

Cut-off Tools

F67 to F96

F

Cut-off
Tools

L

Grooving

Cut-off

Threading

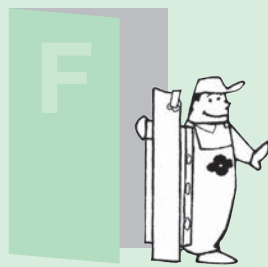
External

Face

Internal

Necking

CBN



Cut-off Tools		SEC-Cut-off Tool Holder series Selection Guide ... F68
		SumiGrip Introduction F69
	SumiGrip Jr.	STFH type F70
		STFS type F72
	SumiGrip	WCFH type F74
		WCFS type F76
	SEC-Small Diameter Cut-off Tool Holders	SCT type F78
	SEC-Cut-off Tool Holders	GNDM type / GNDL type (For Small Lathes) F80
		GNDM-J type / GNDL-J type (Internal Coolant Supply for Small Lathes) ... F82
		GNDS type F84
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		GNDM-J type (Internal Coolant Supply) F88
		GNDL type F90
		GNDL-J type (Internal Coolant Supply) F92
		 GNDXL type F94

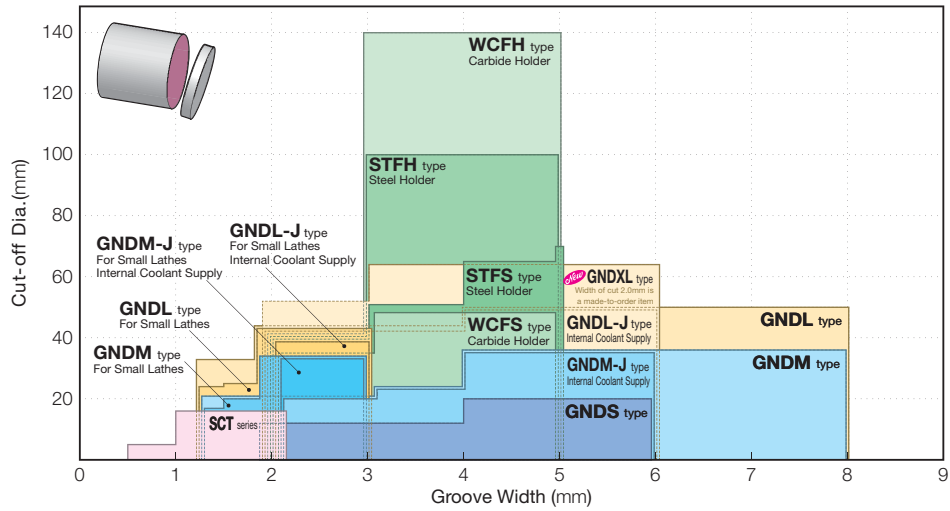
Stock Markings and Symbols

- 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)

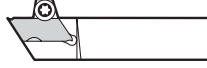

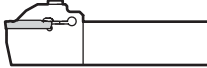

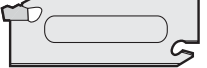
- * mark: Semi-standard stocked item (please confirm stock availability)
- mark: Stock or planned stock (please confirm stock availability)
- Blank: Made-to-order item
- mark: Not available

Selection Guide

Cut-off



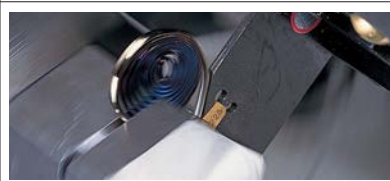


Range of Applications (For Solid Workpieces)

Applications	Series	Shape	Insert Shape (1) indicates no. of cutting edges	Cut-off Dia. (mm)				Features		
				25	50	75	100			
				Groove Width (mm)						
				2	4	6	8	10		
For Small Lathes	SCT	 → F78	 Right Hand / Left-handed / Neutral	16.0 2.0 0.5					<ul style="list-style-type: none"> Ground insert with good sharpness Can clamp even from behind 2-cornered type inserts 	
For Small to Medium Diameters	GND For Small Lathes GNDM/GNDM-J GNDL/GNDL-J	 → F80~	 Right Hand / Left-handed / Neutral	32.0 1.25 3.0					<ul style="list-style-type: none"> High-rigidity design and outstanding chip control Unground 2-cornered type inserts, available with widths starting at 1.25mm 	
	GND GNDS GNDM/GNDM-J GNDL/GNDL-J GNDXL	 → F84~	 Right Hand / Left-handed / Neutral	50.0 * 2.0 8.0					<ul style="list-style-type: none"> High-rigidity body, rigid clamping Outstanding chip control Unground 2-cornered type inserts 	
For Medium to Large Diameters	STFH STFS (SumiGrip Jr.)	 → F70 / F72	 Right Hand / Left-handed / Neutral	100.0 2.0 5.0					<ul style="list-style-type: none"> Can be used for large diameter cut-off up to ϕ100mm Economical steel shank 1-cornered self-grip type inserts 	
	WCFH WCFS (SumiGrip)	 → F74 / F76	 Right Hand / Left-handed / Neutral	140.0 2.0 5.0					<ul style="list-style-type: none"> Can be used for large diameter cut-off up to ϕ140mm High-rigidity carbide shank 1-cornered self-grip type inserts 	

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

Cut-off Tool series

SEC-Small Diameter Cut-off Tool Holders SCT series		<ul style="list-style-type: none"> Our first recommendation for small lathes Excellent sharpness suppresses cutting resistance and central pips 	
SEC-Cut-off Tool Holders GND series GNDS type GNDM/GNDM-J type GNDL type / GNDL-J type GNDXL type		<ul style="list-style-type: none"> Our first recommendation for small to medium diameters Enables stable cut-off thanks to high-rigidity body and rigid clamping 	
SEC-Cut-off Tool Holders STFH type / STFS type Steel Shank (SumiGrip Jr.) WCFH type / WCFS type Carbide Shank (SumiGrip)		<ul style="list-style-type: none"> Our first recommendation for medium to large diameters Blade type is also available for cut-off up to ϕ140mm 	

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CBN

SumiGrip

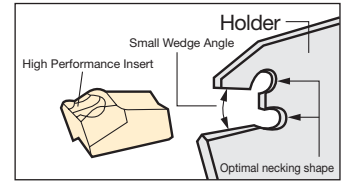


■ Features

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

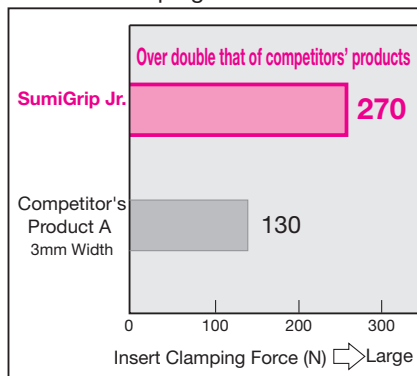
■ Types

- (1) Tool Block type
STFH type (Steel)/
WCFH type (Carbide)
- (2) Shank type
STFS type (Steel)/
WCFS type (Carbide)

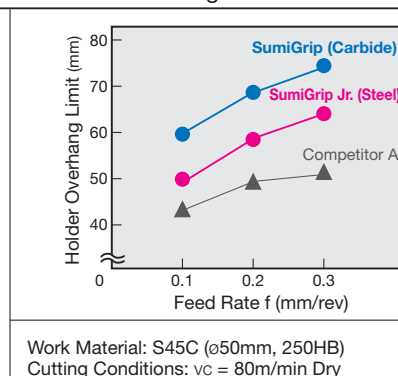


■ Cutting Performance (Holder)

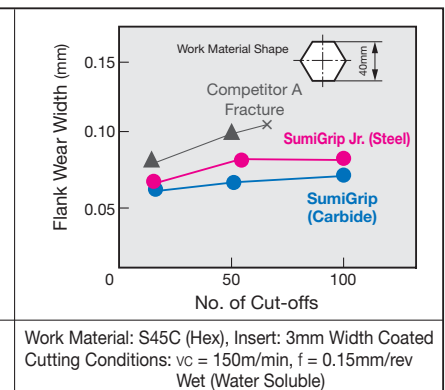
● Insert Clamping Force



● Holder Overhang



● Wear Resistance



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

- The grooving tool 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 blade, enable stable machining and prevent chattering even when machining stainless steel.
- Achieving stable long tool life with the AC1030U grade.

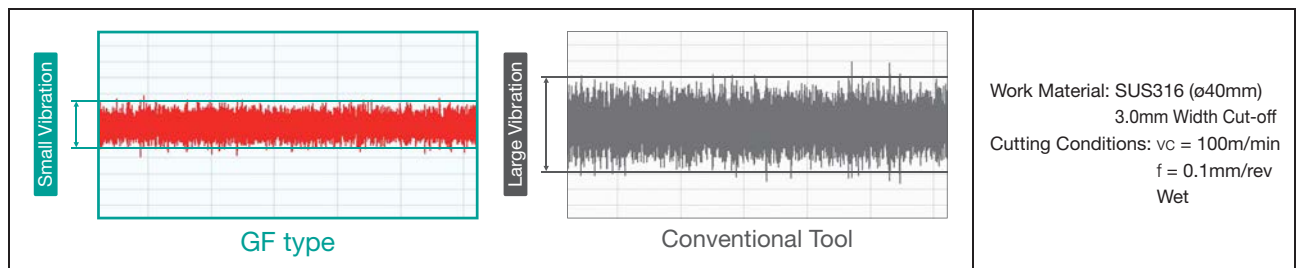


■ Cutting Performance (Chipbreaker)

● Chip Control (Performance)



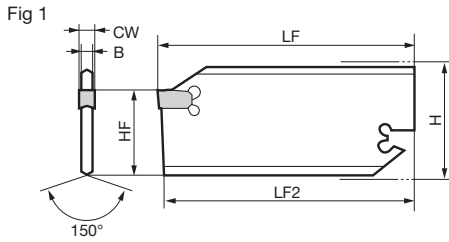
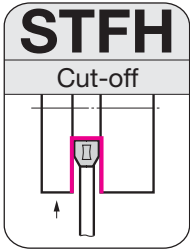
● Anti-Vibration Performance



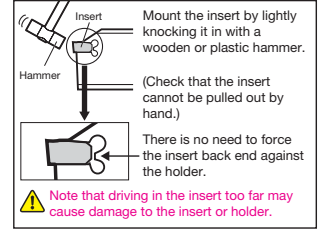
STFH type



Cut-off
(Steel Holder/Tool Block type)



● Insert Mounting Method



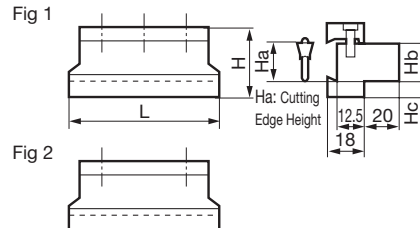
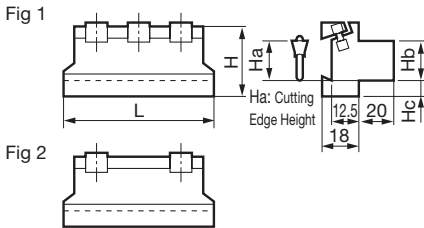
Cut-off Tools

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
STFH 26-3	●	26	2.4	109	21.4	108	3.0	70	WCFO3□		1	
STFH 26-4	●	26	3.4	109	21.4	108	4.0	70	WCFO4□		1	
STFH 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	1	
STFH 32-3	●	32	2.4	149	25.0	148	3.0	100	WCFO3□	SBN 25-32	1	
STFH 32-4	●	32	3.4	149	25.0	148	4.0	100	WCFO4□	SBU 20-32	1	
STFH 32-5	●	32	4.3	149	25.0	148	5.0	100	WCFO5□	SBU 25-32	1	

* The shape of STFH32-2 is slightly different from the above figure. Refer to F71 for applicable inserts.



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
SBN 20-32	●	20	20	13.5	50	100	1			
SBN 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	Cap Screw	Wrench
SBU 20-26	●	20	20	10.0	45	80	2	BCS15 BCS20 BCS25	BX0622	LH050
SBU 20-32	●	20	20	13.5	50	100	1			
SBU 25-32	●	25	25	8.5	50	110	1			

Tool Block type Selection Guide

Integrated type	<p>SBN type Example: SBN20-32</p> <p>Applicable to toolpost A shown on the right.</p>	<p>A General-purpose Lathe, etc. SBN type SBU type</p> <p>Toolpost Tool Block Spacer (Clamp from above)</p>	<p>B Turret type Toolpost, etc. SBU type</p> <p>Toolpost Tool Block Wedge (Clamp from the side)</p>
	<p>SBU type Example: SBU20-32</p> <p>Applicable to toolposts A B shown on the right. Large clamp plate ensures a wide clamp area that enables long holder overhang.</p>		

SumiGrip Jr. STFH type

Fig 1 (Neutral (N))

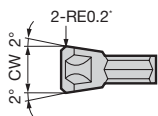


Fig 2 (Right Hand (R))

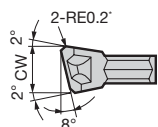
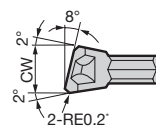


Fig 3 (Left Hand (L))



* WCF□ 2T: 2-RE0.15

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

Appearance	Cat. No.	AC830P	AC225	AC1030U	T1500A	A30	G10E	Width of Cut CW	Applicable Holder	Fig
WCF NO-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 NO-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	STFH ○○-3	3
	WCF R4-CF	—	—	●	—	—	—	4.0	STFH ○○-4	2
	WCF L4-CF	—	—	●	—	—	—	4.0	STFH ○○-4	3
WCF □2T Small Diameter Low Cutting Force	WCF N2T	●	—	—	—	—	—	2.0	STFH ○○-2	1
	WCF R2T	●	—	—	—	—	—	2.0	STFH ○○-2	2
	WCF L2T	●	—	—	—	—	—	2.0	STFH ○○-2	3
WCF □○ No Chipbreaker For General Steel	WCF N3	●	—	—	—	—	—	3.0	STFH ○○-3	1
	WCF R3	●	—	—	—	—	—	3.0	STFH ○○-3	2
	WCF L3	●	—	—	—	—	—	3.0	STFH ○○-3	3
	WCF N4	●	—	—	—	—	—	4.0	STFH ○○-4	1
	WCF R4	●	—	—	—	—	—	4.0	STFH ○○-4	2
	WCF L4	●	—	—	—	—	—	4.0	STFH ○○-4	3
	WCF N5	●	—	—	—	—	—	5.0	STFH ○○-5	1
	WCF R5	●	—	—	—	—	—	5.0	STFH ○○-5	2
	WCF L5	●	—	—	—	—	—	5.0	STFH ○○-5	3
	WCF □○A Exotic Alloy Low Feed	WCF N2A	—	●	—	—	—	—	2.0	STFH ○○-2
WCF N3A		—	●	—	●	●	—	3.0	STFH ○○-3	1
WCF R3A		—	●	—	—	●	—	3.0	STFH ○○-3	2
WCF L3A		—	●	—	—	—	—	3.0	STFH ○○-3	3
WCF N4A		—	●	—	●	—	—	4.0	STFH ○○-4	1
WCF R4A		—	●	—	—	—	—	4.0	STFH ○○-4	2
WCF L4A		—	●	—	—	—	—	4.0	STFH ○○-4	3
WCF N5A		—	●	—	—	—	—	5.0	STFH ○○-5	1
WCF R5A		—	●	—	—	—	—	5.0	STFH ○○-5	2
WCF L5A		—	●	—	—	—	—	5.0	STFH ○○-5	3
WCF □○B Cast Iron Light Alloys	WCF N3B	—	—	—	—	—	●	3.0	STFH ○○-3	1
	WCF R3B	—	—	—	—	—	●	3.0	STFH ○○-3	2
	WCF L3B	—	—	—	—	—	●	3.0	STFH ○○-3	3
	WCF N4B	—	—	—	—	—	●	4.0	STFH ○○-4	1
	WCF R4B	—	—	—	—	—	●	4.0	STFH ○○-4	2
	WCF L4B	—	—	—	—	—	●	4.0	STFH ○○-4	3
	WCF N5B	—	—	—	—	—	●	5.0	STFH ○○-5	1
	WCF R5B	—	—	—	—	—	●	5.0	STFH ○○-5	2
	WCF L5B	—	—	—	—	—	●	5.0	STFH ○○-5	3

* Same chipbreaker shape as the type for general steel (WCF□○), but with smaller cutting edge treatment.

Recommended Cutting Conditions

Work Material		Cutting Speed vc (m/min)					
		Coated Carbide			Cermet	Cemented Carbide	
		AC830P	AC225	AC1030U	T1500A	A30	G10E
P Steel	General Steel	80 to 200	80 to 200	50 to 200	80 to 200	50 to 120	—
	Mild Steel	100 to 230	100 to 230	50 to 230	100 to 230	70 to 150	—
	Die Steel	60 to 150	60 to 150	50 to 150	60 to 150	50 to 120	—
M Stainless Steel	70 to 150	60 to 150	50 to 150	—	70 to 130	—	
K Cast Iron	—	—	50 to 200	—	—	50 to 120	
N Non-Ferrous Metal	—	—	200 to 500	—	—	200 to 500	

Chipbreaker		Feed Rate f (mm/rev)										
		Neutral					Handed					
		GG	GF	No Chipbreaker	T	A	B	No Chipbreaker	CF	T	A	B
Width of Cut CW (mm)	2.0	0.05 to 0.20	0.03 to 0.12	—	0.03 to 0.10	0.03 to 0.12	—	—	—	0.03 to 0.10	—	—
	3.0	0.08 to 0.25	0.04 to 0.15	0.08 to 0.25	—	0.04 to 0.15	0.05 to 0.15	0.08 to 0.25	0.05 to 0.12	—	0.04 to 0.15	0.05 to 0.15
	4.0	0.10 to 0.30	0.05 to 0.18	0.10 to 0.30	—	0.05 to 0.18	0.05 to 0.18	0.10 to 0.30	0.05 to 0.12	—	0.05 to 0.18	0.05 to 0.18
	5.0	0.10 to 0.35	0.05 to 0.20	0.10 to 0.30	—	0.05 to 0.20	0.06 to 0.20	0.10 to 0.30	—	—	—	0.06 to 0.20

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SumiGrip Jr. STFS type



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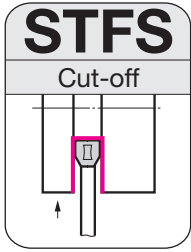
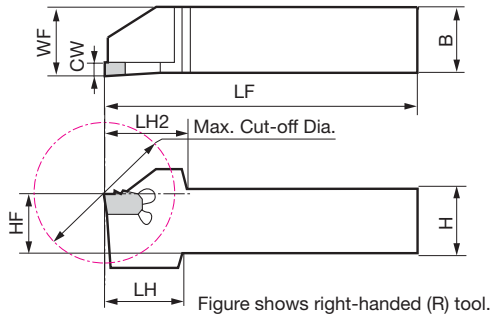
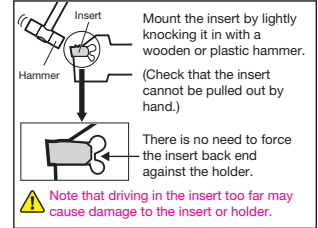


Fig 1



For Cut-off
(Steel Holder/Shank type)

● Insert Mounting Method



Holder

Parts Dimensions (mm)

Cat. No.	Stock		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	
	R	L												Fig	Wrench
STFS R/L1010-2	●	●	10	10	86	10	10	17	17	2.0	28	WCFO2□	1	SL-4	
STFS R/L1212-2	●	●	12	12	110	12	12	18	18	2.0	30				
STFS R/L1616-2	●	●	16	16	110	16	16	—	19	2.0	32				
STFS R/L2020-2	●	●	20	20	125	20	20	—	24	2.0	40				
STFS R/L1616-3	●	●	16	16	110	16	16	20	22	3.0	35	WCFO3□	1	SL-4	
STFS R/L2012-3	●	●	20	12	110	12	20	—	24	3.0	40				
STFS R/L2020-3	●	●	20	20	125	20	20	—	30	3.0	50				
STFS R/L2525-3	●	●	25	25	150	25	25	—	30	3.0	50				
STFS R/L2020-4	●	●	20	20	125	20	20	—	33	4.0	55	WCFO4□	1	SL-4	
STFS R/L2525-4	●	●	25	25	150	25	25	—	38	4.0	65				
STFS R/L2020-5	●	●	20	20	125	20	20	—	35	5.0	60	WCFO5□	1	SL-4	
STFS R/L2525-5	●	●	25	25	150	25	25	—	40	5.0	70				

Refer to F73 for applicable inserts.

Grooving

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CBN

SumiGrip Jr. STFS type

Fig 1 (Neutral (N))

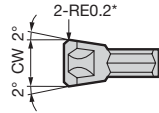


Fig 2 (Right Hand (R))

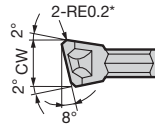
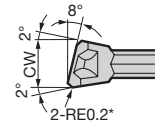


Fig 3 (Left Hand (L))



* WCF□ 2T: 2-RE0.15

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

Appearance	Cat. No.	Material					Width of Cut CW	Applicable Holder	Fig
		AC830P	AC225	AC1030U	T1500A	A30			
WCF NO-GG General-purpose	WCF N2-GG	●	—	—	—	—	2.0	STFS R/L0000-2	1
	WCF N3-GG	●	—	—	—	—	3.0	STFS R/L0000-3	1
	WCF N4-GG	●	—	—	—	—	4.0	STFS R/L0000-4	1
	WCF N5-GG	●	—	—	—	—	5.0	STFS R/L0000-5	1
WCF NO-GF Exotic Alloy Low Feed	WCF N2-GF	—	—	●	—	—	2.0	STFS R/L0000-2	1
	WCF N3-GF	—	—	●	—	—	3.0	STFS R/L0000-3	1
	WCF N4-GF	—	—	●	—	—	4.0	STFS R/L0000-4	1
	WCF N5-GF	—	—	●	—	—	5.0	STFS R/L0000-5	1
WCF □○-CF Exotic Alloy Low Feed (Handed)	WCF R3-CF	—	—	●	—	—	3.0	STFS R/L0000-3	2
	WCF L3-CF	—	—	●	—	—	3.0	STFS R/L0000-3	3
	WCF R4-CF	—	—	●	—	—	4.0	STFS R/L0000-4	2
	WCF L4-CF	—	—	●	—	—	4.0	STFS R/L0000-4	3
WCF □2T Small Diameter Low Cutting Force	WCF N2T	●	—	—	—	—	2.0	STFS R/L0000-2	1
	WCF R2T	●	—	—	—	—	2.0		2
	WCF L2T	●	—	—	—	—	2.0		3
WCF □○ No Chipbreaker For General Steel	WCF N3	●	—	—	—	—	3.0	STFS R/L0000-3	1
	WCF R3	●	—	—	—	—	3.0		2
	WCF L3	●	—	—	—	—	3.0		3
	WCF N4	●	—	—	—	—	4.0	STFS R/L0000-4	1
	WCF R4	●	—	—	—	—	4.0		2
	WCF L4	●	—	—	—	—	4.0		3
	WCF N5	●	—	—	—	—	5.0	STFS R/L0000-5	1
	WCF R5	●	—	—	—	—	5.0		2
	WCF L5	●	—	—	—	—	5.0		3
	WCF □○A Exotic Alloy Low Feed	WCF N2A	—	●	—	—	—	2.0	STFS R/L0000-2
WCF N3A		—	●	—	●	●	3.0	1	
WCF R3A		—	●	—	—	●	3.0	2	
WCF L3A		—	●	—	—	—	3.0	3	
WCF N4A		—	●	—	●	—	4.0	STFS R/L0000-4	1
WCF R4A		—	●	—	—	—	4.0		2
WCF L4A		—	●	—	—	—	4.0		3
WCF N5A		—	●	—	—	—	5.0	STFS R/L0000-5	1
WCF R5A	—	—	—	—	—	5.0	2		
WCF L5A	—	—	—	—	—	5.0	3		
WCF □○B Cast Iron Light Alloys	WCF N3B	—	—	—	—	●	3.0	STFS R/L0000-3	1
	WCF R3B	—	—	—	—	●	3.0		2
	WCF L3B	—	—	—	—	●	3.0		3
	WCF N4B	—	—	—	—	●	4.0	STFS R/L0000-4	1
	WCF R4B	—	—	—	—	●	4.0		2
	WCF L4B	—	—	—	—	●	4.0		3
	WCF N5B	—	—	—	—	●	5.0	STFS R/L0000-5	1
WCF R5B	—	—	—	—	●	5.0	2		
WCF L5B	—	—	—	—	●	5.0	3		

* Same chipbreaker shape as the type for general steel (WCF□○), but with smaller cutting edge treatment.

Recommended Cutting Conditions

Work Material		Cutting Speed vc (m/min)					
		Coated Carbide			Cermet	Cemented Carbide	
		AC830P	AC225	AC1030U	T1500A	A30	G10E
P Steel	General Steel	80 to 200	80 to 200	50 to 200	80 to 200	50 to 120	—
	Mild Steel	100 to 230	100 to 230	50 to 230	100 to 230	70 to 150	—
	Die Steel	60 to 150	60 to 150	50 to 150	60 to 150	50 to 120	—
M Stainless Steel	70 to 150	60 to 150	50 to 150	—	70 to 130	—	
K Cast Iron	—	—	50 to 200	—	—	50 to 120	
N Non-Ferrous Metal	—	—	200 to 500	—	—	200 to 500	

Chipbreaker		Feed Rate f (mm/rev)										
		Neutral					Handed					
		GG	GF	No Chipbreaker	T	A	B	No Chipbreaker	CF	T	A	B
Width of Cut CW (mm)	2.0	0.05 to 0.20	0.03 to 0.12	—	0.03 to 0.10	0.03 to 0.12	—	—	—	0.03 to 0.10	—	—
	3.0	0.08 to 0.25	0.04 to 0.15	0.08 to 0.25	—	0.04 to 0.15	0.05 to 0.15	0.08 to 0.25	0.05 to 0.12	—	0.04 to 0.15	0.05 to 0.15
	4.0	0.10 to 0.30	0.05 to 0.18	0.10 to 0.30	—	0.05 to 0.18	0.05 to 0.18	0.10 to 0.30	0.05 to 0.12	—	0.05 to 0.18	0.05 to 0.18
	5.0	0.10 to 0.35	0.05 to 0.20	0.10 to 0.30	—	0.05 to 0.20	0.06 to 0.20	0.10 to 0.30	—	—	—	0.06 to 0.20

Tools

Cut-off

Grooving

Cut-off

Threading

External

Face

Internal

Necking

CBN

SumiGrip WCFH type



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

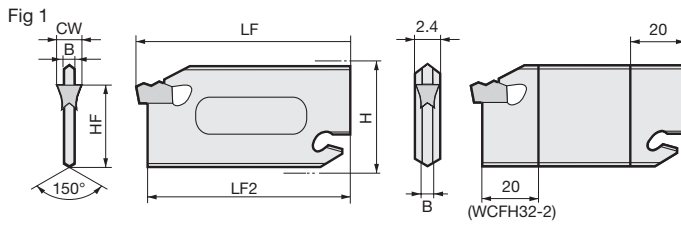
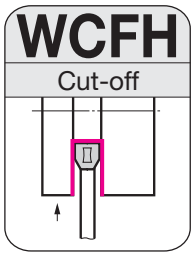
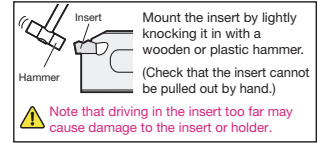


Figure shows right-handed (R) tool.

● Insert Mounting Method



Cut-off Tools

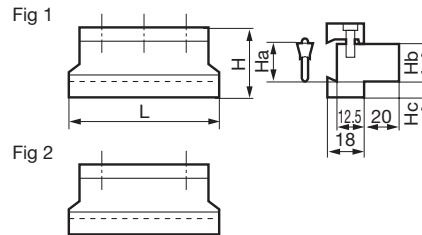
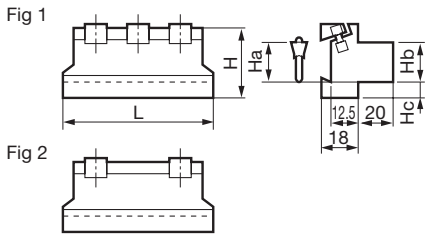
F

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	1	SL-2
WCFH 26-3	●	26	2.4	110	21.4	108.5	3.0	80	WCF□3○	SBU 20-26	1	SL-1
WCFH 26-4	●	26	3.4	110	21.4	108.5	4.0	80	WCF□4○		1	SL-1
WCFH 26-5	●	26	4.3	110	21.4	108.5	5.0	80	WCF□5○		1	SL-1
WCFH 32-2	●	32	1.7	150	25.0	149.0	2.0	40	WCF□2○	SBN 20-32	1	SL-2
WCFH 32-3	●	32	2.4	150	25.0	148.5	3.0	140	WCF□3○	SBN 25-32	1	SL-1
WCFH 32-4	●	32	3.4	150	25.0	148.5	4.0	140	WCF□4○	SBU 20-32	1	SL-1
WCFH 32-5	●	32	4.3	150	25.0	148.5	5.0	140	WCF□5○	SBU 25-32	1	SL-1

Refer to F75 for applicable inserts.



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			
SBN 20-32	●	20	20	13.5	50	100	1	BWS30	WB8-20	LH040
SBN 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	Cap Screw	Wrench
SBU 20-26	●	20	20	10.0	45	80	2	BCS15		
SBU 20-32	●	20	20	13.5	50	100	1	BCS20	BX0622	LH050
SBU 25-32	●	25	25	8.5	50	110	1	BCS25		

Tool Block type Selection Guide

Integrated type	<p>SBN type Example: SBN20-32</p> <p>• Applicable to toolpost A shown on the right.</p>	<p>A General-purpose Lathe, etc. SBN type SBU type</p> <p>(Clamp from above)</p>	<p>B Turret type Toolpost, etc. SBU type</p> <p>(Clamp from the side)</p>
	<p>SBU type Example: SBU20-32</p> <p>• Applicable to toolposts A B shown on the right. • Large clamp plate ensures a wide clamp area that enables long holder overhang.</p>		

Grooving

Cut-off

Threading

External

Face

Internal

Necking

CBN

SumiGrip WCFH type

Fig 1 (Neutral (N))

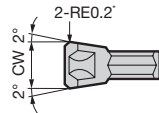


Fig 2 (Right Hand (R))

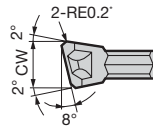
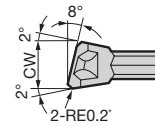


Fig 3 (Left Hand (L))



* WCF□ 2T: 2-RE0.15

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

Appearance	Cat. No.	AC830P	AC225	AC1030U	T1500A	A30	G10E	Width of Cut CW	Applicable Holder	Fig
WCF NO-GG General-purpose	WCF N2-GG	●	—	—	—	—	—	2.0	WCFH ○○-2	1
	WCF N3-GG	●	—	—	—	—	—	3.0	WCFH ○○-3	1
	WCF N4-GG	●	—	—	—	—	—	4.0	WCFH ○○-4	1
	WCF N5-GG	●	—	—	—	—	—	5.0	WCFH ○○-5	1
WCF NO-GF Exotic Alloy Low Feed	WCF N2-GF	—	—	●	—	—	—	2.0	WCFH ○○-2	1
	WCF N3-GF	—	—	●	—	—	—	3.0	WCFH ○○-3	1
	WCF N4-GF	—	—	●	—	—	—	4.0	WCFH ○○-4	1
	WCF N5-GF	—	—	●	—	—	—	5.0	WCFH ○○-5	1
WCF □○-CF Exotic Alloy Low Feed (Handed)	WCF R3-CF	—	—	●	—	—	—	3.0	WCFH ○○-3	2
	WCF L3-CF	—	—	●	—	—	—	3.0	WCFH ○○-3	3
	WCF R4-CF	—	—	●	—	—	—	4.0	WCFH ○○-4	2
	WCF L4-CF	—	—	●	—	—	—	4.0	WCFH ○○-4	3
WCF □2T Small Diameter Low Cutting Force	WCF N2T	●	—	—	—	—	—	2.0	WCFH ○○-2	1
	WCF R2T	●	—	—	—	—	—	2.0	WCFH ○○-2	2
	WCF L2T	●	—	—	—	—	—	2.0	WCFH ○○-2	3
WCF □○ No Chipbreaker For General Steel	WCF N3	●	—	—	—	—	—	3.0	WCFH ○○-3	1
	WCF R3	●	—	—	—	—	—	3.0	WCFH ○○-3	2
	WCF L3	●	—	—	—	—	—	3.0	WCFH ○○-3	3
	WCF N4	●	—	—	—	—	—	4.0	WCFH ○○-4	1
	WCF R4	●	—	—	—	—	—	4.0	WCFH ○○-4	2
	WCF L4	●	—	—	—	—	—	4.0	WCFH ○○-4	3
	WCF N5	●	—	—	—	—	—	5.0	WCFH ○○-5	1
	WCF R5	●	—	—	—	—	—	5.0	WCFH ○○-5	2
	WCF L5	●	—	—	—	—	—	5.0	WCFH ○○-5	3
WCF □○A Exotic Alloy Low Feed	WCF N2A	—	●	—	—	—	—	2.0	WCFH ○○-2	1
	WCF N3A	—	●	—	●	●	—	3.0	WCFH ○○-3	1
	WCF R3A	—	●	—	—	●	—	3.0	WCFH ○○-3	2
	WCF L3A	—	●	—	—	—	—	3.0	WCFH ○○-3	3
	WCF N4A	—	●	—	●	—	—	4.0	WCFH ○○-4	1
	WCF R4A	—	●	—	—	—	—	4.0	WCFH ○○-4	2
	WCF L4A	—	●	—	—	—	—	4.0	WCFH ○○-4	3
	WCF N5A	—	●	—	—	—	—	5.0	WCFH ○○-5	1
	WCF R5A	—	—	—	—	—	—	5.0	WCFH ○○-5	2
WCF L5A	—	—	—	—	—	—	5.0	WCFH ○○-5	3	
WCF □○B Cast Iron Light Alloys	WCF N3B	—	—	—	—	—	●	3.0	WCFH ○○-3	1
	WCF R3B	—	—	—	—	—	●	3.0	WCFH ○○-3	2
	WCF L3B	—	—	—	—	—	●	3.0	WCFH ○○-3	3
	WCF N4B	—	—	—	—	—	●	4.0	WCFH ○○-4	1
	WCF R4B	—	—	—	—	—	●	4.0	WCFH ○○-4	2
	WCF L4B	—	—	—	—	—	●	4.0	WCFH ○○-4	3
	WCF N5B	—	—	—	—	—	●	5.0	WCFH ○○-5	1
	WCF R5B	—	—	—	—	—	●	5.0	WCFH ○○-5	2
	WCF L5B	—	—	—	—	—	●	5.0	WCFH ○○-5	3

* Same chipbreaker shape as the type for general steel (WCF□○), but with smaller cutting edge treatment.

Recommended Cutting Conditions

Work Material		Cutting Speed vc (m/min)					
		Coated Carbide			Cermet	Cemented Carbide	
		AC830P	AC225	AC1030U	T1500A	A30	G10E
P Steel	General Steel	80 to 200	80 to 200	50 to 200	80 to 200	50 to 120	—
	Mild Steel	100 to 230	100 to 230	50 to 230	100 to 230	70 to 150	—
	Die Steel	60 to 150	60 to 150	50 to 150	60 to 150	50 to 120	—
M Stainless Steel	70 to 150	60 to 150	50 to 150	—	70 to 130	—	
K Cast Iron	—	—	50 to 200	—	—	50 to 120	
N Non-Ferrous Metal	—	—	200 to 500	—	—	200 to 500	

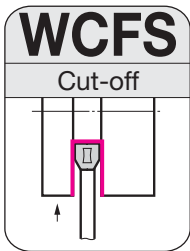
Chipbreaker	Feed Rate f (mm/rev)										
	Neutral						Handed				
	GG	GF	No Chipbreaker	T	A	B	No Chipbreaker	CF	T	A	B
	General-purpose	Exotic Alloy/Low Cutting Force type	General Steel	Small Diameter/Low Cutting Force	Exotic Alloy/Low Feed	Cast Iron/Light Alloys	General Steel	Exotic Alloy/Low Cutting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

Tools
Cut-off
Grooving
Cut-off
Threading
External
Face
Internal
Necking
CBN

SumiGrip WCFS type



For Cut-off
(Carbide Holder/Shank type)



Brazed Blade type

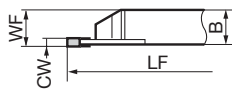


Fig 1

Blade Clamp type

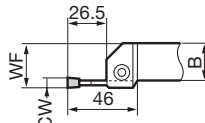


Fig 3

● Insert Mounting Method

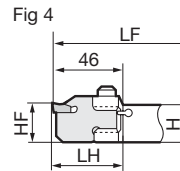
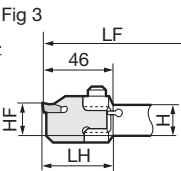
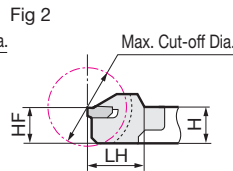
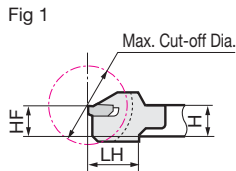
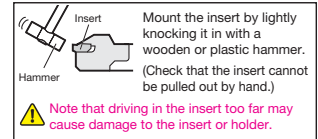


Figure shows right-handed (R) tool.

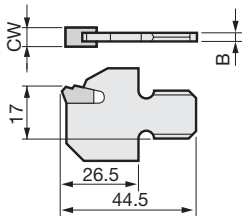
Holder

Parts Dimensions (mm)

Type	Cat. No.	Stock		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
		R	L											
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	
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 F77 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

SumiGrip WCFS type

Fig 1 (Neutral (N))

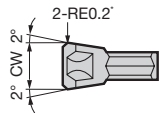


Fig 2 (Right Hand (R))

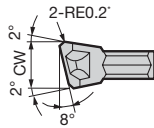
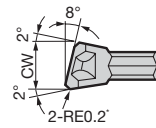


Fig 3 (Left Hand (L))



* WCF□ 2T: 2-RE0.15

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

Appearance	Cat. No.	Material						Width of Cut CW	Applicable Holder	Fig
		AC830P	AC225	AC1030U	T1500A	A30	G10E			
WCF NO-GG General-purpose	WCF N2-GG	●	—	—	—	—	—	2.0	WCFS R/L0000-2	1
	WCF N3-GG	●	—	—	—	—	—	3.0	WCFS R/L0000-3,WCFS R/LOO-3	1
	WCF N4-GG	●	—	—	—	—	—	4.0	WCFS R/LOO-4	1
	WCF N5-GG	●	—	—	—	—	—	5.0	WCFS R/LOO-5	1
WCF NO-GF Exotic Alloy Low Feed	WCF N2-GF	—	—	●	—	—	—	2.0	WCFS R/L0000-2	1
	WCF N3-GF	—	—	●	—	—	—	3.0	WCFS R/L0000-3,WCFS R/LOO-3	1
	WCF N4-GF	—	—	●	—	—	—	4.0	WCFS R/LOO-4	1
	WCF N5-GF	—	—	●	—	—	—	5.0	WCFS R/LOO-5	1
WCF □○-CF Exotic Alloy Low Feed (Handed)	WCF R3-CF	—	—	●	—	—	—	3.0	WCFS R/L0000-3	2
	WCF L3-CF	—	—	●	—	—	—	3.0	WCFS R/LOO-3	3
	WCF R4-CF	—	—	●	—	—	—	4.0	WCFS R/LOO-4	2
	WCF L4-CF	—	—	●	—	—	—	4.0	WCFS R/LOO-4	3
WCF □2T Small Diameter Low Cutting Force	WCF N2T	●	—	—	—	—	—	2.0	WCFS R/L0000-2	1
	WCF R2T	●	—	—	—	—	—	2.0	WCFS R/L0000-2	2
	WCF L2T	●	—	—	—	—	—	2.0	WCFS R/L0000-2	3
WCF □○ No Chipbreaker For General Steel	WCF N3	●	—	—	—	—	—	3.0	WCFS R/L0000-3	1
	WCF R3	●	—	—	—	—	—	3.0	WCFS R/L0000-3	2
	WCF L3	●	—	—	—	—	—	3.0	WCFS R/LOO-3	3
	WCF N4	●	—	—	—	—	—	4.0	WCFS R/LOO-4	1
	WCF R4	●	—	—	—	—	—	4.0	WCFS R/LOO-4	2
	WCF L4	●	—	—	—	—	—	4.0	WCFS R/LOO-4	3
	WCF N5	●	—	—	—	—	—	5.0	WCFS R/LOO-5	1
	WCF R5	●	—	—	—	—	—	5.0	WCFS R/LOO-5	2
	WCF L5	●	—	—	—	—	—	5.0	WCFS R/LOO-5	3
WCF □○A Exotic Alloy Low Feed	WCF N2A	—	●	—	—	—	—	2.0	WCFS R/L0000-2	1
	WCF N3A	—	●	—	●	●	—	3.0	WCFS R/L0000-3	1
	WCF R3A	—	●	—	—	●	—	3.0	WCFS R/L0000-3	2
	WCF L3A	—	●	—	—	—	—	3.0	WCFS R/LOO-3	3
	WCF N4A	—	●	—	●	—	—	4.0	WCFS R/LOO-4	1
	WCF R4A	—	●	—	—	—	—	4.0	WCFS R/LOO-4	2
	WCF L4A	—	●	—	—	—	—	4.0	WCFS R/LOO-4	3
	WCF N5A	—	●	—	—	—	—	5.0	WCFS R/LOO-5	1
	WCF R5A	—	●	—	—	—	—	5.0	WCFS R/LOO-5	2
WCF L5A	—	●	—	—	—	—	5.0	WCFS R/LOO-5	3	
WCF □○B Cast Iron Light Alloys	WCF N3B	—	—	—	—	—	●	3.0	WCFS R/L0000-3	1
	WCF R3B	—	—	—	—	—	●	3.0	WCFS R/L0000-3	2
	WCF L3B	—	—	—	—	—	●	3.0	WCFS R/LOO-3	3
	WCF N4B	—	—	—	—	—	●	4.0	WCFS R/LOO-4	1
	WCF R4B	—	—	—	—	—	●	4.0	WCFS R/LOO-4	2
	WCF L4B	—	—	—	—	—	●	4.0	WCFS R/LOO-4	3
	WCF N5B	—	—	—	—	—	●	5.0	WCFS R/LOO-5	1
	WCF R5B	—	—	—	—	—	●	5.0	WCFS R/LOO-5	2
	WCF L5B	—	—	—	—	—	●	5.0	WCFS R/LOO-5	3

* Same chipbreaker shape as the type for general steel (WCF□○), but with smaller cutting edge treatment.

Recommended Cutting Conditions

Work Material		Cutting Speed vc (m/min)					
		Coated Carbide			Cermet	Cemented Carbide	
		AC830P	AC225	AC1030U	T1500A	A30	G10E
P Steel	General Steel	80 to 200	80 to 200	50 to 200	80 to 200	50 to 120	—
	Mild Steel	100 to 230	100 to 230	50 to 230	100 to 230	70 to 150	—
	Die Steel	60 to 150	60 to 150	50 to 150	60 to 150	50 to 120	—
M Stainless Steel	70 to 150	60 to 150	50 to 150	—	70 to 130	—	
K Cast Iron	—	—	50 to 200	—	—	50 to 120	
N Non-Ferrous Metal	—	—	200 to 500	—	—	200 to 500	

Chipbreaker		Feed Rate f (mm/rev)										
		Neutral					Handed					
		GG	GF	No Chipbreaker	T	A	B	No Chipbreaker	CF	T	A	B
Width of Cut CW (mm)	2.0	0.05 to 0.20	0.03 to 0.12	—	0.03 to 0.10	0.03 to 0.12	—	—	—	0.03 to 0.10	—	—
	3.0	0.08 to 0.25	0.04 to 0.15	0.08 to 0.25	—	0.04 to 0.15	0.05 to 0.15	0.08 to 0.25	0.05 to 0.12	—	0.04 to 0.15	0.05 to 0.15
	4.0	0.10 to 0.30	0.05 to 0.18	0.10 to 0.30	—	0.05 to 0.18	0.05 to 0.18	0.10 to 0.30	0.05 to 0.12	—	0.05 to 0.18	0.05 to 0.18
	5.0	0.10 to 0.35	0.05 to 0.20	0.10 to 0.30	—	0.05 to 0.20	0.06 to 0.20	0.10 to 0.30	—	—	—	0.06 to 0.20

Tools
Cut-off
Grooving
Cut-off
Threading
External
Face
Internal
Necking
CBN

SCT type

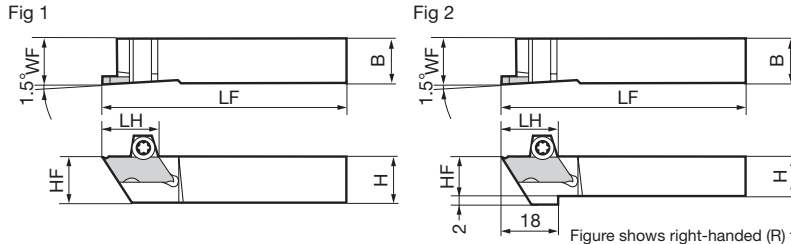
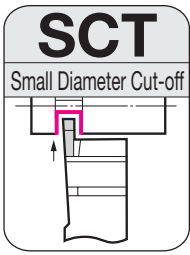


Figure shows right-handed (R) tool.



Cut-off Tools

F

Grooving

Cut-off

Threading

External

Face

Internal

Necking

CBN

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 R050000(-NB) CT R120000(-NB)	1		
SCT R1212	●	12	12	120	12	12	15		1		
SCT R1616	●	16	16	120	16	16	15		1		
SCT R1010-16	●	10	10	120	10	10	18	CT R160000(-NB)	2		
SCT R1212-16	●	12	12	120	12	12	18		1		
SCT R1616-16	●	16	16	120	16	16	18		1		

Holder (Left-Hand)

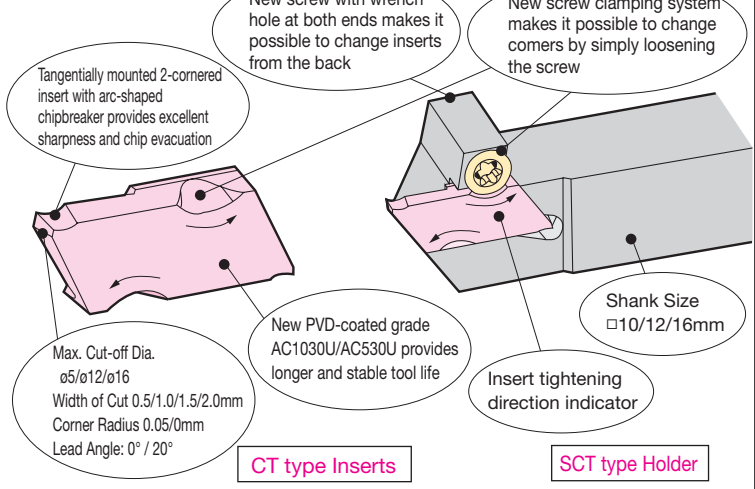
Parts Dimensions (mm)

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 L050000(-NB) CT L120000(-NB)	1		
SCT L1212	●	12	12	120	12	12	15		1		
SCT L1616	●	16	16	120	16	16	15		1		
SCT L1010-16	●	10	10	120	10	10	18	CT L160000(-NB)	2		
SCT L1212-16	●	12	12	120	12	12	18		1		
SCT L1616-16	●	16	16	120	16	16	18		1		

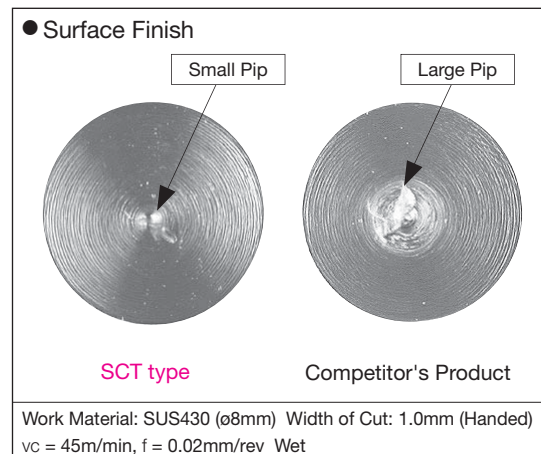
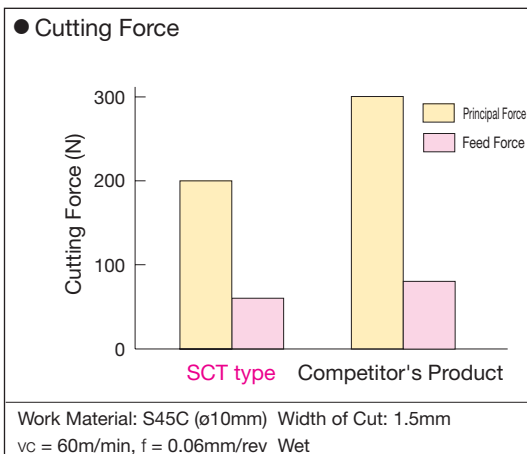
Features

- **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 center of the work face.
- **Long, Stable Tool Life**
PVD Coating
Long, stable tool life with AC1030U/AC530U

Design Features

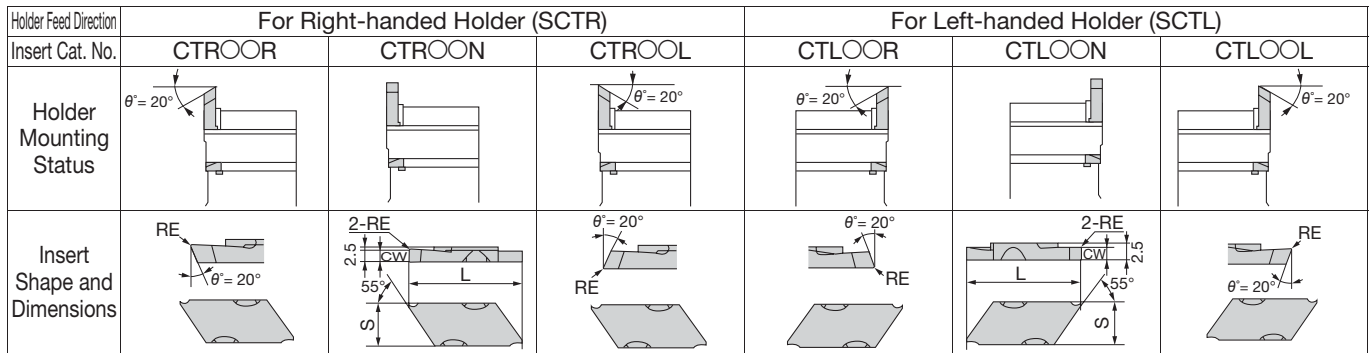


Cutting Performance



SCT type

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



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

Dimensions (mm)

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

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

Dimensions (mm)

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

Cut-off Tools

L

Grooving

Cut-off

Threading

External

Face

Internal

Necking

CBN

GNDM type / GNDL type



Cut-off Tools

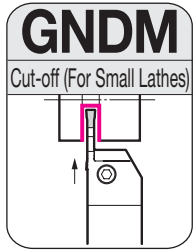


Fig 1

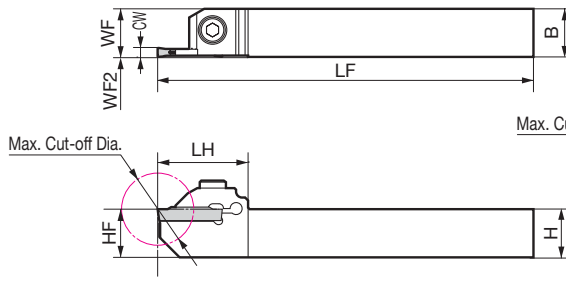


Fig 2

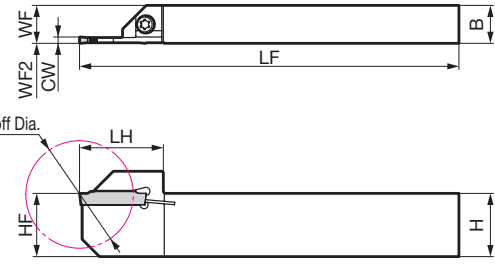


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		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		Wrench
	R	L												BFTX0414	N-m	
GNDM R/L1616JX-1.2508	●	●	16	16	120	(16)	16	26	0	1.25	16	GCM N125005-GF	1	BX0515	4.0	LH040
GNDM R/L1616JX-1.510	●	●	16	16	120	(16)	16	26	0	1.50	20	GCM N150005-GF	1	BX0515	4.0	LH040
GNDM R/L1616JX-212	●	●	16	16	120	(16)	16	30	0	2.00	24	GC □ □20○○-□□	1	BX0515	4.0	LH040
GNDM R/L1616JX-312	●	●	16	16	120	(16)	16	30	0	3.00	24	GC □ □30○○-□□	1	BX0515	4.0	LH040
GNDM R/L2012JX-217	●	●	20	12	120	(12)	20	26.5	0	2.00	34	GC □ □20○○-□□	2	BFTX0414	3.0	LT15-10
GNDM R/L2012JX-317	●	●	20	12	120	(12)	20	26.5	0	3.00	34	GC □ □30○○-□□	2	BFTX0414	3.0	LT15-10

Select holders and inserts with matching width of cut (CW). Refer to F81 for applicable inserts.

Grooving

Cut-off

Threading



External

Face

Internal

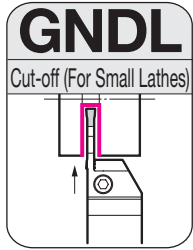


Fig 1

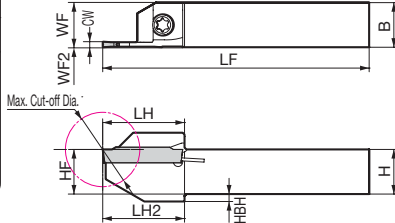


Fig 2

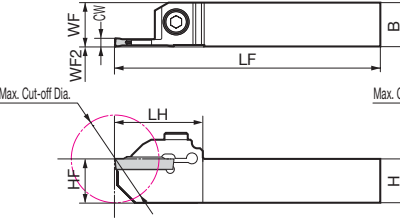


Fig 3

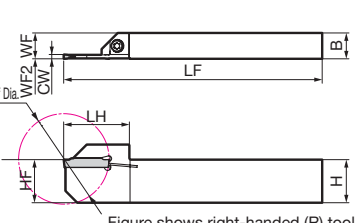


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		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		Wrench
	R	L														BFTX0412N	N-m	
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
GNDL R/L1010JX-1.510	●	●	10	10	120	(10)	10	2.0	18	18.3	0	1.50	20	GCM N150005-GF	1	BFTX0412N	3.0	LT15-10
GNDL R/L1010JX-210	●	●	10	10	120	(10)	10	2.0	22	22.3	0	2.00	20	GC □ □20○○-□□	1	BFTX0412N	3.0	LT15-10
GNDL R/L1010JX-310	●	●	10	10	120	(10)	10	2.0	22	22.3	0	3.00	20	GC □ □30○○-□□	1	BFTX0412N	3.0	LT15-10
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
GNDL R/L1212JX-1.512	●	●	12	12	120	(12)	12	2.0	19	19.3	0	1.50	24	GCM N150005-GF	1	BFTX0412N	3.0	LT15-10
GNDL R/L1212JX-212.5	●	●	12	12	120	(12)	12	2.0	22	22.3	0	2.00	25	GC □ □20○○-□□	1	BFTX0412N	3.0	LT15-10
GNDL R/L1212JX-312.5	●	●	12	12	120	(12)	12	2.0	22	22.3	0	3.00	25	GC □ □30○○-□□	1	BFTX0412N	3.0	LT15-10
GNDL R/L1616JX-1.2512.5	●	●	16	16	120	(16)	16	—	28	—	0	1.25	20	GCM N125005-GF	2	BX0515	4.0	LH040
GNDL R/L1616JX-1.512.5	●	●	16	16	120	(16)	16	—	28	—	0	1.50	25	GCM N150005-GF	2	BX0515	4.0	LH040
GNDL R/L1616JX-216	●	●	16	16	120	(16)	16	—	32	—	0	2.00	32	GC □ □20○○-□□	2	BX0515	4.0	LH040
GNDL R/L1616JX-316	●	●	16	16	120	(16)	16	—	32	—	0	3.00	32	GC □ □30○○-□□	2	BX0515	4.0	LH040
GNDL R/L2012JX-221	●	●	20	12	120	(12)	20	—	30.5	—	0	2.00	42	GC □ □20○○-□□	3	BFTX0414	3.0	LT15-10
GNDL R/L2012JX-321	●	●	20	12	120	(12)	20	—	30.5	—	0	3.00	42	GC □ □30○○-□□	3	BFTX0414	3.0	LT15-10

Select holders and inserts with matching width of cut (CW). Refer to F81 for applicable inserts.

Necking

CBN

GNDM type / GNDL type

Inserts for GNDM type (For Small Lathes)/GNDL type (For Small Lathes) (Coated Carbide/ Cermet/ Cemented Carbide)

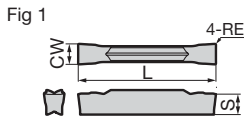
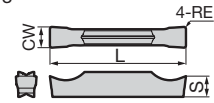


Fig 2 (Figure shows right-handed (R) tool.)



Fig 3



Grooving / Traverse Cutting

Dimensions (mm)

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

Cut-off (Handed Edge)

Dimensions (mm)

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

GCMR: Right-handed, GCML: Left-handed

Grooving / Cut-off

Dimensions (mm)

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

Non-Ferrous Metals

Dimensions (mm)

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

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Applications	Type	Symbol	Applications
Grooving / Traverse Cutting	MG ML	Multi-functional / General-purpose Multi-functional / Low-feed	Cut-off (Handed Edge)	CG CF	Cut-off / General-purpose Cut-off / Low cutting force
Grooving / Cut-off	GG GL GF	Grooving / General-purpose Grooving / Low-feed Grooving / Low cutting force	Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose

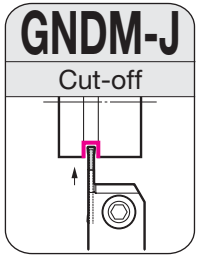
Chipbreaker Selection **F13** Precautions for Use **F22** Recommended Cutting Conditions **F19**

Note: The values in red have been changed from those in the 2021-2022 General Catalogue.

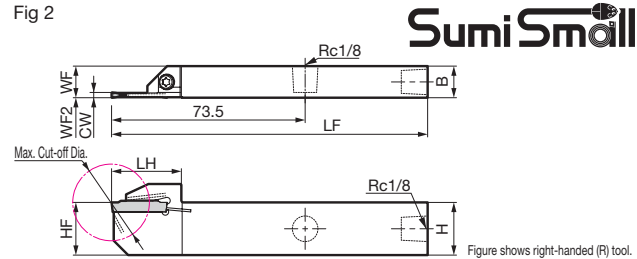
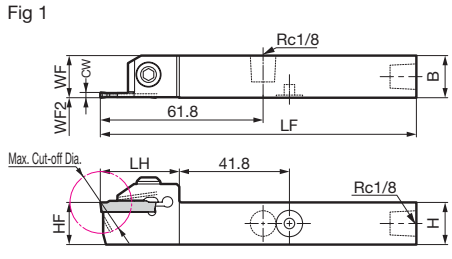
Select holders and inserts with matching width of cut (CW). Not usable with GNDXL type / GNDIS type holders.

GNDM-J type / GNDL-J type

Cut-off Tools



- Cut-off
- Zero Offset
- Internal Coolant



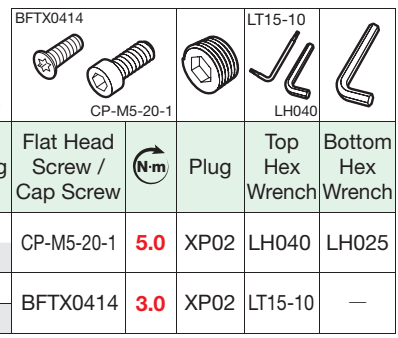
F

Holder

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

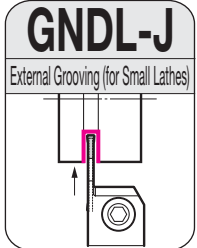
Select holders and inserts with matching width of cut (CW). Refer to F83 for applicable inserts.

Parts

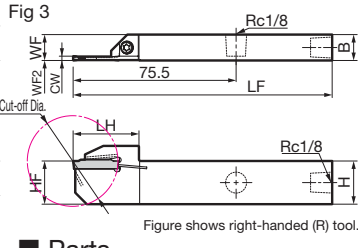
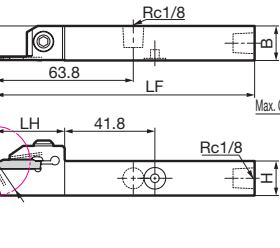
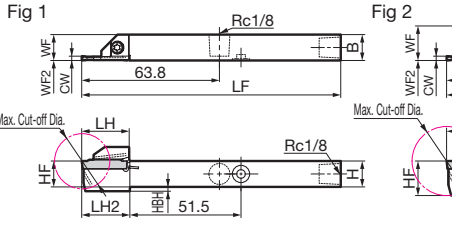


Cut-off

Threading



- Cut-off
- Zero Offset
- Internal Coolant

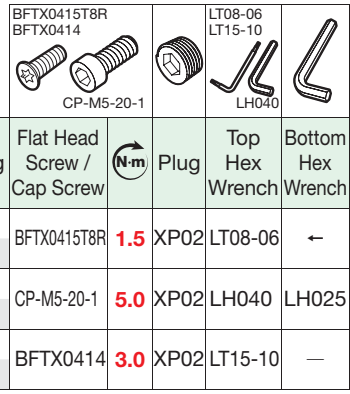


Holder

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

Select holders and inserts with matching width of cut (CW). Refer to F83 for applicable inserts.

Parts

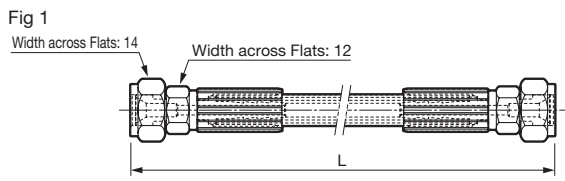


External

Internal

Necking

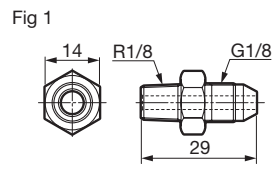
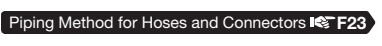
CBN



Parts (Hose)

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

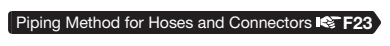
Hoses are sold separately.



Parts (Connector)

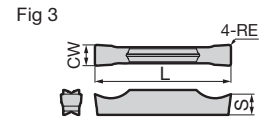
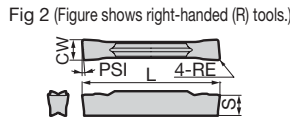
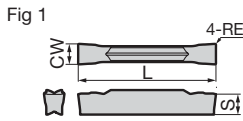
Cat. No.	Stock	Screw Standard	Screw Standard	Fig
J-G1/8-R1/8-00	●	G1/8	R1/8	1
J-G1/8-R1/8-90	●	G1/8	R1/8	2

Connectors are sold separately.



GNDM-J type / GNDL-J type

Inserts for GNDM-J type (For Small Lathes)/GNDL-J type (For Small Lathes) (Coated Carbide/ Cermet/ Cemented Carbide)



Grooving / Traverse Cutting

Dimensions (mm)

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

Cut-off (Handed Edge)

Dimensions (mm)

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

GCMR: Right-handed, GCML: Left-handed

Grooving / Cut-off

Dimensions (mm)

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

Non-Ferrous Metals

Dimensions (mm)

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

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Applications	Type	Symbol	Applications
Grooving / Traverse Cutting	MG	Multi-functional / General-purpose	Cut-off (Handed Edge)	CG	Cut-off / General-purpose
	ML	Multi-functional / Low-feed		CF	Cut-off / Low cutting force
Grooving / Cut-off	GG	Grooving / General-purpose	Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose
	GL	Grooving / Low-feed			
	GF	Grooving / Low cutting force			

Chipbreaker Selection **F13** Precautions for Use **F22** Recommended Cutting Conditions **F19**

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

GNDS type



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

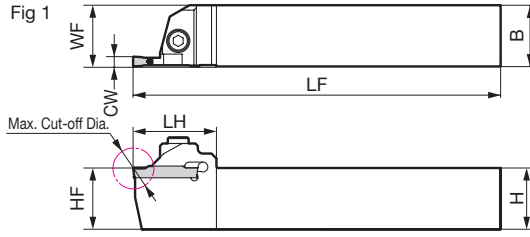
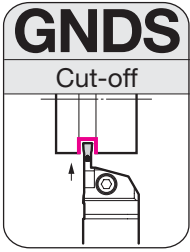


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		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	Parts		
	R	L											Cap Screw	Wrench	
GNDS R/L2020K-206	●	●	20	20	125	20	20	30	2.0	12	GC□ □20○○-□□	1	BX0520	5.0	LH040
GNDS R/L2020K-306	●	●	20	20	125	20	20	30	3.0	12	GC□ □30○○-□□	1			
GNDS R/L2020K-410	●	●	20	20	125	20	20	34	4.0	20	GC□ □40○○-□□	1			
GNDS R/L2020K-510	●	●	20	20	125	20	20	34	5.0	20	GC□ N50○○-□□	1			
GNDS 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
GNDS R/L2525M-306	●	●	25	25	150	25	25	30	3.0	12	GC□ □30○○-□□	1			
GNDS R/L2525M-410	●	●	25	25	150	25	25	34	4.0	20	GC□ □40○○-□□	1			
GNDS R/L2525M-510	●	●	25	25	150	25	25	34	5.0	20	GC□ N50○○-□□	1			
GNDS 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 F85 for applicable inserts.

Cut-off Tools

Grooving

Cut-off

Threading

External

Face

Internal

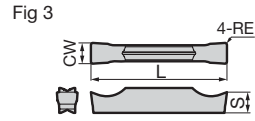
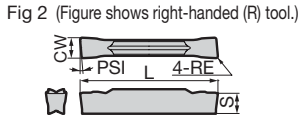
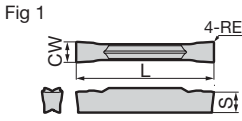
Necking

CBN

GNDS type

Inserts for GNDS type

(Yellow Coated Carbide / Pink Cermet / White Cemented Carbide)



Grooving / Traverse Cutting

Dimensions (mm)

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

Cut-off (Handed Edge)

Dimensions (mm)

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

GCMR: Right-handed, GCML: Left-handed

Grooving / Cut-off

Dimensions (mm)

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

Non-Ferrous Metals

Dimensions (mm)

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

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Applications	Type	Symbol	Applications
Grooving / Traverse Cutting	MG	Multi-functional / General-purpose	Cut-off (Handed Edge)	CG	Cut-off / General-purpose
	ML	Multi-functional / Low-feed		CF	Cut-off / Low cutting force
Grooving / Cut-off	GG	Grooving / General-purpose	Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose
	GL	Grooving / Low-feed			
	GF	Grooving / Low cutting force			

Chipbreaker Selection F13 Precautions for Use F22 Recommended Cutting Conditions F19

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

Cut-off Tools

L

Grooving

Cut-off

Threading

External

Face

Internal

Necking

CBN

GNDM type

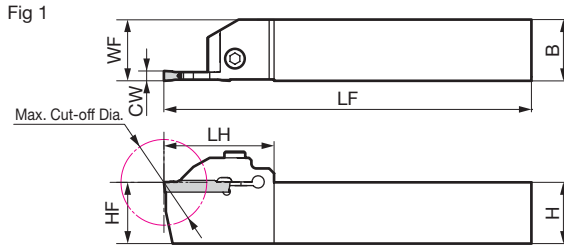
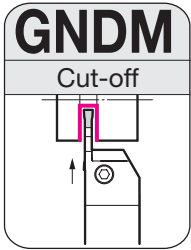


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		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	Parts		
	R	L											Flat Head Screw	Wrench	
GNDM R/L2020K-1.2510	●	●	20	20	125	20	20	34.0	1.25	20	GCM N125005-GF	1	BX0520	5.0	LH040
GNDM R/L2020K-1.510	●	●	20	20	125	20	20	34.0	1.50	20	GCM N150005-GF	1			
GNDM R/L2020K-210	●	●	20	20	125	20	20	33.6	2.00	20	GC □ 20○○-□□	1			
GNDM R/L2020K-312	●	●	20	20	125	20	20	36.6	3.00	24	GC □ 30○○-□□	1			
GNDM R/L2020K-418	●	●	20	20	125	20	20	45.0	4.00	36	GC □ 40○○-□□	1			
GNDM R/L2020K-518	●	●	20	20	125	20	20	45.0	5.00	36	GC □ N50○○-□□	1			
GNDM 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
GNDM R/L2525M-1.510	●	●	25	25	150	25	25	36.0	1.50	20	GCM N150005-GF	1			
GNDM R/L2525M-210	●	●	25	25	150	25	25	33.6	2.00	20	GC □ 20○○-□□	1			
GNDM R/L2525M-312	●	●	25	25	150	25	25	36.6	3.00	24	GC □ 30○○-□□	1			
GNDM R/L2525M-418	●	●	25	25	150	25	25	45.0	4.00	36	GC □ 40○○-□□	1			
GNDM R/L2525M-518	●	●	25	25	150	25	25	45.0	5.00	36	GC □ N50○○-□□	1			
GNDM 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
GNDM R/L3225P-418			32	25	170	25	32	45.0	4.00	36	GC □ 40○○-□□	1			
GNDM R/L3225P-518			32	25	170	25	32	45.0	5.00	36	GC □ N50○○-□□	1			
GNDM R/L3225P-618			32	25	170	25	32	45.0	6.00	36	GC □ N60○○-□□	1	BX0620	6.0	LH050
GNDM R/L3225P-718			32	25	170	25	32	50.0	7.00	36	GCM N70○○-□□	1			
GNDM 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
GNDM R/L3232P-418	●	●	32	32	170	32	32	45.0	4.00	36	GC □ 40○○-□□	1			
GNDM R/L3232P-518	●	●	32	32	170	32	32	45.0	5.00	36	GC □ N50○○-□□	1			
GNDM R/L3232P-618	●	●	32	32	170	32	32	45.0	6.00	36	GC □ N60○○-□□	1			
GNDM R/L3232P-718	●	●	32	32	170	32	32	50.0	7.00	36	GCM N70○○-□□	1			
GNDM 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 F87 for applicable inserts.

Cut-off Tools

Grooving

Cut-off

Threading

External

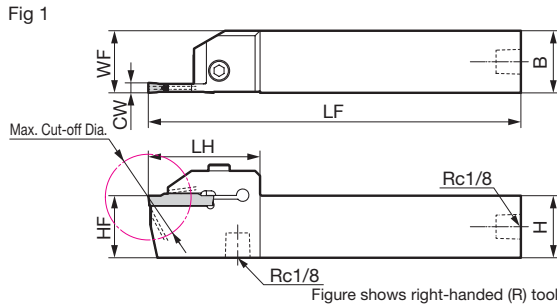
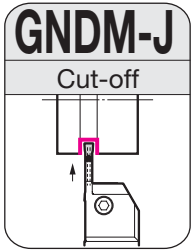
Face

Internal

Necking

CBN

GNDM-J type



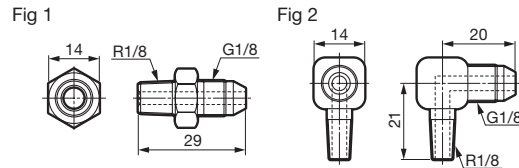
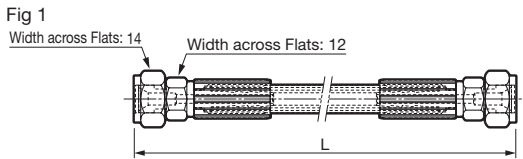
Holder

Parts

Dimensions (mm)

Cat. No.	Stock		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	Plug	Wrench
	R	L											(N·m)		
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 F89 for applicable inserts.



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 **F23**

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 **F23**

Cut-off Tools

F

Grooving

Cut-off

Threading

External

Face

Internal

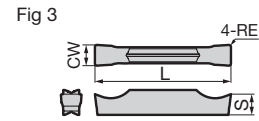
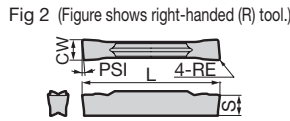
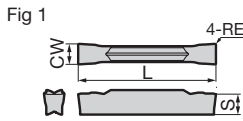
Necking

CBN

GNDM-J type

Inserts for GNDM-J type

(Coated Carbide/ Cermet/ Cemented Carbide)



Grooving / Traverse Cutting

Dimensions (mm)

Cat. No.	Width of Cut CW							Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
	Width of Cut		Tolerance	RE	L	S	Pcs/Pack					
	Width of Cut	Tolerance										
GCM N3002-MG N3004-MG	3.0	±0.03	0.2	21.1	3.8	5	1					
GCM N4002-MG N4004-MG N4008-MG	4.0	±0.03	0.2	26.4	4.0	1	1					
GCM N5004-MG N5008-MG	5.0	±0.03	0.4	26.4	4.1	1	1					
GCM N6004-MG N6008-MG	6.0	±0.03	0.4	26.4	4.5	1	1					
GCM N2002-ML N3002-ML N3004-ML	2.0	±0.03	0.2	21.1	3.6	5	1					
GCM N4002-ML N4004-ML N4008-ML	4.0	±0.03	0.2	26.4	4.0	1	1					
GCM N5004-ML N5008-ML	5.0	±0.03	0.4	26.4	4.1	1	1					
GCM N6004-ML N6008-ML	6.0	±0.03	0.4	26.4	4.5	1	1					

Cut-off (Handed Edge)

Dimensions (mm)

Cat. No.	Width of Cut CW							Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
	Width of Cut		Tolerance	RE	L	S	Pcs/Pack					
	Width of Cut	Tolerance										
GCM R2002-CG-05 L2002-CG-05	2.0	±0.03	0.2	21.1	3.6	5	2					
GCM R3002-CG-05 L3002-CG-05	3.0	±0.03	0.2	21.3	3.8	2	2					
GCM R4002-CG-05 L4002-CG-05	4.0	±0.04	0.2	26.7	4.0	2	2					
GCM R20003-CF-10 L20003-CF-10	2.0	±0.08	0.03	22.4	3.6	5	2					
GCM R30003-CF-10 L30003-CF-10	3.0	±0.08	0.03	22.4	3.8	2	2					
GCM R20003-CF-15 L20003-CF-15	2.0	±0.08	0.03	22.4	3.6	2	2					
GCM R30003-CF-15 L30003-CF-15	3.0	±0.08	0.03	22.4	3.8	2	2					

GCMR: Right-handed, GCML: Left-handed

Grooving / Cut-off

Dimensions (mm)

Cat. No.	Width of Cut CW							Corner Radius RE	Overall Length L	Thickness S	Pcs/Pack	Fig
	Width of Cut		Tolerance	RE	L	S	Pcs/Pack					
	Width of Cut	Tolerance										
GCM N2002-GG N3002-GG N3004-GG	2.0	±0.03	0.2	21.1	3.6	5	1					
GCM N4002-GG N4004-GG	4.0	±0.03	0.2	26.4	4.0	1	1					
GCM N5002-GG N5004-GG	5.0	±0.03	0.2	26.4	4.1	1	1					
GCM N6002-GG N6004-GG	6.0	±0.03	0.2	26.4	4.5	1	1					
GCM N2002-GL N2004-GL	2.0	±0.03	0.2	21.1	3.6	5	1					
GCM N3002-GL N3004-GL	3.0	±0.03	0.2	21.1	3.8	1	1					
GCM N4002-GL N4004-GL	4.0	±0.03	0.2	26.4	4.0	1	1					
GCM N5002-GL N5004-GL	5.0	±0.03	0.2	26.4	4.1	1	1					
GCM N6002-GL N6004-GL	6.0	±0.03	0.2	26.4	4.5	1	1					
GCM N2002-GF N2004-GF	2.0	±0.03	0.2	21.1	3.6	5	1					
GCM N3002-GF N3004-GF	3.0	±0.03	0.2	21.1	3.8	1	1					
GCM N4002-GF N4004-GF	4.0	±0.03	0.2	26.4	4.0	1	1					
GCM N5002-GF N5004-GF	5.0	±0.03	0.2	26.4	4.1	1	1					
GCM N6002-GF N6004-GF	6.0	±0.03	0.2	26.4	4.5	1	1					

Non-Ferrous Metals

Dimensions (mm)

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

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Applications	Type	Symbol	Applications
Grooving / Traverse Cutting	MG ML	Multi-functional / General-purpose Multi-functional / Low-feed	Cut-off (Handed Edge)	CG CF	Cut-off / General-purpose Cut-off / Low cutting force
Grooving / Cut-off	GG GL GF	Grooving / General-purpose Grooving / Low-feed Grooving / Low cutting force	Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose

Chipbreaker Selection **F13** Precautions for Use **F22** Recommended Cutting Conditions **F19**

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

GNDL type

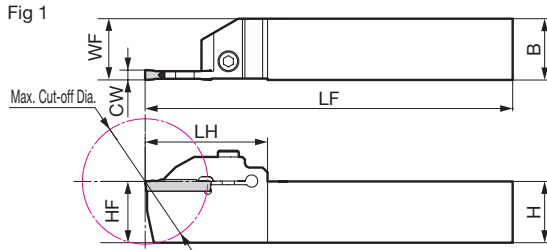
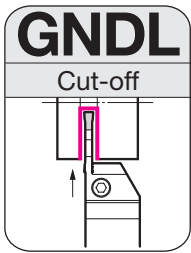


Figure shows right-handed (R) tool.

Holder

Parts

Dimensions (mm)

Cat. No.	Stock		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		Wrench
	R	L											BX0520	N-m	
GNDL R/L2020K-1.2516	●	●	20	20	125	20	20	38.0	1.25	32	GCM N125005-GF	1	BX0520	5.0	LH040
GNDL R/L2020K-1.516	●	●	20	20	125	20	20	38.0	1.50	32	GCM N150005-GF	1			
GNDL R/L2020K-220	●	●	20	20	125	20	20	44.5	2.00	40	GC□ □20○○-□□	1			
GNDL R/L2020K-320	●	●	20	20	125	20	20	44.5	3.00	40	GC□ □30○○-□□	1			
GNDL R/L2020K-425	●	●	20	20	125	20	20	50.0	4.00	50	GC□ □40○○-□□	1			
GNDL R/L2020K-525	●	●	20	20	125	20	20	50.0	5.00	50	GC□ N50○○-□□	1			
GNDL 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
GNDL R/L2525M-1.516	●	●	25	25	150	25	25	40.0	1.50	32	GCM N150005-GF	1			
GNDL R/L2525M-220	●	●	25	25	150	25	25	44.5	2.00	40	GC□ □20○○-□□	1			
GNDL R/L2525M-320	●	●	25	25	150	25	25	44.5	3.00	40	GC□ □30○○-□□	1			
GNDL R/L2525M-425	●	●	25	25	150	25	25	50.0	4.00	50	GC□ □40○○-□□	1			
GNDL R/L2525M-525	●	●	25	25	150	25	25	50.0	5.00	50	GC□ N50○○-□□	1			
GNDL 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
GNDL R/L3225P-425			32	25	170	25	32	50.0	4.00	50	GC□ □40○○-□□	1			
GNDL R/L3225P-525			32	25	170	25	32	50.0	5.00	50	GC□ N50○○-□□	1			
GNDL R/L3225P-625			32	25	170	25	32	50.0	6.00	50	GC□ N60○○-□□	1			
GNDL R/L3225P-725			32	25	170	25	32	50.0	7.00	50	GCM N70○○-□□	1			
GNDL 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
GNDL R/L3232P-425	●	●	32	32	170	32	32	50.0	4.00	50	GC□ □40○○-□□	1			
GNDL R/L3232P-525	●	●	32	32	170	32	32	50.0	5.00	50	GC□ N50○○-□□	1			
GNDL R/L3232P-625	●	●	32	32	170	32	32	50.0	6.00	50	GC□ N60○○-□□	1			
GNDL R/L3232P-725	●	●	32	32	170	32	32	50.0	7.00	50	GCM N70○○-□□	1			
GNDL 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 F91 for applicable inserts.

Cut-off Tools

Grooving

Cut-off

Threading

External

Face

Internal

Necking

CBN

GNDL-J type

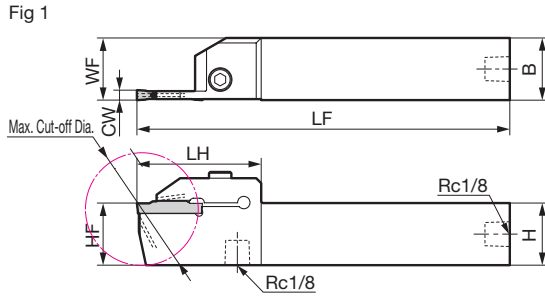
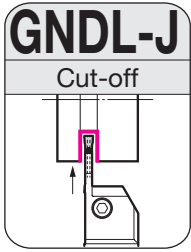


Figure shows right-handed (R) tool.

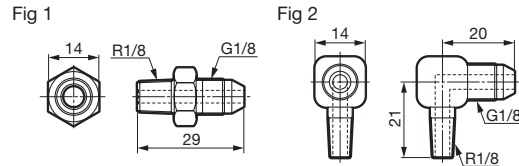
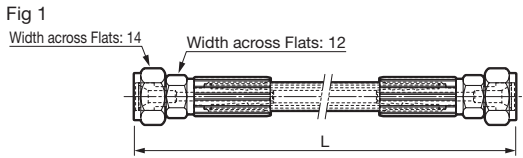
Holder

Parts

Dimensions (mm)

Cat. No.	Stock		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		Plug	Wrench
	R	L											N·m			
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 F93 for applicable inserts.



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 **F23**

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

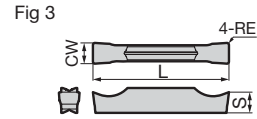
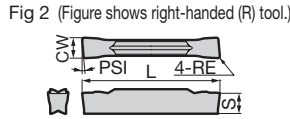
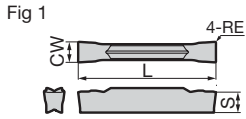
Connectors are sold separately.

Piping Method for Hoses and Connectors **F23**

GNDL-J type

Inserts for GNDL-J type

(Coated Carbide / Cermet / Cemented Carbide)



Grooving / Traverse Cutting

Dimensions (mm)

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

Cut-off (Handed Edge)

Dimensions (mm)

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

GCMR: Right-handed, GCMC: Left-handed

Grooving / Cut-off

Dimensions (mm)

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

Non-Ferrous Metals

Dimensions (mm)

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

Part Number Suffix Code (Chipbreakers)

Type	Symbol	Applications	Type	Symbol	Applications
Grooving / Traverse Cutting	MG	Multi-functional / General-purpose	Cut-off (Handed Edge)	CG	Cut-off / General-purpose
	ML	Multi-functional / Low-feed		CF	Cut-off / Low cutting force
Grooving / Cut-off	GG	Grooving / General-purpose	Non-Ferrous Metals	GA	Non-Ferrous Metals / General-purpose
	GL	Grooving / Low-feed			
	GF	Grooving / Low cutting force			

Chipbreaker Selection **F13** Precautions for Use **F22** Recommended Cutting Conditions **F19**

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

Cut-off Tools

L

Grooving

Cut-off

Threading

External

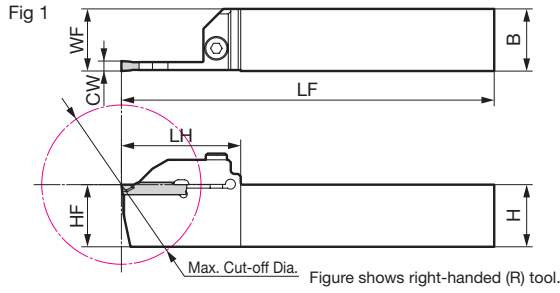
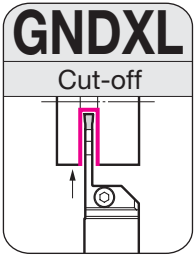
Face

Internal

Necking

CBN

GNDXL type



Holder

Parts

Dimensions (mm)

Cat. No.	Stock		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		Wrench
	R	L											N-m	Wrench	
GNDXL R/L2020K-226			20	20	125	20	20	42.0	2.0	52	GCM N2002-GF1	1			
GNDXL R/L2020K-332	●	●	20	20	125	20	20	48.0	3.0	64	GCM N30○○-□□1	1	BX0520	5.0	LH040
GNDXL R/L2020K-432	●	●	20	20	125	20	20	48.0	4.0	64	GCM N40○○-□□1	1			
GNDXL R/L2020K-532	●	●	20	20	125	20	20	48.0	5.0	64	GCM N50○○-□□1	1			
GNDXL 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			
GNDXL R/L2525M-332	●	●	25	25	150	25	25	48.0	3.0	64	GCM N30○○-□□1	1	BX0520	5.0	LH040
GNDXL R/L2525M-432	●	●	25	25	150	25	25	48.0	4.0	64	GCM N40○○-□□1	1			
GNDXL R/L2525M-532	●	●	25	25	150	25	25	48.0	5.0	64	GCM N50○○-□□1	1			
GNDXL 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 F95 for applicable inserts.

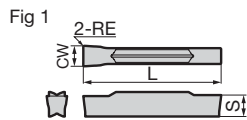
- Cut-off Tools
- F
- Grooving
- Cut-off
- Threading
- External
- Face
- Internal
- Necking
- CBN

GNDXL type



Inserts for GNDXL type (1-cornered)

(Coated Carbide)



Grooving / Traverse Cutting (1-cornered)

Dimensions (mm)

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

Grooving / Cut-off (1-cornered)

Dimensions (mm)

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

Cut-off Tools



Grooving

Cut-off

Threading

External

Face

Internal

Necking

CBN

Part Number Suffix Code (Chipbreakers)

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

Chipbreaker Selection F13 Precautions for Use F22 Recommended Cutting Conditions F19

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

MEMO

