHR2525M90-M25L	●	GYM25LA-G14	●			14	28	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-G14	●					L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LA-G25	●			25*1	50*2	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RA-G25	●					L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LA-H08	●	H	4.75 5.00 5.24	8	16	R	25	25	150	38	25	47	1
GYHL2525M90-M25R	●	GYM25RA-H08	●					L	25	25	150	38	25	47	1
GYHR2020K90-M20L	●	GYM20LA-H12	●			12	24	R	20	20	125	35	20	45	1
GYHL2020K90-M20R	●	GYM20RA-H12	●					L	20	20	125	35	20	45	1
GYHR2525M90-M25L	●	GYM25LA-H14	●			14	28	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-H14	●					L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LA-H25	●			25*1	25*2	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RA-H25	●					L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LA-J08	●	J	6.00 6.31 6.35	8	16	R	25	25	150	38	25	47	1
GYHL2525M90-M25R	●	GYM25RA-J08	●					L	25	25	150	38	25	47	1
GYHR2525M90-M25L	●	GYM25LA-J14	●			14	28	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-J14	●					L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LA-J25	●			25*1	25*2	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RA-J25	●					L	25	25	150	38	25	64	2

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.
*2 The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.
*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 74.

67 Vc

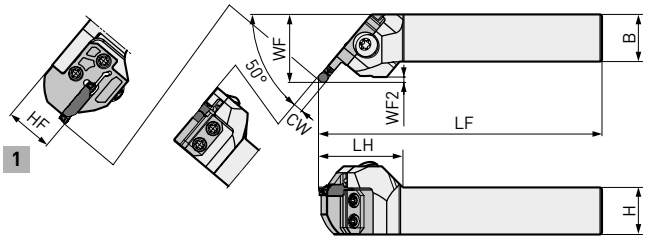
1. Identification: page 18
2. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

GY GROOVING SERIES

EXTERNAL RECESSING

50° TYPE HOLDER



1

Right hand tool holder shown.

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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DMIN	APMX	APMX 2	Hand	H	B	LF*2	LH*2	HF	WF*2	WF2*2	Fig.
GYHR2020K50-M20L	●	GYM20LC-D005	●	D	2.00	0.5	30	1.5	0.646	R	20	20	125	40	20	32	1.6	1
GYHL2020K50-M20R	●	GYM20RC-D005	●							L	20	20	125	40	20	32	1.6	1
GYHR2525M50-M25L	●	GYM25LC-D005	●							R	25	25	150	45	25	35	1.6	1
GYHL2525M50-M25R	●	GYM25RC-D005	●							L	25	25	150	45	25	35	1.6	1
GYHR2020K50-M20L	●	GYM20LC-E005	●	E	2.50			1.75	0.72	R	20	20	125	40	20	32	1.8	1
GYHL2020K50-M20R	●	GYM20RC-E005	●							L	20	20	125	40	20	32	1.8	1
GYHR2525M50-M25L	●	GYM25LC-E005	●							R	25	25	150	45	25	35	1.8	1
GYHL2525M50-M25R	●	GYM25RC-E005	●							L	25	25	150	45	25	35	1.8	1
GYHR2020K50-M20L	●	GYM20LC-F005	●	F	3.00 3.18			2	0.793	R	20	20	125	40	20	32	2.0	1
GYHL2020K50-M20R	●	GYM20RC-F005	●							L	20	20	125	40	20	32	2.0	1
GYHR2525M50-M25L	●	GYM25LC-F005	●							R	25	25	150	45	25	35	2.0	1
GYHL2525M50-M25R	●	GYM25RC-F005	●							L	25	25	150	45	25	35	2.0	1
GYHR2020K50-M20L	●	GYM20LC-G005	●	G	4.00		20	2.5	0.939	R	20	20	125	40	20	32	2.4	1
GYHL2020K50-M20R	●	GYM20RC-G005	●							L	20	20	125	40	20	32	2.4	1
GYHR2525M50-M25L	●	GYM25LC-G005	●							R	25	25	150	45	25	35	2.4	1
GYHL2525M50-M25R	●	GYM25RC-G005	●							L	25	25	150	45	25	35	2.4	1
GYHR2020K50-M20L	●	GYM20LC-H005	●	H	4.75 5.00			2.88	1.049	R	20	20	125	40	20	33	2.8	1
GYHL2020K50-M20R	●	GYM20RC-H005	●							L	20	20	125	40	20	33	2.8	1
GYHR2525M50-M25L	●	GYM25LC-H005	●							R	25	25	150	45	25	36	2.8	1
GYHL2525M50-M25R	●	GYM25RC-H005	●							L	25	25	150	45	25	36	2.8	1
GYHR2525M50-M25L	●	GYM25LC-J005	●	J	6.00 6.35			3.5	1.232	R	25	25	150	44	25	36	3.4	1
GYHL2525M50-M25R	●	GYM25RC-J005	●							L	25	25	150	44	25	36	3.4	1

1. The blade for external grooving and face grooving cannot be used due to interference with the workpiece.

72 Vc

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.
*2 The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.
*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 74.

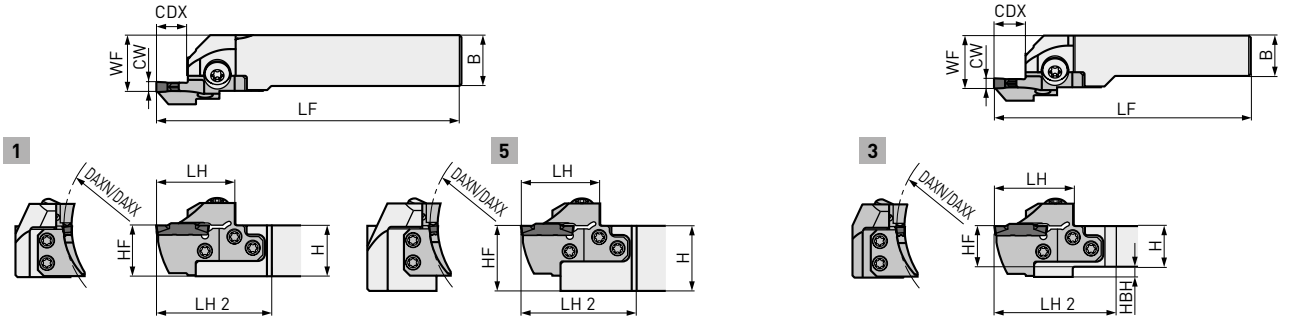
1. Identification: page 18
2. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

GY GROOVING SERIES

FACE GROOVING

00° TYPE HOLDER



Right hand tool holder shown.

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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-D12-040	●	D	2.00 2.24	12	40	50	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-040	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-040	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-D12-040	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-D12-040	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-D12-040	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-D12-040	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-D12-040	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-D12-050	●	D	2.00 2.24	12	50	60	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-050	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-050	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-D12-050	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-D12-050	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-D12-050	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-D12-050	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-D12-050	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-D12-060	●	D	2.00 2.24	12	60	75	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-060	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-060	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-D12-060	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-D12-060	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-D12-060	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-D12-060	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-D12-060	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-D12-075	●	D	2.00 2.24	12	75	100	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-075	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-075	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-D12-075	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-D12-075	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-D12-075	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-D12-075	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-D12-075	●						L	32	32	170	39	57	32	35	–	5

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-D12-100	●	D	2.00 2.24	12	100	150	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-100	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-100	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-D12-100	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-D12-100	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-D12-100	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-D12-100	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-D12-100	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-D12-135	●	D	2.00 2.24	12	135	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-135	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-135	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-D12-135	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-D12-135	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-D12-135	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-D12-135	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-D12-135	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-D12-180	●	D	2.00 2.24	12	180	250	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-180	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-D12-180	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-D12-180	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-D12-180	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-D12-180	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-D12-180	●						L	32	32	170	39	57	32	35	–	5

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

80 Vc

1. Identification: page 18
2. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-E12-040	●	E	2.39 2.50 2.74	12	40	50	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-040	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-040	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-E12-040	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-E12-040	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-E12-040	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-E12-040	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-E12-040	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-E12-050	●	E	2.39 2.50 2.74	12	50	60	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-050	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-050	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-E12-050	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-E12-050	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-E12-050	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-E12-050	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-E12-050	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-E12-060	●	E	2.39 2.50 2.74	12	60	75	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-060	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-060	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-E12-060	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-E12-060	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-E12-060	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-E12-060	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-E12-060	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-E12-075	●	E	2.39 2.50 2.74	12	75	100	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-075	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-075	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-E12-075	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-E12-075	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-E12-075	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-E12-075	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-E12-075	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-E12-100	●	E	2.39 2.50 2.74	12	100	150	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-100	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-100	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-E12-100	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-E12-100	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-E12-100	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-E12-100	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-E12-100	●						L	32	32	170	39	57	32	35	–	5

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-E12-135	●	E	2.39 2.50 2.74	12	135	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-135	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-135	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-E12-135	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-E12-135	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-E12-135	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-E12-135	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-E12-135	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-E12-180	●	E	2.39 2.50 2.74	12	180	250	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-180	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-E12-180	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-E12-180	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-E12-180	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-E12-180	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-E12-180	●						L	32	32	170	39	57	32	35	–	5

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.

80 Vc

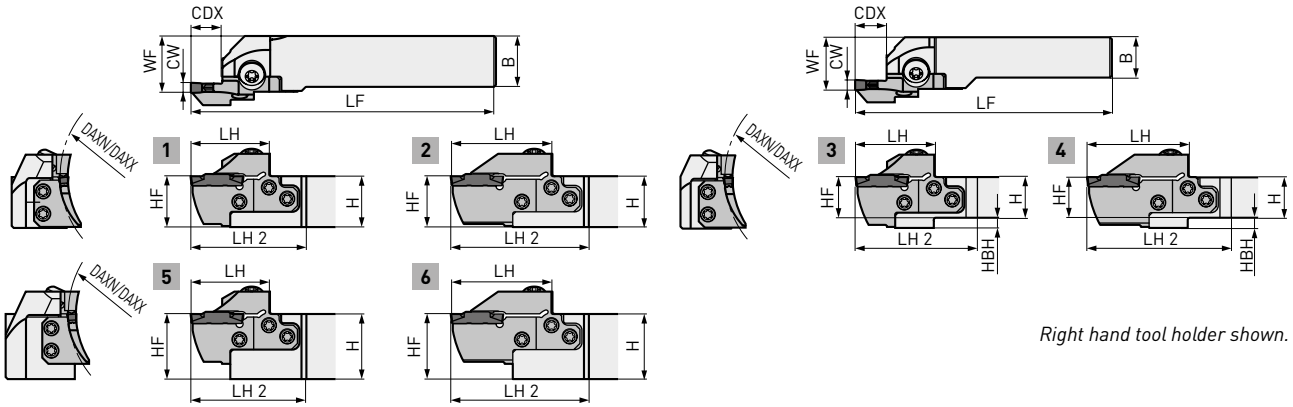
1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
2. Identification: page 18
3. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

GY GROOVING SERIES

FACE GROOVING

00° TYPE HOLDER



Right hand tool holder shown.

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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-F12-035	●	F	3.00 3.18 3.24	12	35	40	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-035	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-035	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-035	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-035	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-035	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-035	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-035	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-F12-040	●	F	3.00 3.18 3.24	12	40	50	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-040	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-040	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-040	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-040	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-040	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-040	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-040	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-F12-050	●	F	3.00 3.18 3.24	12	50	60	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-050	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-050	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-050	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-050	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-050	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-050	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-050	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-F12-060	●	F	3.00 3.18 3.24	12	60	75	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-060	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-060	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-060	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-060	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-060	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-060	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-060	●						L	32	32	170	39	57	32	35	–	5

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-F20-060	●	F	3.00 3.18 3.24	20*2	60	75	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-060	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-060	●						R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-F20-060	●						L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-F20-060	●						R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-F20-060	●						L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-F20-060	●						R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-F20-060	●						L	32	32	176	45	63	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-F12-075	●	F	3.00 3.18 3.24	12	75	100	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-075	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-075	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-075	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-075	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-075	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-075	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-075	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-F20-075	●	F	3.00 3.18 3.24	20*2	75	100	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-075	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-075	●						R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-F20-075	●						L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-F20-075	●						R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-F20-075	●						L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-F20-075	●						R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-F20-075	●						L	32	32	176	45	63	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-F12-100	●	F	3.00 3.18 3.24	12	100	150	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-100	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-100	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-100	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-100	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-100	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-100	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-100	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-F20-100	●	F	3.00 3.18 3.24	20*2	100	150	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-100	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-100	●						R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-F20-100	●						L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-F20-100	●						R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-F20-100	●						L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-F20-100	●						R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-F20-100	●						L	32	32	176	45	63	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-F12-135	●	F	3.00 3.18 3.24	12	135	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-135	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-135	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-135	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-135	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-135	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-135	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-135	●						L	32	32	170	39	57	32	35	–	5

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.

80 Vc

1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
2. Identification: page 18
3. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-F20-135	●	F	3.00 3.18 3.24	20*2	135	200	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-135	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-135	●						R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-F20-135	●						L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-F20-135	●	F	3.00 3.18 3.24	20*2	135	200	R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-F20-135	●						L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-F20-135	●						R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-F20-135	●						L	32	32	176	45	63	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-F12-180	●	F	3.00 3.18 3.24	12	180	250	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-180	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-180	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-180	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-180	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-180	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-180	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-F20-180	●	F	3.00 3.18 3.24	20*2	180	250	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-180	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-180	●						R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-F20-180	●						L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-F20-180	●						R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-F20-180	●						L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-F20-180	●						R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-F20-180	●						L	32	32	176	45	63	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-F12-225	●	F	3.00 3.18 3.24	12	225	999	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-225	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-225	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-225	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-225	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-225	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-225	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-225	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-F20-225	●	F	3.00 3.18 3.24	20*2	225	999	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-225	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-225	●						R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-F20-225	●						L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-F20-225	●						R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-F20-225	●						L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-F20-225	●						R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-F20-225	●						L	32	32	176	45	63	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-G14-040	●	G	4.00 4.24	14	40	50	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-040	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-040	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-G14-040	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-G14-040	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-G14-040	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-G14-040	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-G14-040	●						L	32	32	170	39	57	32	35	–	5

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-G14-050	●	G	4.00 4.24	14	50	60	R	20	20	125	39	60	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G14-050	●						L	20	20	125	39	60	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G14-050	●						R	25	25	150	39	57	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-G14-050	●						L	25	25	150	39	57	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-G14-050	●						R	32	25	170	39	57	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-G14-050	●						L	32	25	170	39	57	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-G14-050	●						R	32	32	170	39	57	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-G14-050	●						L	32	32	170	39	57	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-G14-060	●	G	4.00 4.24	14	60	85	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-060	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-060	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-G14-060	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-G14-060	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-G14-060	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-G14-060	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-G14-060	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-G25-060	●	G	4.00 4.24	25*2	60	85	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-060	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-060	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-G25-060	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-G25-060	●	G	4.00 4.24	25*2	60	85	R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-G25-060	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-G25-060	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-G25-060	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-G14-085	●	G	4.00 4.24	14	85	125	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-085	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-085	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-G14-085	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-G14-085	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-G14-085	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-G14-085	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-G14-085	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-G25-085	●	G	4.00 4.24	25*2	85	125	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-085	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-085	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-G25-085	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-G25-085	●						R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-G25-085	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-G25-085	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-G25-085	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-G14-125	●	G	4.00 4.24	14	125	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-125	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-125	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-G14-125	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-G14-125	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-G14-125	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-G14-125	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-G14-125	●						L	32	32	170	39	57	32	35	–	5

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.

1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
2. Identification: page 18
3. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-G25-125	●	G	4.00 4.24	25*2	125	200	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-125	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-125	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-G25-125	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-G25-125	●						R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-G25-125	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-G25-125	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-G25-125	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-G14-180	●	G	4.00 4.24	14	180	280	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-180	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-G14-180	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-G14-180	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-G14-180	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-G14-180	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-G14-180	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-G25-180	●	G	4.00 4.24	25*2	180	280	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-180	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-180	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-G25-180	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-G25-180	●						R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-G25-180	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-G25-180	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-G25-180	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-G14-250	●	G	4.00 4.24	14	250	999	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-250	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-250	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-G14-250	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-G14-250	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-G14-250	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-G14-250	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-G14-250	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-G25-250	●	G	4.00 4.24	25*2	250	999	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-250	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-250	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-G25-250	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-G25-250	●	G	4.00 4.24	25*2	250	999	R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-G25-250	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-G25-250	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-G25-250	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-G14-180	●	H	4.75 5.00 5.24	14	50	60	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-180	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-G14-180	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-G14-180	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-G14-180	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-G14-180	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-G14-180	●						L	32	32	170	39	57	32	35	–	5

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-G25-180	●	H	4.75 5.00 5.24	14	60	85	R	20	20	125	39	60	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-180	●						L	20	20	125	39	60	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-180	●						R	25	25	150	39	57	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-G25-180	●						L	25	25	150	39	57	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-G25-180	●						R	32	25	170	39	57	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-G25-180	●						L	32	25	170	39	57	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-G25-180	●						R	32	32	170	39	57	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-G25-180	●						L	32	32	170	39	57	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-G14-250	●	H	4.75 5.00 5.24	25*2	60	85	R	20	20	136	50	71	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-250	●						L	20	20	136	50	71	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-250	●						R	25	25	161	50	68	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-G14-250	●						L	25	25	161	50	68	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-G14-250	●						R	32	25	181	50	68	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-G14-250	●						L	32	25	181	50	68	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-G14-250	●						R	32	32	181	50	68	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-G14-250	●						L	32	32	181	50	68	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-H14-085	●	H	4.75 5.00 5.24	14	85	125	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-H14-085	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-H14-085	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-H14-085	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-H14-085	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-H14-085	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-H14-085	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-H14-085	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-H25-085	●	H	4.75 5.00 5.24	25*2	85	125	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-H25-085	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-H25-085	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-H25-085	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-H25-085	●						R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-H25-085	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-H25-085	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-H25-085	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-H14-125	●	H	4.75 5.00 5.24	14	125	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-H14-125	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-H14-125	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-H14-125	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-H14-125	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-H14-125	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-H14-125	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-H14-125	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-H25-125	●	H	4.75 5.00 5.24	25*2	125	200	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-H25-125	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-H25-125	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-H25-125	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-H25-125	●						R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-H25-125	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-H25-125	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-H25-125	●						L	32	32	181	50	68	32	35	–	6

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.

1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
2. Identification: page 18
3. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-H14-180	●	H	4.75 5.00 5.24	14	180	280	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-H14-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-H14-180	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-H14-180	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-H14-180	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-H14-180	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-H14-180	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-H14-180	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-H25-180	●	H	4.75 5.00 5.24	25*2	180	280	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-H25-180	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-H25-180	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-H25-180	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-H25-180	●	H	4.75 5.00 5.24	25*2	180	280	R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-H25-180	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-H25-180	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-H25-180	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-H14-250	●	H	4.75 5.00 5.24	14	250	999	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-H14-250	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-H14-250	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-H14-250	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-H14-250	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-H14-250	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-H14-250	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-H14-250	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-H25-250	●	H	4.75 5.00 5.24	25*2	250	999	R	20	20	136	50	71	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-H25-250	●						L	20	20	136	50	71	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-H25-250	●						R	25	25	161	50	68	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-H25-250	●						L	25	25	161	50	68	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-H25-250	●						R	32	25	181	50	68	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-H25-250	●						L	32	25	181	50	68	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-H25-250	●						R	32	32	181	50	68	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-H25-250	●						L	32	32	181	50	68	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-J14-050	●	J	6.00 6.31 6.35	14	50	70	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-J14-050	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-J14-050	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-J14-050	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-J14-050	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-J14-050	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-J14-050	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-J14-050	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-J14-070	●	J	6.00 6.31 6.35	14	70	110	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-J14-070	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-J14-070	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-J14-070	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-J14-070	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-J14-070	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-J14-070	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-J14-070	●						L	32	32	170	39	57	32	35	–	5

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-J25-070	●	J	6.00 6.31 6.35	25*2	70	110	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-J25-070	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-J25-070	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-J25-070	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-J25-070	●						R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-J25-070	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-J25-070	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-J25-070	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-J14-110	●	J	6.00 6.31 6.35	14	110	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-J14-110	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-J14-110	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-J14-110	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-J14-110	●	J	6.00 6.31 6.35	14	110	200	R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-J14-110	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-J14-110	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-J14-110	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-J25-110	●	J	6.00 6.31 6.35	25*2	110	200	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-J25-110	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-J25-110	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-J25-110	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-J25-110	●						R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-J25-110	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-J25-110	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-J25-110	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-J14-170	●	J	6.00 6.31 6.35	14	170	280	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-J14-170	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-J14-170	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-J14-170	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-J14-170	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-J14-170	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-J14-170	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-J14-170	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-J25-170	●	J	6.00 6.31 6.35	25*2	170	280	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-J25-170	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-J25-170	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-J25-170	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-J25-170	●						R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-J25-170	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-J25-170	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-J25-170	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-J14-250	●	J	6.00 6.31 6.35	14	250	999	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-J14-250	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-J14-250	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-J14-250	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-J14-250	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-J14-250	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-J14-250	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-J14-250	●						L	32	32	170	39	57	32	35	–	5

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.

1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
2. Identification: page 18
3. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-J25-250	●	J	6.00 6.31 6.35	25*2	250	999	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-J25-250	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-J25-250	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-J25-250	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-J25-250	●						R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-J25-250	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-J25-250	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-J25-250	●						L	32	32	181	50	68	32	35	–	6

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.

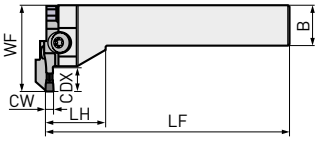
80 Vc

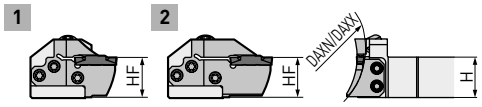
1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
2. Identification: page 18
3. Spare parts: page 25

GY GROOVING SERIES

FACE GROOVING

90° TYPE HOLDER





Right hand tool holder shown.

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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	HF	WF*1	Fig.
GYHR2525M90-M25L	●	GYM25LD-D12-040	●	D	2.00 2.24	12	40	50	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-040	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-050	●			12	50	60	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-050	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-060	●			12	60	75	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-060	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-075	●			12	75	100	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-075	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-100	●			12	100	150	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-100	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-135	●			12	135	200	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-135	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-180	●			12	180	250	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-180	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-040	●	E	2.39 2.50 2.74	12	40	50	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-040	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-050	●			12	50	60	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-050	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-060	●			12	60	75	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-060	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-075	●			12	75	100	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-075	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-100	●			12	100	150	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-100	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-135	●			12	135	200	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-135	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-180	●			12	180	250	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-180	●						L	25	25	150	38	25	53	1

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 90° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	HF	WF*1	Fig.
GYHR2525M90-M25L	●	GYM25LD-F12-035	●	F	3.00 3.18 3.24	12	35	40	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-035	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F12-040	●			12	40	50	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-040	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F12-050	●			12	50	60	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-050	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F12-060	●			12	60	75	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-060	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-060	●			20*2	60	75	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-060	●						L	25	25	150	38	38	59	2
GYHR2525M90-M25L	●	GYM25LD-F12-075	●			12	75	100	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-075	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-075	●			20*2	75	100	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-075	●						L	25	25	150	38	38	59	2
GYHR2525M90-M25L	●	GYM25LD-F12-100	●			12	100	150	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-100	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-100	●			20*2	100	150	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-100	●						L	25	25	150	38	38	59	2
GYHR2525M90-M25L	●	GYM25LD-F12-135	●			12	135	200	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-135	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-135	●			20*2	135	200	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-135	●						L	25	25	150	38	38	59	2
GYHR2525M90-M25L	●	GYM25LD-F12-180	●			12	180	250	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-180	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-180	●			20*2	180	250	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-180	●						L	25	25	150	38	38	59	2
GYHR2525M90-M25L	●	GYM25LD-F12-225	●			12	225	999	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-225	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-225	●			20*2	225	999	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-225	●						L	25	25	150	38	38	59	2

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.

80 Vc

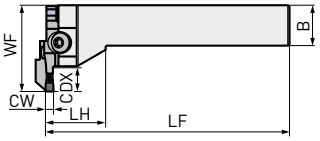
1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
2. Identification: page 18
3. Spare parts: page 25

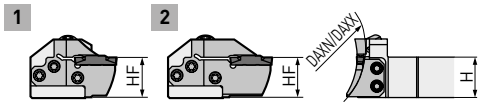
● : Inventory maintained. ★ : Inventory maintained in Japan.

GY GROOVING SERIES

FACE GROOVING

90° TYPE HOLDER





Right hand tool holder shown.

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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	HF	WF*1	Fig.
GYHR2525M90-M25L	●	GYM25LD-G14-040	●	G	4.00 4.24	14	40	50	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-040	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G14-050	●			14	50	60	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-050	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G14-060	●			14	60	85	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-060	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G25-060	●			25*2	60	85	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-G25-060	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-G14-085	●			14	85	125	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-085	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G25-085	●			25*2	85	125	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-G25-085	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-G14-125	●			14	125	200	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-125	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G25-125	●			25*2	125	200	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-G25-125	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-G14-180	●			14	180	280	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-180	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G25-180	●			25*2	180	280	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-G25-180	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-G14-250	●			14	250	999	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-250	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G25-250	●			25*2	250	999	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-G25-250	●						L	25	25	150	38	25	64	2

● : Inventory maintained. ★ : Inventory maintained in Japan.

FACE GROOVING – 90° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	HF	WF*1	Fig.
GYHR2525M90-M25L	●	GYM25LD-H14-050	●	H	4.75 5.00 5.24	14	50	60	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-050	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H14-060	●			14	60	85	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-060	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H25-060	●			25*2	60	85	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-H25-060	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-H14-085	●			14	85	125	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-085	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H25-085	●			25*2	85	125	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-H25-085	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-H14-125	●			14	125	200	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-125	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H25-125	●			25*2	125	200	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-H25-125	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-H14-180	●			14	180	280	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-180	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H25-180	●			25*2	180	280	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-H25-180	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-H14-250	●			14	250	999	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-250	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H25-250	●			25*2	250	999	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-H25-250	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-J14-050	●	J	6.00 6.31 6.35	14	50	70	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-J14-050	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-J14-070	●			14	70	110	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-J14-070	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-J25-070	●			25*2	70	110	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-J25-070	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-J14-110	●			14	110	200	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-J14-110	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-J25-110	●			25*2	110	200	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-J25-110	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-J14-170	●			14	170	280	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-J14-170	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-J25-170	●			25*2	170	280	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-J25-170	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-J14-250	●			14	250	999	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-J14-250	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-J25-250	●			25*2	250	999	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-J25-250	●						L	25	25	150	38	25	64	2

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.

80 Vc

1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
2. Identification: page 18
3. Spare parts: page 25

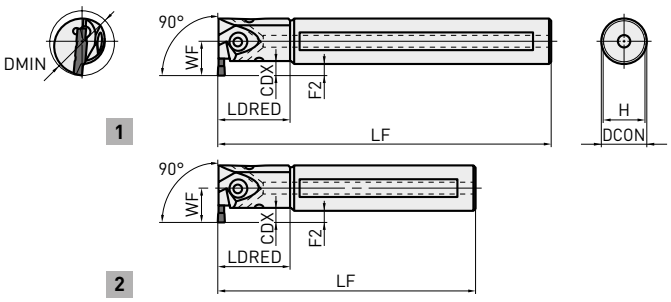
● : Inventory maintained. ★ : Inventory maintained in Japan.

GY GROOVING SERIES

INTERNAL GROOVING

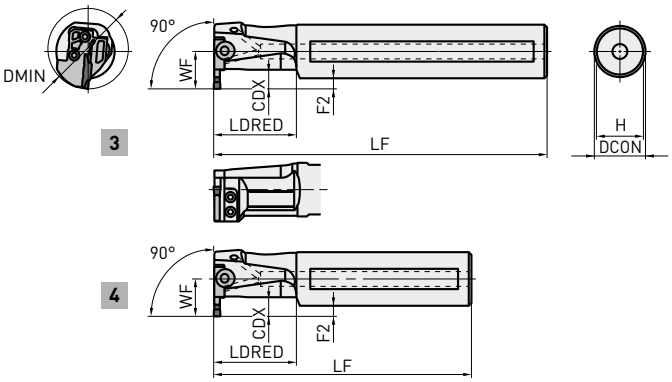
90° TYPE HOLDER

- Monoblock type (Air / coolant through)



Right hand tool holder shown.

- Modular blade type (Air / coolant through)



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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX*3	DMIN	Hand	DCON	LF*2	LDRED*2	WF*2	F2*2	H	Fig.
GYAR20K90A-D06	●	–	–	D	2.00 2.24	6	25	R	20	125	30	14.5	4.5	18	2
GYAL20K90A-D06	●	–	–					L	20	125	30	14.5	4.5	18	2
GYAR20Q90A-D06	●	–	–			6	25	R	20	180	30	14.5	4.5	18	1
GYAL20Q90A-D06	●	–	–					L	20	180	30	14.5	4.5	18	1
GYAR25K90B-D06	●	–	–			6	32	R	25	125	40	19	6.5	23	2
GYAL25K90B-D06	●	–	–					L	25	125	40	19	6.5	23	2
GYAR25R90B-D06	●	–	–			6	32	R	25	200	40	19	6.5	23	1
GYAL25R90B-D06	●	–	–					L	25	200	40	19	6.5	23	1
GYDR32L90C-M20L	●	GYM20LA-D10	●			4–9.5*1	40	R	32	140	50	22	6	30	4
GYDL32L90C-M20R	●	GYM20RA-D10	●					L	32	140	50	22	6	30	4
GYDR32S90C-M20L	●	GYM20LA-D10	●			4–9.5*1	40	R	32	250	50	22	6	30	3
GYDL32S90C-M20R	●	GYM20RA-D10	●					L	32	250	50	22	6	30	3
GYDR40M90D-M20L	●	GYM20LA-D10	●			5.5–9.5*1	50	R	40	150	60	28	8	37	4
GYDL40M90D-M20R	●	GYM20RA-D10	●					L	40	150	60	28	8	37	4
GYDR40T90D-M20L	●	GYM20LA-D10	●			5.5–9.5*1	50	R	40	300	60	28	8	37	3
GYDL40T90D-M20R	●	GYM20RA-D10	●					L	40	300	60	28	8	37	3
GYDR40M90D-M25L	●	GYM25LA-D12	●			7–11.5*1	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-D12	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-D12	●			7–11.5*1	60	R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-D12	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-D12	●			7–11.5*1	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-D12	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-D12	●			7–11.5*1	70	R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-D12	●					L	50	300	80	34	9	47	3

● : Inventory maintained. ★ : Inventory maintained in Japan.

INTERNAL GROOVING – 90° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX*3	DMIN	Hand	DCON	LF*2	LDRED*2	WF*2	F2*2	H	Fig.
GYAR20K90A-E06	●	–	–	E	2.39 2.50 2.74	6	25	R	20	125	30	14.5	4.5	18	2
GYAL20K90A-E06	●	–	–					L	20	125	30	14.5	4.5	18	2
GYAR20Q90A-E06	●	–	–			6	25	R	20	180	30	14.5	4.5	18	1
GYAL20Q90A-E06	●	–	–					L	20	180	30	14.5	4.5	18	1
GYAR25K90B-E06	●	–	–			6	32	R	25	125	40	19	6.5	23	2
GYAL25K90B-E06	●	–	–					L	25	125	40	19	6.5	23	2
GYAR25R90B-E06	●	–	–			6	32	R	25	200	40	19	6.5	23	1
GYAL25R90B-E06	●	–	–					L	25	200	40	19	6.5	23	1
GYDR32L90C-M20L	●	GYM20LA-E10	●			4–9.5*1	40	R	32	140	50	22	6	30	4
GYDL32L90C-M20R	●	GYM20RA-E10	●					L	32	140	50	22	6	30	4
GYDR32S90C-M20L	●	GYM20LA-E10	●			4–9.5*1	40	R	32	250	50	22	6	30	3
GYDL32S90C-M20R	●	GYM20RA-E10	●					L	32	250	50	22	6	30	3
GYDR40M90D-M20L	●	GYM20LA-E10	●			5.5–9.5*1	50	R	40	150	60	28	8	37	4
GYDL40M90D-M20R	●	GYM20RA-E10	●					L	40	150	60	28	8	37	4
GYDR40T90D-M20L	●	GYM20LA-E10	●			5.5–9.5*1	50	R	40	300	60	28	8	37	3
GYDL40T90D-M20R	●	GYM20RA-E10	●					L	40	300	60	28	8	37	3
GYDR40M90D-M25L	●	GYM25LA-E12	●			7–11.5*1	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-E12	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-E12	●			7–11.5*1	60	R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-E12	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-E12	●			7–11.5*1	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-E12	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-E12	●			7–11.5*1	70	R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-E12	●					L	50	300	80	34	9	47	3
GYAR20K90A-F06	●	–	–	F	3.00 3.18 3.24	6	25	R	20	125	30	14.5	4.5	18	2
GYAL20K90A-F06	●	–	–					L	20	125	30	14.5	4.5	18	2
GYAR20Q90A-F06	●	–	–			6	25	R	20	180	30	14.5	4.5	18	1
GYAL20Q90A-F06	●	–	–					L	20	180	30	14.5	4.5	18	1
GYAR25K90B-F06	●	–	–			6	32	R	25	125	40	19	6.5	23	2
GYAL25K90B-F06	●	–	–					L	25	125	40	19	6.5	23	2
GYAR25R90B-F06	●	–	–			6	32	R	25	200	40	19	6.5	23	1
GYAL25R90B-F06	●	–	–					L	25	200	40	19	6.5	23	1
GYDR32L90C-M20L	●	GYM20LA-F10	●			4–9.5*1	40	R	32	140	50	22	6	30	4
GYDL32L90C-M20R	●	GYM20RA-F10	●					L	32	140	50	22	6	30	4
GYDR32S90C-M20L	●	GYM20LA-F10	●			4–9.5*1	40	R	32	250	50	22	6	30	3
GYDL32S90C-M20R	●	GYM20RA-F10	●					L	32	250	50	22	6	30	3
GYDR40M90D-M20L	●	GYM20LA-F10	●			5.5–9.5*1	50	R	40	150	60	28	8	37	4
GYDL40M90D-M20R	●	GYM20RA-F10	●					L	40	150	60	28	8	37	4
GYDR40T90D-M20L	●	GYM20LA-F10	●			5.5–9.5*1	50	R	40	300	60	28	8	37	3
GYDL40T90D-M20R	●	GYM20RA-F10	●					L	40	300	60	28	8	37	3
GYDR40M90D-M25L	●	GYM25LA-F12	●			7–11.5*1	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-F12	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-F12	●			7–11.5*1	60	R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-F12	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-F12	●			7–11.5*1	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-F12	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-F12	●			7–11.5*1	70	R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-F12	●					L	50	300	80	34	9	47	3

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.
*2 The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.
1. Identification: page 18
2. Spare parts: page 25

● : Inventory maintained. ★ : Inventory maintained in Japan.

INTERNAL GROOVING – 90° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX*3	DMIN	Hand	DCON	LF*2	LDRED*2	WF*2	F2*2	H	Fig.
GYAR25K90B-G07	●	–	–	G	4.00 4.24	7	32	R	25	125	40	19	6.5	23	2
GYAL25K90B-G07	●	–	–					L	25	125	40	19	6.5	23	2
GYAR25R90B-G07	●	–	–			7	32	R	25	200	40	19	6.5	23	1
GYAL25R90B-G07	●	–	–					L	25	200	40	19	6.5	23	1
GYDR32L90C-M20L	●	GYM20LA-G12	●			4.5–11.5*1	40	R	32	140	50	22	6	30	4
GYDL32L90C-M20R	●	GYM20RA-G12	●					L	32	140	50	22	6	30	4
GYDR32S90C-M20L	●	GYM20LA-G12	●			4.5–11.5*1	40	R	32	250	50	22	6	30	3
GYDL32S90C-M20R	●	GYM20RA-G12	●					L	32	250	50	22	6	30	3
GYDR40M90D-M20L	●	GYM20LA-G12	●			6–11.5*1	50	R	40	150	60	28	8	37	4
GYDL40M90D-M20R	●	GYM20RA-G12	●					L	40	150	60	28	8	37	4
GYDR40T90D-M20L	●	GYM20LA-G12	●			6–11.5*1	50	R	40	300	60	28	8	37	3
GYDL40T90D-M20R	●	GYM20RA-G12	●					L	40	300	60	28	8	37	3
GYDR40M90D-M25L	●	GYM25LA-G14	●			7.5–13*1	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-G14	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-G14	●			7.5–13*1	60	R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-G14	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-G14	●			7.5–13*1	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-G14	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-G14	●			7.5–13*1	70	R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-G14	●					L	50	300	80	34	9	47	3
GYAR25K90B-H07	●	–	–	H	4.75 5.00 5.24	7	32	R	25	125	40	19	6.5	23	2
GYAL25K90B-H07	●	–	–					L	25	125	40	19	6.5	23	2
GYAR25R90B-H07	●	–	–					R	25	200	40	19	6.5	23	1
GYAL25R90B-H07	●	–	–					L	25	200	40	19	6.5	23	1
GYDR32L90C-M20L	●	GYM20LA-H12	●	H	4.75 5.00 5.24	4.5–11.5*1	40	R	32	140	50	22	6	30	4
GYDL32L90C-M20R	●	GYM20RA-H12	●					L	32	140	50	22	6	30	4
GYDR32S90C-M20L	●	GYM20LA-H12	●					R	32	250	50	22	6	30	3
GYDL32S90C-M20R	●	GYM20RA-H12	●					L	32	250	50	22	6	30	3
GYDR40M90D-M20L	●	GYM20LA-H12	●			6–11.5*1	50	R	40	150	60	28	8	37	4
GYDL40M90D-M20R	●	GYM20RA-H12	●					L	40	150	60	28	8	37	4
GYDR40T90D-M20L	●	GYM20LA-H12	●					R	40	300	60	28	8	37	3
GYDL40T90D-M20R	●	GYM20RA-H12	●					L	40	300	60	28	8	37	3
GYDR40M90D-M25L	●	GYM25LA-H14	●			7.5–13*1	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-H14	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-H14	●					R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-H14	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-H14	●			7.5–13*1	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-H14	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-H14	●					R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-H14	●					L	50	300	80	34	9	47	3
GYDR40M90D-M25L	●	GYM25LA-J14	●	J	6.00 6.31 6.35	7.5–13*1	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-J14	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-J14	●			7.5–13*1	60	R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-J14	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-J14	●			7.5–13*1	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-J14	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-J14	●			7.5–13*1	70	R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-J14	●					L	50	300	80	34	9	47	3

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 27 – 30.
*2 The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 27 – 30.
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.
1. Identification: page 18
2. Spare parts: page 25

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GY GROOVING SERIES

RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED (FOR EXTERNAL GROOVING)

	Material	Hardness	Grade	Vc
P	Mild steel	<160HB	VP20RT	155 (100–220)
			VP10RT	170 (110–230)
			NX2525	150 (90–210)
	Carbon steel Alloy steel	160–280HB	VP20RT	120 (80–180)
			VP10RT	140 (90–190)
			MY5015	180 (110–250)
			NX2525	120 (70–170)
		≥280HB	VP20RT	100 (60–140)
			VP10RT	110 (70–150)
			MY5015	150 (90–210)
			NX2525	95 (55–135)
M	Stainless steel	≤270HB	VP20RT	100 (60–140)
			VP10RT	110 (70–150)
K	Gray cast iron	Tensile strength ≤300MPa	VP20RT	120 (80–180)
			VP10RT	140 (90–190)
			MY5015	120 (140–300)
	Ductile cast iron	Tensile strength ≤800MPa	VP20RT	100 (60–140)
			VP10RT	110 (70–150)
			MY5015	150 (90–210)
N	Aluminium alloy (A6061, 7075)	Content Si<5 %	RT9010	275 (150–400)
	Aluminium alloy (AC4B)	Content 5 %≤Si≤10 %	RT9010	275 (150–400)
	Aluminium alloy (ADC12, A390)	Content Si>10 %	RT9010	110 (80–160)
S	Heat resistant alloy Titanium alloy	—	MP9015	70 (40–100)
			MP9025	60 (30– 90)
			VP20RT	45 (30– 60)
			VP10RT	55 (40– 70)
			RT9010	55 (40– 70)
H	Hardened steel	≥50HRC	BC8110	90 (60–120)

1. **VP20RT** is the first recommended grade for materials other than hardened steel.
2. For VP10RT, VP20RT, MP9015, MP9025 and MY5015, wet cutting is recommended.
3. GL Chipbreaker is not recommended for face grooving.

GY GROOVING SERIES FOR EXTERNAL SWISS TYPE LATHES

RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED (FOR EXTERNAL GROOVING AND CUTTING OFF)

	Material	Hardness	Grade	Vc
P	Mild steel	<160HB	VP20RT	155 (100–220)
			VP10RT	170 (110–230)
			NX2525	150 (90–210)
	Carbon steel Alloy steel	160–280HB	VP20RT	120 (80–180)
			VP10RT	140 (90–190)
			MY5015	180 (110–250)
			NX2525	120 (70–170)
		≥280HB	VP20RT	100 (60–140)
			VP10RT	110 (70–150)
			MY5015	150 (90–210)
			NX2525	95 (55–135)
M	Stainless steel	≤270HB	VP20RT	100 (60–140)
			VP10RT	110 (70–150)
K	Gray cast iron	Tensile strength ≤300MPa	VP20RT	120 (80–180)
			VP10RT	140 (90–190)
			MY5015	120 (140–300)
	Ductile cast iron	Tensile strength ≤800MPa	VP20RT	100 (60–140)
			VP10RT	110 (70–150)
			MY5015	150 (90–210)
N	Aluminium alloy (A6061, 7075)	Content Si<5 %	RT9010	250 (200–500)
	Aluminium alloy (AC4B)	Content 5 %≤Si≤10 %	RT9010	250 (200–500)
	Aluminium alloy (ADC12, A390)	Content Si>10 %	RT9010	150 (100–200)
S	Heat resistant alloy Titanium alloy	—	MP9015	70 (40–100)
			MP9025	60 (30– 90)
			VP20RT	45 (30– 60)
			VP10RT	55 (40– 70)
			RT9010	55 (40– 70)
H	Hardened steel	≥50HRC	BC8110	100 (80–120)

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

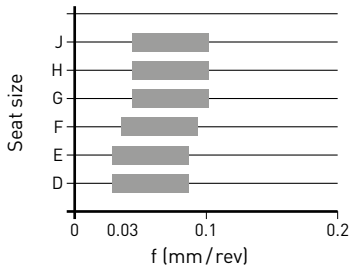
RECOMMENDED FEED RATE

RECOMMENDED CUTTING CONDITIONS (FOR EXTERNAL GROOVING)

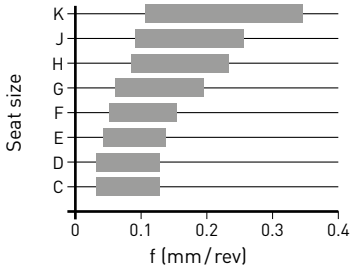
Below are the recommended cutting conditions when using the modular holder GYHR/L2525M00/90-M25R/L with the modular blade GYM25R/LA-○○○.

GROOVING, CUTTING OFF

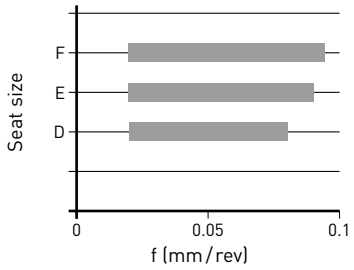
GU Breaker



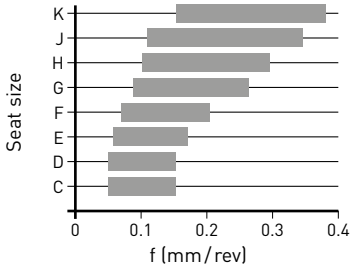
GS Breaker



GL Breaker

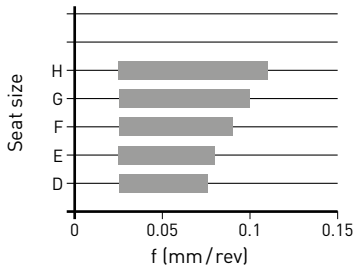


GM Breaker



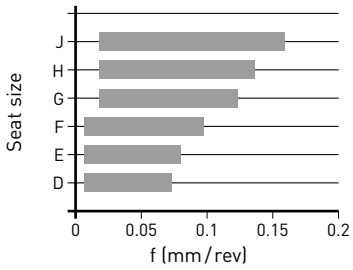
GROOVING

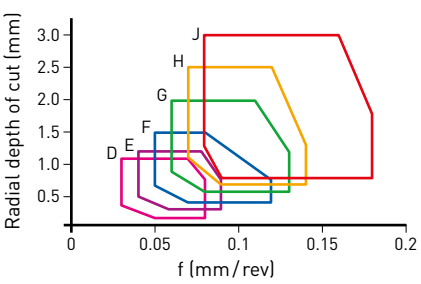
Flat top GFGS (PCBN)



RECOMMENDED FEED RATE AND DEPTH OF CUT

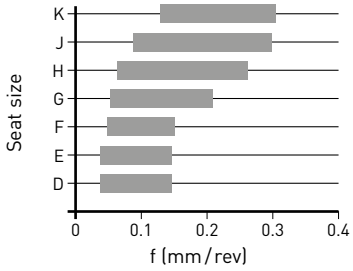
MF Breaker

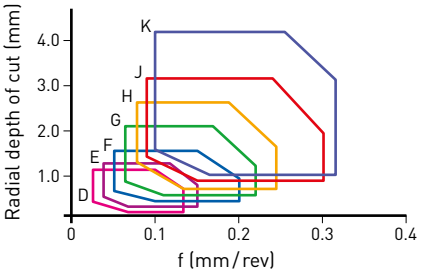




Seat size

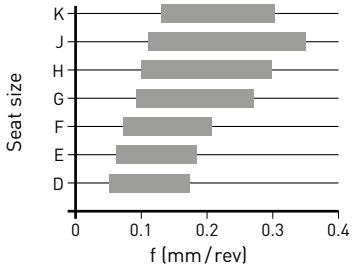
MS Breaker

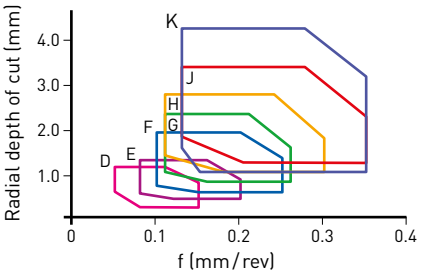




Seat size

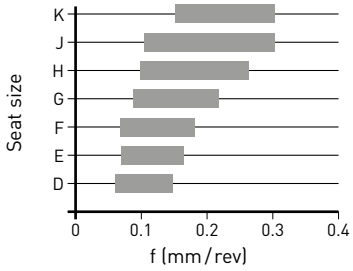
MM Breaker

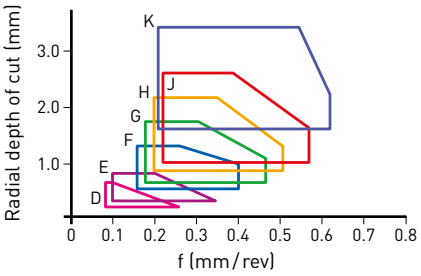




Seat size

BM Breaker





Seat size

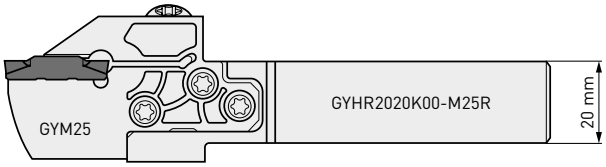
Seat size	C	D	E	F	G	H	J	K
Insert width (mm)	1.50	2.00	2.39	3.00	4.00	4.75	6.00	8.00
	–	2.24	2.50	3.18	4.24	5.00	6.31	–
	–	–	2.74	3.24	–	5.24	6.35	–

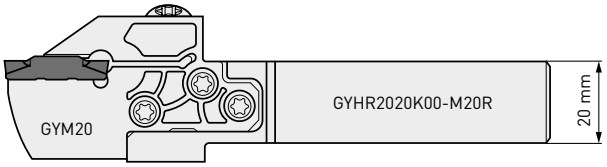
RECOMMENDED FEED RATE

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

DECREASE THE FEED RATE BY 20 %

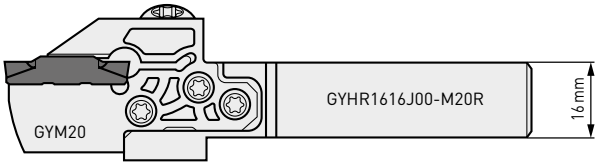
(20 mm x 20 mm Square holder)



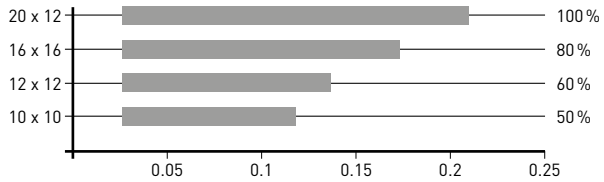


DECREASE THE FEED RATE BY 40 %

(16 mm x 16 mm Square holder)



IN THE CASE OF MONOBLOCK TYPE HOLDER FOR SWISS STYLE LATHES



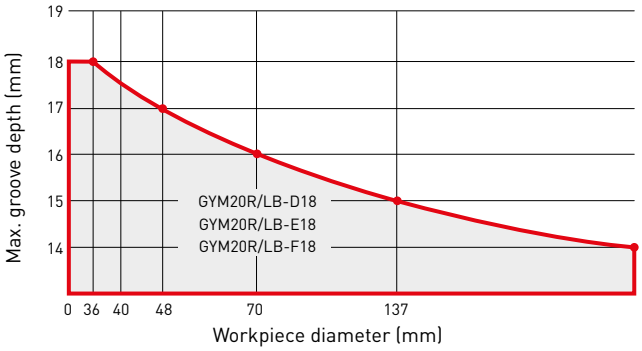
Recommended maximum feed

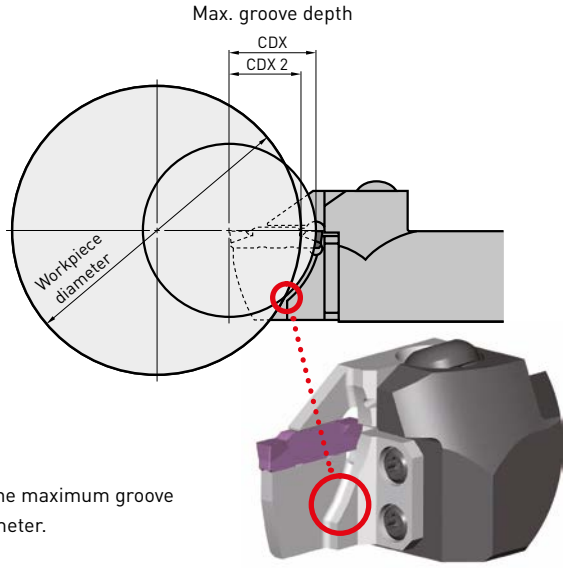
Please refer to the tables above on recommended cutting conditions for external grooving.
Apply the percentage ratio shown on each shank size with the values in the table.

RECOMMENDED DEPTH OF CUT

LIMITATION OF THE MAXIMUM GROOVE DEPTH (FOR EXTERNAL GROOVING)

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





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

RECOMMENDED CUTTING CONDITIONS

RECOMMENDED CUTTING SPEED (M/MIN) (FOR EXTERNAL RECESSING)

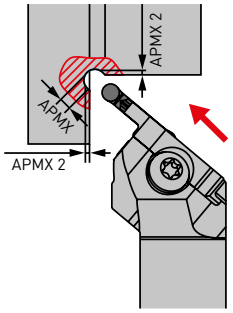
	Material	Hardness	Grade	Vc
P	Mild steel	<180HB	VP20RT	80–180
			VP10RT	90–190
	Carbon steel Alloy steel	180–280HB	VP20RT	60–140
			VP10RT	70–150
			MY5015	90–210
			NX2525	55–135
		280–350HB	VP20RT	50–110
			VP10RT	60–120
			MY5015	80–160
			NX2525	45–105
M	Stainless steel	≤350HB	VP20RT	50–110
			VP10RT	60–120
K	Gray cast iron	Tensile strength ≤350MPa	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	Titanium alloy Heat resistant alloy	—	MP9015	40–100
			MP9025	30– 90
			VP20RT	30– 60
			VP10RT	40– 70
			VP20RT	30– 60
			VP10RT	40– 70

1. VP20RT is the first recommended grade for materials other than hardened steel.
2. For VP10RT, VP20RT, MP9015, MP9025 and MY5015, wet cutting is recommended.

RECOMMENDED FEED RATE AND DEPTH OF CUT

DISTANCE FROM THE WORKPIECE TO THE RECESS DEPTH

Grooving width CW	Recessing depth APMX	Distance workpiece to the recess depth APMX 2
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

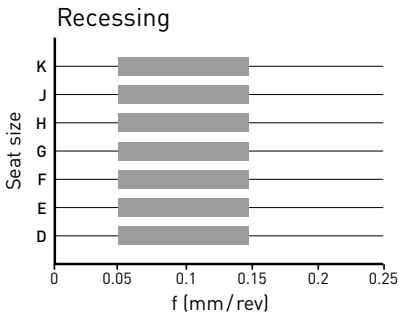


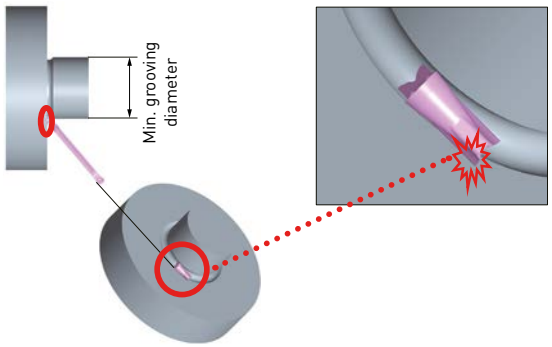
BM BREAKER

MINIMUM GROOVING DIAMETER

Ensure the tool is suitable for the diameter being machined. Refer to the Min. Grooving Diameter DMIN as shown in the table on page 46 to avoid a collision with the workpiece as shown below.

Recommended feed rate and depth of cut

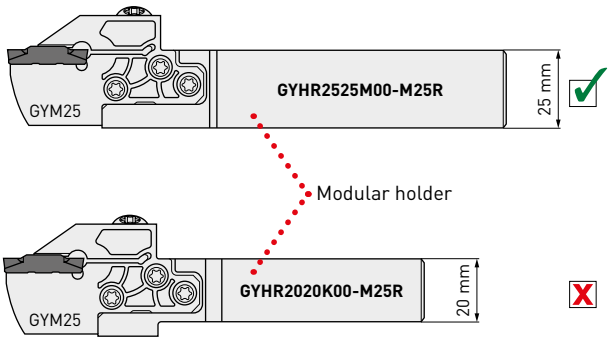




TOOL SELECTION

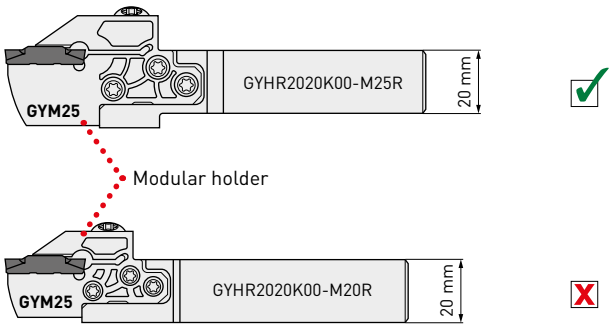
NOTES WHEN SELECTING THE TOOL BODY

MODULAR HOLDER



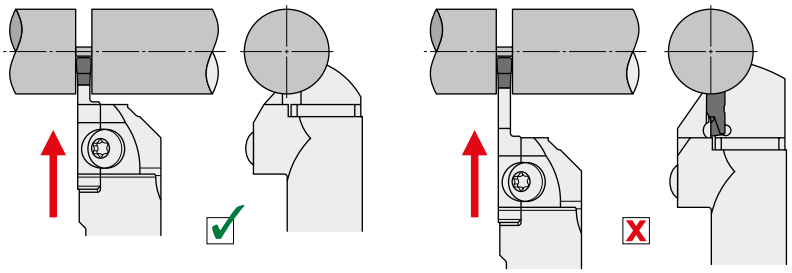
To ensure sufficient clamping rigidity, select a modular holder with the largest possible shank size.

MODULAR BLADE



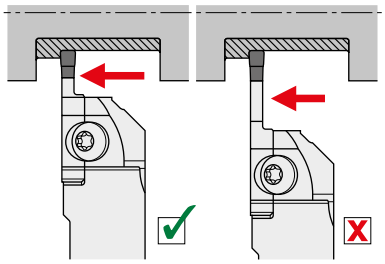
If there is no restriction for use, select the largest modular blade with the highest stability for the same shank size.

MODULAR BLADE



Select the shortest possible blade suitable for the application.

MODULAR BLADE

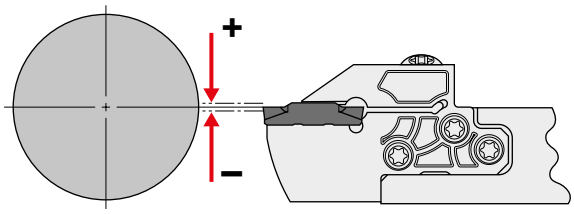


Select the shortest possible blade suitable for the application.

TOOL SELECTION

NOTES WHEN SETTING THE TOOL

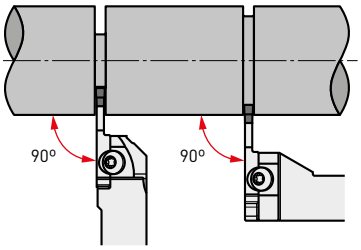
SETTING OF CUTTING EDGE HEIGHT



Grooving / Cross-feed machining
Set the cutting edge height to ± 0.1 mm parallel to the central axis.

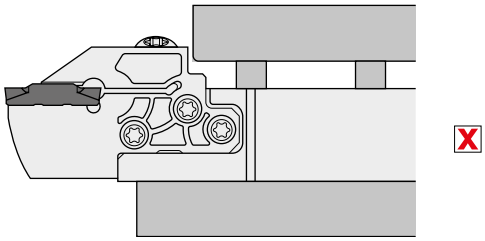
Cutting off
Set the cutting edge height to 0 – + 0.2 mm parallel to the central axis.

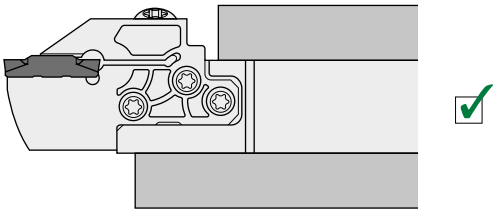
TOOL BODY SETTING ANGLE



Set the insert perpendicular to the central axis.

OVERHANG



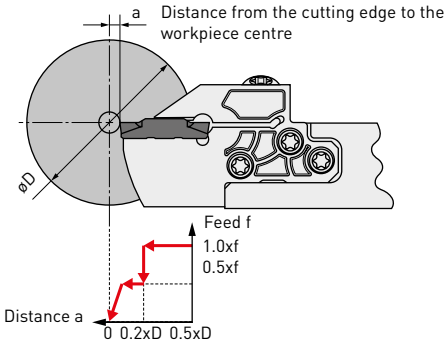


When setting the tool, ensure that the overhang is as short as possible and avoid contact of the tool post with the top clamp as shown in the figures above.

MACHINING RECOMMENDATIONS

NOTES FOR CUTTING OFF

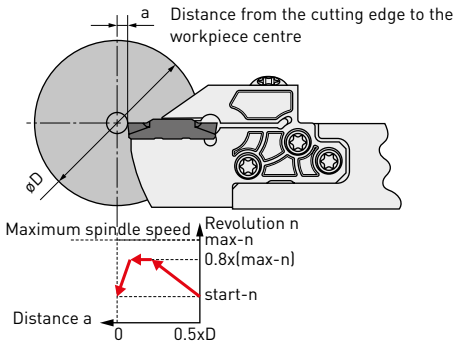
FEED



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.

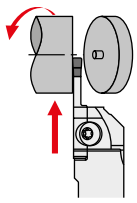
REVOLUTION

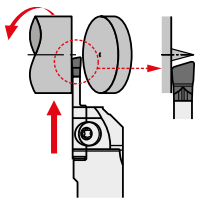


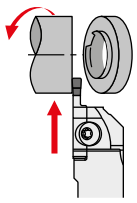
When using constant cutting speed during a cutting off cycle, it is recommended to limit the spindle speed to 80 % of maximum to ensure stability.

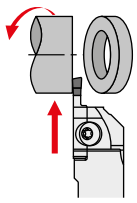
To prevent the workpiece from being expelled, lower the spindle speed before finishing the grooving operation.

INSERT


Neutral insert


Handed insert


Neutral insert

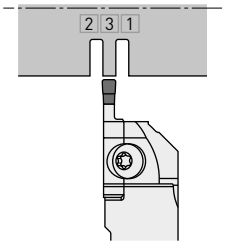

Handed insert

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.

MACHINING RECOMMENDATIONS

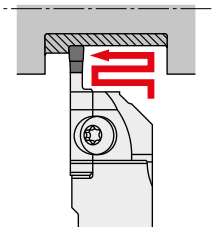
NOTES ON MULTI-FUNCTIONAL MACHINING (MS AND MM BREAKERS)

MACHINING NARROW GROOVES



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

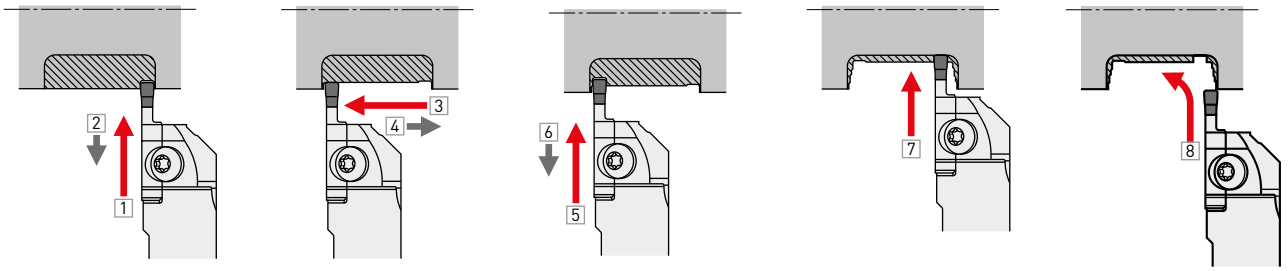
MACHINING WIDE GROOVES



It is recommended that cross-feed machining is used.

MACHINING WIDE GROOVES

ROUGHING FINISHING



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

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

5 Carry out grooving.
6 Retract the tool approx 0.1 mm.
* Repeat the steps z–n.

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

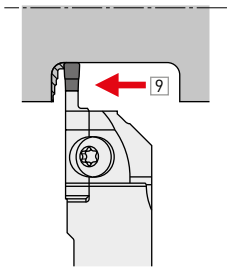
8 Machining of the wall surface, corner radius and bottom face should be carried out in one process.

MACHINING RECOMMENDATIONS

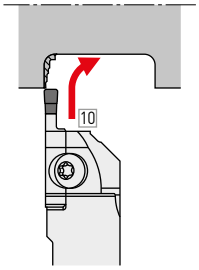
NOTES ON MULTI-FUNCTIONAL MACHINING (MS AND MM BREAKERS)

MACHINING WIDE GROOVES

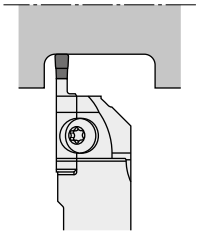
FINISHING



9 Stop at the bottom of the corner radius.

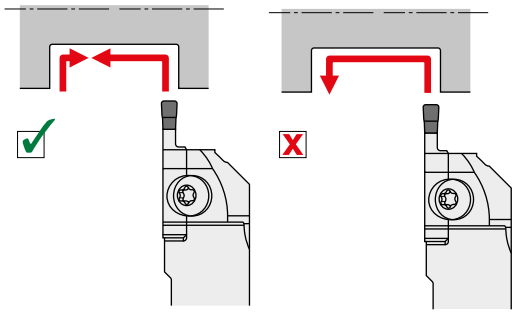


10 Machine the counter wall to the corner radius in one process.



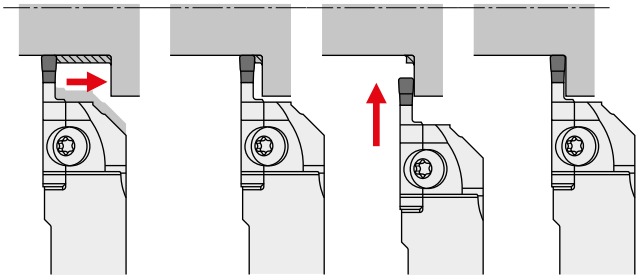
11 Finish machining.

PRECAUTIONS WHEN FINISHING WALLS



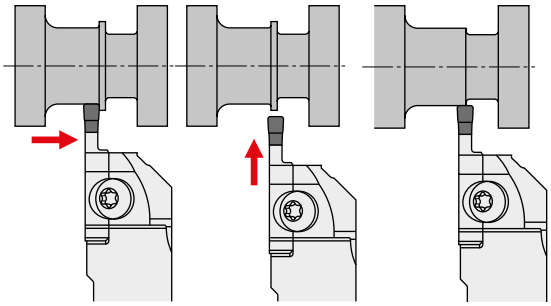
To produce high accuracy walls using MS or MM breaker insert, do not carry out back turning. Plunging is recommended.

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

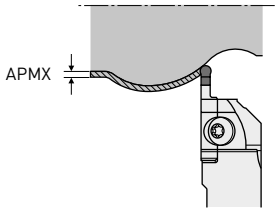


When a ring remains in a cross feed end process, finish cross feed machining 1 – 1.5 mm short of the end point, then remove the ring by plunging.

MACHINING RECOMMENDATIONS

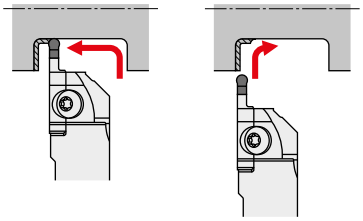
NOTES ON MULTI-FUNCTIONAL MACHINING (BM BREAKER)

COPYING



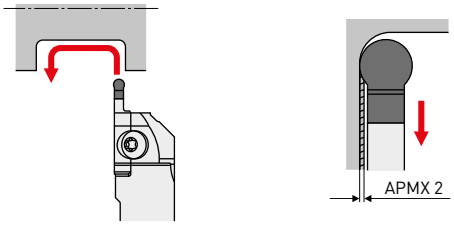
With the BM breaker insert, 3 dimensional copying is possible.
Set the depth of cut (APMX) to 40 % less than the insert width.

ROUGHING



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

FINISHING



Carry out finishing in one process.
For the depth of cut (APMX 2) when back turning, refer to the table on the right.

Insert	APMX 2
GY2M0200D100N-BM	0.05
GY2M0250E125N-BM	0.10
GY2M0300F150N-BM	0.15
GY2M0318F159N-BM	
GY2M0400G200N-BM	0.20
GY2M0475H238N-BM	0.24
GY2M0500H250N-BM	
GY2M0600J300N-BM	0.30
GY2M0635J318N-BM	
GY2M0800K400N-BM	0.40

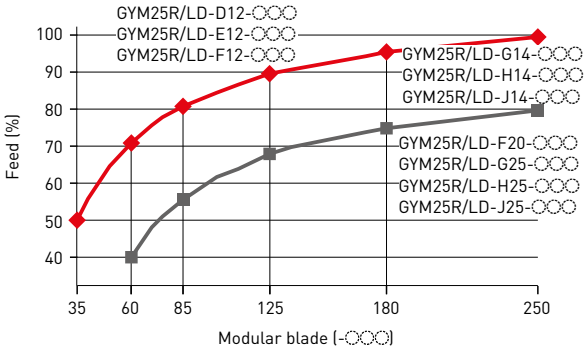
RECOMMENDED CUTTING CONDITIONS

RECOMMENDED CUTTING SPEED (M/MIN) (FOR FACE GROOVING)

	Material	Hardness	Grade	Vc
P	Mild steel	<160HB	VP20RT	130 (80–180)
			VP10RT	140 (90–190)
			NX2525	120 (70–170)
	Carbon steel Alloy steel	160–280HB	VP20RT	100 (60–140)
			VP10RT	110 (70–150)
			MY5015	150 (90–210)
			NX2525	95 (55–135)
		≥280HB	VP20RT	80 (50–110)
			VP10RT	90 (60–120)
			MY5015	120 (80–160)
			NX2525	75 (45–105)
M	Stainless steel	≤270HB	VP20RT	80 (50–110)
			VP10RT	90 (60–120)
K	Gray cast iron	Tensile strength ≤300MPa	VP20RT	100 (60–140)
			VP10RT	110 (70–150)
			MY5015	150 (90–210)
	Ductile cast iron	Tensile strength ≤800MPa	VP20RT	80 (50–110)
			VP10RT	90 (60–120)
			MY5015	120 (80–160)
S	Heat resistant alloy Titanium alloy	—	MP9015	70 (40–100)
			MP9025	60 (30– 90)
			VP20RT	45 (30– 60)
			VP10RT	55 (40– 70)
			RT9010	55 (40– 70)
H	Hardened steel	≥50HRC	BC8110	80 (60–100)

1. VP20RT is the first recommended grade for materials other than hardened steel.
2. For VP10RT, VP20RT, MP9015, MP9025 and MY5015, wet cutting is recommended.

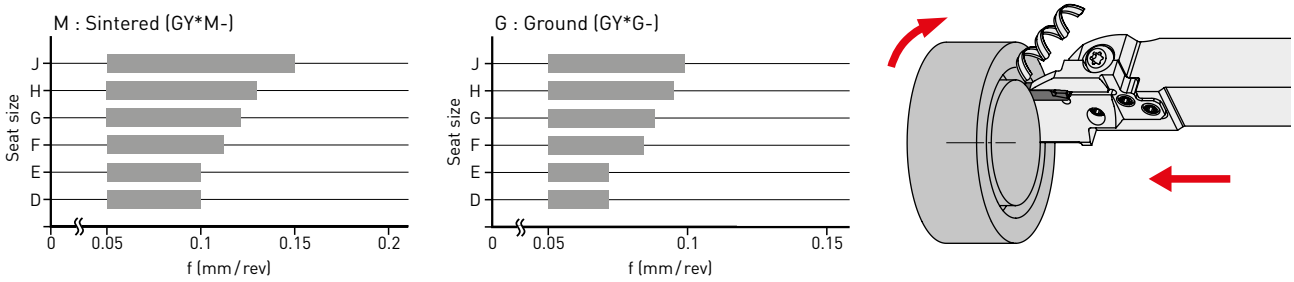
RELATIONSHIP BETWEEN THE MODULAR BLADE AND FEED PER ROTATION (FOR FACE GROOVING)



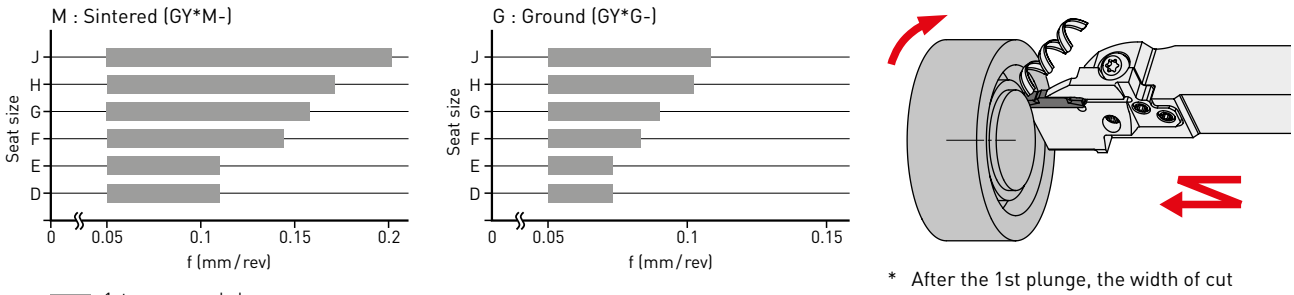
1. Adjust the feed per rotation in the cutting conditions to the percentage shown in the table above.

RECOMMENDED CUTTING CONDITIONS (FOR FACE GROOVING)

FACE GROOVING

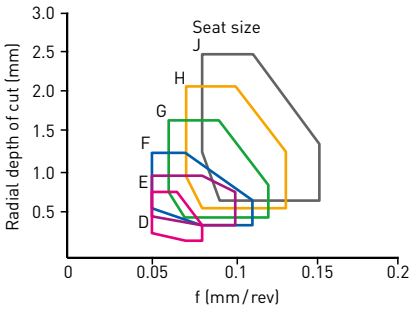


FACE PLUNGING

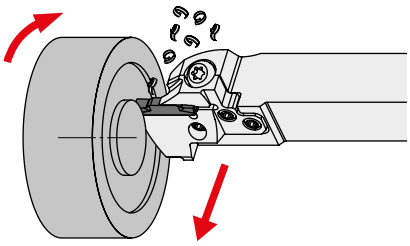


* After the 1st plunge, the width of cut should be set narrower than insert width CW.

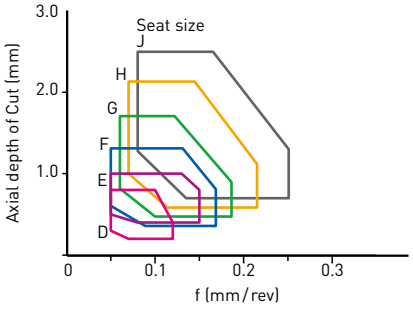
TRAVERSE MACHINING (MF BREAKER)

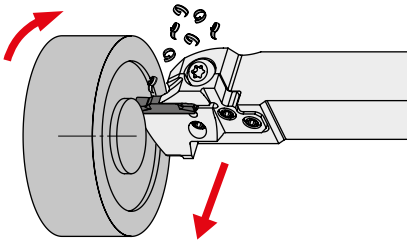


Seat size	Insert width (mm)	Seat size	Insert width (mm)
D	2.00	G	4.00
	2.24		4.24
E	2.39	H	4.75
	2.50		5.00
	2.74		5.24
F	3.00	J	6.00
	3.18		6.31
	3.24		6.35

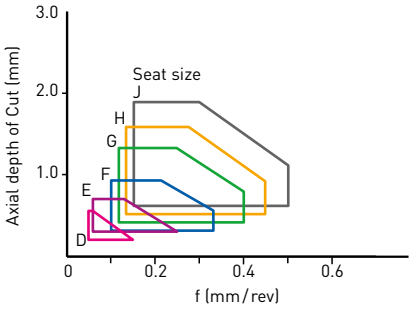


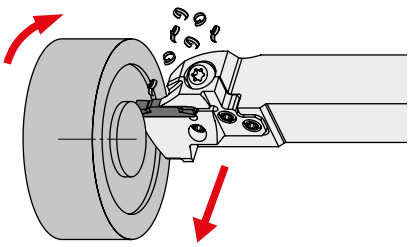
TRAVERSE MACHINING (MM/MS BREAKER)





TRAVERSE MACHINING (BM BREAKER)



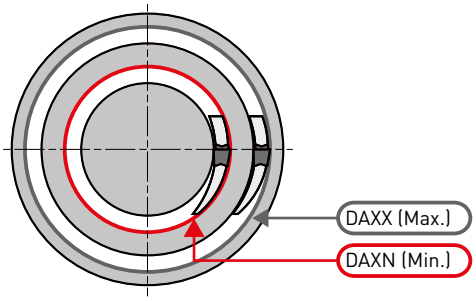


TOOL SELECTION

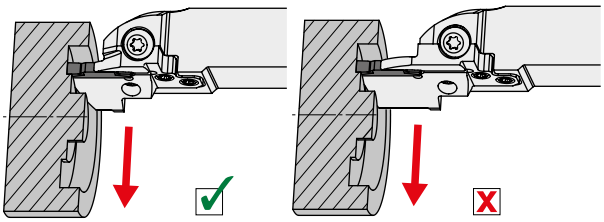
NOTES WHEN SELECTING THE TOOL BODY

MODULAR BLADE (1)

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

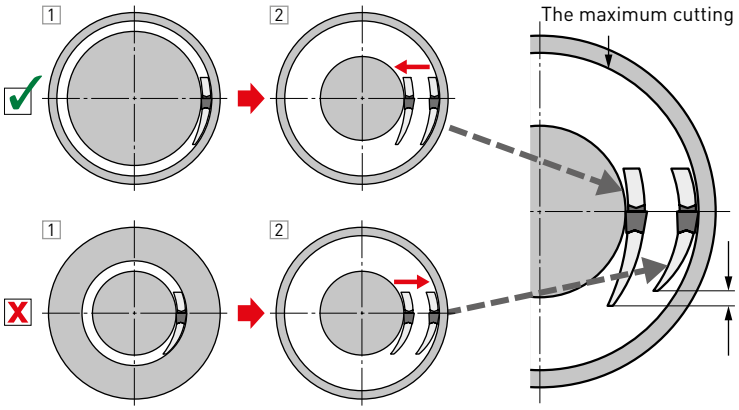


MODULAR BLADE (2)



Select the shortest possible blade suitable for the application.

MODULAR BLADE (3)



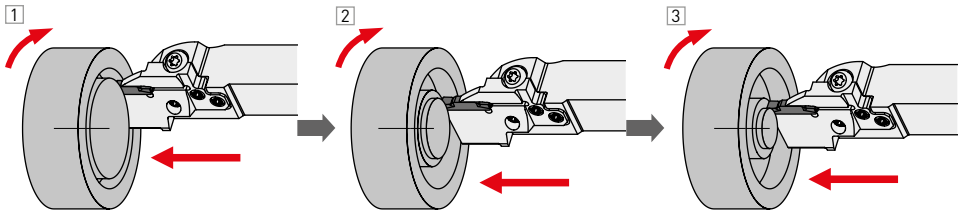
Select the largest size blade within the maximum cutting diameter of the workpiece.

Machine from the outer diameter towards the centre.

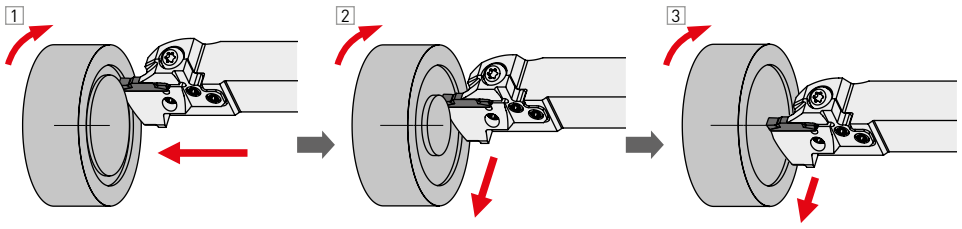
Increased machining stability and rigidity is possible if a modular blade with the largest possible back metal is used.

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

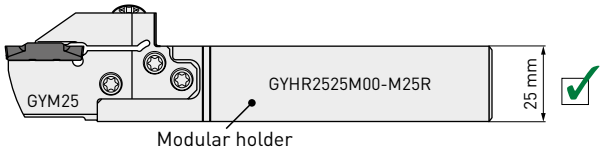
When plunging in several passes.

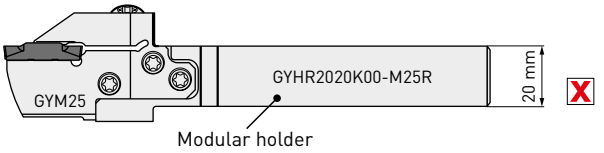


When combining plunging and infeed machining.



MODULAR HOLDER



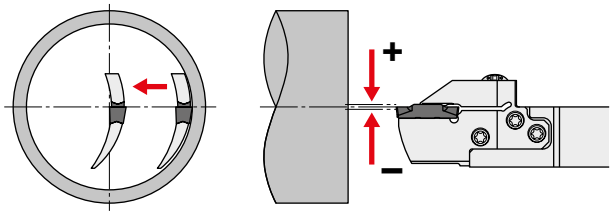


1. To ensure sufficient clamping rigidity, select a modular holder with the largest possible shank size.

TOOL SELECTION

NOTES WHEN SETTING THE TOOL

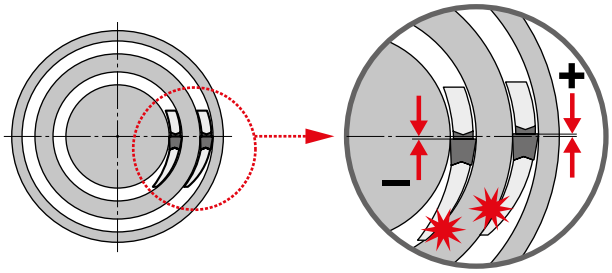
SETTING THE CUTTING EDGE HEIGHT



Set the cutting edge height to ±0.1 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.

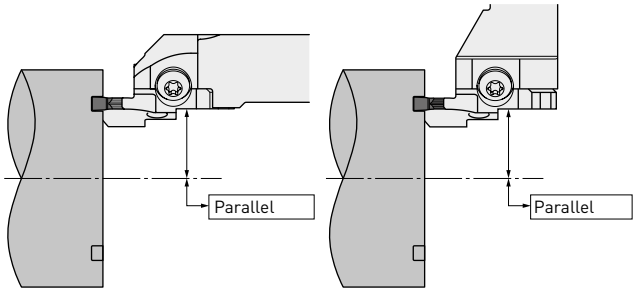
WHEN INTERTERING THE WALL OF GROOVE AND THE MODULAR BLADE



If interference occurs even when the correct blade is used, the cutting edge height could be incorrect.

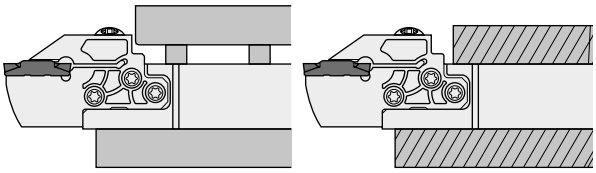
When interference occurs on the inner side of the blade, the cutting edge height is set too high. When interference occurs on the outer side of the blade, the cutting edge height is set too low.

SETTING THE TOOL



Set the insert parallel to the central axis.

TOOL OVERHANG



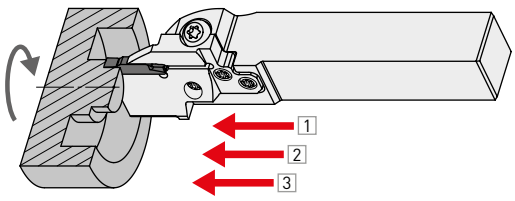
When setting the tool, ensure that the overhang is as short as possible and avoid contact of the tool post with the top clamp as shown in the figures above.

MACHINING RECOMMENDATIONS

NOTES WHEN FACE GROOVING (1)

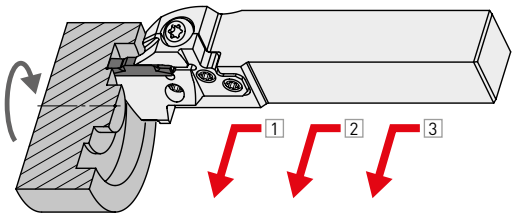
Always machine from the outer diameter towards the centre.

MACHINING NARROW GROOVES



Plunging in several passes is recommended.

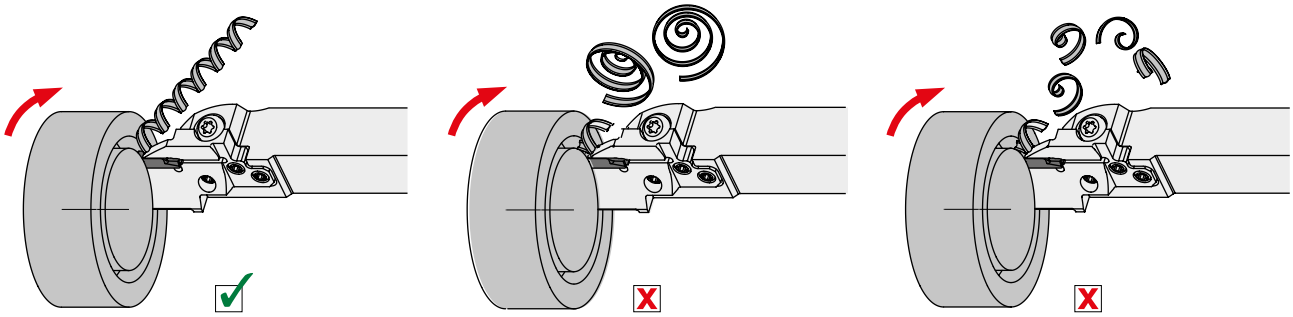
MACHINING WIDE GROOVES



Cross feed machining is recommended.

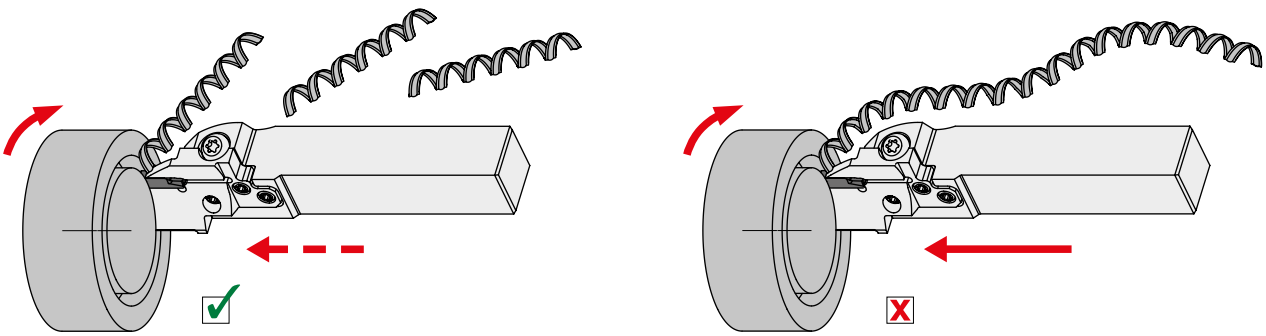
NOTES WHEN FACE GROOVING (2)

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)

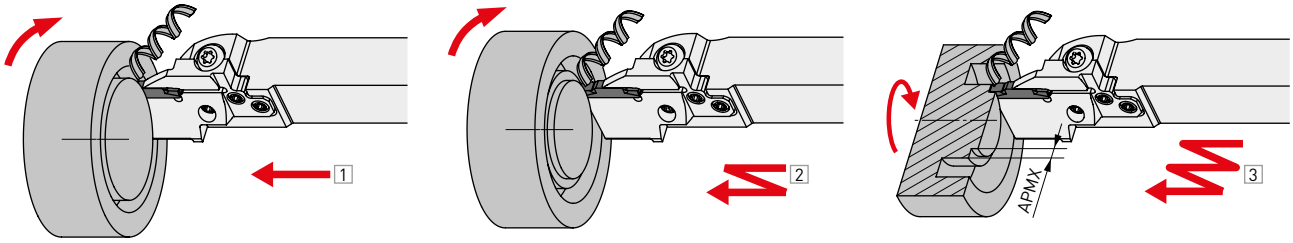


When chips become too long, use peck feed to break them into a suitable length.

MACHINING RECOMMENDATIONS

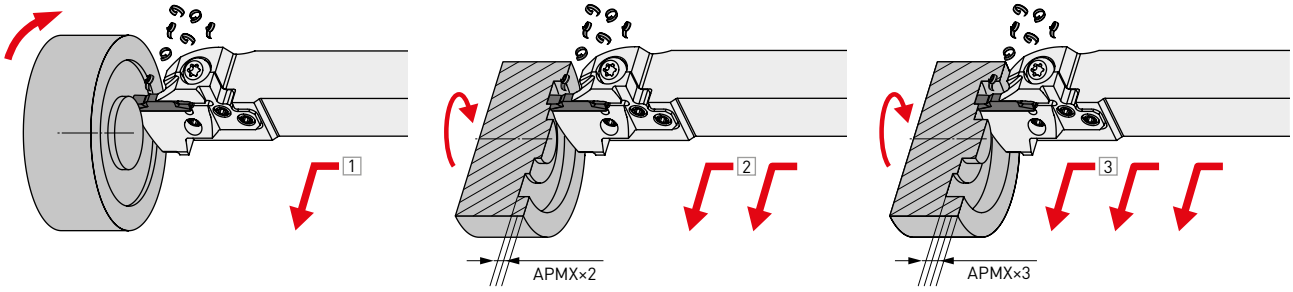
NOTES WHEN FACE GROOVING (1)

NOTES WHEN WIDE FACE GROOVING BY PLUNGING IN SEVERAL PASSES.



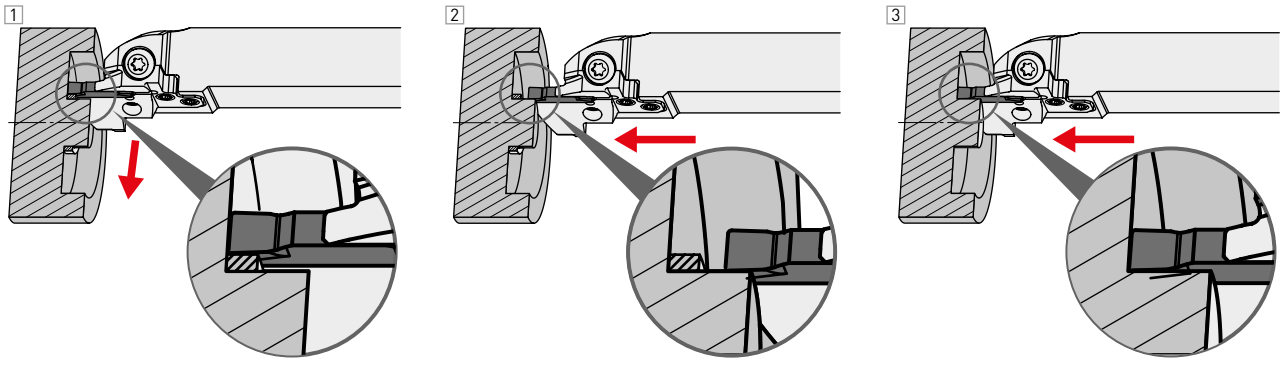
When machining a face groove in several passes, machine from the outer diameter towards the centre so that space for discharging chips is created to prevent insert damage caused by chip jamming.
Plunging width of cut is recommended to be set at 60 – 80 % of the insert width. This enhances the effect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

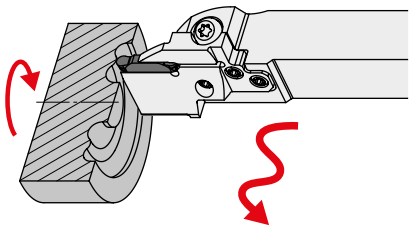


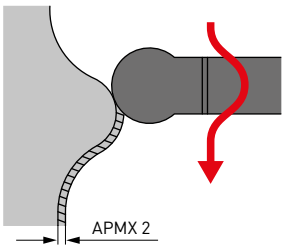
When infeed machining at the bottom of a deep groove, chips may interfere on the cutting edge near the centre wall. In such cases, stop infeed machining just before the centre wall (at a point less than the insert width) then remove the remaining material by plunging.

MACHINING RECOMMENDATIONS

NOTES WHEN FACE GROOVING (1)

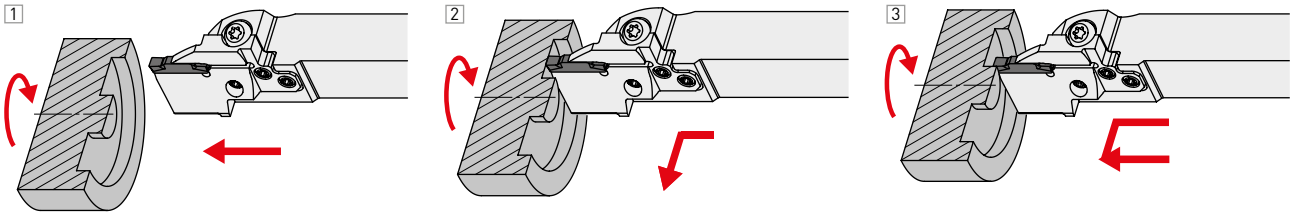
NOTES WHEN FACE COPYING (BM BREAKER)





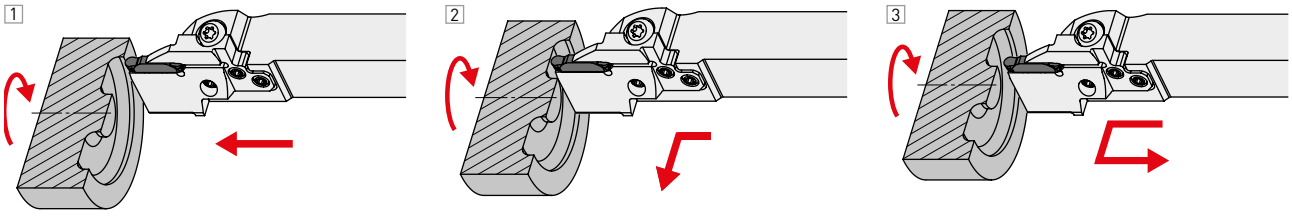
With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (APMX 2) to 30 % less than the insert width.

FINISHING (1)

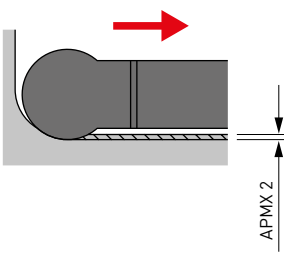


When finish cutting, machine continuously from the outer wall to the bottom of the groove, then finally plunge cut the centre wall.

FINISHING (2) (BM BREAKER)



Carry out finishing in one process. For the depth of cut (APMX 2) when back turning, refer to the table on the right.

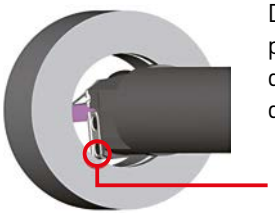


Insert	APMX 2
GY2M0200D100N-BM	0.10
GY2M0250E125N-BM	
GY2M0300F150N-BM	
GY2M0318F159N-BM	
GY2M0400G200N-BM	0.15
GY2M0475H238N-BM	0.20
GY2M0500H250N-BM	
GY2M0600J300N-BM	0.25
GY2M0635J318N-BM	

LIMITATION OF THE MAXIMUM GROOVE DEPTH (FOR INTERNAL GROOVING)

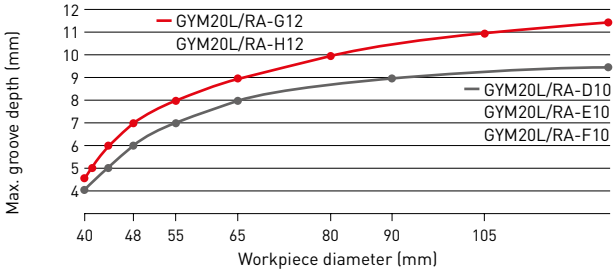
When using the monoblock type
The maximum groove depth is not limited by the cutting diameter.

When using the modular blade type
The maximum groove depth is limited by the cutting diameter.

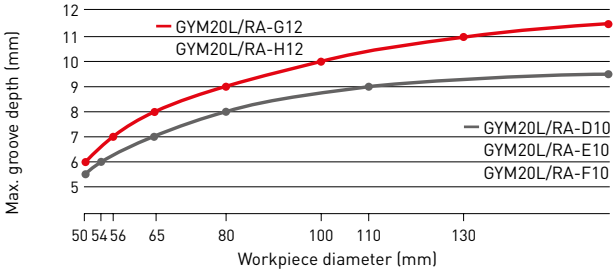


Due to interference of this part, the maximum groove depth is limited by the cutting diameter.

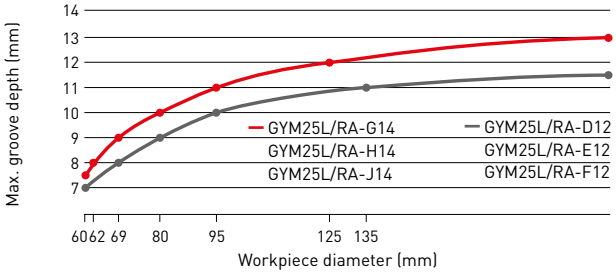
Shank diameter = 32 mm (GYM20 Blade)



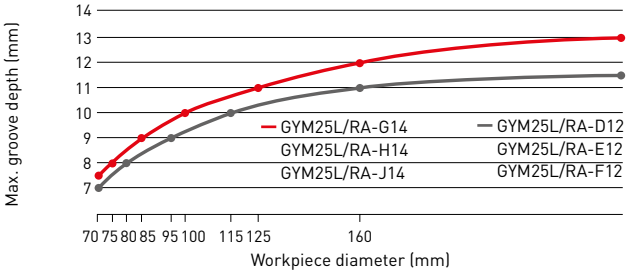
Shank diameter = 40 mm (GYM20 Blade)



Shank diameter = 40 mm (GYM25 Blade)



Shank diameter = 50 mm (GYM25 Blade)



RECOMMENDED CUTTING CONDITIONS

RECOMMENDED CUTTING SPEED (M/MIN) (FOR INTERNAL GROOVING)

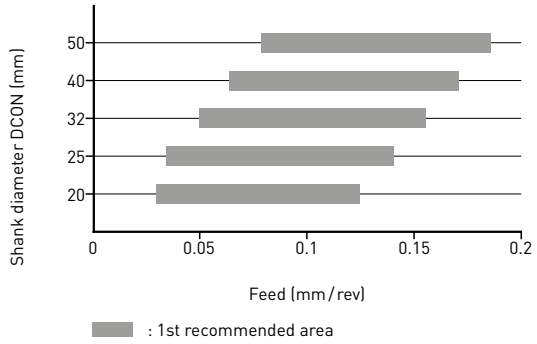
	Material	Hardness	Grade	Vc
P	Mild steel	<160HB	VP20RT	130 (80–180)
			VP10RT	140 (90–190)
			NX2525	120 (70–170)
	Carbon steel Alloy steel	160–280HB	VP20RT	100 (60–140)
			VP10RT	110 (70–150)
			MY5015	150 (90–210)
			NX2525	95 (55–135)
		≥280HB	VP20RT	80 (50–110)
			VP10RT	90 (60–120)
			MY5015	120 (80–160)
			NX2525	75 (45–105)
M	Stainless steel	≤270HB	VP20RT	80 (50–110)
			VP10RT	90 (60–120)
K	Gray cast iron	Tensile strength ≤300MPa	VP20RT	100 (60–140)
			VP10RT	110 (70–150)
			MY5015	150 (90–210)
	Ductile cast iron	Tensile strength ≤800MPa	VP20RT	80 (50–110)
			VP10RT	90 (60–120)
			MY5015	120 (80–160)
S	Heat resistant alloy Titanium alloy	—	MP9015	70 (40–100)
			MP9025	60 (30– 90)
			VP20RT	45 (30– 60)
			VP10RT	55 (40– 70)
			RT9010	55 (40– 70)
H	Hardened steel	≥50HRC	BC8110	80 (60–100)

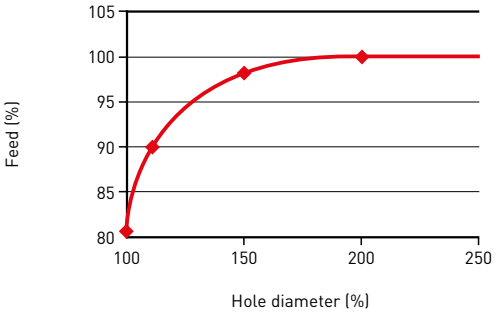
1. VP20RT is the first recommended grade for materials other than hardened steel.
2. For VP10RT, VP20RT, MP9015, MP9025 and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS

FOR INTERNAL GROOVING

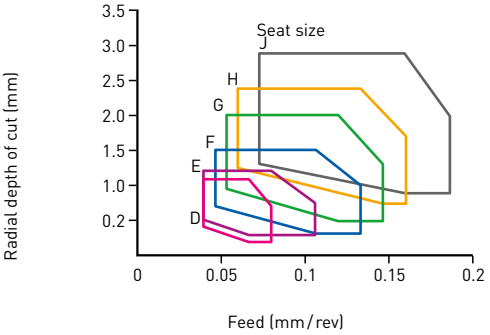
Grooving

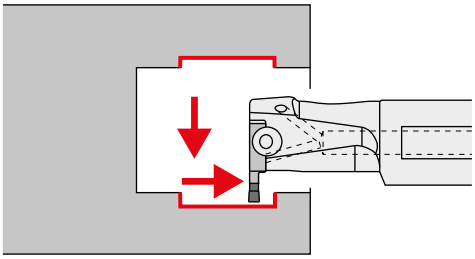




1. The cutting diameter 100 % represents the minimum cutting diameter (DMIN).
2. The graph on the left shows the cutting conditions when setting the feed to 100 %.

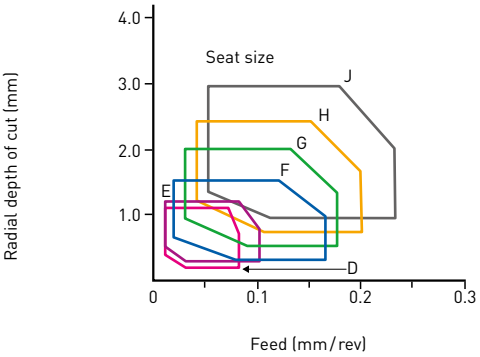
Traverse machining (MF Breaker)

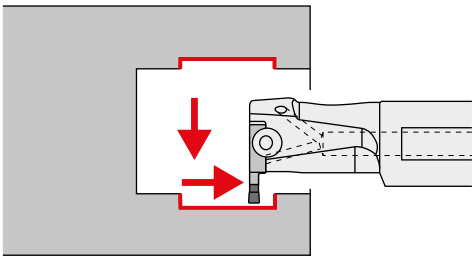




When traverse machining a blind hole, it is recommended to carry out back turning considering chip disposal.

Traverse machining (MM/MS Breaker)

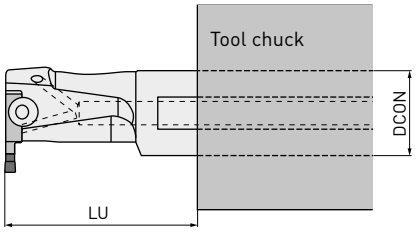




When traverse machining a blind hole, it is recommended to carry out back turning considering chip disposal.

1. The above cutting conditions are for when using the tool overhang (LU) 1.6-2.0 times larger than the shank diameter (DCON). (L/D=1.6-2.0). When using L/D larger than 2.0, reduce the cutting conditions.

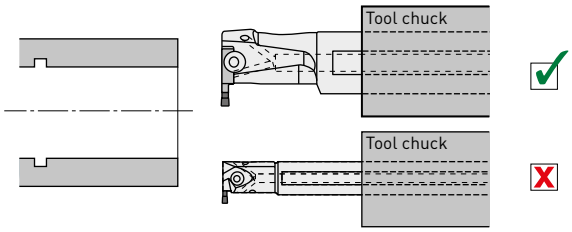
Seat size	Insert width (mm)
D	2.00 2.24
E	2.39 2.50 2.74
F	3.00 3.18 3.24
G	4.00 4.24
H	4.75 5.00 5.24
J	6.00 6.31 6.35



TOOL SELECTION

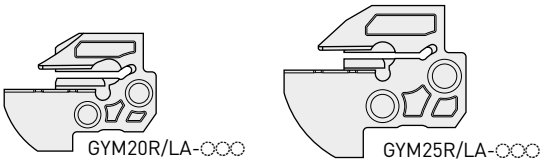
NOTES WHEN SELECTING THE TOOL BODY

HOLDER



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

MODULAR BLADE (1)

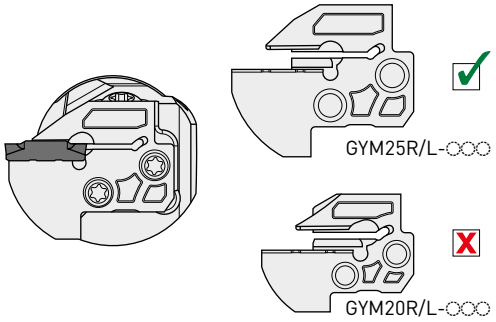


GYM20R/LA-D10
GYM20R/LA-E10
GYM20R/LA-F10
GYM20R/LA-G12
GYM20R/LA-H12

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

For a Ø40 shank holder, if there is no restriction for use, select a holder suitable for GYM25 blade.

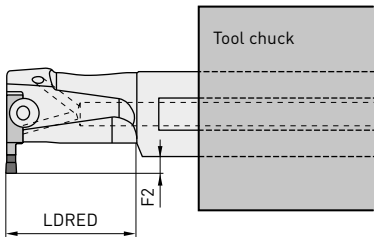
MODULAR BLADE (2)



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

NOTES WHEN SETTING THE TOOL

OVERHANG



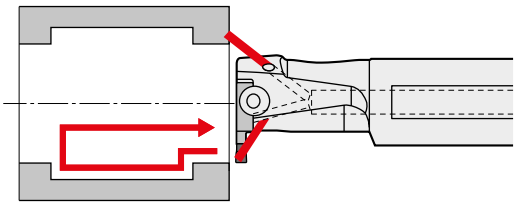
The maximum groove depth is limited to the dimension LDRED. When machining with longer overhangs, refer to the dimension F2 of the tool used.

MACHINING RECOMMENDATIONS

NOTES ON MULTI-FUNCTION MACHINING (MS AND MM BREAKERS)

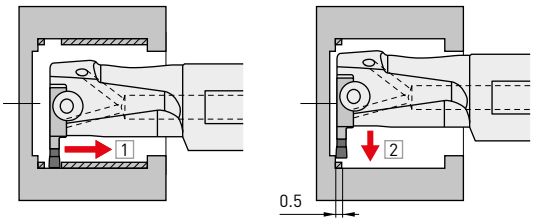
For internal grooving, the machining methods for external grooving (37) can be used, but please note the following precautions.

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

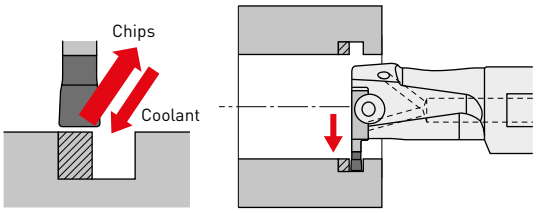


As continuous chips tend to elongate at the back of the bore, the above operation is recommended. The recommended width of cut for x is 0.5 mm.

MACHINING WIDE GROOVES

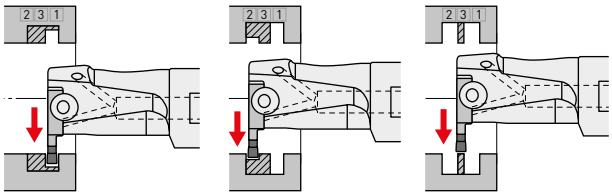
GROOVING

When the cutting edge width is x 2 ≥ 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

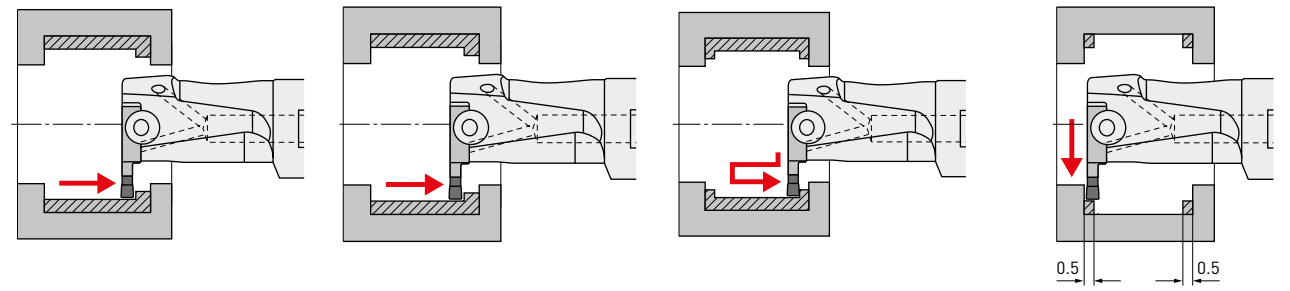


When the groove depth is larger than the cutting edge width, carry out plunging in the steps above to break up chips efficiently.

MACHINING RECOMMENDATIONS

NOTES ON MULTI-FUNCTION MACHINING (MS AND MM BREAKERS)

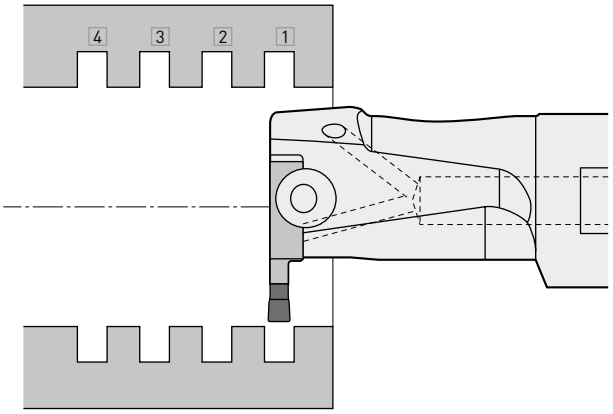
TURNING



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

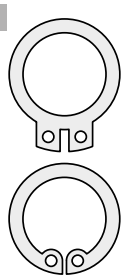


It is recommended to carry out grooving from the front end of the workpiece. This reduces workpiece deflection.

REFERENCE MATERIAL

CIRCLIP STANDARDS

1

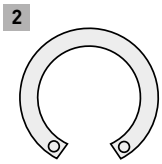


C type circlip

ANSI B27.7/27.8 (US) / BS 3673 (UK) / DIN 471/ 472 (DE) / NF E 22 163 (FR) / UNI 7435/7438 (IT)

Fig.	For shaft Width	For shaft Tolerance	For hole Width	For hole Tolerance
	0.5	+0.14 0	9	+0.14 0
	0.7		1.1	
	0.8		1.3	
	0.9		1.6	
	1.1		1.85	
	1.3		2.15	
1	1.6*3		2.65	
2	1.85*3		3.15	+0.18 0
	2.15*1		4.15	
	2.65*1		5.15	
	3.15*1	+0.18 0	6.2	+0.22 0
	4.15*1			
	5.15*1			
	6.2*1	+0.22 0		
3	0.32	+0.05 0		
	0.5			
	0.7	+0.10 0		
	1.0			
	1.2	+0.14 0		
	1.4			

2

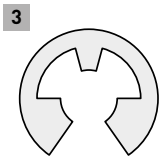


C type retaining ring

JIS B 2804 (JP)

Fig.	For shaft Width	For shaft Tolerance	For hole Width	For hole Tolerance
	1.15	+0.14 0		
	1.35			
	1.75*3			
	1.95*2			
	2.2*1			
	2.7*1			
1	3.2*1	+0.18 0		
2	4.2*1			
3	0.3	+0.05 0		
	0.4			
	0.5			
	0.7	+0.10 0		
	0.9			
	1.15	+0.14 0		
	1.75*3			
	2.2*1			

3



E type circlip

N1* AMERICAN**

Fig.	For shaft Width	For shaft Tolerance	For hole Width	For hole Tolerance
	0.305	+0.051 0	0.457	+0.051 0
	0.457	+0.076 0	0.737	+0.076 0
	0.737		0.991	
	0.991		1.168	
	1.168	+0.102 0	1.422	+0.102 0
	1.422		1.727*3	
1	1.727*3	+0.127 0	2.184*1	+0.102 0
2	2.184*1		2.616*3	
	2.616*3		3.048*3	
	3.048*3	+0.152 0		
	3.531*3			
3	0.305	+0.151 0		
	0.457			
	0.584			
	0.737	+0.076 0		
	0.991			
	1.168			
	1.422	+0.102 0		
	1.727*3			

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

REFERENCE MATERIAL

O-RING STANDARDS

DIN 3770/3771 (De)

General		For oil pressure		For air pressure	
Width	Tolerance	Width	Tolerance	Width	Tolerance
STATIC USE					
		1.9*3	+0.1 0		
		2.3*3			
		2.9*2	+0.15 0		
		3.6*3	+0.2 0		
		4.5*3			
DYNAMIC USE					
		5.5*3	+0.3 0		
		7.0*3			
		8.6*3	+0.4 0		
		10.7*3	+0.5 0		

JIS B 2401 (JP) ISO 3601

General		For oil pressure		For air pressure	
Width	Tolerance	Width	Tolerance	Width	Tolerance
STATIC USE					
DYNAMIC USE					
2.5		2.4		2.2	
3.2		3.6		3.4	
4.7	+0.14 0	4.8	+0.25 0	4.6	+0.25 0
7.5		7.1		6.9	
11.1		9.5		9.3	

O-RING STANDARDS

SMS 1586/1588 (Se) / BS 1806/4518 (UK)

General		For oil pressure		For air pressure	
Width	Tolerance	Width	Tolerance	Width	Tolerance
STATIC USE					
3.2	+0.2 0	2.3		2.3	
4.0		3.1		3.1	
		3.7	+0.2 0	3.7	+0.2 0
		6.4		6.4	
		9.0		9.0	
DYNAMIC USE					
7.5	+0.2 0				
11.0					

SAE AS-568 (US)

General		For oil pressure		For air pressure	
Width	Tolerance	Width	Tolerance	Width	Tolerance
STATIC USE					
2.54					
3.18					
4.32	+0.13 0				
6.1					
8.0					
DYNAMIC USE					
2.39					
3.58					
4.78	+0.25 0				
7.14					
9.58					

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

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