Cut-off Tools F

F69 to F106

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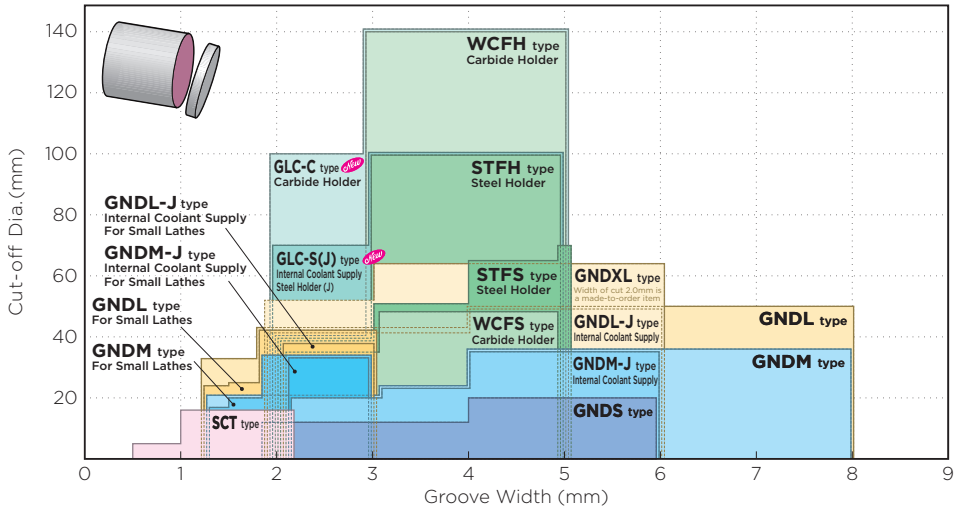
Stock Markings and Symbols

- ●● mark: Standard stocked item
- ● mark: To be replaced with the new item featured on the same page
- ▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability)
- * mark: Semi-standard stock (please confirm stock availability)
- ○ mark: Stock or planned stock (please confirm stock availability)
- Blank: Made-to-order item
- — mark: Not available

Selection Guide

Cut-off



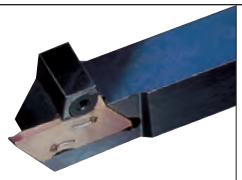
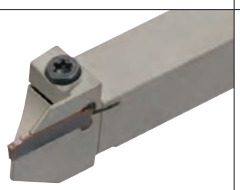
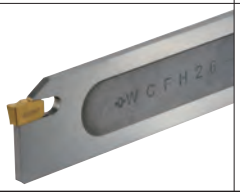
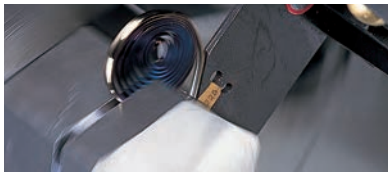
■ Range of Applications (For Solid Workpieces)

Application	Series	Shape	Insert Shape (( ) indicates no. of cutting edges)	Cut-off Dia. 25 50 75 100(mm) / Groove Width 2 4 6 8 10 (mm)	Features
For Small Lathes	**SCT type**	→ F88	(2) Right-handed Left-handed Neutral	16.0 / 0.5 – 2.0	· Ground insert with good sharpness · Can clamp even from behind · 2-cornered type inserts
For Small to Medium Diameters	**GND series** Expansion For Small Lathes GNDM/GNDM-J GNDL/GNDL-J	→ F90 ~	(2)	32.0 / 1.25 – 3.0	· High-rigidity design and outstanding chip control · Unground 2-cornered type inserts, available with widths starting at 1.25mm
For Small to Medium Diameters	**GND series** Expansion GNDS GNDM/GNDM-J GNDL/GNDL-J GNDXL	→ F94 ~	Right-handed Left-handed Neutral	50.0 / *2.0 – 8.0	· High-rigidity body, rigid clamping · Outstanding chip control · Unground 2-cornered type inserts
For Medium to Large Diameters	**GLC-S type** New **GLC-SJ type** Steel Shank (Suffix J indicates internal coolant supply)	→ F74	(1) Right-handed Left-handed Neutral	100.0 / 2.0 – 5.0	· Can be used for large diameter cut-off up to ø100mm · Insert life extended with internal coolant supply · 1-cornered self-restrained type inserts
For Medium to Large Diameters	**GLSC-C type** New Carbide Shank	→ F76	(1) Right-handed Left-handed Neutral	140.0 / 2.0 – 5.0	· Can be used for large diameter cut-off up to ø140mm · Extraordinary stability with carbide body · 1-cornered self-restrained type inserts
For Medium to Large Diameters	**STFH type** Expansion **STFS type** Steel Shank (SumiGrip Jr.)	→ F80 / F82	(1) Right-handed Left-handed Neutral	100.0 / 2.0 – 5.0	· Can be used for large diameter cut-off up to ø100mm · Economical steel shank · 1-cornered self-restrained type inserts
For Medium to Large Diameters	**WCFH type** Expansion **WCFS type** Carbide Shank (SumiGrip)	→ F84 / F86	(1) Right-handed Left-handed Neutral	140.0 / 2.0 – 5.0	· Can be used for large diameter cut-off up to ø140mm · High-rigidity carbide shank · 1-cornered self-restrained type inserts

*Width of cut 2.0mm is a made-to-order item.

Selection Guide

■ Cut-off Tool series

SEC-Small Diameter Cut-off Tool Holders **SCT type**		· Our first recommendation for small lathes · Excellent sharpness suppresses cutting resistance and central pips.	
SEC-Cut-off Tool Holders **GND series** Economic GNDS type GNDM / GNDM-J type GNDL type / GNDL-J type GNDXL type		· Our first recommendation for small to medium diameters · High-rigidity body and strong clamping enable stable cut-off	
SEC-Cut-off Tool Holders **GLC-S type** New **GLC-SJ type** New (Internal Coolant Supply) Steel Shank		· Our first recommendation for medium to large diameters · Achieves high machining accuracy and durability with optimised blade shape · Lineup also includes internal coolant supply (Steel Shank)	
SEC-Cut-off Tool Holders **GLC-C type** New Carbide Shank			
SEC-Cut-off Tool Holders **STFH type / STFS type** Economic Steel Shank (SumiGrip Jr.) **WCFH type / WCFS type** Economic Carbide Shank (SumiGrip)		· For medium to large-diameter cut-off machining · Blade type is also available for cut-off up to ø140mm	

GLC series

New

■ Features

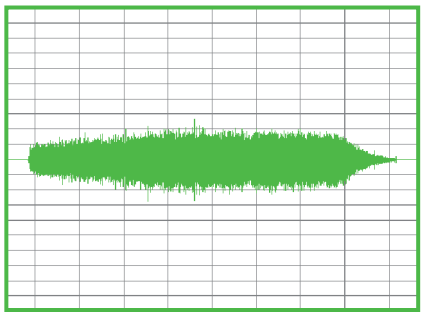
- Achieves high machining accuracy and durability with optimised blade shape
- Insert can be mounted and removed with just a wrench
- Internal coolant supply extends insert life
- Lineup includes steel holders, steel holders with internal coolant supply (max. cut-off dia. ø100mm), and carbide holders (max. cut-off dia. ø140mm)
- Combine with general-purpose chipbreaker GG type and low cutting force chipbreakers GF type (neutral) or CF type (handed) to support a wide range of applications

■ Cutting Performance

● Low vibration

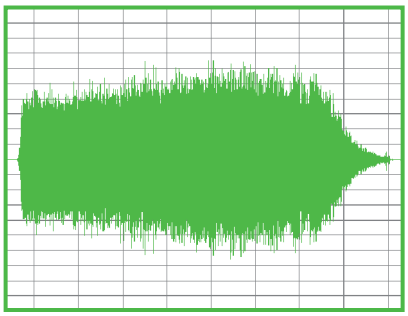
Achieves stable machining with a high-rigidity holder and strong clamping

Low runout / stable vibration



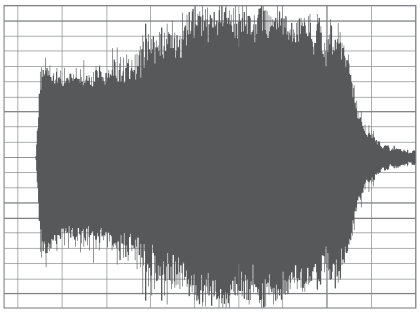
GLC-C type
Carbide Holder

Stable vibration



GLC-S type
Steel Holder

High runout / unstable vibration

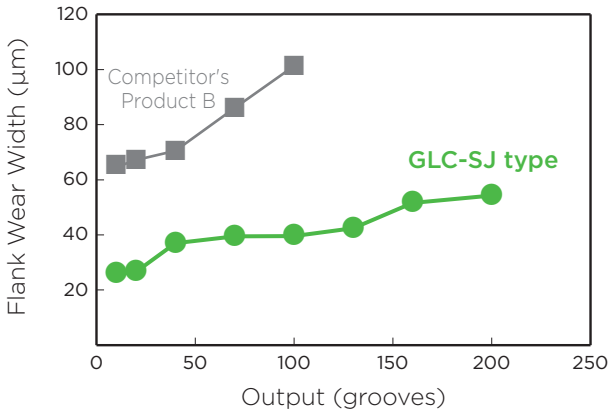


Competitor's Product A
Steel Holder

Work Material: SUS316 (ø40) Insert: WCFN3-GF (AC1030U) Holder: GLCBN32-3C (Carbide) / GLCBN32-3S (Steel)
Cutting Conditions: vc = 100m/min, f = 0.1mm/rev, Wet (External Coolant Supply)

● Tool life

Achieves longer tool life with optimised coolant supply outlets and a wide lineup of grades



Work Material: SUS316
Holder: GLCBN32-3SJ (Steel) Insert: WCFN3-GF (AC1030U)
Cutting Conditions: vc = 200m/min, f = 0.1mm/rev, Wet (Internal Coolant Supply)

● Chip control

Outstanding chip control even in cut-off machining of stainless steel

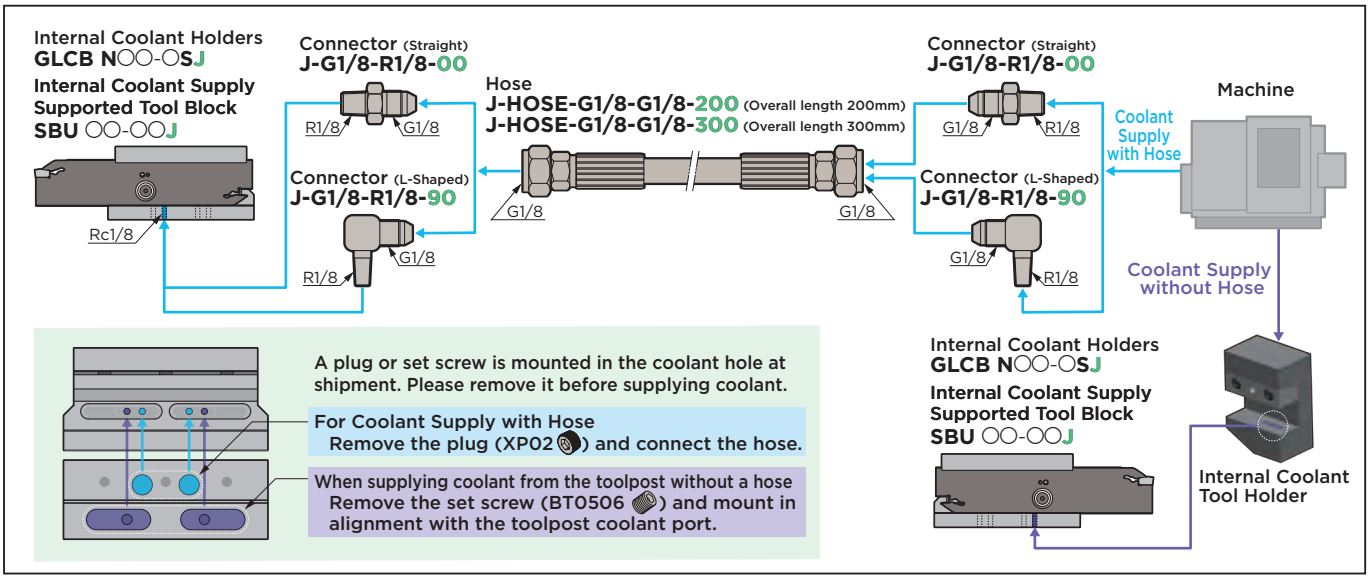
GF type Chipbreaker
(AC1030U)

Competitor's Product C

Work Material: SUS316
Holder: GLCBN32-3S (Steel) Insert: WCFN3-GF (AC1030U)
Cutting Conditions: vc = 100m/min, f = 0.1mm/rev, Wet (External Coolant Supply)

GLC series

■ Piping Method for Hoses and Connectors



■ Hoses and Connectors

Fig 1

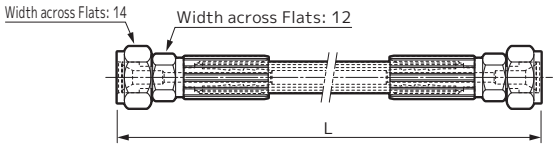


Fig 1

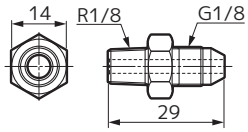
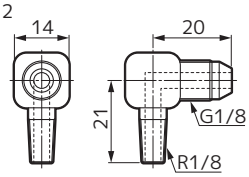


Fig 2



Parts (Hose)

Dimensions (mm)

Cat. No.	Stock	L	Screw Standard	Screw Standard	Fig
J-HOSE-G1/8-G1/8-200	●	200	G1/8	G1/8	1
J-HOSE-G1/8-G1/8-300	●	300	G1/8	G1/8	1

Hoses are sold separately.

Parts (Connector)

Dimensions (mm)

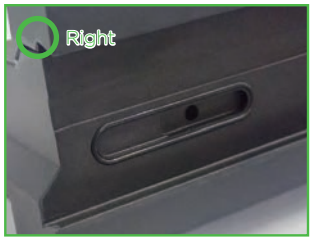
Cat. No.	Stock	Screw Standard	Screw Standard	Fig
J-G1/8-R1/8-00	●	G1/8	R1/8	1
J-G1/8-R1/8-90	●	G1/8	R1/8	2

Connectors are sold separately.

Precautions for Coolant Supply without Hose

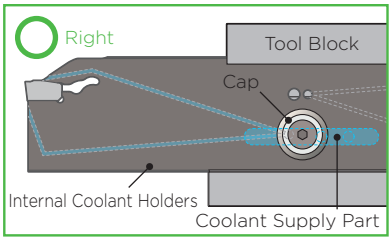
■ Internal Coolant Supply Supported Tool Block SBU-J type

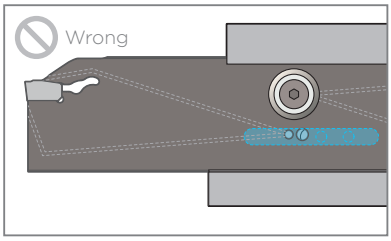
· Mount the O-ring correctly.

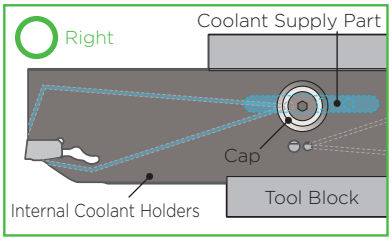


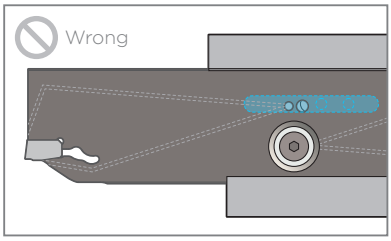
■ Internal Coolant Holder GLC-J type

· To prevent coolant leakage, mount the cap in the correct position.









GLC-S(J) type

New | Cut-off | Steel

Cut-off
(Steel Holder/Tool Block type)

GLC-S

Cut-off

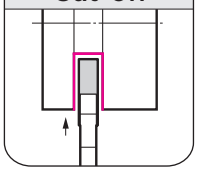


Fig 1

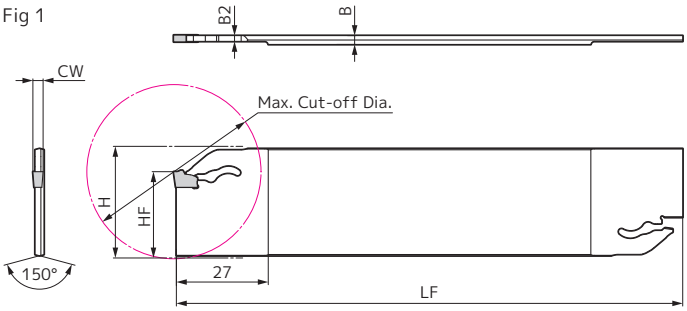
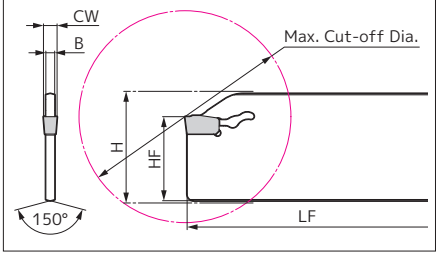


Fig 2



Holder (Steel)

Parts Dimensions (mm)

Cat. No.	Stock	Height H	Width B	Width B2	Overall Length LF	Cutting Edge Height HF	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Applicable Tool Blocks	Fig	Wrench
GLCB N26-2S	○	26	2.6	1.7	120.0	21.4	**2**	**50**	WCF□2-□□	SB□20-26	1	SL-5(*)
N26-3S	○	26	2.6	—	120.0	21.4	**3**	**70**	WCF□3-□□		2	
N26-4S	○	26	3.6	—	120.0	21.4	**4**	**70**	WCF□4-□□		2	
N26-5S	○	26	4.6	—	120.0	21.4	**5**	**70**	WCF□5-□□		2	
GLCB N32-2S	○	32	2.6	1.7	148.8	25.0	**2**	**50**	WCF□2-□□	SB□20-32 SB□25-32	1	SL-5(*)
N32-3S	○	32	2.6	—	148.8	25.0	**3**	**100**	WCF□3-□□		2	
N32-4S	○	32	3.6	—	148.8	25.0	**4**	**100**	WCF□4-□□		2	
N32-5S	○	32	4.6	—	148.8	25.0	**5**	**100**	WCF□5-□□		2	

*Wrench is sold separately from the main body.
Refer to page F75 for applicable inserts.

Tool Blocks F78

New | Cut-off | Steel | Internal Coolant

Cut-off with Internal Coolant Supply
(Steel Holder/Tool Block type)

GLC-SJ

Cut-off

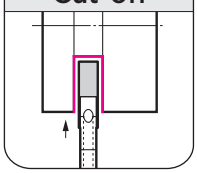


Fig 1

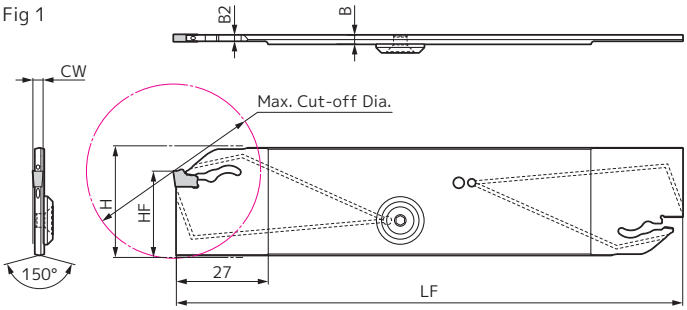
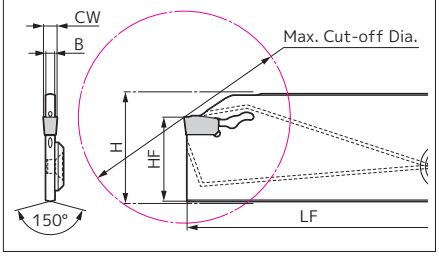


Fig 2



Holder (Steel, Internal Coolant Supply)

Parts Dimensions (mm)

Cat. No.	Stock	Height H	Width B	Width B2	Overall Length LF	Cutting Edge Height HF	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Applicable Tool Blocks	Fig	Wrench	Cap	Flat Head Screw
GLCB N26-2SJ	○	26	2.6	1.7	120.0	21.4	**2**	**50**	WCF□2-□□	SBU20-26J (SB□20-26)	1	SL-5(*)	RW14M4	BFT0405T15ZN
N26-3SJ	○	26	2.6	—	120.0	21.4	**3**	**70**	WCF□3-□□		2			
N26-4SJ	○	26	3.6	—	120.0	21.4	**4**	**70**	WCF□4-□□		2			
N26-5SJ	○	26	4.6	—	120.0	21.4	**5**	**70**	WCF□5-□□		2			
GLCB N32-2SJ	○	32	2.6	1.7	148.8	25.0	**2**	**50**	WCF□2-□□	SBU20-32J SBU25-32J (SB□20-32) (SB□25-32)	1	SL-5(*)	RW14M4	BFT0405T15ZN
N32-3SJ	○	32	2.6	—	148.8	25.0	**3**	**100**	WCF□3-□□		2			
N32-4SJ	○	32	3.6	—	148.8	25.0	**4**	**100**	WCF□4-□□		2			
N32-5SJ	○	32	4.6	—	148.8	25.0	**5**	**100**	WCF□5-□□		2			

*Wrench is sold separately from the main body.
Refer to page F75 for applicable inserts. The parentheses for applicable tool blocks are for use without internal coolant supply.

Tool Blocks F78
Piping Method and Precautions F73

○ mark: Planned stock (around autumn 2025)

GLC-S(J) type

Expansion

(Coated Carbide)

Fig 1 (Neutral (N))

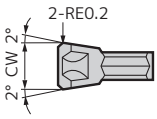


Fig 2 (Right Hand (R))

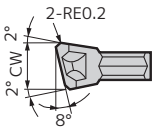
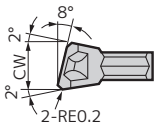
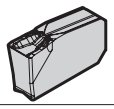
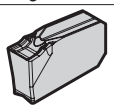
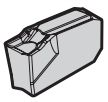


Fig 3 (Left Hand (L))



Insert for GLC type (Common)

Dimensions (mm)

Appearance	Cat. No.	AC830P	AC1030U	AC5015S	AC5025S	Width of Cut CW	Applicable Holder	Fig
WCF NO-GG General-purpose 	**WCF N2-GG**	●	●	●	●	**2.0**	GLCBNOO-2...	1
	WCF N3-GG	●	●	●	●	**3.0**	GLCBNOO-3...	1
	WCF N4-GG	●	●	●	●	**4.0**	GLCBNOO-4...	1
	WCF N5-GG	●	●	●	●	**5.0**	GLCBNOO-5...	1
WCF NO-GF Exotic Alloy Low Feed 	**WCF N2-GF**		●	●	●	**2.0**	GLCBNOO-2...	1
	WCF N3-GF		●	●	●	**3.0**	GLCBNOO-3...	1
	WCF N4-GF		●	●	●	**4.0**	GLCBNOO-4...	1
	WCF N5-GF		●	●	●	**5.0**	GLCBNOO-5...	1
WCF □O-CF Exotic Alloy Low Feed (Handed) 	**WCF R3-CF**		●	●	●	**3.0**	GLCBNOO-3...	2
	WCF L3-CF		●	●	●	**3.0**		3
	WCF R4-CF		●	●	●	**4.0**	GLCBNOO-4...	2
	WCF L4-CF		●	●	●	**4.0**		3

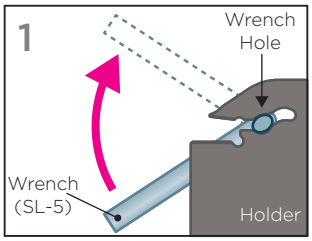
Recommended Cutting Conditions

Work Material	Cutting Speed vc (m/min)			
	AC830P	AC1030U	AC5015S	AC5025S
P Carbon Steel / Alloy Steel	80-200	50-200	80-200	50-200
M Stainless Steel	70-150	50-150	70-150	50-150
K Cast Iron	—	50-200	60-200	50-200
S Exotic Alloy	—	20- 60	20- 80	20- 60
N Non-Ferrous Metal	—	150-300	—	—

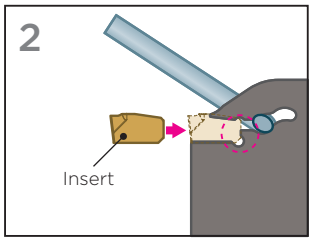
Chipbreaker		Feed Rate f (mm/rev)		
		Neutral		Handed
		GG	GF	CF
		General-purpose	Exotic Alloy/Low Cutting Force type	Low Cutting Force
Width of Cut CW (mm)	**2.0**	0.05-0.15	0.03-0.12	—
	3.0	0.08-0.25	0.05-0.15	0.05-0.10
	4.0	0.10-0.30	0.05-0.18	0.05-0.10
	5.0	0.10-0.30	0.05-0.20	—

Insert Mounting Method and Precautions (Steel Holder)

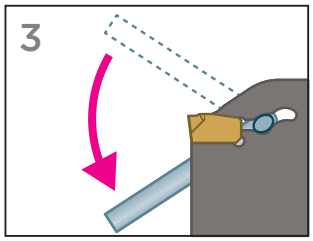
Insert Mounting



Insert the wrench into the wrench hole above and rotate it in the direction of the arrow

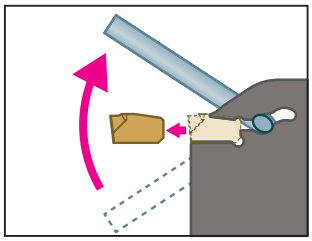


Push in the insert until its back touches the backstop of the holder



Rotate the wrench in the direction of the arrow to complete mounting

Insert Removal



Perform step 1 on the left to remove the insert

■ Insert Mounting Precautions

- Remove any chips or other foreign matter on the insert and holder seats.
- To prevent breakage, do not insert the wrench anywhere else but the wrench hole.
- To prevent breakage, do not use anything but the dedicated wrench (sold separately).
- To extend tool life, lubricate the wrench and the wrench hole with oil, etc.

● mark: Standard stocked item (new product/expanded item)

GLC-C type

New Cut-off Carbide

For Cut-off
(Carbide Holder/Tool Block type)

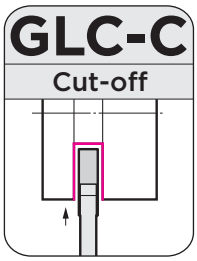


Fig 1

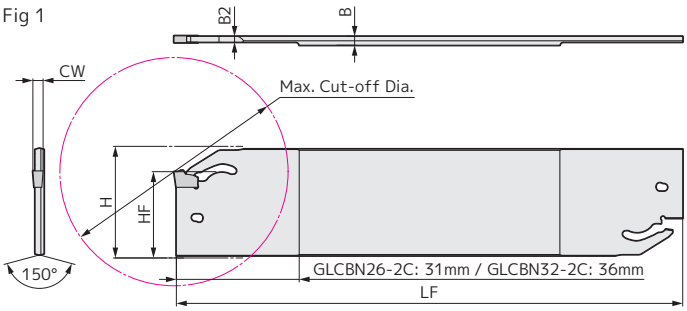
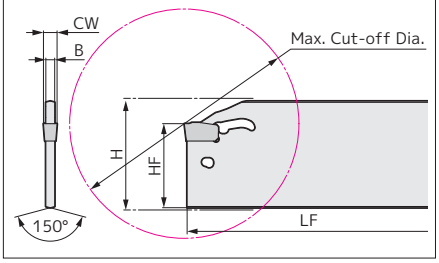


Fig 2



Holder

Parts Dimensions (mm)

Cat. No.	Stock	Height H	Width B	Width B2	Overall Length LF	Cutting Edge Height HF	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Applicable Tool Blocks	Fig	Wrench
GLCB N26-2C	●	26	2.6	1.7	120.0	21.4	**2**	**60**	WCF□2-□□	SB□20-26	1	SL-2(*)
N26-3C	●	26	2.6	—	120.0	21.4	**3**	**80**	WCF□3-□□		2	SL-6(*)
N26-4C	●	26	3.6	—	120.0	21.4	**4**	**80**	WCF□4-□□		2	
N26-5C	●	26	4.6	—	120.0	21.4	**5**	**80**	WCF□5-□□		2	
GLCB N32-2C	●	32	2.6	1.7	148.8	25.0	**2**	**68**	WCF□2-□□	SB□20-32 SB□25-32	1	SL-2(*)
N32-3C	●	32	2.6	—	148.8	25.0	**3**	**140**	WCF□3-□□		2	SL-6(*)
N32-4C	●	32	3.6	—	148.8	25.0	**4**	**140**	WCF□4-□□		2	
N32-5C	●	32	4.6	—	148.8	25.0	**5**	**140**	WCF□5-□□		2	

*Wrench is sold separately from the main body.
Refer to page F77 for applicable inserts.

Tool Blocks F78

● mark: Standard stocked item (new product/expanded item)

GLC-C type

Expansion

(Coated Carbide)

Fig 1 (Neutral (N))

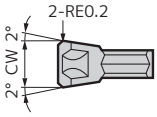


Fig 2 (Right Hand (R))

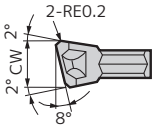
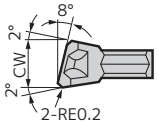
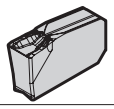
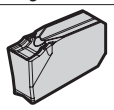
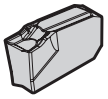


Fig 3 (Left Hand (L))



Insert for GLC type (Common)

Dimensions (mm)

Appearance	Cat. No.	AC830P	AC1030U	AC5015S	AC5025S	Width of Cut CW	Applicable Holder	Fig
WCF NO-GG General-purpose 	**WCF N2-GG**	●	●	●	●	**2.0**	GLCBNOO-2...	1
	WCF N3-GG	●	●	●	●	**3.0**	GLCBNOO-3...	1
	WCF N4-GG	●	●	●	●	**4.0**	GLCBNOO-4...	1
	WCF N5-GG	●	●	●	●	**5.0**	GLCBNOO-5...	1
WCF NO-GF Exotic Alloy Low Feed 	**WCF N2-GF**		●	●	●	**2.0**	GLCBNOO-2...	1
	WCF N3-GF		●	●	●	**3.0**	GLCBNOO-3...	1
	WCF N4-GF		●	●	●	**4.0**	GLCBNOO-4...	1
	WCF N5-GF		●	●	●	**5.0**	GLCBNOO-5...	1
WCF □O-CF Exotic Alloy Low Feed (Handed) 	**WCF R3-CF**		●	●	●	**3.0**	GLCBNOO-3...	2
	WCF L3-CF		●	●	●	**3.0**		3
	WCF R4-CF		●	●	●	**4.0**	GLCBNOO-4...	2
	WCF L4-CF		●	●	●	**4.0**		3

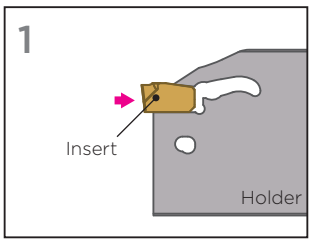
Recommended Cutting Conditions

Work Material	Cutting Speed vc (m/min)			
	AC830P	AC1030U	AC5015S	AC5025S
P Carbon Steel / Alloy Steel	80-200	50-200	80-200	50-200
M Stainless Steel	70-150	50-150	70-150	50-150
K Cast Iron	—	50-200	60-200	50-200
S Exotic Alloy	—	20- 60	20- 80	20- 60
N Non-Ferrous Metal	—	150-300	—	—

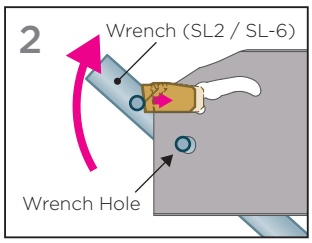
Chipbreaker		Feed Rate f (mm/rev)		
		Neutral		Handed
		GG	GF	CF
		General-purpose	Exotic Alloy/Low Cutting Force type	Low Cutting Force
Width of Cut CW (mm)	**2.0**	0.05-0.15	0.03-0.12	—
	3.0	0.08-0.25	0.05-0.15	0.05-0.10
	4.0	0.10-0.30	0.05-0.18	0.05-0.10
	5.0	0.10-0.30	0.05-0.20	—

Insert Mounting Method and Precautions (Carbide Holder)

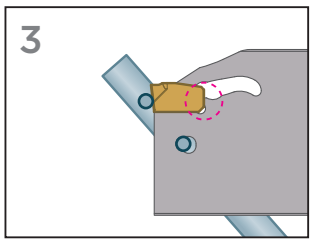
Insert Mounting



Gently put the insert into the holder

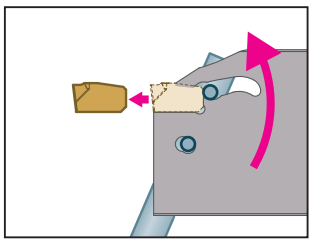


Insert the wrench into the wrench hole as shown and push in the insert from the front while rotating it in the direction of the arrow



Push in the insert until its back touches the backstop of the holder to complete mounting

Insert Removal

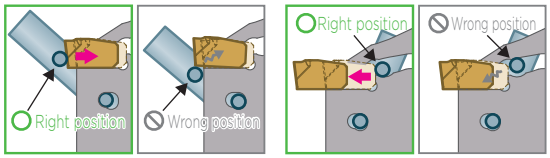


Insert the wrench into the wrench hole as shown and push out the insert from the back while rotating it in the direction of the arrow

■ Insert Mounting Precautions

- Remove any chips or other foreign matter on the insert and holder seats.
- To prevent holder breakage, check that the wrench is in the correct position.
- To prevent breakage, do not use anything but the dedicated wrench (sold separately).
- When removing the insert, the wrench will contact the clamp portion of the holder; do not apply excessive force to the holder after contact is made.

Check that the wrench is in the correct position



When mounting insert

When removing insert

● mark: Standard stocked item (new product/expanded item)

GLC series

Fig 1

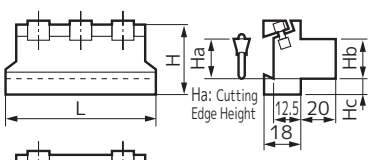


Fig 2

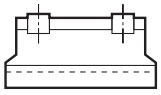


Fig 1

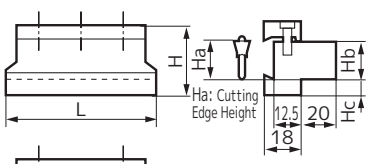
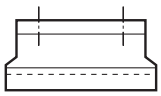


Fig 2



Tool Block SBN type (Integrated) Parts

Dimensions (mm)

Cat. No.	Stock	Cutting Edge Height Ha	Mounting Length Hb	Mounting Position Hc	Height H	Overall Length L	Fig	Clamp Plate	Double Screw	Wrench
SBN 20-26	●	20	20	10.0	45	80	2	BWS30	WB8-20	LH040
20-32	●	20	20	13.5	50	100	1			
25-32	●	25	25	8.5	50	110	1			

Tool Block SBU type (Split type) Parts

Dimensions (mm)

Cat. No.	Stock	Cutting Edge Height Ha	Mounting Length Hb	Mounting Position Hc	Height H	Overall Length L	Fig	Clamp Wedge (BCS15 / BCS20 / BCS25)	Cap Screw	Wrench
SBU 20-26	●	20	20	10.0	45	80	2	BCS15	BX0622	LH050
20-32	●	20	20	13.5	50	100	1	BCS20		
25-32	●	25	25	8.5	50	110	1	BCS25		

Fig 1

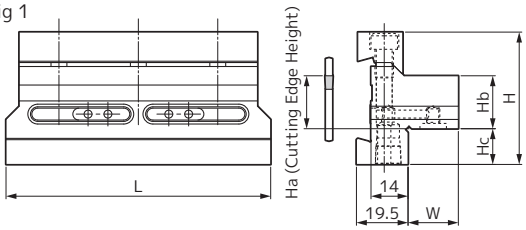
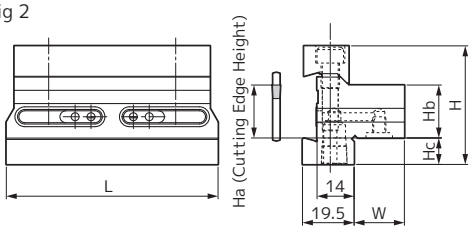


Fig 2



Tool Block for Internal Coolant Supply SBU-J type (Split type) Parts

Dimensions (mm)

Cat. No.	Stock	Cutting Edge Height Ha	Mounting Length Hb	Mounting Position Hc	Height H	Width W	Overall Length L	Fig	Clamp Wedge (BCS15 / BCS20 / BCS25)	O-ring	Cap Screw	Set Screw	Wrench	Plug
SBU 20-26J New	○	20	20	10	45	19	80	2	BCS15	ID210W1	BX0622	BT0506	LH050	XP02
20-32J New	○	20	20	13.5	50	19	100	1	BCS20	ID255W1				
25-32J New	○	25	25	8.5	50	23	110	1	BCS25	ID280W1				

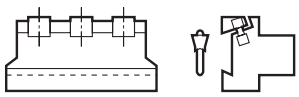
For Internal Coolant Supply Supported Holder GLC-SJ type.

Piping Method and Precautions F73

Tool Block type Selection Guide

Integrated type

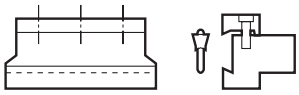
SBN type Example: SBN20-32



· Applicable to toolpost shown on the right **A**.

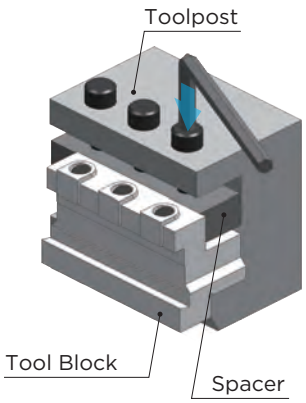
Split type

SBU(-J) type Example: SBU20-32



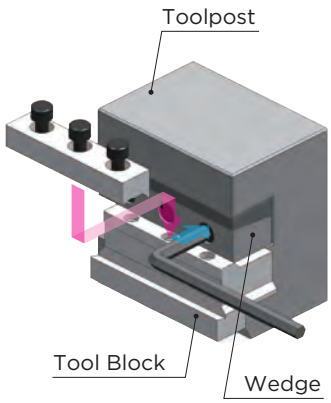
· Applicable to toolpost shown on the right **A** **B**.
· Large clamp plate ensures a wide clamp area that enables long holder overhang.

A General-purpose Lathe, etc.
SBN type | SBU(-J) type



(Clamp from above)

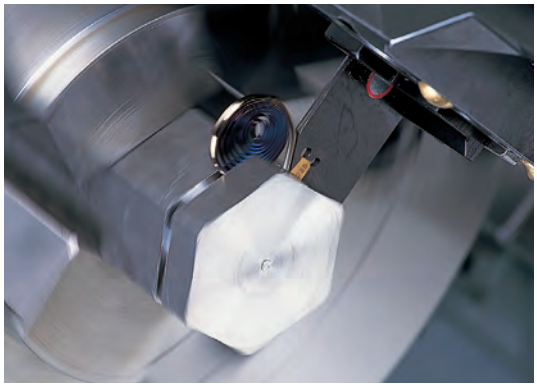
B Turret type Toolpost, etc.
SBU(-J) type



(Clamp from the side)

○ mark: Planned stock (around autumn 2025)

SumiGrip



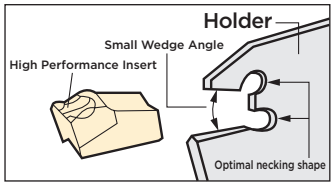
■ Features

- Available in carbide holder (SumiGrip) and steel holder (SumiGrip Jr.)
- Capable of interrupted cutting
- Can be used for cut-off, grooving, chamfering, etc.

■ Types

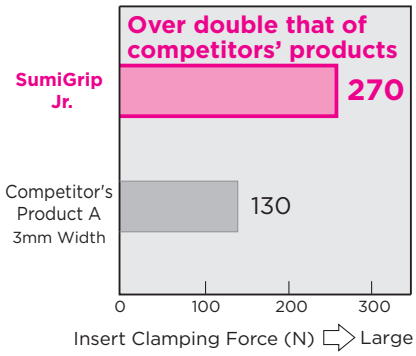
(1) Tool Block type
STFH type (Steel)/
WCFH type (Carbide)

(2) Shank type
STFS type (Steel)/
WCFS type (Carbide)

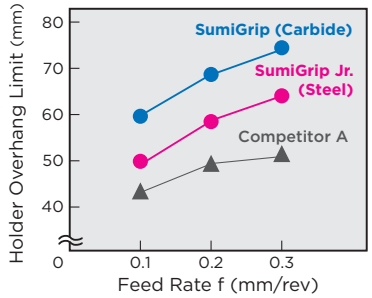


■ Cutting Performance (Holder)

● Insert Clamping Force

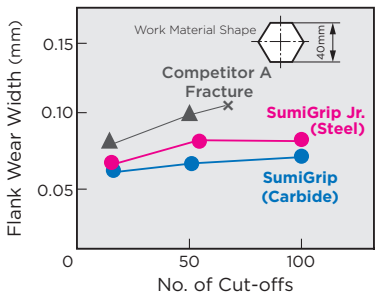


● Holder Overhang



Work Material: S45C (ø50mm, 250HB)
Cutting Conditions: vc = 80m/min Dry

● Wear Resistance



Work Material: S45C (Hex), Insert: 3mm Width Coated
Cutting Conditions: vc = 150m/min, f = 0.15mm/rev
Wet (Water Soluble)

■ GG type / GF type / CF type Chipbreaker + AC1030U

- The grooving tool holder GND series offers several chipbreakers for excellent chip control.
- Low cutting force chipbreaker GF type (neutral) or CF type (handed) inserts, coupled with a carbide holder, enable stable machining and prevent chattering even when machining stainless steel.
- Achieving long and stable tool life with the AC1030U grade.

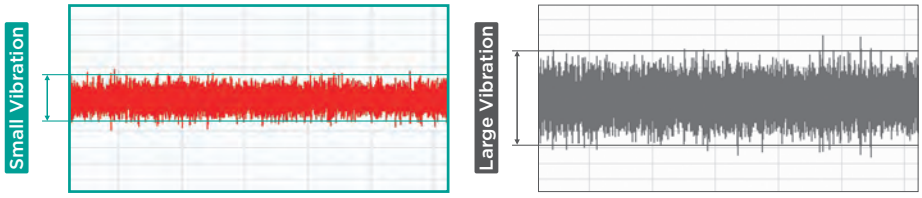
■ Cutting Performance (Chipbreaker)

● Chip Control (Performance)

GF type | GG type | Conventional Tool

Work Material: S45C (ø40mm)
3.0mm Width Cut-off
Cutting Conditions: vc = 100m/min
f = 0.1mm/rev
Wet

● Anti-Vibration Performance



GF type | Conventional Tool

Work Material: SUS316 (ø40mm)
3.0mm Width Cut-off
Cutting Conditions: vc = 100m/min
f = 0.1mm/rev
Wet

STFH type

Cut-off

Cut-off
(Steel Holder/Tool Block type)

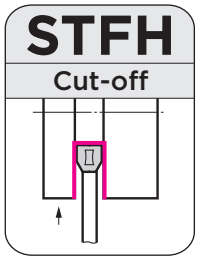
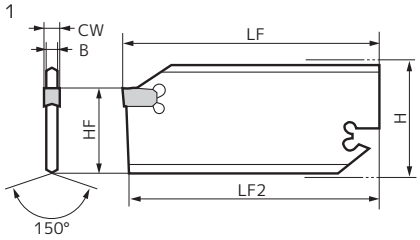
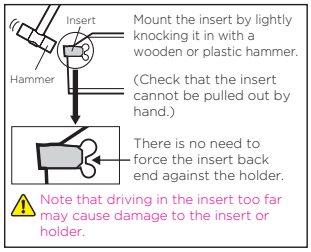


Fig 1



● Insert Mounting Method



Holder

Parts Dimensions (mm)

Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge Height HF	Reference Length LF2	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Applicable Tool Blocks	Fig	Wrench
STFH 26-2	▲	26	1.6	109	21.4	108	**2.0**	**40**	WCFO2□	SBN 20-26 SBU 20-26	1	SL-4
26-3	▲	26	2.4	109	21.4	108	**3.0**	**70**	WCFO3□		1	
26-4	▲	26	3.4	109	21.4	108	**4.0**	**70**	WCFO4□		1	
26-5	▲	26	4.3	109	21.4	108	**5.0**	**70**	WCFO5□		1	
STFH 32-2	▲	32	1.6	149	25.0	148	**2.0**	**40**	WCFO2□	SBN 20-32 SBN 25-32 SBU 20-32 SBU 25-32	1	SL-4
32-3	▲	32	2.4	149	25.0	148	**3.0**	**100**	WCFO3□		1	
32-4	▲	32	3.4	149	25.0	148	**4.0**	**100**	WCFO4□		1	
32-5	▲	32	4.3	149	25.0	148	**5.0**	**100**	WCFO5□		1	

*The shape of STFH32-2 is slightly different from the above figure. Refer to page F81 for applicable inserts.

Fig 1

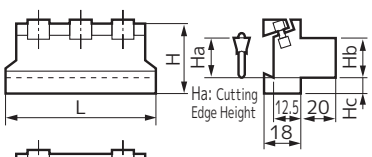


Fig 2

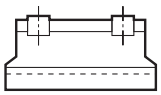


Fig 1

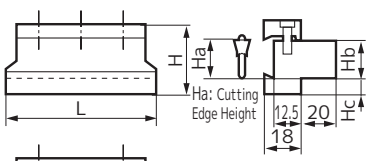
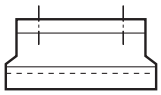


Fig 2



Tool Block SBN type (Integrated) Parts

Dimensions (mm)

Cat. No.	Stock	Cutting Edge Height Ha	Mounting Length Hb	Mounting Position Hc	Height H	Overall Length L	Fig	Clamp Plate	Double Screw	Wrench
SBN 20-26	●	20	20	10.0	45	80	2	BWS30	WB8-20	LH040
20-32	●	20	20	13.5	50	100	1			
25-32	●	25	25	8.5	50	110	1			

Tool Block SBU type (Split type) Parts

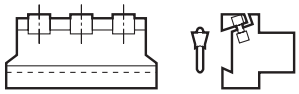
Dimensions (mm)

Cat. No.	Stock	Cutting Edge Height Ha	Mounting Length Hb	Mounting Position Hc	Height H	Overall Length L	Fig	Clamp Wedge (BCS15, BCS20, BCS25)	Cap Screw	Wrench
SBU 20-26	●	20	20	10.0	45	80	2	BCS15	BX0622	LH050
20-32	●	20	20	13.5	50	100	1	BCS20		
25-32	●	25	25	8.5	50	110	1	BCS25		

Tool Block type Selection Guide

Integrated type

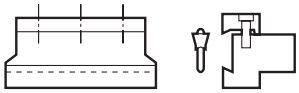
SBN type Example: SBN20-32



· Applicable to toolpost shown on the right **A**.

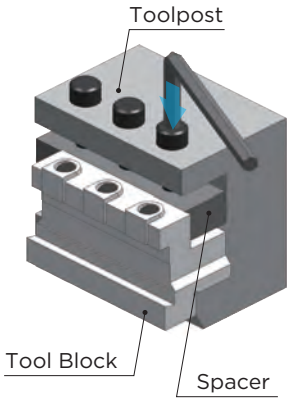
Split type

SBU type Example: SBU20-32



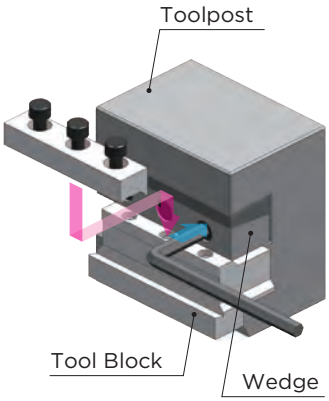
· Applicable to toolpost shown on the right **A** **B**.
· Large clamp plate ensures a wide clamp area that enables long holder overhang.

A General-purpose Lathe, etc.
SBN type | SBU type



(Clamp from above)

B Turret type Toolpost, etc.
SBU type



(Clamp from the side)

▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability)

STFH type

Expansion

Fig 1 (Neutral (N))

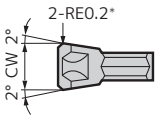


Fig 2 (Right Hand (R))

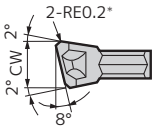
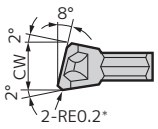


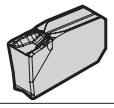
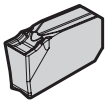
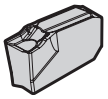
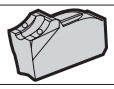
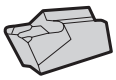
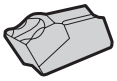
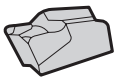
Fig 3 (Left Hand (L))



*WCF□ 2T: 2-RE0.15

Inserts for STFH (SumiGrip / SumiGrip Jr. common) (Coated Carbide / Cermet / Cemented Carbide)

Dimensions (mm)

Appearance	Cat. No.	AC830P	AC225	AC5015S	AC5025S	AC1030U	T1500A	A30	G10E	Width of Cut CW	Applicable Holder	Fig
WCF N○-GG General-purpose 	**WCF N2-GG**	●	—	●	●	●	—	—	—	**2.0**	STFH ○○-2	1
	WCF N3-GG	●	—	●	●	●	—	—	—	**3.0**	STFH ○○-3	1
	WCF N4-GG	●	—	●	●	●	—	—	—	**4.0**	STFH ○○-4	1
	WCF N5-GG	●	—	●	●	●	—	—	—	**5.0**	STFH ○○-5	1
WCF N○-GF Exotic Alloy Low Feed 	**WCF N2-GF**		—	●	●	●	—	—	—	**2.0**	STFH ○○-2	1
	WCF N3-GF		—	●	●	●	—	—	—	**3.0**	STFH ○○-3	1
	WCF N4-GF		—	●	●	●	—	—	—	**4.0**	STFH ○○-4	1
	WCF N5-GF		—	●	●	●	—	—	—	**5.0**	STFH ○○-5	1
WCF □○-CF Exotic Alloy Low Feed (Handed) 	**WCF R3-CF**		—	●	●	●	—	—	—	**3.0**	STFH ○○-3	2
	WCF L3-CF		—	●	●	●	—	—	—	**3.0**		3
	WCF R4-CF		—	●	●	●	—	—	—	**4.0**	STFH ○○-4	2
	WCF L4-CF		—	●	●	●	—	—	—	**4.0**		3
WCF □2T Small Diameter Low Cutting Force 	**WCF N2T**	●	—	—	—	—	—	—	—	**2.0**	STFH ○○-2	1
	WCF R2T	●	—	—	—	—	—	—	—	**2.0**		2
	WCF L2T	●	—	—	—	—	—	—	—	**2.0**		3
WCF □○ No Chipbreaker For General Steel 	**WCF N3**	●	—	—	—	—	—	—	—	**3.0**	STFH ○○-3	1
	WCF R3	●	—	—	—	—	—	—	—	**3.0**		2
	WCF L3	●	—	—	—	—	—	—	—	**3.0**		3
	WCF N4	●	—	—	—	—	—	—	—	**4.0**	STFH ○○-4	1
	WCF R4	●	—	—	—	—	—	—	—	**4.0**		2
	WCF L4	●	—	—	—	—	—	—	—	**4.0**		3
	WCF N5	●	—	—	—	—	—	—	—	**5.0**	STFH ○○-5	1
	WCF R5	●	—	—	—	—	—	—	—	**5.0**		2
	WCF L5	●	—	—	—	—	—	—	—	**5.0**		3
WCF □○A Exotic Alloy Low Feed 	**WCF N2A**		●	—	—	—	—			**2.0**	STFH ○○-2	1
	WCF N3A		●	—	—	—	●	●	●	**3.0**	STFH ○○-3	1
	WCF R3A		●	—	—	—		●		**3.0**		2
	WCF L3A		●	—	—	—	—			**3.0**		3
	WCF N4A		●	—	—	—	●			**4.0**	STFH ○○-4	1
	WCF R4A		●	—	—	—	—			**4.0**		2
	WCF L4A		●	—	—	—	—			**4.0**		3
	WCF N5A		●	—	—	—	—			**5.0**	STFH ○○-5	1
	WCF R5A		—	—	—	—	—			**5.0**		2
	WCF L5A		—	—	—	—	—			**5.0**		3
WCF □○B Cast Iron Light Alloys 	**WCF N3B**		—	—	—	—	—	—	●	**3.0**	STFH ○○-3	1
	WCF R3B		—	—	—	—	—	—	●	**3.0**		2
	WCF L3B		—	—	—	—	—	—	●	**3.0**		3
	WCF N4B		—	—	—	—	—	—	●	**4.0**	STFH ○○-4	1
	WCF R4B		—	—	—	—	—	—	●	**4.0**		2
	WCF L4B		—	—	—	—	—	—		**4.0**		3
*Same chipbreaker shape as the type for general steel (WCF□○), but with smaller cutting edge treatment.	**WCF N5B**		—	—	—	—	—	—	●	**5.0**	STFH ○○-5	1
	WCF R5B		—	—	—	—	—	—		**5.0**		2
	WCF L5B		—	—	—	—	—	—	●	**5.0**		3

Recommended Cutting Conditions

Work Material	Cutting Speed vc (m/min)							
	Coated Carbide					Cermet	Cemented Carbide	
	AC830P	AC5015S	AC5025S	AC225	AC1030U	T1500A	A30	G10E
P Carbon Steel / Alloy Steel	80-200	80-200	50-200	80-200	50-200	80-200	50-120	—
M Stainless Steel	70-150	70-150	50-150	60-150	50-150	—	70-130	—
K Cast Iron	—	60-200	50-200	—	50-200	—	—	50-120
N Non-Ferrous Metal	—	—	—	—	200-500	—	—	200-500

Chipbreaker		Feed Rate f (mm/rev)										
		Neutral						Handed				
		GG	GF	No Chipbreaker	T	A	B	No Chipbreaker	CF	T	A	B
		General-purpose	Exotic Alloy/Low Cutting Force type	General Steel	Small Diameter/ Low Cutting Force	Exotic Alloy/Low Feed	Cast Iron/Light Alloys	General Steel	Exotic Alloy/Low Cutting Force type	Small Diameter/ Low Cutting Force	Exotic Alloy/Low Feed	Cast Iron/Light Alloys
Width of Cut CW (mm)	**2.0**	0.05-0.20	0.03-0.12	—	0.03-0.10	0.03-0.12	—	—	—	0.03-0.10	—	—
	3.0	0.08-0.25	0.04-0.15	0.08-0.25	—	0.04-0.15	0.05-0.15	0.08-0.25	0.05-0.12	—	0.04-0.15	0.05-0.15
	4.0	0.10-0.30	0.05-0.18	0.10-0.30	—	0.05-0.18	0.05-0.18	0.10-0.30	0.05-0.12	—	0.05-0.18	0.05-0.18
	5.0	0.10-0.35	0.05-0.20	0.10-0.30	—	0.05-0.20	0.06-0.20	0.10-0.30	—	—	—	0.06-0.20

● mark: Standard stocked item (new product/expanded item)

STFS type

Cut-off

For Cut-off
(Steel Holder/Shank type)

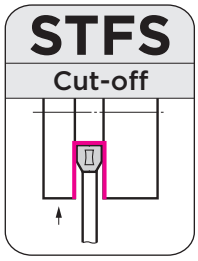


Fig 1

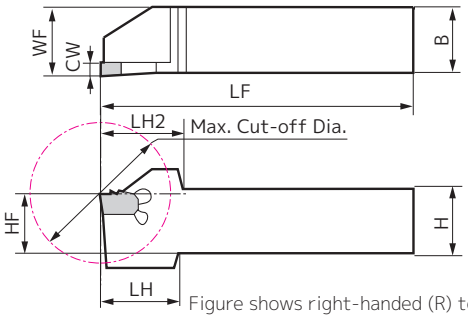
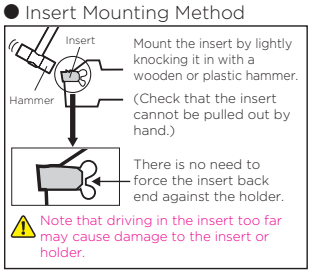


Figure shows right-handed (R) tool.

● Insert Mounting Method



Holder

Parts Dimensions (mm)

Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Head LH	Head LH2	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Fig	Wrench
STFS R/L1010-2	●	●	10	10	86	10	10	17	17	**2.0**	**28**	WCF○2□	1	SL-4
R/L1212-2	●	●	12	12	110	12	12	18	18	**2.0**	**30**		1	
R/L1616-2	●	●	16	16	110	16	16	—	19	**2.0**	**32**		1	
R/L2020-2	●	●	20	20	125	20	20	—	24	**2.0**	**40**		1	
STFS R/L1616-3	●	●	16	16	110	16	16	20	22	**3.0**	**35**	WCF○3□	1	SL-4
R/L2012-3	●	●	20	12	110	12	20	—	24	**3.0**	**40**		1	
R/L2020-3	●	●	20	20	125	20	20	—	30	**3.0**	**50**		1	
R/L2525-3	●	●	25	25	150	25	25	—	30	**3.0**	**50**		1	
STFS R/L2020-4	●	●	20	20	125	20	20	—	33	**4.0**	**55**	WCF○4□	1	SL-4
R/L2525-4	●	●	25	25	150	25	25	—	38	**4.0**	**65**		1	
STFS R/L2020-5	●	●	20	20	125	20	20	—	35	**5.0**	**60**	WCF○5□	1	SL-4
R/L2525-5	●	●	25	25	150	25	25	—	40	**5.0**	**70**		1	

Refer to page F83 for applicable inserts.

STFS type

Expansion

Fig 1 (Neutral (N))

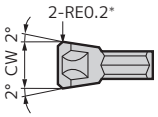


Fig 2 (Right Hand (R))

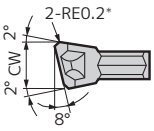
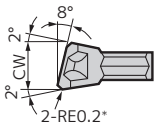


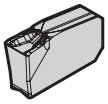
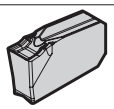
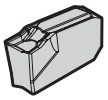
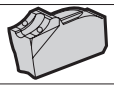
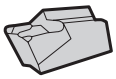
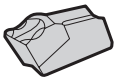
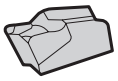
Fig 3 (Left Hand (L))



*WCF□ 2T: 2-RE0.15

Inserts for STFS (SumiGrip / SumiGrip Jr. common) (Coated Carbide / Cermet / Cemented Carbide)

Dimensions (mm)

Appearance	Cat. No.	AC830P	AC225	AC5015S	AC5025S	AC1030U	T1500A	A30	G10E	Width of Cut CW	Applicable Holder	Fig
WCF NO-GG General-purpose 	**WCF N2-GG**	●	—	●	●	●	—	—	—	**2.0**	STFS R/LOOOO-2	1
	WCF N3-GG	●	—	●	●	●	—	—	—	**3.0**	STFS R/LOOOO-3	1
	WCF N4-GG	●	—	●	●	●	—	—	—	**4.0**	STFS R/LOOOO-4	1
	WCF N5-GG	●	—	●	●	●	—	—	—	**5.0**	STFS R/LOOOO-5	1
WCF NO-GF Exotic Alloy Low Feed 	**WCF N2-GF**		—	●	●	●	—	—	—	**2.0**	STFS R/LOOOO-2	1
	WCF N3-GF		—	●	●	●	—	—	—	**3.0**	STFS R/LOOOO-3	1
	WCF N4-GF		—	●	●	●	—	—	—	**4.0**	STFS R/LOOOO-4	1
	WCF N5-GF		—	●	●	●	—	—	—	**5.0**	STFS R/LOOOO-5	1
WCF □O-CF Exotic Alloy Low Feed (Handed) 	**WCF R3-CF**		—	●	●	●	—	—	—	**3.0**	STFS R/LOOOO-3	2
	WCF L3-CF		—	●	●	●	—	—	—	**3.0**		3
	WCF R4-CF		—	●	●	●	—	—	—	**4.0**	STFS R/LOOOO-4	2
	WCF L4-CF		—	●	●	●	—	—	—	**4.0**		3
WCF □2T Small Diameter Low Cutting Force 	**WCF N2T**	●	—	—	—	—	—	—	—	**2.0**	STFS R/LOOOO-2	1
	WCF R2T	●	—	—	—	—	—	—	—	**2.0**		2
	WCF L2T	●	—	—	—	—	—	—	—	**2.0**		3
WCF □O No Chipbreaker For General Steel 	**WCF N3**	●	—	—	—	—	—	—	—	**3.0**	STFS R/LOOOO-3	1
	WCF R3	●	—	—	—	—	—	—	—	**3.0**		2
	WCF L3	●	—	—	—	—	—	—	—	**3.0**		3
	WCF N4	●	—	—	—	—	—	—	—	**4.0**	STFS R/LOOOO-4	1
	WCF R4	●	—	—	—	—	—	—	—	**4.0**		2
	WCF L4	●	—	—	—	—	—	—	—	**4.0**		3
	WCF N5	●	—	—	—	—	—	—	—	**5.0**	STFS R/LOOOO-5	1
	WCF R5	●	—	—	—	—	—	—	—	**5.0**		2
	WCF L5	●	—	—	—	—	—	—	—	**5.0**		3
WCF □OA Exotic Alloy Low Feed 	**WCF N2A**		●	—	—	—	—			**2.0**	STFS R/LOOOO-2	1
	WCF N3A		●	—	—	—	●	●	●	**3.0**	STFS R/LOOOO-3	1
	WCF R3A		●	—	—	—		●		**3.0**		2
	WCF L3A		●	—	—	—	—			**3.0**		3
	WCF N4A		●	—	—	—	●			**4.0**	STFS R/LOOOO-4	1
	WCF R4A		●	—	—	—	—			**4.0**		2
	WCF L4A		●	—	—	—	—			**4.0**		3
	WCF N5A		●	—	—	—	—			**5.0**	STFS R/LOOOO-5	1
	WCF R5A		—	—	—	—	—			**5.0**		2
	WCF L5A		—	—	—	—	—			**5.0**		3
WCF □OB Cast Iron Light Alloys 	**WCF N3B**		—	—	—	—	—	—	●	**3.0**	STFS R/LOOOO-3	1
	WCF R3B		—	—	—	—	—	—	●	**3.0**		2
	WCF L3B		—	—	—	—	—	—	●	**3.0**		3
	WCF N4B		—	—	—	—	—	—	●	**4.0**	STFS R/LOOOO-4	1
	WCF R4B		—	—	—	—	—	—	●	**4.0**		2
	WCF L4B		—	—	—	—	—	—		**4.0**		3
*Same chipbreaker shape as the type for general steel (WCF□O), but with smaller cutting edge treatment.	**WCF N5B**		—	—	—	—	—	—	●	**5.0**	STFS R/LOOOO-5	1
	WCF R5B		—	—	—	—	—	—		**5.0**		2
	WCF L5B		—	—	—	—	—	—	●	**5.0**		3

Recommended Cutting Conditions

Work Material	Cutting Speed vc (m/min)							
	Coated Carbide					Cermet	Cemented Carbide	
	AC830P	AC5015S	AC5025S	AC225	AC1030U	T1500A	A30	G10E
P Carbon Steel / Alloy Steel	80-200	80-200	50-200	80-200	50-200	80-200	50-120	—
M Stainless Steel	70-150	70-150	50-150	60-150	50-150	—	70-130	—
K Cast Iron	—	60-200	50-200	—	50-200	—	—	50-120
N Non-Ferrous Metal	—	—	—	—	200-500	—	—	200-500

Chipbreaker		Feed Rate f (mm/rev)										
		Neutral						Handed				
		GG	GF	No Chipbreaker	T	A	B	No Chipbreaker	CF	T	A	B
		General-purpose	Exotic Alloy/Low Cutting Force type	General Steel	Small Diameter/ Low Cutting Force	Exotic Alloy/Low Feed	Cast Iron/Light Alloys	General Steel	Exotic Alloy/Low Cutting Force type	Small Diameter/ Low Cutting Force	Exotic Alloy/Low Feed	Cast Iron/Light Alloys
Width of Cut CW (mm)	**2.0**	0.05-0.20	0.03-0.12	—	0.03-0.10	0.03-0.12	—	—	—	0.03-0.10	—	—
	3.0	0.08-0.25	0.04-0.15	0.08-0.25	—	0.04-0.15	0.05-0.15	0.08-0.25	0.05-0.12	—	0.04-0.15	0.05-0.15
	4.0	0.10-0.30	0.05-0.18	0.10-0.30	—	0.05-0.18	0.05-0.18	0.10-0.30	0.05-0.12	—	0.05-0.18	0.05-0.18
	5.0	0.10-0.35	0.05-0.20	0.10-0.30	—	0.05-0.20	0.06-0.20	0.10-0.30	—	—	—	0.06-0.20

● mark: Standard stocked item (new product/expanded item)

WCFH type

Cut-off

For Cut-off
(Carbide Holder/Tool Block type)

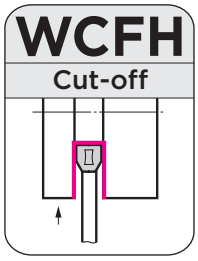
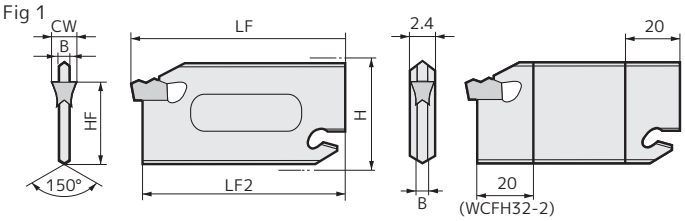
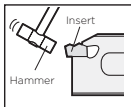


Fig 1



● Insert Mounting Method



Mount the insert by lightly knocking it in with a wooden or plastic hammer.
(Check that the insert cannot be pulled out by hand.)

⚠ Note that driving in the insert too far may cause damage to the insert or holder.

Holder

Parts Dimensions (mm)

Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge Height HF	Reference Length LF2	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Applicable Tool Blocks	Fig	Wrench
WCFH 26-2	▲	26	1.7	110	21.4	109.0	**2.0**	**40**	WCF□2○	SBN 20-26 SBU 20-26	1	SL-2
26-3	▲	26	2.4	110	21.4	108.5	**3.0**	**80**	WCF□3○		1	SL-1
26-4	▲	26	3.4	110	21.4	108.5	**4.0**	**80**	WCF□4○		1	
26-5	▲	26	4.3	110	21.4	108.5	**5.0**	**80**	WCF□5○		1	
WCFH 32-2	▲	32	1.7	150	25.0	149.0	**2.0**	**40**	WCF□2○	SBN 20-32 SBN 25-32 SBU 20-32 SBU 25-32	1	SL-2
32-3	▲	32	2.4	150	25.0	148.5	**3.0**	**140**	WCF□3○		1	SL-1
32-4	▲	32	3.4	150	25.0	148.5	**4.0**	**140**	WCF□4○		1	
32-5	▲	32	4.3	150	25.0	148.5	**5.0**	**140**	WCF□5○		1	

Refer to page F85 for applicable inserts.

Fig 1

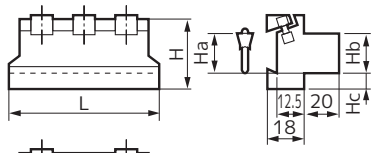


Fig 2

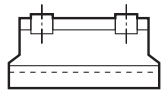


Fig 1

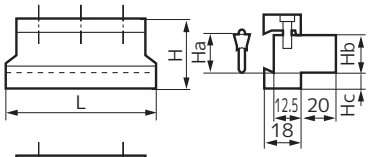
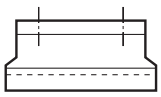


Fig 2



Tool Block SBN type (Integrated) Parts

Dimensions (mm)

Cat. No.	Stock	Cutting Edge Height Ha	Mounting Length Hb	Mounting Position Hc	Height H	Overall Length L	Fig	Clamp Plate	Double Screw	Wrench
SBN 20-26	●	20	20	10.0	45	80	2	BWS30	WB8-20	LH040
20-32	●	20	20	13.5	50	100	1			
25-32	●	25	25	8.5	50	110	1			

Tool Block SBU type (Split type) Parts

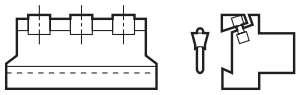
Dimensions (mm)

Cat. No.	Stock	Cutting Edge Height Ha	Mounting Length Hb	Mounting Position Hc	Height H	Overall Length L	Fig	Clamp Wedge (BCS15 / BCS20 / BCS25)	Cap Screw	Wrench
SBU 20-26	●	20	20	10.0	45	80	2	BCS15	BX0622	LH050
20-32	●	20	20	13.5	50	100	1	BCS20		
25-32	●	25	25	8.5	50	110	1	BCS25		

Tool Block type Selection Guide

Integrated type

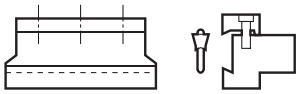
SBN type Example: SBN20-32



· Applicable to toolpost shown on the right **A**.

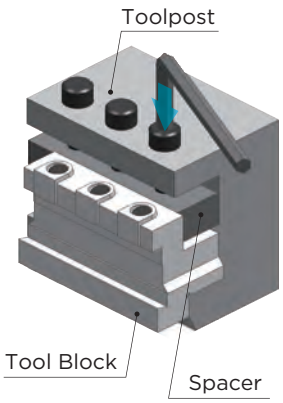
Split type

SBU type Example: SBU20-32



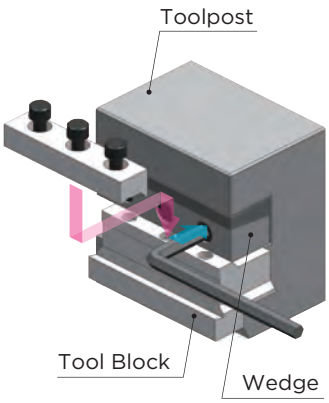
· Applicable to toolpost shown on the right **A** **B**.
· Large clamp plate ensures a wide clamp area that enables long holder overhang.

A General-purpose Lathe, etc.
SBN type | SBU type



(Clamp from above)

B Turret type Toolpost, etc.
SBU type



(Clamp from the side)

▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability)

WCFH type

Expansion

Fig 1 (Neutral (N))

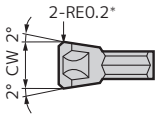


Fig 2 (Right Hand (R))

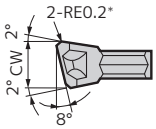
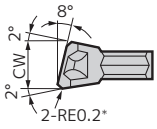


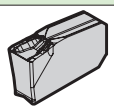
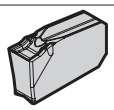
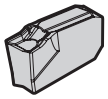
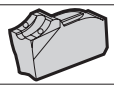
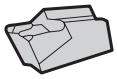
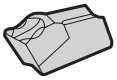
Fig 3 (Left Hand (L))



*WCF□ 2T: 2-RE0.15

Inserts for WCFH (SumiGrip / SumiGrip Jr. common) (Coated Carbide / Cermet / Cemented Carbide)

Dimensions (mm)

Appearance	Cat. No.	AC830P	AC225	AC5015S	AC5025S	AC1030U	T1500A	A30	G10E	Width of Cut CW	Applicable Holder	Fig
WCF NO-GG General-purpose 	**WCF N2-GG**	●	—	●	●	●	—	—	—	**2.0**	WCFH OO-2	1
	WCF N3-GG	●	—	●	●	●	—	—	—	**3.0**	WCFH OO-3	1
	WCF N4-GG	●	—	●	●	●	—	—	—	**4.0**	WCFH OO-4	1
	WCF N5-GG	●	—	●	●	●	—	—	—	**5.0**	WCFH OO-5	1
WCF NO-GF Exotic Alloy Low Feed 	**WCF N2-GF**		—	●	●	●	—	—	—	**2.0**	WCFH OO-2	1
	WCF N3-GF		—	●	●	●	—	—	—	**3.0**	WCFH OO-3	1
	WCF N4-GF		—	●	●	●	—	—	—	**4.0**	WCFH OO-4	1
	WCF N5-GF		—	●	●	●	—	—	—	**5.0**	WCFH OO-5	1
WCF □O-CF Exotic Alloy Low Feed (Handed) 	**WCF R3-CF**		—	●	●	●	—	—	—	**3.0**	WCFH OO-3	2
	WCF L3-CF		—	●	●	●	—	—	—	**3.0**		3
	WCF R4-CF		—	●	●	●	—	—	—	**4.0**	WCFH OO-4	2
	WCF L4-CF		—	●	●	●	—	—	—	**4.0**		3
WCF □2T Small Diameter Low Cutting Force 	**WCF N2T**	●	—	—	—	—	—	—	—	**2.0**	WCFH OO-2	1
	WCF R2T	●	—	—	—	—	—	—	—	**2.0**		2
	WCF L2T	●	—	—	—	—	—	—	—	**2.0**		3
WCF □O No Chipbreaker For General Steel 	**WCF N3**	●	—	—	—	—	—	—	—	**3.0**	WCFH OO-3	1
	WCF R3	●	—	—	—	—	—	—	—	**3.0**		2
	WCF L3	●	—	—	—	—	—	—	—	**3.0**		3
	WCF N4	●	—	—	—	—	—	—	—	**4.0**	WCFH OO-4	1
	WCF R4	●	—	—	—	—	—	—	—	**4.0**		2
	WCF L4	●	—	—	—	—	—	—	—	**4.0**		3
	WCF N5	●	—	—	—	—	—	—	—	**5.0**	WCFH OO-5	1
	WCF R5	●	—	—	—	—	—	—	—	**5.0**		2
	WCF L5	●	—	—	—	—	—	—	—	**5.0**		3
WCF □OA Exotic Alloy Low Feed 	**WCF N2A**		●	—	—	—	—			**2.0**	WCFH OO-2	1
	WCF N3A		●	—	—	—	●	●	●	**3.0**	WCFH OO-3	1
	WCF R3A		●	—	—	—		●		**3.0**		2
	WCF L3A		●	—	—	—	—			**3.0**		3
	WCF N4A		●	—	—	—	●			**4.0**	WCFH OO-4	1
	WCF R4A		●	—	—	—	—			**4.0**		2
	WCF L4A		●	—	—	—	—			**4.0**		3
	WCF N5A		●	—	—	—	—			**5.0**	WCFH OO-5	1
	WCF R5A		—	—	—	—	—			**5.0**		2
	WCF L5A		—	—	—	—	—			**5.0**		3
WCF □OB Cast Iron Light Alloys	**WCF N3B**		—	—	—	—	—	—	●	**3.0**	WCFH OO-3	1
	WCF R3B		—	—	—	—	—	—	●	**3.0**		2
	WCF L3B		—	—	—	—	—	—	●	**3.0**		3
	WCF N4B		—	—	—	—	—	—	●	**4.0**	WCFH OO-4	1
	WCF R4B		—	—	—	—	—	—	●	**4.0**		2
	WCF L4B		—	—	—	—	—	—		**4.0**		3
*Same chipbreaker shape as the type for general steel (WCF□O), but with smaller cutting edge treatment.	**WCF N5B**		—	—	—	—	—	—	●	**5.0**	WCFH OO-5	1
	WCF R5B		—	—	—	—	—	—		**5.0**		2
	WCF L5B		—	—	—	—	—	—	●	**5.0**		3

Recommended Cutting Conditions

Work Material	Cutting Speed vc (m/min)							
	Coated Carbide					Cermet	Cemented Carbide	
	AC830P	AC5015S	AC5025S	AC225	AC1030U	T1500A	A30	G10E
P Carbon Steel / Alloy Steel	80-200	80-200	50-200	80-200	50-200	80-200	50-120	—
M Stainless Steel	70-150	70-150	50-150	60-150	50-150	—	70-130	—
K Cast Iron	—	60-200	50-200	—	50-200	—	—	50-120
N Non-Ferrous Metal	—	—	—	—	200-500	—	—	200-500

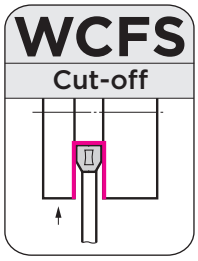
Chipbreaker		Feed Rate f (mm/rev)										
		Neutral						Handed				
		GG	GF	No Chipbreaker	T	A	B	No Chipbreaker	CF	T	A	B
		General-purpose	Exotic Alloy/Low Cutting Force type	General Steel	Small Diameter/ Low Cutting Force	Exotic Alloy/Low Feed	Cast Iron/Light Alloys	General Steel	Exotic Alloy/Low Cutting Force type	Small Diameter/ Low Cutting Force	Exotic Alloy/Low Feed	Cast Iron/Light Alloys
Width of Cut CW (mm)	**2.0**	0.05-0.20	0.03-0.12	—	0.03-0.10	0.03-0.12	—	—	—	0.03-0.10	—	—
	3.0	0.08-0.25	0.04-0.15	0.08-0.25	—	0.04-0.15	0.05-0.15	0.08-0.25	0.05-0.12	—	0.04-0.15	0.05-0.15
	4.0	0.10-0.30	0.05-0.18	0.10-0.30	—	0.05-0.18	0.05-0.18	0.10-0.30	0.05-0.12	—	0.05-0.18	0.05-0.18
	5.0	0.10-0.35	0.05-0.20	0.10-0.30	—	0.05-0.20	0.06-0.20	0.10-0.30	—	—	—	0.06-0.20

● mark: Standard stocked item (new product/expanded item)

WCFS type

Cut-off

For Cut-off
(Carbide Holder/Shank type)



Brazed Blade type

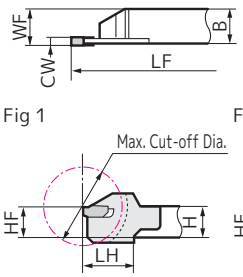


Fig 1 Fig 2

Blade Clamp type

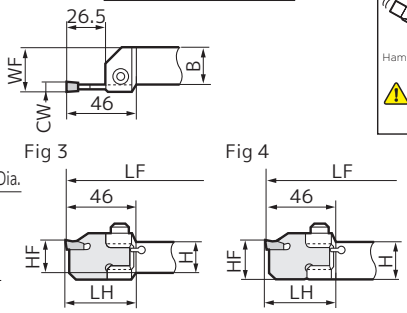
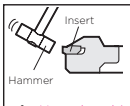


Fig 3 Fig 4

● Insert Mounting Method



Mount the insert by lightly knocking it in with a wooden or plastic hammer.
(Check that the insert cannot be pulled out by hand.)
⚠ Note that driving in the insert too far may cause damage to the insert or holder.

Figure shows right-handed (R) tool.

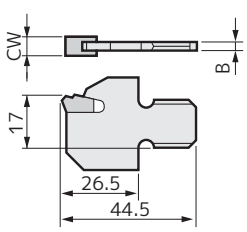
Holder

Parts Dimensions (mm)

Type	Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Height HF	Head LH	Width of Cut CW	Max. Cut-off Dia.	Applicable Blades	Applicable Insert	Fig	Wrench
Brazed type	**WCFS R/L1010-2**	●	●	10	10	86	10	10	**2.0**	**28**	—	WCF□2○	1	SL-2
	R/L1212-2	●	●	12	12	110	12	18	**2.0**	**30**	—	WCF□2○	1	
	R/L1616-2	●	●	16	16	100	16	25	**2.0**	**35**	—	WCF□2○	2	
	R/L1616-3	●	●	16	16	100	16	25	**3.0**	**35**	—	WCF□3○	2	SL-1
Clamp type	**WCFS R/L20-3**	●	●	20	20	125	20	46	**3.0**	**50**	WCFH17-3	WCF□3○	3	SL-1
	R/L20-4	●	●	20	20	125	20	46	**4.0**	**50**	WCFH17-4	WCF□4○	3	
	R/L20-5	●		20	20	125	20	46	**5.0**	**50**	WCFH17-5	WCF□5○	3	
	WCFS R/L25-3	●	●	25	25	150	25	46	**3.0**	**50**	WCFH17-3	WCF□3○	4	SL-1
	R/L25-4	●	●	25	25	150	25	46	**4.0**	**50**	WCFH17-4	WCF□4○	4	
	R/L25-5	●		25	25	150	25	46	**5.0**	**50**	WCFH17-5	WCF□5○	4	

Refer to page F87 for applicable inserts. Blade is included with the holder.

Fig 1



Blade

Dimensions (mm)

Cat. No.	Stock	Width of Cut CW	Width B	Applicable Holder
WCFH 17-3	●	**3**	2.4	WCFS R/L20-3,25-3
WCFH 17-4	●	**4**	3.4	WCFS R/L20-4,25-4
WCFH 17-5	●	**5**	4.3	WCFS R/L20-5,25-5

Parts

Applicable Holder	Cap Screw	Wrench
WCFS R/L20-○, WCFS R/L25-○	BX0622	LH050

WCFS type

Expansion

Fig 1 (Neutral (N))

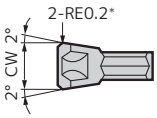


Fig 2 (Right Hand (R))

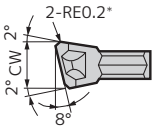
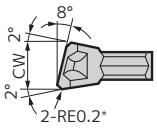


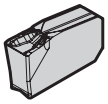
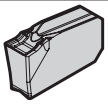
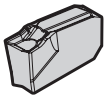
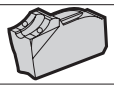
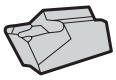
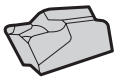
Fig 3 (Left Hand (L))



*WCF□ 2T: 2-RE0.15

Inserts for WCFS (SumiGrip / SumiGrip Jr. common) (Coated Carbide / Cermet / Cemented Carbide)

Dimensions (mm)

Appearance	Cat. No.	AC830P	AC225	AC5015S	AC5025S	AC1030U	T1500A	A30	G10E	Width of Cut CW	Applicable Holder	Fig
WCF N○-GG General-purpose 	**WCF N2-GG**	●	—	●	●	●	—	—	—	**2.0**	WCFS R/L○○○○-2	1
	WCF N3-GG	●	—	●	●	●	—	—	—	**3.0**	WCFS R/L○○○○-3,WCFS R/L○○-3	1
	WCF N4-GG	●	—	●	●	●	—	—	—	**4.0**	WCFS R/L○○-4	1
	WCF N5-GG	●	—	●	●	●	—	—	—	**5.0**	WCFS R/L○○-5	1
WCF N○-GF Exotic Alloy Low Feed 	**WCF N2-GF**		—	●	●	●	—	—	—	**2.0**	WCFS R/L○○○○-2	1
	WCF N3-GF		—	●	●	●	—	—	—	**3.0**	WCFS R/L○○○○-3,WCFS R/L○○-3	1
	WCF N4-GF		—	●	●	●	—	—	—	**4.0**	WCFS R/L○○-4	1
	WCF N5-GF		—	●	●	●	—	—	—	**5.0**	WCFS R/L○○-5	1
WCF □○-CF Exotic Alloy Low Feed (Handed) 	**WCF R3-CF**		—	●	●	●	—	—	—	**3.0**	WCFS R/L○○○○-3	2
	WCF L3-CF		—	●	●	●	—	—	—	**3.0**	WCFS R/L○○-3	3
	WCF R4-CF		—	●	●	●	—	—	—	**4.0**	WCFS R/L○○-4	2
	WCF L4-CF		—	●	●	●	—	—	—	**4.0**		3
WCF □2T Small Diameter Low Cutting Force 	**WCF N2T**	●	—	—	—	—	—	—	—	**2.0**	WCFS R/L○○○○-2	1
	WCF R2T	●	—	—	—	—	—	—	—	**2.0**		2
	WCF L2T	●	—	—	—	—	—	—	—	**2.0**		3
WCF □○ No Chipbreaker For General Steel 	**WCF N3**	●	—	—	—	—	—	—	—	**3.0**	WCFS R/L○○○○-3 WCFS R/L○○-3	1
	WCF R3	●	—	—	—	—	—	—	—	**3.0**		2
	WCF L3	●	—	—	—	—	—	—	—	**3.0**		3
	WCF N4	●	—	—	—	—	—	—	—	**4.0**	WCFS R/L○○-4	1
	WCF R4	●	—	—	—	—	—	—	—	**4.0**		2
	WCF L4	●	—	—	—	—	—	—	—	**4.0**		3
	WCF N5	●	—	—	—	—	—	—	—	**5.0**	WCFS R/L○○-5	1
	WCF R5	●	—	—	—	—	—	—	—	**5.0**		2
	WCF L5	●	—	—	—	—	—	—	—	**5.0**		3
WCF □○A Exotic Alloy Low Feed	**WCF N2A**		●	—	—	—	—			**2.0**	WCFS R/L○○○○-2	1
	WCF N3A		●	—	—	—	●	●	●	**3.0**	WCFS R/L○○○○-3 WCFS R/L○○-3	1
	WCF R3A		●	—	—	—		●		**3.0**		2
	WCF L3A		●	—	—	—	—			**3.0**		3
	WCF N4A		●	—	—	—	●			**4.0**	WCFS R/L○○-4	1
	WCF R4A		●	—	—	—	—			**4.0**		2
	WCF L4A		●	—	—	—	—			**4.0**		3
	WCF N5A		●	—	—	—	—			**5.0**	WCFS R/L○○-5	1
	WCF R5A		—	—	—	—	—			**5.0**		2
	WCF L5A		—	—	—	—	—			**5.0**		3
WCF □○B Cast Iron Light Alloys 	**WCF N3B**		—	—	—	—	—	—	●	**3.0**	WCFS R/L○○○○-3 WCFS R/L○○-3	1
	WCF R3B		—	—	—	—	—	—	●	**3.0**		2
	WCF L3B		—	—	—	—	—	—	●	**3.0**		3
	WCF N4B		—	—	—	—	—	—	●	**4.0**	WCFS R/L○○-4	1
	WCF R4B		—	—	—	—	—	—	●	**4.0**		2
	WCF L4B		—	—	—	—	—	—		**4.0**		3
*Same chipbreaker shape as the type for general steel (WCF□○), but with smaller cutting edge treatment.	**WCF N5B**		—	—	—	—	—	—	●	**5.0**	WCFS R/L○○-5	1
	WCF R5B		—	—	—	—	—	—		**5.0**		2
	WCF L5B		—	—	—	—	—	—	●	**5.0**		3

Recommended Cutting Conditions

Work Material	Cutting Speed vc (m/min)							
	Coated Carbide					Cermet	Cemented Carbide	
	AC830P	AC5015S	AC5025S	AC225	AC1030U	T1500A	A30	G10E
P Carbon Steel / Alloy Steel	80-200	80-200	50-200	80-200	50-200	80-200	50-120	—
M Stainless Steel	70-150	70-150	50-150	60-150	50-150	—	70-130	—
K Cast Iron	—	60-200	50-200	—	50-200	—	—	50-120
N Non-Ferrous Metal	—	—	—	—	200-500	—	—	200-500

Chipbreaker		Feed Rate f (mm/rev)										
		Neutral						Handed				
		GG	GF	No Chipbreaker	T	A	B	No Chipbreaker	CF	T	A	B
		General-purpose	Exotic Alloy/Low Cutting Force type	General Steel	Small Diameter/ Low Cutting Force	Exotic Alloy/Low Feed	Cast Iron/Light Alloys	General Steel	Exotic Alloy/Low Cutting Force type	Small Diameter/ Low Cutting Force	Exotic Alloy/Low Feed	Cast Iron/Light Alloys
Width of Cut CW (mm)	**2.0**	0.05-0.20	0.03-0.12	—	0.03-0.10	0.03-0.12	—	—	—	0.03-0.10	—	—
	3.0	0.08-0.25	0.04-0.15	0.08-0.25	—	0.04-0.15	0.05-0.15	0.08-0.25	0.05-0.12	—	0.04-0.15	0.05-0.15
	4.0	0.10-0.30	0.05-0.18	0.10-0.30	—	0.05-0.18	0.05-0.18	0.10-0.30	0.05-0.12	—	0.05-0.18	0.05-0.18
	5.0	0.10-0.35	0.05-0.20	0.10-0.30	—	0.05-0.20	0.06-0.20	0.10-0.30	—	—	—	0.06-0.20

● mark: Standard stocked item (new product/expanded item)

SCT type

Cut-off

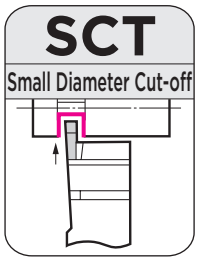


Fig 1

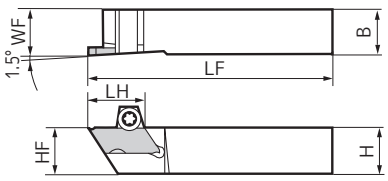


Fig 2

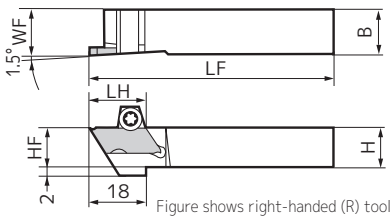


Figure shows right-handed (R) tool.

SumiSmall

Holder (Right-Hand)

Parts Dimensions (mm)

Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Head LH	Applicable Insert	Fig	Flat Head Screw	Wrench
SCT R1010	●	10	10	120	10	10	15	CT R05OOOO(-NB) CT R12OOOO(-NB)	1	BFTX0410T8L	TRX08
R1212	●	12	12	120	12	12	15		1		
R1616	●	16	16	120	16	16	15		1		
SCT R1010-16	●	10	10	120	10	10	18	CT R16OOOO(-NB)	2	BFTX0410T8L	TRX08
R1212-16	●	12	12	120	12	12	18		1		
R1616-16	●	16	16	120	16	16	18		1		

Holder (Left-Hand)

Parts Dimensions (mm)

Cat. No.	Stock	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Head LH	Applicable Insert	Fig	Flat Head Screw	Wrench
SCT L1010	●	10	10	120	10	10	15	CT L05OOOO(-NB) CT L12OOOO(-NB)	1	BFTX0410T8R	TRX08
L1212	●	12	12	120	12	12	15		1		
L1616	●	16	16	120	16	16	15		1		
SCT L1010-16	●	10	10	120	10	10	18	CT L16OOOO(-NB)	2	BFTX0410T8R	TRX08
L1212-16	●	12	12	120	12	12	18		1		
L1616-16	●	16	16	120	16	16	18		1		

Features

● Simple Indexable Inserts

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

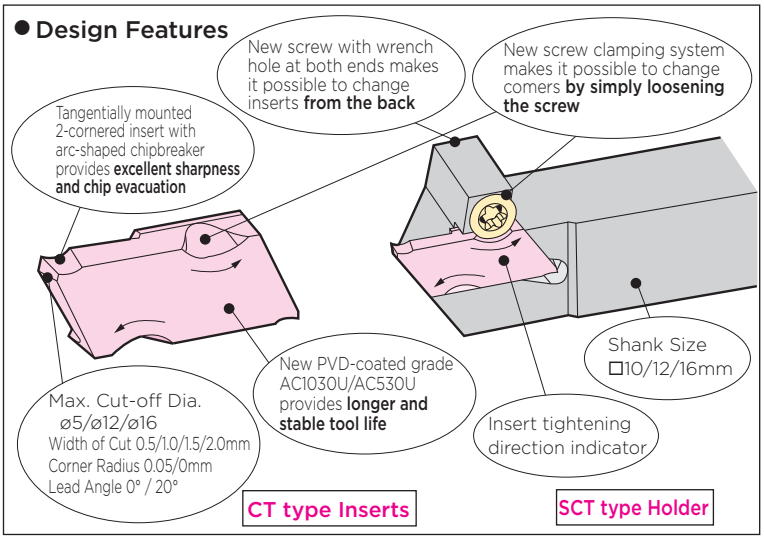
● High Quality Surface Finish

Excellent chip removal, leaves only a small pip at centre of the work face.

● Long, Stable Tool Life

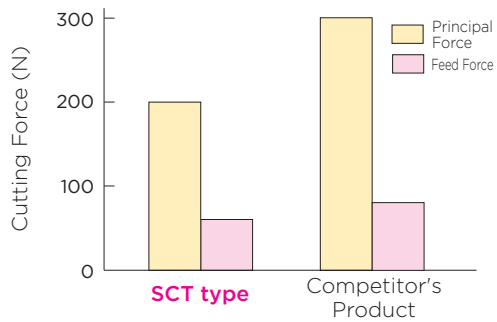
PVD Coating
Long, stable tool life with AC1030U/AC530U

● Design Features



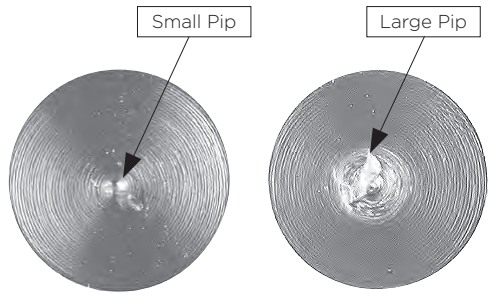
Cutting Performance

● Cutting Force



Work Material: S45C (ø10mm) Width of Cut: 1.5mm
vc = 60m/min, f = 0.06mm/rev Wet

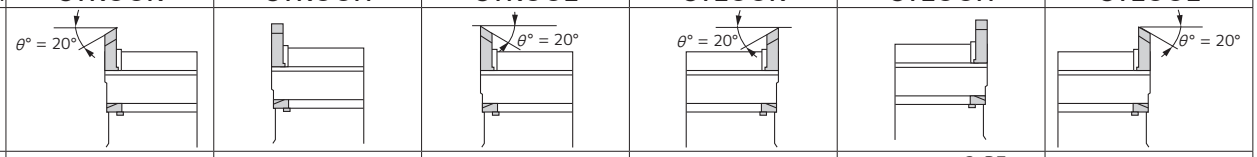
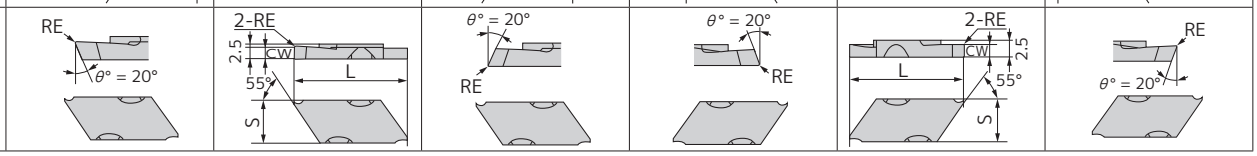
● Surface Finish



Work Material: SUS430 (ø8mm) Width of Cut: 1.0mm (Handed)
vc = 45m/min, f = 0.02mm/rev Wet

SCT type

Insert Mounting Status and Dimensions (Figure shows insert with chipbreaker)

Holder Feed Direction	For Right-handed Holder (SCTR)			For Left-handed Holder (SCTL)		
Insert Cat. No.	CTR○○R	CTR○○N	CTR○○L	CTL○○R	CTL○○N	CTL○○L
Holder Mounting Status						
Insert Shape and Dimensions						

Insert (For Right-handed Holders) (Coated Carbide)

Dimensions (mm)

Cat. No.	AC1030U R	AC1030U N	AC1030U L	AC530U R	AC530U N	AC530U L	Max. Cut-off Dia.	Width of Cut CW	Corner Radius RE	Overall Length L	Thickness S	Chipbreaker	Applicable Holder
CTR 050505 R/N/L	●	●	●	●	●	●	**5**	**0.5**	0.05	19	7	Yes	SCT R1010 SCT R1212 SCT R1616
050500 R/N/L	●	●		●	●		**5**	**0.5**	0	19	7	Yes	
CTR 121005 R/N/L	●	●	●	●	●	●	**12**	**1.0**	0.05	19	7	Yes	
121505 R/N/L	●	●	●	●	●	●	**12**	**1.5**	0.05	19	7	Yes	
122005 R/N/L	●	●		●	●		**12**	**2.0**	0.05	19	7	Yes	
121000 R/N/L	●	●		●	●		**12**	**1.0**	0	19	7	Yes	
121500 R/N/L	●	●		●	●		**12**	**1.5**	0	19	7	Yes	
122000 R/N/L	●	●		●	●		**12**	**2.0**	0	19	7	Yes	
CTR 161005 R/N/L							**16**	**1.0**	0.05	23.1	8.3	Yes	SCT R1010-16 SCT R1212-16 SCT R1616-16
161505 R/N/L	●	●		●	●		**16**	**1.5**	0.05	23.1	8.3	Yes	
162005 R/N/L	●	●	●	●	●	●	**16**	**2.0**	0.05	23.1	8.3	Yes	
161000 R/N/L							**16**	**1.0**	0	23.1	8.3	Yes	
161500 R/N/L	●	●		●	●		**16**	**1.5**	0	23.1	8.3	Yes	
162000 R/N/L	●	●	●	●	●	●	**16**	**2.0**	0	23.1	8.3	Yes	
CTR 050500 R/N/L-NB							**5**	**0.5**	0	19	7	No	SCT R1010 SCT R1212 SCT R1616
CTR 121000 R/N/L-NB	●			●			**12**	**1.0**	0	19	7	No	
121500 R/N/L-NB	●			●			**12**	**1.5**	0	19	7	No	
122000 R/N/L-NB	●			●			**12**	**2.0**	0	19	7	No	
CTR 161000 R/N/L-NB							**16**	**1.0**	0	23.1	8.3	No	SCT R1010-16 SCT R1212-16 SCT R1616-16
161500 R/N/L-NB							**16**	**1.5**	0	23.1	8.3	No	
162000 R/N/L-NB	●			●			**16**	**2.0**	0	23.1	8.3	No	

Insert (For Left-handed Holders) (Coated Carbide)

Dimensions (mm)

Cat. No.	AC1030U R	AC1030U N	AC1030U L	AC530U R	AC530U N	AC530U L	Max. Cut-off Dia.	Width of Cut CW	Corner Radius RE	Overall Length L	Thickness S	Chipbreaker	Applicable Holder
CTL 050505 R/N/L	●	●		●	●		**5**	**0.5**	0.05	19	7	Yes	SCT L1010 SCT L1212 SCT L1616
050500 R/N/L	●	●		●	●		**5**	**0.5**	0	19	7	Yes	
CTL 121005 R/N/L	●	●	●	●	●	●	**12**	**1.0**	0.05	19	7	Yes	
121505 R/N/L	●	●	●	●	●	●	**12**	**1.5**	0.05	19	7	Yes	
122005 R/N/L	●	●		●	●		**12**	**2.0**	0.05	19	7	Yes	
121000 R/N/L	●	●		●	●		**12**	**1.0**	0	19	7	Yes	
121500 R/N/L	●	●		●	●		**12**	**1.5**	0	19	7	Yes	
122000 R/N/L	●	●		●	●		**12**	**2.0**	0	19	7	Yes	
CTL 161005 R/N/L							**16**	**1.0**	0.05	23.1	8.3	Yes	SCT L1010-16 SCT L1212-16 SCT L1616-16
161505 R/N/L	●	●		●	●		**16**	**1.5**	0.05	23.1	8.3	Yes	
162005 R/N/L	●	●	●	●	●	●	**16**	**2.0**	0.05	23.1	8.3	Yes	
161000 R/N/L							**16**	**1.0**	0	23.1	8.3	Yes	
161500 R/N/L	●	●		●	●		**16**	**1.5**	0	23.1	8.3	Yes	
162000 R/N/L	●	●		●	●		**16**	**2.0**	0	23.1	8.3	Yes	
CTL 050500 R/N/L-NB							**5**	**0.5**	0	19	7	No	SCT L1010 SCT L1212 SCT L1616
CTL 121000 R/N/L-NB							**12**	**1.0**	0	19	7	No	
121500 R/N/L-NB							**12**	**1.5**	0	19	7	No	
122000 R/N/L-NB							**12**	**2.0**	0	19	7	No	
CTL 161000 R/N/L-NB							**16**	**1.0**	0	23.1	8.3	No	SCT L1010-16 SCT L1212-16 SCT L1616-16
161500 R/N/L-NB							**16**	**1.5**	0	23.1	8.3	No	
162000 R/N/L-NB							**16**	**2.0**	0	23.1	8.3	No	

GNDM type / GNDL type

Cut-off | Zero Offset

SumiSmall

GNDM

Cut-off (For Small Lathes)

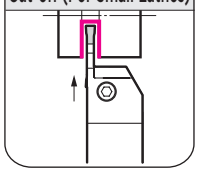


Fig 1

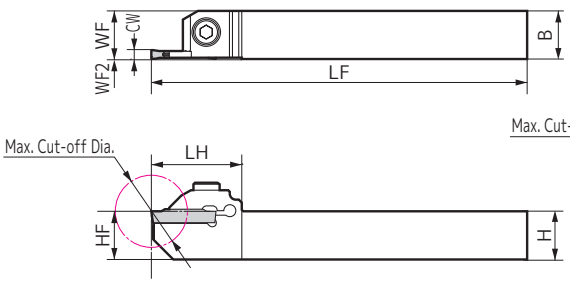


Fig 2

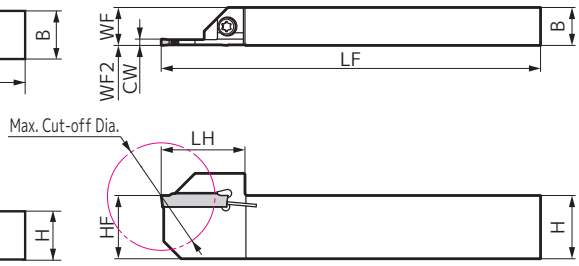


Figure shows right-handed (R) tool.

Holder / Parts

Dimensions (mm)

Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Head LH	Offset WF2	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Fig	Cap Screw (BX0515 / BFTX0414)	N·m	Wrench (LT15-10 / LH040)
GNDM R/L1616JX-1.2508	●	●	16	16	120	(16)	16	26	0	**1.25**	**16**	GCM N125005-GF	1	BX0515	**4.0**	LH040
R/L1616JX-1.510	●	●	16	16	120	(16)	16	26	0	**1.50**	**20**	GCM N150005-GF	1			
R/L1616JX-212	●	●	16	16	120	(16)	16	30	0	**2.00**	**24**	GC□ □20○○-□□	1			
R/L1616JX-312	●	●	16	16	120	(16)	16	30	0	**3.00**	**24**	GC□ □30○○-□□	1			
GNDM R/L2012JX-217	●	●	20	12	120	(12)	20	26.5	0	**2.00**	**34**	GC□ □20○○-□□	2	BFTX0414	**3.0**	LT15-10
R/L2012JX-317	●	●	20	12	120	(12)	20	26.5	0	**3.00**	**34**	GC□ □30○○-□□	2			

Select holders and inserts with matching width of cut (CW).
Refer to page F91 for applicable inserts.

Cut-off | Zero Offset

SumiSmall

GNDL

Cut-off (For Small Lathes)

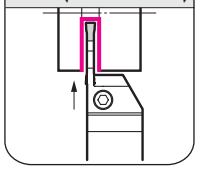


Fig 1

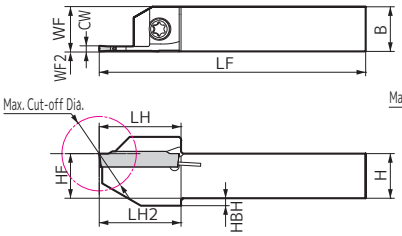


Fig 2

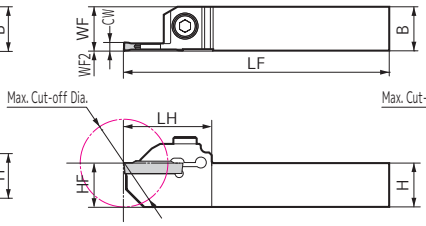


Fig 3

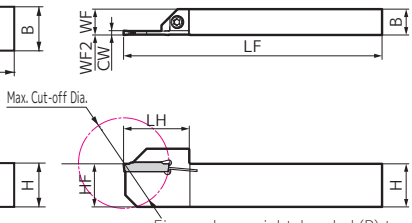


Figure shows right-handed (R) tool.

Holder / Parts

Dimensions (mm)

Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Step HBH	Head LH	Head LH2	Offset WF2	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Fig	Flat Head Screw / Cap Screw (BFTX0412N BFTX0414 / BX0515)	N·m	Wrench (LT15-10 / LH040)
GNDL R/L1010JX-1.2510	●	●	10	10	120	(10)	10	2.0	18	18.3	0	**1.25**	**20**	GCM N125005-GF	1	BFTX0412N	**3.0**	LT15-10
R/L1010JX-1.510	●	●	10	10	120	(10)	10	2.0	18	18.3	0	**1.50**	**20**	GCM N150005-GF	1			
R/L1010JX-210	●	●	10	10	120	(10)	10	2.0	22	22.3	0	**2.00**	**20**	GC□ □20○○-□□	1			
R/L1010JX-310	●	●	10	10	120	(10)	10	2.0	22	22.3	0	**3.00**	**20**	GC□ □30○○-□□	1			
GNDL R/L1212JX-1.2512	●	●	12	12	120	(12)	12	2.0	19	19.3	0	**1.25**	**24**	GCM N125005-GF	1	BFTX0412N	**3.0**	LT15-10
R/L1212JX-1.512	●	●	12	12	120	(12)	12	2.0	19	19.3	0	**1.50**	**24**	GCM N150005-GF	1			
R/L1212JX-212.5	●	●	12	12	120	(12)	12	2.0	22	22.3	0	**2.00**	**25**	GC□ □20○○-□□	1			
R/L1212JX-312.5	●	●	12	12	120	(12)	12	2.0	22	22.3	0	**3.00**	**25**	GC□ □30○○-□□	1			
GNDL R/L1616JX-1.2512.5	●	●	16	16	120	(16)	16	—	28	—	0	**1.25**	**20**	GCM N125005-GF	2	BX0515	**4.0**	LH040
R/L1616JX-1.512.5	●	●	16	16	120	(16)	16	—	28	—	0	**1.50**	**25**	GCM N150005-GF	2			
R/L1616JX-216	●	●	16	16	120	(16)	16	—	32	—	0	**2.00**	**32**	GC□ □20○○-□□	2			
R/L1616JX-316	●	●	16	16	120	(16)	16	—	32	—	0	**3.00**	**32**	GC□ □30○○-□□	2			
GNDL R/L2012JX-221	●	●	20	12	120	(12)	20	—	30.5	—	0	**2.00**	**42**	GC□ □20○○-□□	3	BFTX0414	**3.0**	LT15-10
R/L2012JX-321	●	●	20	12	120	(12)	20	—	30.5	—	0	**3.00**	**42**	GC□ □30○○-□□	3			

Select holders and inserts with matching width of cut (CW).
Refer to page F91 for applicable inserts.

N·m Recommended Tightening Torque (N·m)

GNDM type / GNDL type

Expansion

Inserts for GNDM type (For Small Lathes)/GNDL type (For Small Lathes)

(Coated Carbide/ Cermet / Cemented Carbide / DLC)

Fig 1

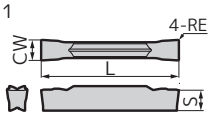
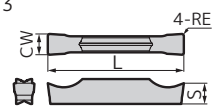


Fig 2 (Figure shows right-handed (R) tool.)

Fig 3



Grooving / Traverse Cutting

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N3002-MG	●	●		●	●	●		●	—	3.0	±0.03	0.2	21.1	3.8	5	1
N3004-MG	●	●	▲	●	●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N2002-ML	—	—	—	—	●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-ML	●	●	▲	●	●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-ML	●	●		●	●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1

Grooving / Cut-off

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N2002-GG		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N2002-GL		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
N2004-GL		●			●	●		●	—	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GL		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GL		●			●	●		●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N125005-GF	—	—	—	—	—	—	—	●	—	1.25	±0.03	0.05	17.4	3.2	5	1
GCM N150005-GF	—	—	—	—	—	—	—	●	—	1.5	±0.03	0.05	17.8	3.7		1
GCM N2002-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.2	21.1	3.6		1
N2004-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GF		●	▲		●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-GF		●			●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1

Cut-off (Handed Edge)

Dimensions (mm)

Cat. No.	AC8035P	AC830P	AC5015S	AC5025S	AC520U	AC530U	AC1030U	Lead Angle PSI	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM R2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6	5	2
L2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6		2
GCM R3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
L3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
GCM R20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6	5	2
L20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
GCM R20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
L20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2

GCM R: Right-handed, GCM L: Left-handed

Non-Ferrous Metals

Dimensions (mm)

Cat. No.	H10	DL1500	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCG N2002-GA	●	●	2.0	±0.025	0.2	21.1	3.6	5	3
N3002-GA	●	●	3.0	±0.025	0.2	21.1	3.8		3

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Application
Grooving / Traverse Cutting	MG	Multi-functional / General-purpose
	ML	Multi-functional / Low feed
Grooving / Cut-off	GG	Grooving / General-purpose
	GL	Grooving / Low feed
	GF	Grooving / Low cutting force

Type	Symbol	Application
Cut-off (Handed Edge)	CG	Cut-off / General-purpose
	CF	Cut-off / Low cutting force
For Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose

Chipbreaker Selection F15 Precautions for Use F24 Recommended Cutting Conditions F21

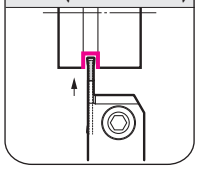
Select holders and inserts with matching width of cut (CW). Not usable with GNDXL type / GNDIS type holders.

● mark: Standard stocked item (new product/expanded item) ▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability)

GNDM-J type / GNDL-J type

GNDM-J

Cut-Off (For Small Lathes)



Cut-off
Zero Offset
Internal Coolant

Fig 1

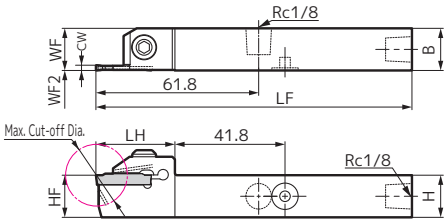


Fig 2

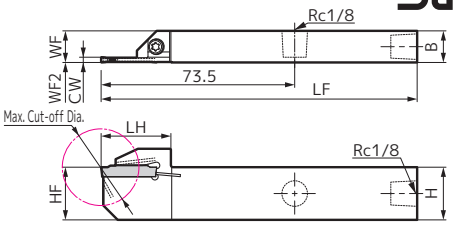
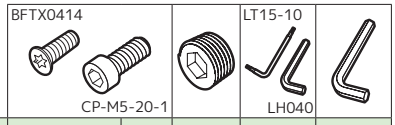


Figure shows right-handed (R) tool.

Parts



Holder

Dimensions (mm)

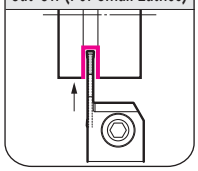
Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Head LH	Offset WF2	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Fig	Flat Head Screw / Cap Screw	N·m	Plug	Top Hex Wrench	Bottom Hex Wrench
GNDM R/L1616JX-212J	●	●	16	16	120	(16)	16	30.0	0	**2.0**	**24**	GC□ □20○○-□□	1	CP-M5-20-1	**5.0**	XP02	LH040	LH025
R/L1616JX-312J	●	●	16	16	120	(16)	16	30.0	0	**3.0**	**24**	GC□ □30○○-□□	1					
GNDM R/L2012JX-217J	●	●	20	12	120	(12)	20	26.5	0	**2.0**	**34**	GC□ □20○○-□□	2	BFTX0414	**3.0**	XP02	LT15-10	—
R/L2012JX-317J	●	●	20	12	120	(12)	20	26.5	0	**3.0**	**34**	GC□ □30○○-□□	2					

Select holders and inserts with matching width of cut (CW). Refer to page F93 for applicable inserts.

Indexable Heads ☞ D20

GNDL-J

Cut-Off (For Small Lathes)



Cut-off
Zero Offset
Internal Coolant

Fig 1

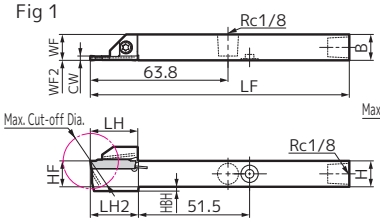


Fig 2

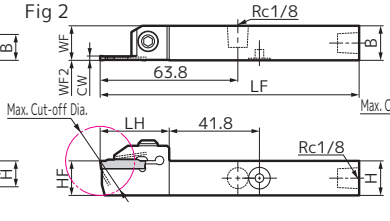


Fig 3

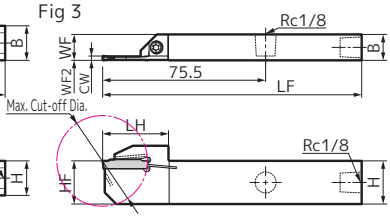
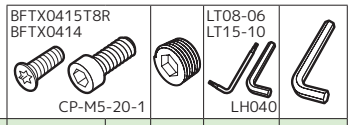


Figure shows right-handed (R) tool.

Parts



Holder

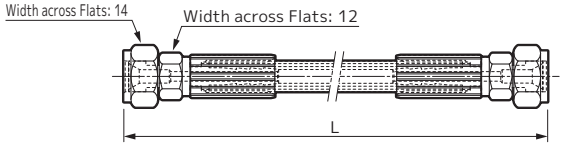
Dimensions (mm)

Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Step HBH	Head LH	Head LH2	Offset WF2	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Fig	Flat Head Screw / Cap Screw	N·m	Plug	Top Hex Wrench	Bottom Hex Wrench
GNDL R/L1212JX-212.5J	●	●	12	12	120	(12)	12	2.0	22.0	22.3	0	**2.0**	**25**	GC□ □20○○-□□	1	BFTX0415T8R	**1.5**	XP02	LT08-06	←
R/L1212JX-312.5J	●	●	12	12	120	(12)	12	2.0	22.0	22.3	0	**3.0**	**25**	GC□ □30○○-□□	1					
GNDL R/L1616JX-216J	●	●	16	16	120	(16)	16	—	32.0	—	0	**2.0**	**32**	GC□ □20○○-□□	2	CP-M5-20-1	**5.0**	XP02	LH040	LH025
R/L1616JX-316J	●	●	16	16	120	(16)	16	—	32.0	—	0	**3.0**	**32**	GC□ □30○○-□□	2					
GNDL R/L2012JX-221J	●	●	20	12	120	(12)	20	—	30.5	—	0	**2.0**	**42**	GC□ □20○○-□□	3	BFTX0414	**3.0**	XP02	LT15-10	—
R/L2012JX-321J	●	●	20	12	120	(12)	20	—	30.5	—	0	**3.0**	**42**	GC□ □30○○-□□	3					

Select holders and inserts with matching width of cut (CW). Refer to page F93 for applicable inserts.

Indexable Heads ☞ D20

Fig 1



Parts (Hose)

Dimensions (mm)

Cat. No.	Stock	L	Screw Standard	Screw Standard	Fig
J-HOSE-G1/8-G1/8-200	●	200	G1/8	G1/8	1
J-HOSE-G1/8-G1/8-300	●	300	G1/8	G1/8	1

Hoses are sold separately.

Piping Method for Hoses and Connectors ☞ F25

Fig 1

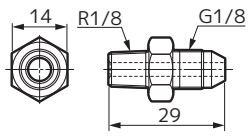
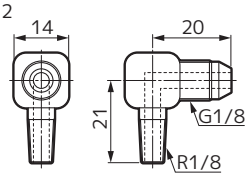


Fig 2



Parts (Connector)

Dimensions (mm)

Cat. No.	Stock	Screw Standard	Screw Standard	Fig
J-G1/8-R1/8-00	●	G1/8	R1/8	1
J-G1/8-R1/8-90	●	G1/8	R1/8	2

Connectors are sold separately.

Piping Method for Hoses and Connectors ☞ F25

N·m Recommended Tightening Torque (N·m)

GNDM-J type / GNDL-J type

Expansion

Inserts for GNDM-J type (For Small Lathes)/GNDL-J type (For Small Lathes)

(Coated Carbide / Cermet / Cemented Carbide / DLC)

Fig 1

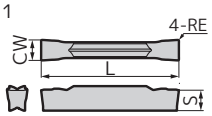
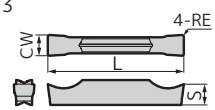


Fig 2 (Figure shows right-handed (R) tool.)

Fig 3



Grooving / Traverse Cutting

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N3002-MG	●	●		●	●	●		●	—	3.0	±0.03	0.2	21.1	3.8	5	1
N3004-MG	●	●	▲	●	●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N2002-ML	—	—	—	—	●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-ML	●	●	▲	●	●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-ML	●	●		●	●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1

Grooving / Cut-off

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N2002-GG		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N2002-GL		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
N2004-GL		●			●	●		●	—	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GL		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GL		●			●	●		●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N2002-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.2	21.1	3.6	5	1
N2004-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GF		●	▲		●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-GF		●			●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1

Cut-off (Handed Edge)

Dimensions (mm)

Cat. No.	AC8035P	AC830P	AC5015S	AC5025S	AC520U	AC530U	AC1030U	Lead Angle PSI	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM R2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6	5	2
L2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6		2
GCM R3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
L3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
GCM R20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6	5	2
L20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
GCM R20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
L20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2

GCM R: Right-handed, GCM L: Left-handed

Non-Ferrous Metals

Dimensions (mm)

Cat. No.	H10	DL1500	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCG N2002-GA	●	●	2.0	±0.025	0.2	21.1	3.6	5	3
N3002-GA	●	●	3.0	±0.025	0.2	21.1	3.8		3

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Application
Grooving / Traverse Cutting	MG	Multi-functional / General-purpose
	ML	Multi-functional / Low feed
Grooving / Cut-off	GG	Grooving / General-purpose
	GL	Grooving / Low feed
	GF	Grooving / Low cutting force

Type	Symbol	Application
Cut-off (Handed Edge)	CG	Cut-off / General-purpose
	CF	Cut-off / Low cutting force
For Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose

Chipbreaker Selection F15 Precautions for Use F24 Recommended Cutting Conditions F21

Select holders and inserts with matching width of cut (CW). Not usable with GNDXL type / GNDIS type holders.

● mark: Standard stocked item (new product/expanded item) ▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability)

GNDS type

External

* For traverse cutting (groove expansion), use a multi-functional or profiling insert.

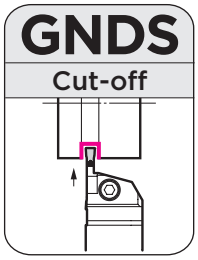


Fig 1

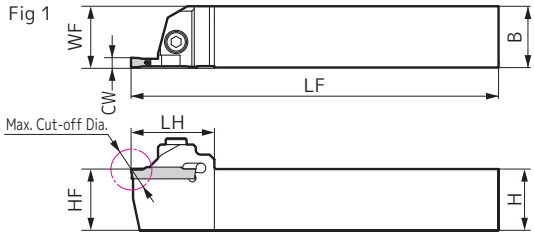


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Head LH	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Fig	Cap Screw	Cap Screw N·m	Wrench
GNDS R/L2020K-206	●	●	20	20	125	20	20	30	**2.0**	**12**	GC□ □20○○-□□	1	BX0520	**5.0**	LH040
R/L2020K-306	●	●	20	20	125	20	20	30	**3.0**	**12**	GC□ □30○○-□□	1			
R/L2020K-410	●	●	20	20	125	20	20	34	**4.0**	**20**	GC□ □40○○-□□	1			
R/L2020K-510	●	●	20	20	125	20	20	34	**5.0**	**20**	GC□ N50○○-□□	1			
R/L2020K-610	●	●	20	20	125	20	20	34	**6.0**	**20**	GC□ N60○○-□□	1			
GNDS R/L2525M-206	●	●	25	25	150	25	25	30	**2.0**	**12**	GC□ □20○○-□□	1	BX0520	**5.0**	LH040
R/L2525M-306	●	●	25	25	150	25	25	30	**3.0**	**12**	GC□ □30○○-□□	1			
R/L2525M-410	●	●	25	25	150	25	25	34	**4.0**	**20**	GC□ □40○○-□□	1			
R/L2525M-510	●	●	25	25	150	25	25	34	**5.0**	**20**	GC□ N50○○-□□	1			
R/L2525M-610	●	●	25	25	150	25	25	34	**6.0**	**20**	GC□ N60○○-□□	1			

Select holders and inserts with matching width of cut (CW). Refer to page F95 for applicable inserts.

N·m Recommended Tightening Torque (N·m)

GNDS type

Expansion

Inserts for GNDS type

(Coated Carbide / Cermet / Cemented Carbide / DLC)

Fig 1

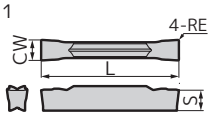
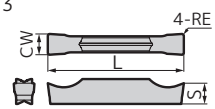


Fig 2 (Figure shows right-handed (R) tool.)

Fig 3



Grooving / Traverse Cutting

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N3002-MG	●	●		●	●	●		●	—	3.0	±0.03	0.2	21.1	3.8	5	1
N3004-MG	●	●	▲	●	●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-MG	●	●		●	●	●		●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-MG	●	●		●	●	●		●	—	4.0	±0.03	0.4	26.4	4.0		1
N4008-MG	●	●	▲	●	●	●	●	●	—	4.0	±0.03	0.8	26.4	4.0		1
GCM N5004-MG	●	●		●	●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
N5008-MG	●	●	▲	●	●	●	●	●	—	5.0	±0.03	0.8	26.4	4.1		1
GCM N6004-MG	●	●		●	●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
N6008-MG	●	●	▲	●	●	●	●	●	—	6.0	±0.03	0.8	26.4	4.5		1
GCM N2002-ML	—	—	—	—	●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-ML	●	●	▲	●	●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-ML	●	●		●	●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-ML	●	●		●	●	●		●	●	4.0	±0.03	0.2	26.4	4.0		1
N4004-ML	●	●	▲	●	●	●	●	●	●	4.0	±0.03	0.4	26.4	4.0		1
N4008-ML	●	●		●	●	●		●	●	4.0	±0.03	0.8	26.4	4.0		1
GCM N5004-ML	●	●	▲	●	●	●	●	●	—	5.0	±0.03	0.4	26.4	4.1		1
N5008-ML	●	●		●	●	●		●	—	5.0	±0.03	0.8	26.4	4.1		1
GCM N6004-ML	●	●	▲	●	●	●	●	●	—	6.0	±0.03	0.4	26.4	4.5		1
N6008-ML	●	●		●	●	●		●	—	6.0	±0.03	0.8	26.4	4.5		1

Grooving / Cut-off

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N2002-GG		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GG		●	▲		●	●	●	●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-GG		●	▲		●	●	●	●	—	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GG		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GG		●	▲		●	●	●	●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GG		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GG		●	▲		●	●	●	●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N2002-GL		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6		1
N2004-GL		●			●	●		●	—	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GL		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GL		●			●	●		●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GL		●	▲		●	●	●	●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-GL		●			●	●		●	—	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GL		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GL		●			●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GL		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GL		●			●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N2002-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.2	21.1	3.6		1
N2004-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GF		●	▲		●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-GF		●			●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GF		●	▲		●	●	●	●	●	4.0	±0.03	0.2	26.4	4.0		1
N4004-GF		●			●	●		●	●	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GF		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GF		●			●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GF		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GF		●			●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1

Cut-off (Handed Edge)

Dimensions (mm)

Cat. No.	AC8035P	AC830P	AC5015S	AC5025S	AC520U	AC530U	AC1030U	Lead Angle PSI	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM R2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6	5	2
L2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6		2
GCM R3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
L3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
GCM R4002-CG-05	●	▲	●	●	●	●	—	5°	4.0	±0.04	0.2	26.7	4.0		2
L4002-CG-05	●	▲	●	●	●	●	—	5°	4.0	±0.04	0.2	26.7	4.0		2
GCM R20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6	5	2
L20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
GCM R20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
L20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2

GCM R: Right-handed, GCM L: Left-handed

Non-Ferrous Metals

Dimensions (mm)

Cat. No.	H10	DL1500	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCG N2002-GA	●	●	2.0	±0.025	0.2	21.1	3.6	5	3
N3002-GA	●	●	3.0	±0.025	0.2	21.1	3.8		3
GCG N4004-GA	●	●	4.0	±0.025	0.4	26.4	4.0		3
N5004-GA	●	●	5.0	±0.025	0.4	26.4	4.1		3
N6004-GA	●	●	6.0	±0.025	0.4	26.4	4.5		3

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Application
Grooving / Traverse Cutting	MG	Multi-functional / General-purpose
	ML	Multi-functional / Low feed
Grooving / Cut-off	GG	Grooving / General-purpose
	GL	Grooving / Low feed
	GF	Grooving / Low cutting force

Type	Symbol	Application
Cut-off (Handed Edge)	CG	Cut-off / General-purpose
	CF	Cut-off / Low cutting force
For Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose

Chipbreaker Selection F15 Precautions for Use F24 Recommended Cutting Conditions F21

Select holders and inserts with matching width of cut (CW). Not usable with GNDXL type / GNDIS type holders.

● mark: Standard stocked item (new product/expanded item) ▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability)

GNDM type

Cut-off

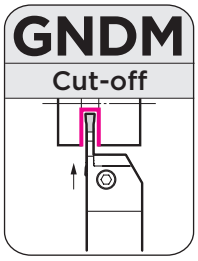


Fig 1

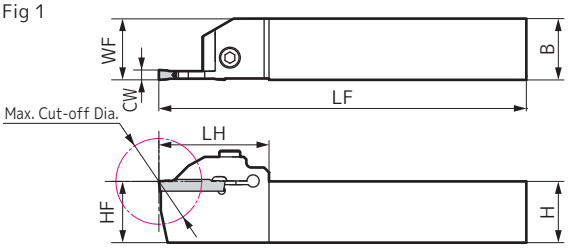


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Head LH	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Fig	Flat Head Screw (BX0520 / BX0620)	N·m	Wrench
GNDM R/L2020K-1.2510	●	●	20	20	125	20	20	34.0	**1.25**	**20**	GCM N125005-GF	1	BX0520	5.0	LH040
R/L2020K-1.510	●	●	20	20	125	20	20	34.0	**1.50**	**20**	GCM N150005-GF	1			
R/L2020K-210	●	●	20	20	125	20	20	33.6	**2.00**	**20**	GC□ □20○○-□□	1			
R/L2020K-312	●	●	20	20	125	20	20	36.6	**3.00**	**24**	GC□ □30○○-□□	1			
R/L2020K-418	●	●	20	20	125	20	20	45.0	**4.00**	**36**	GC□ □40○○-□□	1			
R/L2020K-518	●	●	20	20	125	20	20	45.0	**5.00**	**36**	GC□ N50○○-□□	1			
R/L2020K-618	●	●	20	20	125	20	20	45.0	**6.00**	**36**	GC□ N60○○-□□	1			
GNDM R/L2525M-1.2510	●	●	25	25	150	25	25	36.0	**1.25**	**20**	GCM N125005-GF	1	BX0520	5.0	LH040
R/L2525M-1.510	●	●	25	25	150	25	25	36.0	**1.50**	**20**	GCM N150005-GF	1			
R/L2525M-210	●	●	25	25	150	25	25	33.6	**2.00**	**20**	GC□ □20○○-□□	1			
R/L2525M-312	●	●	25	25	150	25	25	36.6	**3.00**	**24**	GC□ □30○○-□□	1			
R/L2525M-418	●	●	25	25	150	25	25	45.0	**4.00**	**36**	GC□ □40○○-□□	1			
R/L2525M-518	●	●	25	25	150	25	25	45.0	**5.00**	**36**	GC□ N50○○-□□	1			
R/L2525M-618	●	●	25	25	150	25	25	45.0	**6.00**	**36**	GC□ N60○○-□□	1			
GNDM R/L3225P-312			32	25	170	25	32	36.6	**3.00**	**24**	GC□ □30○○-□□	1	BX0520	5.0	LH040
R/L3225P-418			32	25	170	25	32	45.0	**4.00**	**36**	GC□ □40○○-□□	1			
R/L3225P-518			32	25	170	25	32	45.0	**5.00**	**36**	GC□ N50○○-□□	1			
R/L3225P-618			32	25	170	25	32	45.0	**6.00**	**36**	GC□ N60○○-□□	1			
R/L3225P-718			32	25	170	25	32	50.0	**7.00**	**36**	GCM N70○○-□□	1	BX0620	6.0	LH050
R/L3225P-818			32	25	170	25	32	50.0	**8.00**	**36**	GCM N80○○-□□	1			
GNDM R/L3232P-312	●	●	32	32	170	32	32	36.6	**3.00**	**24**	GC□ □30○○-□□	1	BX0620	6.0	LH050
R/L3232P-418	●	●	32	32	170	32	32	45.0	**4.00**	**36**	GC□ □40○○-□□	1			
R/L3232P-518	●	●	32	32	170	32	32	45.0	**5.00**	**36**	GC□ N50○○-□□	1			
R/L3232P-618	●	●	32	32	170	32	32	45.0	**6.00**	**36**	GC□ N60○○-□□	1			
R/L3232P-718	●	●	32	32	170	32	32	50.0	**7.00**	**36**	GCM N70○○-□□	1			
R/L3232P-818	●	●	32	32	170	32	32	50.0	**8.00**	**36**	GCM N80○○-□□	1			

Select holders and inserts with matching width of cut (CW). The maximum cut-off diameter indicated above is for inserts with RE = 0.2mm.
Refer to page F97 for applicable inserts.

N·m Recommended Tightening Torque (N·m)

GNDM type

Expansion Inserts for GNDM type

(Coated Carbide / Cermet / Cemented Carbide / DLC)

Fig 1

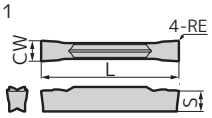
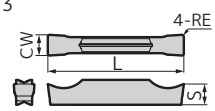


Fig 2 (Figure shows right-handed (R) tool.)

Fig 3



Grooving / Traverse Cutting

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N3002-MG	●	●		●	●	●		●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-MG	●	●	▲	●	●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-MG	●	●		●	●	●		●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-MG	●	●		●	●	●		●	—	4.0	±0.03	0.4	26.4	4.0		1
N4008-MG	●	●	▲	●	●	●	●	●	—	4.0	±0.03	0.8	26.4	4.0		1
GCM N5004-MG	●	●		●	●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
N5008-MG	●	●	▲	●	●	●	●	●	—	5.0	±0.03	0.8	26.4	4.1	5	1
GCM N6004-MG	●	●		●	●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
N6008-MG	●	●	▲	●	●	●	●	●	—	6.0	±0.03	0.8	26.4	4.5		1
GCM N7004-MG	●	●		●	●	●		●	—	7.0	±0.04	0.4	28.8	5.5		1
N7008-MG	●	●	▲	●	●	●	●	●	—	7.0	±0.04	0.8	28.8	5.5		1
GCM N8004-MG	●	●		●	●	●		●	—	8.0	±0.04	0.4	28.8	6.0		1
N8008-MG	●	●	▲	●	●	●	●	●	—	8.0	±0.04	0.8	28.8	6.0		1
GCM N2002-ML	—	—	—	—	●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6		1
GCM N3002-ML	●	●	●	●	●	●	●	●	▲	3.0	±0.03	0.2	21.1	3.8		1
N3004-ML	●	●		●	●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-ML	●	●		●	●	●		●	●	4.0	±0.03	0.2	26.4	4.0		1
N4004-ML	●	●	▲	●	●	●	●	●	●	4.0	±0.03	0.4	26.4	4.0		1
N4008-ML	●	●		●	●	●		●	●	4.0	±0.03	0.8	26.4	4.0		1
GCM N5004-ML	●	●	▲	●	●	●	●	●	—	5.0	±0.03	0.4	26.4	4.1		1
N5008-ML	●	●		●	●	●		●	—	5.0	±0.03	0.8	26.4	4.1	5	1
GCM N6004-ML	●	●	▲	●	●	●	●	●	—	6.0	±0.03	0.4	26.4	4.5		1
N6008-ML	●	●		●	●	●		●	—	6.0	±0.03	0.8	26.4	4.5		1
GCM N7004-ML	●	●	▲	●	●	●	●	●	—	7.0	±0.04	0.4	28.8	5.5		1
N7008-ML	●	●		●	●	●		●	—	7.0	±0.04	0.8	28.8	5.5		1
GCM N8004-ML	●	●	▲	●	●	●	●	●	—	8.0	±0.04	0.4	28.8	6.0		1
N8008-ML	●	●		●	●	●		●	—	8.0	±0.04	0.8	28.8	6.0		1

Grooving / Cut-off

Dimensions (mm)

Cat. No.																
GCM N2002-GG		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6		1
GCM N3002-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GG		●	▲		●	●	●	●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-GG		●	▲		●	●	●	●	—	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GG		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1	5	1
N5004-GG		●	▲		●	●	●	●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GG		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GG		●	▲		●	●	●	●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N7004-GG		●	▲		●	●	●	●	—	7.0	±0.04	0.4	28.8	5.5		1
GCM N8004-GG		●	▲		●	●	●	●	—	8.0	±0.04	0.4	28.8	6.0		1
GCM N2002-GL		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6		1
N2004-GL		●			●	●		●	—	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GL		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GL		●			●	●		●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GL		●	▲		●	●	●	●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-GL		●			●	●		●	—	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GL		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1	5	1
N5004-GL		●			●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GL		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GL		●			●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N7004-GL		●	▲		●	●	●	●	—	7.0	±0.04	0.4	28.8	5.5		1
GCM N8004-GL		●	▲		●	●	●	●	—	8.0	±0.04	0.4	28.8	6.0		1
GCM N125005-GF	—	—	—	—	—	—	—	●	—	1.25	±0.03	0.05	17.4	3.2		1
GCM N150005-GF	—	—	—	—	—	—	—	●	—	1.5	±0.03	0.05	17.8	3.7		1
GCM N2002-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.2	21.1	3.6		1
N2004-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GF		●	▲		●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-GF		●			●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GF		●	▲		●	●	●	●	●	4.0	±0.03	0.2	26.4	4.0		1
N4004-GF		●			●	●		●	●	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GF		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1	5	1
N5004-GF		●			●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GF		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GF		●			●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N7002-GF		●	▲		●	●	●	●	—	7.0	±0.04	0.2	28.8	5.5		1
N7004-GF		●	▲		●	●	●	●	—	7.0	±0.04	0.4	28.8	5.5		1
GCM N8002-GF		●	▲		●	●	●	●	—	8.0	±0.04	0.2	28.8	6.0		1
N8004-GF		●	▲		●	●	●	●	—	8.0	±0.04	0.4	28.8	6.0		1

Cut-off (Handed Edge)

Dimensions (mm)

Cat. No.	AC8035P	AC830P	AC5015S	AC5025S	AC520U	AC530U	AC1030U	Lead Angle PSI	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM R2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6		2
L2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6		2
GCM R3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8	5	2
L3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
GCM R4002-CG-05	●	▲	●	●	●	●	—	5°	4.0	±0.04	0.2	26.7	4.0		2
L4002-CG-05	●	▲	●	●	●	●	—	5°	4.0	±0.04	0.2	26.7	4.0		2
GCM R20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6		2
L20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8	5	2
GCM R20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
L20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2

GCM R: Right-handed, GCM L: Left-handed

Non-Ferrous Metals

Dimensions (mm)

Cat. No.	H10	DL1500	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCG N2002-GA	●	●	2.0	±0.025	0.2	21.1	3.6		3
N3002-GA	●	●	3.0	±0.025	0.2	21.1	3.8		3
GCG N4004-GA	●	●	4.0	±0.025	0.4	26.4	4.0	5	3
N5004-GA	●	●	5.0	±0.025	0.4	26.4	4.1		3
N6004-GA	●	●	6.0	±0.025	0.4	26.4	4.5		3

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Application
Grooving / Traverse Cutting	MG	Multi-functional / General-purpose
	ML	Multi-functional / Low feed
Grooving / Cut-off	GG	Grooving / General-purpose
	GL	Grooving / Low feed
	GF	Grooving / Low cutting force

Type	Symbol	Application
Cut-off (Handed Edge)	CG	Cut-off / General-purpose
	CF	Cut-off / Low cutting force
For Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose

Chipbreaker Selection F15 Precautions for Use F24 Recommended Cutting Conditions F21

Select holders and inserts with matching width of cut (CW). Not usable with GNDXL type / GNDIS type holders.

● mark: Standard stocked item (new product/expanded item) ▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability)

GNDM-J type

Cut-off | Internal Coolant

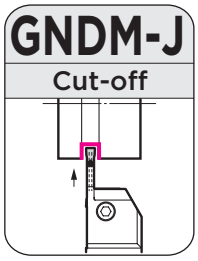


Fig 1

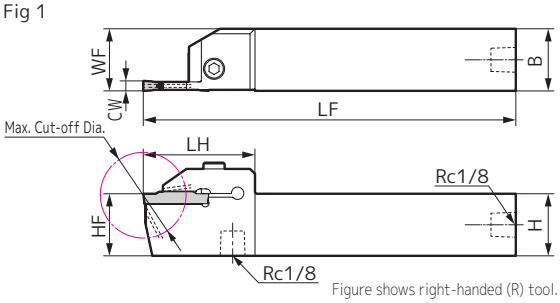


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Head LH	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Fig	Cap Screw	N·m	Plug	Wrench
GNDM R/L2020K-210J	●	●	20	20	125	20	20	33.6	**2.00**	**20**	GC□ □20○○-□□	1	BX0520	6.0	XP02	LH040
R/L2020K-312J	●	●	20	20	125	20	20	36.6	**3.00**	**24**	GC□ □30○○-□□	1				
R/L2020K-418J	●	●	20	20	125	20	20	45	**4.00**	**36**	GC□ □40○○-□□	1				
R/L2020K-518J	●	●	20	20	125	20	20	45	**5.00**	**36**	GC□ N50○○-□□	1				
R/L2020K-618J	●	●	20	20	125	20	20	45	**6.00**	**36**	GC□ N60○○-□□	1				
GNDM R/L2525K-210J	●	●	25	25	125	25	25	33.6	**2.00**	**20**	GC□ □20○○-□□	1	BX0520	6.0	XP02	LH040
R/L2525K-312J	●	●	25	25	125	25	25	36.6	**3.00**	**24**	GC□ □30○○-□□	1				
R/L2525K-418J	●	●	25	25	125	25	25	45	**4.00**	**36**	GC□ □40○○-□□	1				
R/L2525K-518J	●	●	25	25	125	25	25	45	**5.00**	**36**	GC□ N50○○-□□	1				
R/L2525K-618J	●	●	25	25	125	25	25	45	**6.00**	**36**	GC□ N60○○-□□	1				

Select holders and inserts with matching width of cut (CW). The maximum cut-off diameter indicated above is for inserts with RE = 0.2mm.
Refer to page F99 for applicable inserts.

Fig 1

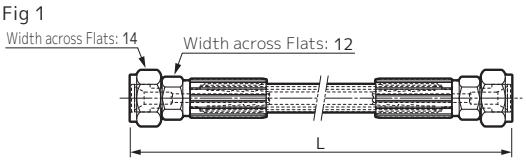


Fig 1

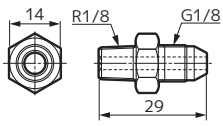
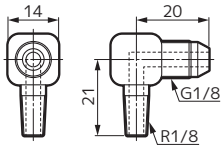


Fig 2



Parts (Hose)

Dimensions (mm)

Cat. No.	Stock	L	Screw Standard	Screw Standard	Fig
J-HOSE-G1/8-G1/8-200	●	200	G1/8	G1/8	1
J-HOSE-G1/8-G1/8-300	●	300	G1/8	G1/8	1

Hoses are sold separately.

Piping Method for Hoses and Connectors ☞F25

Parts (Connector)

Dimensions (mm)

Cat. No.	Stock	Screw Standard	Screw Standard	Fig
J-G1/8-R1/8-00	●	G1/8	R1/8	1
J-G1/8-R1/8-90	●	G1/8	R1/8	2

Connectors are sold separately.

Piping Method for Hoses and Connectors ☞F25

N·m Recommended Tightening Torque (N·m)

GNDM-J type

Expansion

Inserts for GNDM-J type

(Coated Carbide / Cermet / Cemented Carbide / DLC)

Fig 1

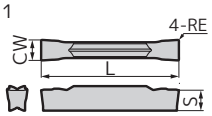
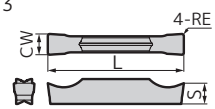


Fig 2 (Figure shows right-handed (R) tool.)

Fig 3



Grooving / Traverse Cutting

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N3002-MG	●	●		●	●	●		●	—	3.0	±0.03	0.2	21.1	3.8	5	1
N3004-MG	●	●	▲	●	●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-MG	●	●		●	●	●		●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-MG	●	●		●	●	●		●	—	4.0	±0.03	0.4	26.4	4.0		1
N4008-MG	●	●	▲	●	●	●	●	●	—	4.0	±0.03	0.8	26.4	4.0		1
GCM N5004-MG	●	●		●	●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
N5008-MG	●	●	▲	●	●	●	●	●	—	5.0	±0.03	0.8	26.4	4.1		1
GCM N6004-MG	●	●		●	●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
N6008-MG	●	●	▲	●	●	●	●	●	—	6.0	±0.03	0.8	26.4	4.5		1
GCM N2002-ML	—	—	—	—	●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-ML	●	●	▲	●	●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-ML	●	●		●	●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-ML	●	●		●	●	●		●	●	4.0	±0.03	0.2	26.4	4.0		1
N4004-ML	●	●	▲	●	●	●	●	●	●	4.0	±0.03	0.4	26.4	4.0		1
N4008-ML	●	●		●	●	●		●	●	4.0	±0.03	0.8	26.4	4.0		1
GCM N5004-ML	●	●	▲	●	●	●	●	●	—	5.0	±0.03	0.4	26.4	4.1		1
N5008-ML	●	●		●	●	●		●	—	5.0	±0.03	0.8	26.4	4.1		1
GCM N6004-ML	●	●	▲	●	●	●	●	●	—	6.0	±0.03	0.4	26.4	4.5		1
N6008-ML	●	●		●	●	●		●	—	6.0	±0.03	0.8	26.4	4.5		1

Grooving / Cut-off

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N2002-GG		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GG		●	▲		●	●	●	●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-GG		●	▲		●	●	●	●	—	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GG		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GG		●	▲		●	●	●	●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GG		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GG		●	▲		●	●	●	●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N2002-GL		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6		1
N2004-GL		●			●	●		●	—	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GL		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GL		●			●	●		●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GL		●	▲		●	●	●	●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-GL		●			●	●		●	—	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GL		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GL		●			●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GL		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GL		●			●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N2002-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.2	21.1	3.6		1
N2004-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GF		●	▲		●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-GF		●			●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GF		●	▲		●	●	●	●	●	4.0	±0.03	0.2	26.4	4.0		1
N4004-GF		●			●	●		●	●	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GF		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GF		●			●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GF		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GF		●			●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1

Cut-off (Handed Edge)

Dimensions (mm)

Cat. No.	AC8035P	AC830P	AC5015S	AC5025S	AC520U	AC530U	AC1030U	Lead Angle PSI	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM R2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6	5	2
L2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6		2
GCM R3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
L3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
GCM R4002-CG-05	●	▲	●	●	●	●	—	5°	4.0	±0.04	0.2	26.7	4.0		2
L4002-CG-05	●	▲	●	●	●	●	—	5°	4.0	±0.04	0.2	26.7	4.0		2
GCM R20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6	5	2
L20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
GCM R20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
L20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2

GCM R: Right-handed, GCM L: Left-handed

Non-Ferrous Metals

Dimensions (mm)

Cat. No.	H10	DL1500	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCG N2002-GA	●	●	2.0	±0.025	0.2	21.1	3.6	5	3
N3002-GA	●	●	3.0	±0.025	0.2	21.1	3.8		3
GCG N4004-GA	●	●	4.0	±0.025	0.4	26.4	4.0		3
N5004-GA	●	●	5.0	±0.025	0.4	26.4	4.1		3
N6004-GA	●	●	6.0	±0.025	0.4	26.4	4.5		3

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Application
Grooving / Traverse Cutting	MG	Multi-functional / General-purpose
	ML	Multi-functional / Low feed
Grooving / Cut-off	GG	Grooving / General-purpose
	GL	Grooving / Low feed
	GF	Grooving / Low cutting force

Type	Symbol	Application
Cut-off (Handed Edge)	CG	Cut-off / General-purpose
	CF	Cut-off / Low cutting force
For Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose

Chipbreaker Selection F15 Precautions for Use F24 Recommended Cutting Conditions F21

Select holders and inserts with matching width of cut (CW). Not usable with GNDXL type / GNDIS type holders.

● mark: Standard stocked item (new product/expanded item) ▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability)

GNDL type

Cut-off

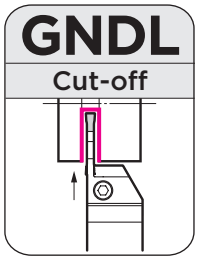


Fig 1

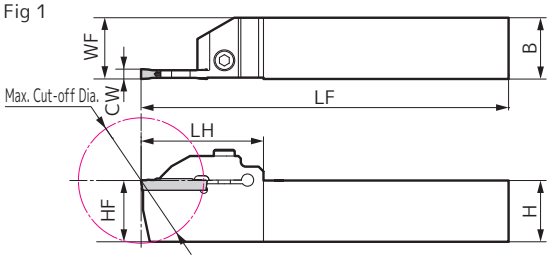


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Head LH	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Fig	Cap Screw (BX0520 / BX0620)	Cap Screw N·m	Wrench
GNDL R/L2020K-1.2516	●	●	20	20	125	20	20	38.0	**1.25**	**32**	GCM N125005-GF	1	BX0520	**5.0**	LH040
R/L2020K-1.516	●	●	20	20	125	20	20	38.0	**1.50**	**32**	GCM N150005-GF	1			
R/L2020K-220	●	●	20	20	125	20	20	44.5	**2.00**	**40**	GC□ □20○○-□□	1			
R/L2020K-320	●	●	20	20	125	20	20	44.5	**3.00**	**40**	GC□ □30○○-□□	1			
R/L2020K-425	●	●	20	20	125	20	20	50.0	**4.00**	**50**	GC□ □40○○-□□	1			
R/L2020K-525	●	●	20	20	125	20	20	50.0	**5.00**	**50**	GC□ N50○○-□□	1			
R/L2020K-625	●	●	20	20	125	20	20	50.0	**6.00**	**50**	GC□ N60○○-□□	1			
GNDL R/L2525M-1.2516	●	●	25	25	150	25	25	40.0	**1.25**	**32**	GCM N125005-GF	1	BX0520	**5.0**	LH040
R/L2525M-1.516	●	●	25	25	150	25	25	40.0	**1.50**	**32**	GCM N150005-GF	1			
R/L2525M-220	●	●	25	25	150	25	25	44.5	**2.00**	**40**	GC□ □20○○-□□	1			
R/L2525M-320	●	●	25	25	150	25	25	44.5	**3.00**	**40**	GC□ □30○○-□□	1			
R/L2525M-425	●	●	25	25	150	25	25	50.0	**4.00**	**50**	GC□ □40○○-□□	1			
R/L2525M-525	●	●	25	25	150	25	25	50.0	**5.00**	**50**	GC□ N50○○-□□	1			
R/L2525M-625	●	●	25	25	150	25	25	50.0	**6.00**	**50**	GC□ N60○○-□□	1			
GNDL R/L3225P-320			32	25	170	25	32	44.5	**3.00**	**40**	GC□ □30○○-□□	1	BX0520	**5.0**	LH040
R/L3225P-425			32	25	170	25	32	50.0	**4.00**	**50**	GC□ □40○○-□□	1			
R/L3225P-525			32	25	170	25	32	50.0	**5.00**	**50**	GC□ N50○○-□□	1			
R/L3225P-625			32	25	170	25	32	50.0	**6.00**	**50**	GC□ N60○○-□□	1			
R/L3225P-725			32	25	170	25	32	50.0	**7.00**	**50**	GCM N70○○-□□	1	BX0620	**6.0**	LH050
R/L3225P-825			32	25	170	25	32	50.0	**8.00**	**50**	GCM N80○○-□□	1			
GNDL R/L3232P-320	●	●	32	32	170	32	32	44.5	**3.00**	**40**	GC□ □30○○-□□	1	BX0620	**6.0**	LH050
R/L3232P-425	●	●	32	32	170	32	32	50.0	**4.00**	**50**	GC□ □40○○-□□	1			
R/L3232P-525	●	●	32	32	170	32	32	50.0	**5.00**	**50**	GC□ N50○○-□□	1			
R/L3232P-625	●	●	32	32	170	32	32	50.0	**6.00**	**50**	GC□ N60○○-□□	1			
R/L3232P-725	●	●	32	32	170	32	32	50.0	**7.00**	**50**	GCM N70○○-□□	1			
R/L3232P-825	●	●	32	32	170	32	32	50.0	**8.00**	**50**	GCM N80○○-□□	1			

Select holders and inserts with matching width of cut (CW). The maximum cut-off diameter indicated above is for inserts with RE = 0.2mm.
Refer to page F101 for applicable inserts.

N·m Recommended Tightening Torque (N·m)

GNDL type

Expansion Inserts for GNDL type

(Coated Carbide / Cermet / Cemented Carbide / DLC)

Fig 1

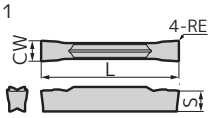
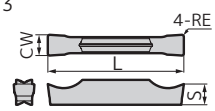


Fig 2 (Figure shows right-handed (R) tool.)

Fig 3



Grooving / Traverse Cutting

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N3002-MG	●	●		●	●	●		●	—	3.0	±0.03	0.2	21.1	3.8	5	1
N3004-MG	●	●	▲	●	●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-MG	●	●		●	●	●		●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-MG	●	●		●	●	●		●	—	4.0	±0.03	0.4	26.4	4.0		1
N4008-MG	●	●	▲	●	●	●	●	●	—	4.0	±0.03	0.8	26.4	4.0		1
GCM N5004-MG	●	●		●	●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
N5008-MG	●	●	▲	●	●	●	●	●	—	5.0	±0.03	0.8	26.4	4.1		1
GCM N6004-MG	●	●		●	●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
N6008-MG	●	●	▲	●	●	●	●	●	—	6.0	±0.03	0.8	26.4	4.5		1
GCM N7004-MG	●	●		●	●	●		●	—	7.0	±0.04	0.4	28.8	5.5		1
N7008-MG	●	●	▲	●	●	●	●	●	—	7.0	±0.04	0.8	28.8	5.5		1
GCM N8004-MG	●	●		●	●	●		●	—	8.0	±0.04	0.4	28.8	6.0		1
N8008-MG	●	●	▲	●	●	●	●	●	—	8.0	±0.04	0.8	28.8	6.0		1
GCM N2002-ML	—	—	—	—	●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-ML	●	●	●	●	●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-ML	●	●		●	●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-ML	●	●		●	●	●		●	●	4.0	±0.03	0.2	26.4	4.0		1
N4004-ML	●	●	▲	●	●	●	●	●	●	4.0	±0.03	0.4	26.4	4.0		1
N4008-ML	●	●		●	●	●		●	●	4.0	±0.03	0.8	26.4	4.0		1
GCM N5004-ML	●	●	▲	●	●	●	●	●	—	5.0	±0.03	0.4	26.4	4.1		1
N5008-ML	●	●		●	●	●		●	—	5.0	±0.03	0.8	26.4	4.1		1
GCM N6004-ML	●	●	▲	●	●	●	●	●	—	6.0	±0.03	0.4	26.4	4.5		1
N6008-ML	●	●		●	●	●		●	—	6.0	±0.03	0.8	26.4	4.5		1
GCM N7004-ML	●	●	▲	●	●	●	●	●	—	7.0	±0.04	0.4	28.8	5.5		1
N7008-ML	●	●		●	●	●		●	—	7.0	±0.04	0.8	28.8	5.5		1
GCM N8004-ML	●	●	▲	●	●	●	●	●	—	8.0	±0.04	0.4	28.8	6.0		1
N8008-ML	●	●		●	●	●		●	—	8.0	±0.04	0.8	28.8	6.0		1

Grooving / Cut-off

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N2002-GG		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GG		●	▲		●	●	●	●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-GG		●	▲		●	●	●	●	—	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GG		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GG		●	▲		●	●	●	●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GG		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GG		●	▲		●	●	●	●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N7004-GG		●	▲		●	●	●	●	—	7.0	±0.04	0.4	28.8	5.5		1
GCM N8004-GG		●	▲		●	●	●	●	—	8.0	±0.04	0.4	28.8	6.0		1
GCM N2002-GL		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
N2004-GL		●			●	●		●	—	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GL		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GL		●			●	●		●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GL		●	▲		●	●	●	●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-GL		●			●	●		●	—	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GL		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GL		●			●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GL		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GL		●			●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N7004-GL		●	▲		●	●	●	●	—	7.0	±0.04	0.4	28.8	5.5		1
GCM N8004-GL		●	▲		●	●	●	●	—	8.0	±0.04	0.4	28.8	6.0		1
GCM N125005-GF	—	—	—	—	—	—	—	●	—	1.25	±0.03	0.05	17.4	3.2	5	1
GCM N150005-GF	—	—	—	—	—	—	—	●	—	1.5	±0.03	0.05	17.8	3.7		1
GCM N2002-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.2	21.1	3.6		1
N2004-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GF		●	▲		●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-GF		●			●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GF		●	▲		●	●	●	●	●	4.0	±0.03	0.2	26.4	4.0		1
N4004-GF		●			●	●		●	●	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GF		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GF		●			●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GF		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GF		●			●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N7002-GF		●	▲		●	●	●	●	—	7.0	±0.04	0.2	28.8	5.5		1
N7004-GF		●	▲		●	●	●	●	—	7.0	±0.04	0.4	28.8	5.5		1
GCM N8002-GF		●	▲		●	●	●	●	—	8.0	±0.04	0.2	28.8	6.0		1
N8004-GF		●	▲		●	●	●	●	—	8.0	±0.04	0.4	28.8	6.0		1

Cut-off (Handed Edge)

Dimensions (mm)

Cat. No.	AC8035P	AC830P	AC5015S	AC5025S	AC520U	AC530U	AC1030U	Lead Angle PSI	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM R2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6	5	2
L2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6		2
GCM R3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
L3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
GCM R4002-CG-05	●	▲	●	●	●	●	—	5°	4.0	±0.04	0.2	26.7	4.0		2
L4002-CG-05	●	▲	●	●	●	●	—	5°	4.0	±0.04	0.2	26.7	4.0		2
GCM R20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6	5	2
L20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
GCM R20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
L20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2

GCM R: Right-handed, GCM L: Left-handed

Non-Ferrous Metals

Dimensions (mm)

Cat. No.	H10	DL1500	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCG N2002-GA	●	●	2.0	±0.025	0.2	21.1	3.6	5	3
N3002-GA	●	●	3.0	±0.025	0.2	21.1	3.8		3
GCG N4004-GA	●	●	4.0	±0.025	0.4	26.4	4.0		3
N5004-GA	●	●	5.0	±0.025	0.4	26.4	4.1		3
N6004-GA	●	●	6.0	±0.025	0.4	26.4	4.5		3

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Application
Grooving / Traverse Cutting	MG	Multi-functional / General-purpose
	ML	Multi-functional / Low feed
Grooving / Cut-off	GG	Grooving / General-purpose
	GL	Grooving / Low feed
	GF	Grooving / Low cutting force

Type	Symbol	Application
Cut-off (Handed Edge)	CG	Cut-off / General-purpose
	CF	Cut-off / Low cutting force
For Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose

Chipbreaker Selection F15 Precautions for Use F24 Recommended Cutting Conditions F21

Select holders and inserts with matching width of cut (CW). Not usable with GNDXL type / GNDIS type holders.

● mark: Standard stocked item (new product/expanded item) ▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability)

GNDL-J type

Cut-off | Internal Coolant

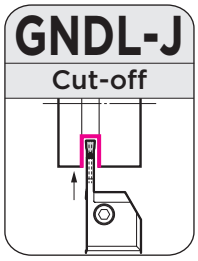


Fig 1

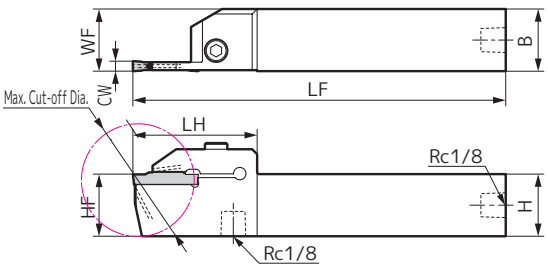


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Head LH	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Fig	Cap Screw	Cap Screw N·m	Plug	Wrench
GNDL R/L2020K-220J	●	●	20	20	125	20	20	44.5	**2.00**	**40**	GC□ □20○○-□□	1	BX0520	**6.0**	XP02	LH040
R/L2020K-320J	●	●	20	20	125	20	20	44.5	**3.00**	**40**	GC□ □30○○-□□	1				
R/L2020K-425J	●	●	20	20	125	20	20	50	**4.00**	**50**	GC□ □40○○-□□	1				
R/L2020K-525J	●	●	20	20	125	20	20	50	**5.00**	**50**	GC□ N50○○-□□	1				
R/L2020K-625J	●	●	20	20	125	20	20	50	**6.00**	**50**	GC□ N60○○-□□	1				
GNDL R/L2525K-220J	●	●	25	25	125	25	25	44.5	**2.00**	**40**	GC□ □20○○-□□	1	BX0520	**6.0**	XP02	LH040
R/L2525K-320J	●	●	25	25	125	25	25	44.5	**3.00**	**40**	GC□ □30○○-□□	1				
R/L2525K-425J	●	●	25	25	125	25	25	50	**4.00**	**50**	GC□ □40○○-□□	1				
R/L2525K-525J	●	●	25	25	125	25	25	50	**5.00**	**50**	GC□ N50○○-□□	1				
R/L2525K-625J	●	●	25	25	125	25	25	50	**6.00**	**50**	GC□ N60○○-□□	1				

Select holders and inserts with matching width of cut (CW). The maximum cut-off diameter indicated above is for inserts with RE = 0.2mm.
Refer to page F103 for applicable inserts.

Fig 1

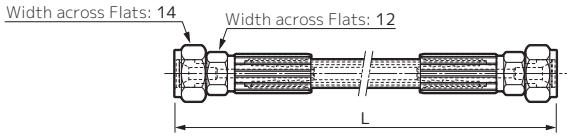


Fig 1

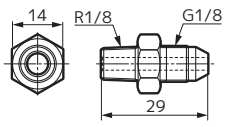
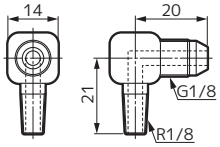


Fig 2



Parts (Hose)

Dimensions (mm)

Cat. No.	Stock	L	Screw Standard	Screw Standard	Fig
J-HOSE-G1/8-G1/8-200	●	200	G1/8	G1/8	1
J-HOSE-G1/8-G1/8-300	●	300	G1/8	G1/8	1

Hoses are sold separately.

Piping Method for Hoses and Connectors ☞F25

Parts (Connector)

Dimensions (mm)

Cat. No.	Stock	Screw Standard	Screw Standard	Fig
J-G1/8-R1/8-00	●	G1/8	R1/8	1
J-G1/8-R1/8-90	●	G1/8	R1/8	2

Connectors are sold separately.

Piping Method for Hoses and Connectors ☞F25

N·m Recommended Tightening Torque (N·m)

GNDL-J type

Expansion

Inserts for GNDL-J type

(Coated Carbide / Cermet / Cemented Carbide / DLC)

Fig 1

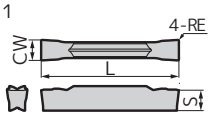
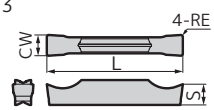


Fig 2 (Figure shows right-handed (R) tool.)

Fig 3



Grooving / Traverse Cutting

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N3002-MG	●	●		●	●	●		●	—	3.0	±0.03	0.2	21.1	3.8	5	1
N3004-MG	●	●	▲	●	●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-MG	●	●		●	●	●		●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-MG	●	●		●	●	●		●	—	4.0	±0.03	0.4	26.4	4.0		1
N4008-MG	●	●	▲	●	●	●	●	●	—	4.0	±0.03	0.8	26.4	4.0		1
GCM N5004-MG	●	●		●	●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
N5008-MG	●	●	▲	●	●	●	●	●	—	5.0	±0.03	0.8	26.4	4.1		1
GCM N6004-MG	●	●		●	●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
N6008-MG	●	●	▲	●	●	●	●	●	—	6.0	±0.03	0.8	26.4	4.5		1
GCM N2002-ML	—	—	—	—	●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-ML	●	●	▲	●	●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-ML	●	●		●	●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-ML	●	●		●	●	●		●	●	4.0	±0.03	0.2	26.4	4.0		1
N4004-ML	●	●	▲	●	●	●	●	●	●	4.0	±0.03	0.4	26.4	4.0		1
N4008-ML	●	●		●	●	●		●	●	4.0	±0.03	0.8	26.4	4.0		1
GCM N5004-ML	●	●	▲	●	●	●	●	●	—	5.0	±0.03	0.4	26.4	4.1		1
N5008-ML	●	●		●	●	●		●	—	5.0	±0.03	0.8	26.4	4.1		1
GCM N6004-ML	●	●	▲	●	●	●	●	●	—	6.0	±0.03	0.4	26.4	4.5		1
N6008-ML	●	●		●	●	●		●	—	6.0	±0.03	0.8	26.4	4.5		1

Grooving / Cut-off

Dimensions (mm)

Cat. No.	AC8025P	AC8035P	AC830P	AC425K	AC5015S	AC5025S	AC520U	AC530U	T2500A	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM N2002-GG		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6	5	1
GCM N3002-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GG		●	▲		●	●	●	●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GG		●	▲		●	●	●	●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-GG		●	▲		●	●	●	●	—	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GG		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GG		●	▲		●	●	●	●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GG		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GG		●	▲		●	●	●	●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N2002-GL		●	▲		●	●	●	●	—	2.0	±0.03	0.2	21.1	3.6		1
N2004-GL		●			●	●		●	—	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GL		●	▲		●	●	●	●	—	3.0	±0.03	0.2	21.1	3.8		1
N3004-GL		●			●	●		●	—	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GL		●	▲		●	●	●	●	—	4.0	±0.03	0.2	26.4	4.0		1
N4004-GL		●			●	●		●	—	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GL		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GL		●			●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GL		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GL		●			●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1
GCM N2002-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.2	21.1	3.6		1
N2004-GF	—	—	—	—	●	●		●	●	2.0	±0.03	0.4	21.1	3.6		1
GCM N3002-GF		●	▲		●	●	●	●	●	3.0	±0.03	0.2	21.1	3.8		1
N3004-GF		●			●	●		●	●	3.0	±0.03	0.4	21.1	3.8		1
GCM N4002-GF		●	▲		●	●	●	●	●	4.0	±0.03	0.2	26.4	4.0		1
N4004-GF		●			●	●		●	●	4.0	±0.03	0.4	26.4	4.0		1
GCM N5002-GF		●	▲		●	●	●	●	—	5.0	±0.03	0.2	26.4	4.1		1
N5004-GF		●			●	●		●	—	5.0	±0.03	0.4	26.4	4.1		1
GCM N6002-GF		●	▲		●	●	●	●	—	6.0	±0.03	0.2	26.4	4.5		1
N6004-GF		●			●	●		●	—	6.0	±0.03	0.4	26.4	4.5		1

Cut-off (Handed Edge)

Dimensions (mm)

Cat. No.	AC8035P	AC830P	AC5015S	AC5025S	AC520U	AC530U	AC1030U	Lead Angle PSI	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCM R2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6	5	2
L2002-CG-05	●	▲	●	●	●	●	—	5°	2.0	±0.03	0.2	21.1	3.6		2
GCM R3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
L3002-CG-05	●	▲	●	●	●	●	—	5°	3.0	±0.03	0.2	21.3	3.8		2
GCM R4002-CG-05	●	▲	●	●	●	●	—	5°	4.0	±0.04	0.2	26.7	4.0		2
L4002-CG-05	●	▲	●	●	●	●	—	5°	4.0	±0.04	0.2	26.7	4.0		2
GCM R20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6	5	2
L20003-CF-10	—	—	●	●	—	—	●	10°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-10	—	—	●	●	—	—	●	10°	3.0	±0.08	0.03	22.4	3.8		2
GCM R20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
L20003-CF-15	—	—	●	●	—	—	●	15°	2.0	±0.08	0.03	22.4	3.6		2
GCM R30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2
L30003-CF-15	—	—	●	●	—	—	●	15°	3.0	±0.08	0.03	22.4	3.8		2

GCM R: Right-handed, GCM L: Left-handed

Non-Ferrous Metals

Dimensions (mm)

Cat. No.	H10	DL1500	Width of Cut CW: Width of Cut	Tolerance	Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
GCG N2002-GA	●	●	2.0	±0.025	0.2	21.1	3.6	5	3
N3002-GA	●	●	3.0	±0.025	0.2	21.1	3.8		3
GCG N4004-GA	●	●	4.0	±0.025	0.4	26.4	4.0		3
N5004-GA	●	●	5.0	±0.025	0.4	26.4	4.1		3
N6004-GA	●	●	6.0	±0.025	0.4	26.4	4.5		3

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Application
Grooving / Traverse Cutting	MG	Multi-functional / General-purpose
	ML	Multi-functional / Low feed
Grooving / Cut-off	GG	Grooving / General-purpose
	GL	Grooving / Low feed
	GF	Grooving / Low cutting force

Type	Symbol	Application
Cut-off (Handed Edge)	CG	Cut-off / General-purpose
	CF	Cut-off / Low cutting force
For Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose

Chipbreaker Selection F15 Precautions for Use F24 Recommended Cutting Conditions F21

Select holders and inserts with matching width of cut (CW). Not usable with GNDXL type / GNDIS type holders.

● mark: Standard stocked item (new product/expanded item) ▲ mark: To be replaced by a new product, made to order, or discontinued (please confirm stock availability)

GNDXL type

Cut-off

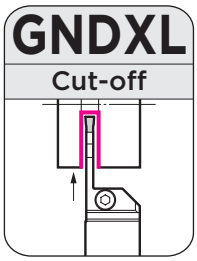


Fig 1

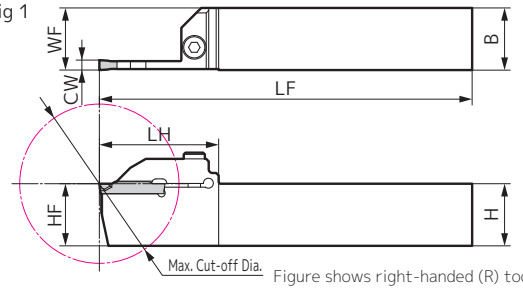


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock R	Stock L	Height H	Width B	Overall Length LF	Cutting Edge Distance WF	Cutting Edge Height HF	Head LH	Width of Cut CW	Max. Cut-off Dia.	Applicable Insert	Fig	Cap Screw	Cap Screw N·m	Wrench
GNDXL R/L2020K-226			20	20	125	20	20	42.0	**2.0**	**52**	GCM N2002-GF1	1	BX0520	**5.0**	LH040
R/L2020K-332	●	●	20	20	125	20	20	48.0	**3.0**	**64**	GCM N30○○-□□1	1			
R/L2020K-432	●	●	20	20	125	20	20	48.0	**4.0**	**64**	GCM N40○○-□□1	1			
R/L2020K-532	●	●	20	20	125	20	20	48.0	**5.0**	**64**	GCM N50○○-□□1	1			
R/L2020K-632	●	●	20	20	125	20	20	48.0	**6.0**	**64**	GCM N60○○-□□1	1			
GNDXL R/L2525M-226			25	25	150	25	25	42.0	**2.0**	**52**	GCM N2002-GF1	1	BX0520	**5.0**	LH040
R/L2525M-332	●	●	25	25	150	25	25	48.0	**3.0**	**64**	GCM N30○○-□□1	1			
R/L2525M-432	●	●	25	25	150	25	25	48.0	**4.0**	**64**	GCM N40○○-□□1	1			
R/L2525M-532	●	●	25	25	150	25	25	48.0	**5.0**	**64**	GCM N50○○-□□1	1			
R/L2525M-632	●	●	25	25	150	25	25	48.0	**6.0**	**64**	GCM N60○○-□□1	1			

Select holders and inserts with matching width of cut (CW). Only 1-cornered inserts can be used. Refer to page F105 for applicable inserts.

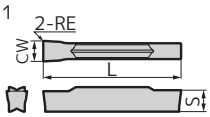
N·m Recommended Tightening Torque (N·m)

GNDXL type

Inserts for GNDXL type (1-cornered)

(Coated Carbide)

Fig 1



Grooving / Traverse Cutting (1-cornered)

Dimensions (mm)

Cat. No.	AC5015S	AC5025S	AC530U	Width of Cut CW		Corner Radius	Overall Length	Thickness	Pcs/Pack	Fig
				Width of Cut	Tolerance	RE	L	S		
GCM N3002-ML1	●	●	●	**3.0**	±0.03	0.2	21.1	3.8	5	1
N4004-ML1	●	●	●	**4.0**	±0.03	0.4	26.4	4.0		1
N5004-ML1	●	●	●	**5.0**	±0.03	0.4	26.4	4.1		1
N6004-ML1	●	●	●	**6.0**	±0.03	0.4	26.4	4.5		1

Grooving / Cut-off (1-cornered)

Dimensions (mm)

Cat. No.	AC5015S	AC5025S	AC530U	Width of Cut CW		Corner Radius	Overall Length	Thickness	Pcs/Pack	Fig
				Width of Cut	Tolerance	RE	L	S		
GCM N2002-GF1				**2.0**	±0.03	0.2	21.1	3.6	5	1
N3002-GF1	●	●	●	**3.0**	±0.03	0.2	21.1	3.8		1
N4002-GF1	●	●	●	**4.0**	±0.03	0.2	26.4	4.0		1
N5002-GF1	●	●	●	**5.0**	±0.03	0.2	26.4	4.1		1
N6002-GF1	●	●	●	**6.0**	±0.03	0.2	26.4	4.5		1

Select holders and inserts with matching width of cut (CW). Use in combination with GNDXL type holders. Not usable with GNDIS type holders.

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Application
Grooving / Traverse Cutting	**ML**	Multi-functional / Low feed
Grooving / Cut-off	**GF**	Grooving / Low cutting force

Chipbreaker Selection F15 Precautions for Use F24 Recommended Cutting Conditions F21

MEMO