

CUTTING TOOLS 2024



COMPLETE METALWORKING SOLUTIONS

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The DIA EDGE logo consists of the word 'DIA' in white, followed by a stylized red and grey diamond shape, and the word 'EDGE' in white. The background of the bottom section of the cover features a collage of industrial images, including a red-tinted close-up of a metal part, a black and white image of a drill bit in a machine, and another red-tinted image of a metal component.

DIA  EDGE

HOW TO READ THE STANDARD OF GROOVING AND CUTTING OFF

● How this section page is organized

- ① Classified according to external or internal applications.
- ② Sub-classified according to product series.
(Refer to the index on the next page.)

[For External Grooving / Cutting Off]

[For Internal Grooving]

FIGURE SHOWING THE TOOLING APPLICATION uses illustrations and arrows to depict available machining applications such as cutting off, grooving, and copying.

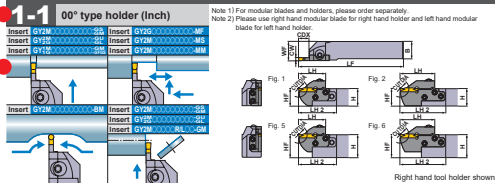
INDICATION OF HOLDER TYPE ACCORDING TO APPLICATION indicates the holder types, such as the standard type or the L type, according to machining application.

TITLE OF PRODUCT

PRODUCT SECTION

GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)



Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				
						Holder	Stock	Modular Blade	Stock	
D .079 .088	236	.472		Modular	R	G YHRUS10B00-M20R	●	G YM20RA-D06	●	3
					L	G YHLUS10B00-M20L	●	G YM20LA-D06	●	3
				Modular	R	G YHRUS12C00-M20R	●	G YM20RA-D06	●	1
					L	G YHLUS12C00-M20L	●	G YM20LA-D06	●	1
				Modular	R	G YHRUS12C00-M25R	●	G YM25RA-D06	●	3
					L	G YHLUS12C00-M25L	●	G YM25LA-D06	●	3
	Mono Block	R	G YQRUS16D00-D06	●	—	—	7			
		L	G YQLUS16D00-D06	●	—	—	7			
	.394	.787		Modular	R	G YHRUS20D00-M20R	●	G YM20RA-D10	●	3
					L	G YHLUS20D00-M20L	●	G YM20LA-D10	●	3
				Modular	R	G YHRUS20D00-M25R	●	G YM25RA-D10	●	1
					L	G YHLUS20D00-M25L	●	G YM25LA-D10	●	1
Modular				R	G YHRUS24E00-M25R	●	G YM25RA-D12	●	3	
				L	G YHLUS24E00-M25L	●	G YM25LA-D12	●	3	
.472	.945		Modular	R	G YHRUS10B00-M20R	●	G YM20RA-D10	●	3	
				L	G YHLUS10B00-M20L	●	G YM20LA-D10	●	3	
			Modular	R	G YHRUS12C00-M20R	●	G YM20RA-D10	●	1	
				L	G YHLUS12C00-M20L	●	G YM20LA-D10	●	1	
			Modular	R	G YHRUS12C00-M25R	●	G YM25RA-D12	●	3	
				L	G YHLUS12C00-M25L	●	G YM25LA-D12	●	3	
Mono Block	R	G YQRUS16D00-D20	●	—	—	7				
	L	G YQLUS16D00-D20	●	—	—	7				
.709	1.417		Modular	R	G YHRUS10B00-M20R	●	G YM20RB-D18	●	4	
				L	G YHLUS10B00-M20L	●	G YM20LB-D18	●	4	
			Modular	R	G YHRUS12C00-M20R	●	G YM20RB-D18	●	2	
				L	G YHLUS12C00-M20L	●	G YM20LB-D18	●	2	
			Modular	R	G YHRUS12C00-M25R	●	G YM25RA-D20	●	4	
				L	G YHLUS12C00-M25L	●	G YM25LA-D20	●	4	
Mono Block	R	G YQRUS16D00-D20	●	—	—	7				
	L	G YQLUS16D00-D20	●	—	—	7				
.787	1.575		Modular	R	G YHRUS16D00-M25R	●	G YM25RA-D20	●	2	
				L	G YHLUS16D00-M25L	●	G YM25LA-D20	●	2	
			Modular	R	G YHRUS20D00-M25R	●	G YM25RA-D20	●	6	
				L	G YHLUS20D00-M25L	●	G YM25LA-D20	●	6	
			Modular	R	G YHRUS24E00-M25R	●	G YM25RA-D20	●	6	
				L	G YHLUS24E00-M25L	●	G YM25LA-D20	●	6	

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter
 #1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
 #2 The maximum cut-off diameter (CUTDIA) varies according to the insert used. The cut-off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
 #3 Dimensions shown are when the gauge insert is used. If other insert geometries are used than LF, LH and LH 2 values may vary.
 * The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F106.

F018 ● : USA Stock

PRODUCT STANDARDS indicates order numbers, stock status (per right/left hand), holders, Modular Blade, cutting widths, maximum groove depths, maximum cut-off diameters, dimensions, applicable inserts, and cutting edge shapes.

MIN. CUTTING DIAMETER is color-coded to let you find, at a glance, the minimum cutting diameters for internal machining.
 GEOMETRY

PRODUCT FEATURES

GROOVING / CUTTING OFF

F TYPE BORING BAR

Internal grooving, Threading
 1 Corner type (FSL5108R,5110R) 2 Corner type (FSL5112R,5114R,5116R)

Order Number	Stock	R	Grooving	Threading	Dimensions (mm)							Max. Groove Depth (mm)	Wrench			
					DCON	H	LF	LU	WF	CW	DMIN*					
FSL5108R	●	MLG	10	L	MLT	100L	8	7	125	30	4.8	1.2	10	1.0	TS25	TKY08F
FSL5110R	●	MLG	10	L	MLT	100L	10	9	150	40	5.8	1.5	12	1.0	TS25	TKY08F
FSL5112R	●	MLG	14	L	MLT	140L	12	10.8	180	60	6.8	1.5	14	2.0	TS32	TKY08F
FSL5114R	●	MLG	14	L	MLT	140L	14	12.4	180	60	7.8	2.0	16	2.0	TS32	TKY08F
FSL5116R	●	MLG	20	L	MLT	200L	16	14	200	70	9.7	3.0	20	3.0	TS43	TKY15F

*DMIN : Min. Cutting Diameter

FSL52 (Carbide shank) Internal grooving, Threading

1 Corner type (FSL5208R,5210R) 2 Corner type (FSL5212R,5214R,5216R)

Order Number	Stock	R	Grooving	Threading	Dimensions (mm)							Max. Groove Depth (mm)	Wrench			
					DCON	H	LF	LU	WF	CW	DMIN*					
FSL5208R	●	MLG	10	L	MLT	100L	8	7	125	60	4.8	1.2	10	1.0	TS25	TKY08F
FSL5210R	●	MLG	10	L	MLT	100L	10	9	150	70	5.8	1.5	12	1.0	TS25	TKY08F
FSL5212R	●	MLG	14	L	MLT	140L	12	10.8	180	80	6.8	1.5	14	2.0	TS32	TKY08F
FSL5214R	●	MLG	14	L	MLT	140L	14	12.4	180	85	7.8	2.0	16	2.0	TS32	TKY08F
FSL5216R	●	MLG	20	L	MLT	200L	16	14	200	115	9.7	3.0	20	3.0	TS43	TKY15F

*DMIN : Min. Cutting Diameter

F234 ● : USA Stock * : Stocked in Japan

LEGEND FOR STOCK STATUS MARK is shown on the left hand page of each double-page spread.

● To Order : For holder, please specify order number and hand of tool (right/left).
 For insert, please specify insert number and grade.

TURNING TOOLS

GROOVING AND CUTTING OFF

CLASSIFICATION (EXTERNAL)..... F002

CLASSIFICATION (INTERNAL)..... F003

STANDARD OF GROOVING AND CUTTING OFF TOOLS

EXTERNAL

FEATURES OF THE GY SERIES..... F004

IDENTIFICATION OF GY SERIES F008

GY SERIES INSERTS F011

GY SERIES REFERENCE DATA F015

GY SERIES F016, F168

GW SERIES..... F218

INTERNAL

GY SERIES..... F152

FSL51/52 TYPE..... F234

S-SL5N TYPE..... F235

MICRO-MINI TWIN BORING BARS F237











*Arranged by Alphabetical order.

F237	CG
F234	FSL5
F016	GY (Holders)
F011	GY (Inserts)
F226	GW (Blades)
F224	GW (Holder)
F229	GW (Inserts)
F236	MLG (Inserts)
F236	MLT (Inserts)
F235	S-SL5N



F001

INTERNAL

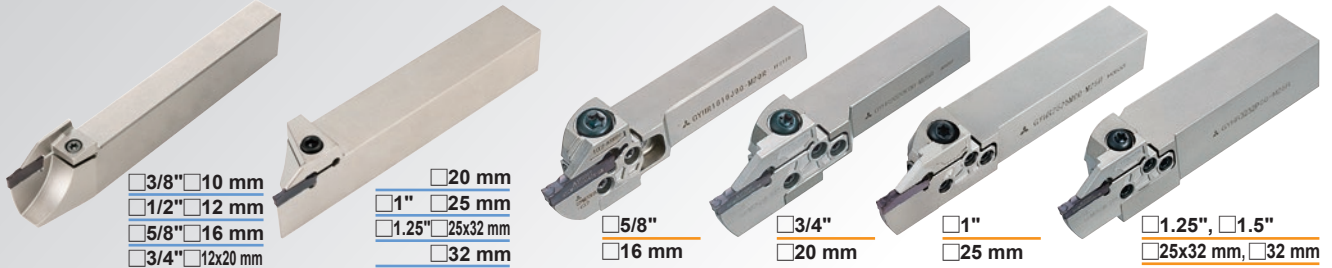
Name of Tool Holder	Insert Shape	Features	Min. Cutting Diameter (inch)	Cutting Width (inch)	Max. Groove Depth (inch)
GY Series    F152		Modular type <ul style="list-style-type: none"> ● Clamp-on type. ● High accuracy and rigidity due to the modular blade. (Tri-lock system) ● Various insert types. Mono block type <ul style="list-style-type: none"> ● Spring clamp type. 	.984" (25 mm)	.079" (2.0 mm) .088" .094" .098" (2.5 mm) .108" .118" (3.0 mm) .125" .128" .157" (4.0 mm) .167" .187" .197" (5.0 mm) .206" .236" (6.0 mm) .248" .250"	.157" .512"
FSL5/S-SL5 Boring Bars    F234		<ul style="list-style-type: none"> ● Screw-on type. ● Precision class insert. ● Holder is capable of performing both grooving and threading. ● Maximum groove depth .118 inch. 	.394"	.047" (1.2 mm) .059" (1.5 mm) .062" .079" (2.0 mm) .094" .118" (3.0 mm) .125" .156" .157" (4.0 mm)	.039" .118"
MICRO-MINI TWIN Boring Bars   F237	—	<ul style="list-style-type: none"> ● Solid carbide type. ● Economical due to single holder with two cutting edges. 	.118"	.04" .08"	.04" .08"
MICRO-MINI Boring Bars   E031	—	<ul style="list-style-type: none"> ● Solid carbide type. ● Insert can be ground to suit the application. 	.126"	.08" .12"	.04" .08"

GY SERIES

A wide selection of holders and inserts available for diverse grooving and cutting off applications

External • Face holders

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



Mono block type

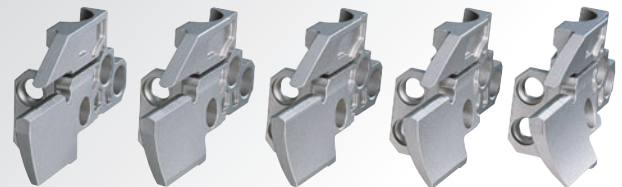
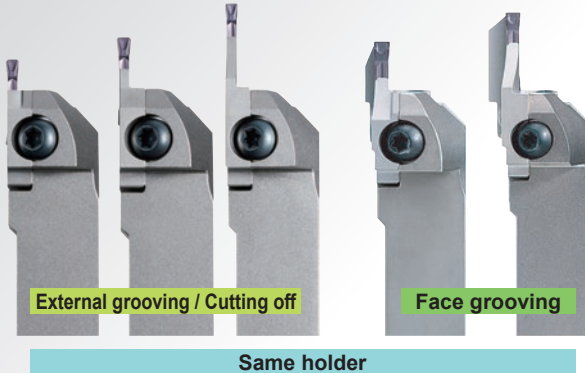
Modular type

F

GROOVING / CUTTING OFF

A wide selection of holders and inserts available for diverse grooving and cutting off applications

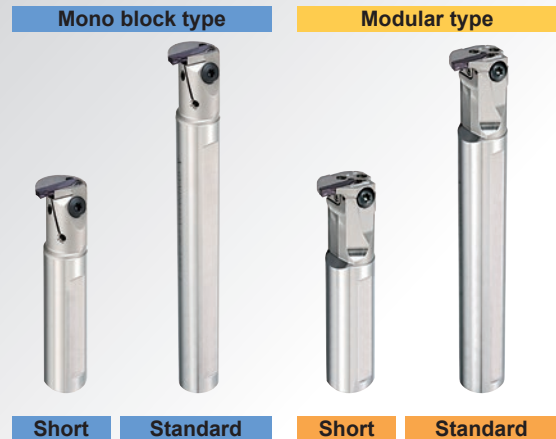
Applicable for various diameters of face grooves by the wide array of modular blades with different grooving diameters



Internal holders

A wide range of holders available from minimum diameter of $\varnothing 25$ mm

Short shank types are standard stocked

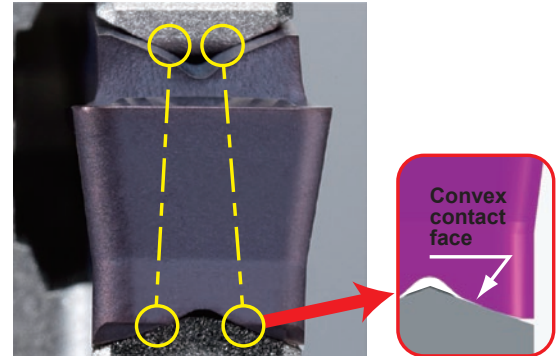
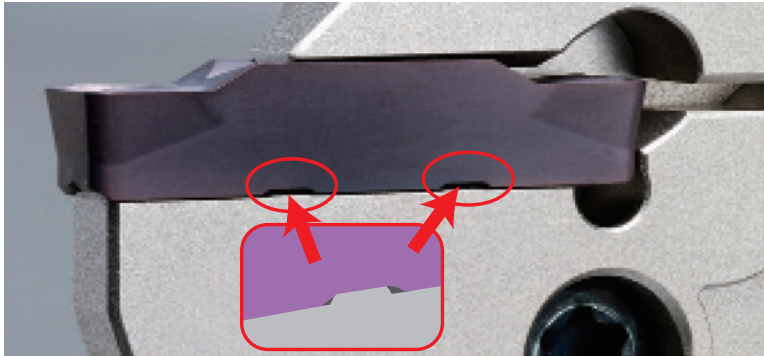


Original insert design leading the way to new grooving and cutting off applications

Highly reliable insert clamping

Safety keys prevent insert movement.

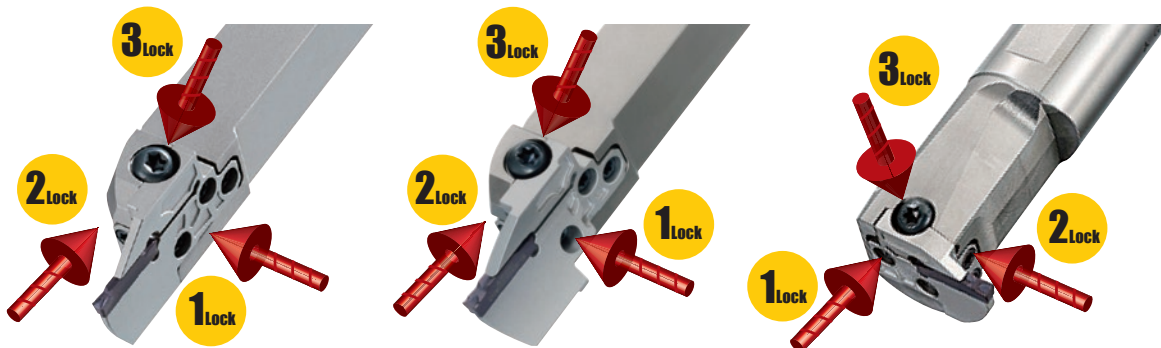
The convex geometry ensures high precision clamping.



New TRI-LOCK System for increased stability and performance!




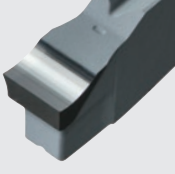
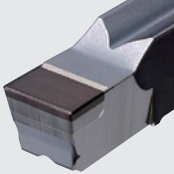
TRI-LOCK System




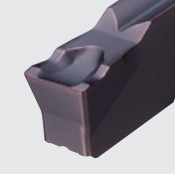
The TRI-LOCK system ensures the blade is securely fixed in 3 directions (side, front and top), giving high rigidity for stable grooving and cutting off performance.







GROOVING / CUTTING OFF

A WIDE SELECTION OF INSERTS BREAKER SYSTEM

Grooving / Cutting Off				Grooving
				
GUBreaker (For Gummy Steel)	GSBreaker (Low feeds)	GMBreaker (Medium feeds)	GLBreaker (For Aluminum Alloy)	GFGS (CBN)



Cutting Off			
			
R08-GSBreaker (Low feeds)	R15-GSBreaker (Low feeds)	GMBreaker (Medium feeds)	R/L05-GMBreaker (Medium feeds)

For Multifunctional Grooving		Copying/Recessing	
			
MFBreaker (G class)	MSBreaker (Low feeds)	MMBreaker (Medium feeds)	BMBreaker

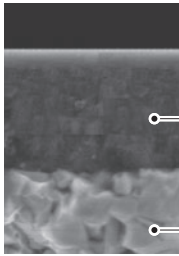
F

GROOVING / CUTTING OFF

INSERT GRADE

Work Material Machining Condition	P Steel	M Stainless Steel	K Cast Iron	N Aluminum Alloy	S Heat resistant Alloy / Titanium Alloy	H Hardened Steel
	Stable  Machining Condition  Unstable	NX2525 MY5015 VP10RT VP20RT	VP10RT VP20RT	MY5015 VP10RT VP20RT	RT9010	NEW MP9015 RT9010 NEW MP9025

MP9000 Series

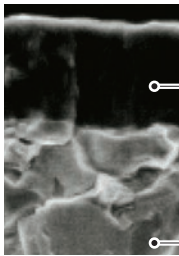


● The high Al-rich (Al, Ti)N single layer coating provides stabilization of the high hardness phase and succeeds in dramatically improving wear, crater and welding resistance.

High Al-rich (Al, Ti)N Single Layer Coating

Special Cemented Carbide Substrate

VP20RT (1st Recommendation)

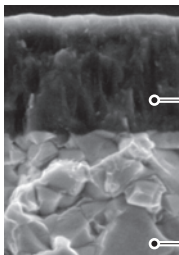


● PVD coated grade suitable for a wide range of applications. The combination of a special tough cemented carbide substrate with MIRACLE coating provides an excellent balance of wear and fracture resistance.

MIRACLE Coating

Carbide substrate (90.5HRA)

VP10RT

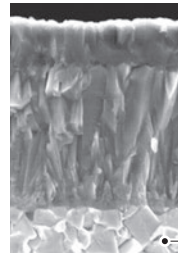


● PVD coated grade with a cemented carbide substrate harder than VP20RT. For use on difficult to cut materials and for extending tool life.

MIRACLE Coating

Carbide substrate (92.0HRA)

MY5015



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

CVD Coated Carbide

Carbide substrate

RT9010

● RT9010 is an uncoated cemented carbide grade. Suitable for processing non-ferrous metals.

NX2525

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

BC8110

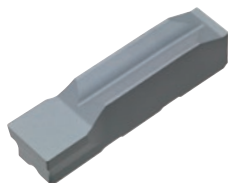
● A CBN coated grade for continuous cutting, which provides longer life when machining hardened steel.

BLANK INSERTS

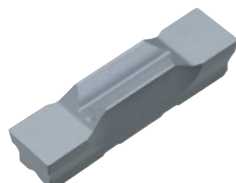
● Blank inserts for custom grinding

RT9010/RT9020 for blank insert

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



1 Edge Type



2 Edge Type

* Insert blank is not suitable for machining without grinding.

GL Breaker for Aluminum Alloys

G Class Breaker

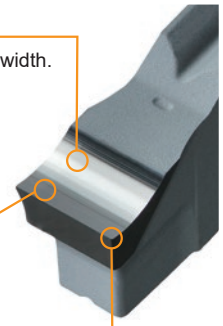
Improved chip control by narrowing the breaker width.

High Rake Angle

Achieves low cutting resistance.

Sharp Edge

Improved welding resistance for aluminium alloys.



MF Breaker (Finishing)

Efficient chip breaking when cross-feed machining.

Chips are controlled when finish machining.



IDENTIFICATION OF GY SERIES

■ INSERT

① **GY** ② **2** ③ **M** ④ **0300** ⑤ **F** ⑥ **030** ⑦ **N** ⑧ **05** - ⑨ **M** ⑩ **F**

① Series Description

② Number of Teeth

1	1 Edge Type
2	2 Edge Type

③ Peripheral

G	Ground
M	Sintered
B	Blank

④ Cutting Width

	Inch	Metric
0150	.059"	1.50 mm
0200	.079"	2.00 mm
⋮	⋮	⋮
0800	.315"	8.00 mm

⑤ Seat Size *1

	Inch	Metric
B	.047"	1.20 mm
C	.059"	1.50 mm
D	.079" .088"	2.00 mm 2.24 mm
E	.094" .098" .108"	2.39 mm 2.50 mm 2.74 mm
F	.118" .125" .128"	3.00 mm 3.18 mm 3.24 mm
G	.157" .167"	4.00 mm 4.24 mm
H	.187" .197" .206"	4.75 mm 5.00 mm 5.24 mm
J	.236" .248" .250"	6.00 mm 6.31 mm 6.35 mm
K	.315"	8.00 mm

⑥ Corner Radius

	Inch	Metric
010	.004"	0.10 mm
015	.006"	0.15 mm
⋮	⋮	⋮
400	.157"	4.00 mm

⑨ Application 1

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

⑩ Application 2

U	For Gummy Steel
F	Finishing
S	Low feeds
M	Medium feeds
L	For Aluminum Alloys

⑧ Lead angle (R/L type insert)

05	5°
08	8°
15	15°

⑦ Hand

N	Neutral
R	Right
L	Left

■ CBN INSERT

① **GY** ② **1** ③ **G** ④ **0300** ⑤ **F** ⑥ **020** ⑦ **N** - ⑧ **G** ⑨ **F** ⑩ **GS**

⑧ Application 3

F	Flat Top
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⑩ Honing Type

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

■ MODULAR BLADE

● EXTERNAL/INTERNAL/RECESSING

① **GY** ② **M25** ③ **R** ④ **A** - ⑤ **F** ⑥ **12** *3

① Series Description

② Modular Blade Size

M20
M25

③ Hand

R	Right
L	Left

④ Modular Blade Type

A	Standard Type
B	Reinforced Type
C	External Recessing
D	Face Grooving

⑤ Seat Size *1

	Inch	Metric
D	.079" .088"	2.00 mm 2.24 mm
E	.094" .098" .108"	2.39 mm 2.50 mm 2.74 mm
F	.118" .125" .128"	3.00 mm 3.18 mm 3.24 mm
G	.157" .167"	4.00 mm 4.24 mm
H	.187" .197" .206"	4.75 mm 5.00 mm 5.24 mm
J	.236" .248" .250"	6.00 mm 6.31 mm 6.35 mm

⑥ Max. Groove Depth *2

	Inch	Metric
005	.197"	0.5 mm
06	.236"	6 mm
⋮	⋮	⋮
25	.984"	25.0 mm

● FACE GROOVING

① **GY** ② **M25** ③ **R** ④ **D** - ⑤ **F** ⑥ **12** - ⑦ **050**

⑦ Min. Groove Diameter

	Inch	Metric
035	1.378"	35 mm
040	1.575"	40 mm
⋮	⋮	⋮
250	9.843"	250 mm

*1 Select a seat size with the same symbol as that of the insert.
 *2 The maximum groove depth is a value when used for external grooving and changes according to the insert used.
 For internal grooving, refer to the maximum groove depth on pages F152 – F167.
 *3 GYM20R/LA-○10, GYM20R/LA-○12, GYM25R/LA-○12 and GYM25R/LA-○14 can be used for both external and internal grooving.

GROOVING / CUTTING OFF

EXTERNAL/FACE GROOVING/RECESSING

MONO BLOCK HOLDER

(Inch) **GY** **P** **R** **US16** **D** **00** - **K** **25**

(Metric) **2525** **M**

① Series Description

② Holder Type	
S	Mono Block Holder for Swiss-type Lathe
P	Offset Mono Block Holder
Q	Zero Offset Mono Block Holder
H	Modular Type Holder

③ Hand of Holder	
R	Right
L	Left

④ Holder Size			
	Inch	Metric	
US06	.375"x.375"	1010	10 mmx10 mm
US08	.500"x.500"	1212	12 mmx12 mm
US10	.625"x.625"	1616	16 mmx16 mm
US12	.750"x.750"	2012	20 mmx20 mm
US16	1.000"x1.000"	2020	20 mmx20 mm
US20	1.250"x1.250"	2525	25 mmx25 mm
US24	1.500"x1.500"	3225	32 mmx25 mm
		3232	32 mmx32 mm

⑤ Holder Length			
	Inch	Metric	
B	4.5"	J	110 mm
C	5.0"	JX	120 mm
D	6.0"	K	125 mm
E	7.0"	M	150 mm
		P	170 mm

⑥ Angle (degree)	
00	0°
50	50°
90	90°

⑦ Seat Size *1		
	Inch	Metric
B	.047"	1.20 mm
C	.059"	1.50 mm
D	.079" .088"	2.00 mm 2.24 mm
E	.094" .098" .108"	2.39 mm 2.50 mm 2.74 mm
F	.118" .125" .128"	3.00 mm 3.18 mm 3.24 mm
G	.157" .167"	4.00 mm 4.24 mm
H	.187" .197" .206"	4.75 mm 5.00 mm 5.24 mm
J	.236" .248" .250"	6.00 mm 6.31 mm 6.35 mm
K	.315"	8.00 mm

⑧ Max. Grooving Depth		
	Inch	Metric
06	.236"	6 mm
08	.315"	8 mm
⋮	⋮	⋮
25	.984"	25 mm

MODULAR TYPE HOLDER

(Inch) **GY** **H** **R** **US16** **M** **00** - **M25** **R**

(Metric) **2525**

⑨ Modular Blade Size	
M20	
M25	

⑩ Hand of Modular Blade	
R	Right
L	Left

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

INTERNAL

MONO BLOCK HOLDER

(Inch) **GY** **A** **R** **US16** **K** **90** **A** - **F** **06**

(Metric) **20**

① Series Description

② Holder Type	
A	Mono Block
D	Modular Type Holder

③ Hand of Holder	
R	Right
L	Left

④ Shank Size			
	Inch	Metric	
US12	.750"	20	20 mm
US16	1.000"	25	25 mm
US20	1.250"	32	32 mm
US24	1.500"	40	40 mm
US32	2.000"	50	50 mm

⑤ Holder Length			
	Inch	Metric	
K	5.0"	125 mm	
L	5.5"	140 mm	
M	6.0"	150 mm	
P	6.75"	170 mm	
Q	7.0"	180 mm	
R	8.0"	200 mm	
S	10.0"	250 mm	
T	12.0"	300 mm	

⑥ Angle (degree)	
90	90°

⑦ Neck Length		
	Inch	Metric
A	1.250"	30 mm
B	1.500"	40 mm
C	2.000"	50 mm
D	2.500"	60 mm
F	3.250"	80 mm

⑧ Seat Size *1		
	Inch	Metric
D	.079" .088"	2.00 mm 2.24 mm
E	.094" .098" .108"	2.39 mm 2.50 mm 2.74 mm
F	.118" .125" .128"	3.00 mm 3.18 mm 3.24 mm
G	.157" .167"	4.00 mm 4.24 mm
H	.187" .197" .206"	4.75 mm 5.00 mm 5.24 mm
J	.236" .248" .250"	6.00 mm 6.31 mm 6.35 mm

⑨ Max. Grooving Depth		
	Inch	Metric
06	.236"	6 mm
07	.276"	7 mm

MODULAR TYPE HOLDER

(Inch) **GY** **D** **R** **US20** **M** **90** **D** - **M25** **L**

(Metric) **40**

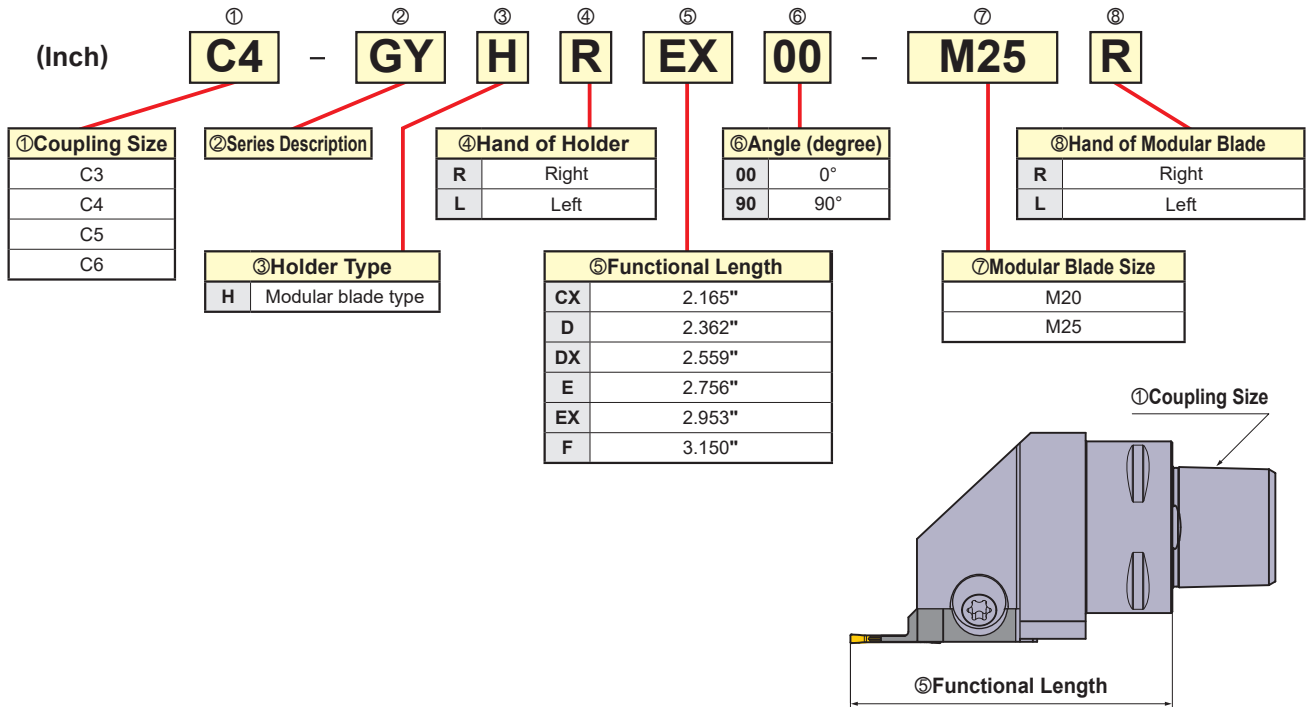
⑩ Modular Blade Size	
M20	
M25	

⑪ Hand of Modular Blade	
R	Right
L	Left

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

IDENTIFICATION OF GY-PSC Holder

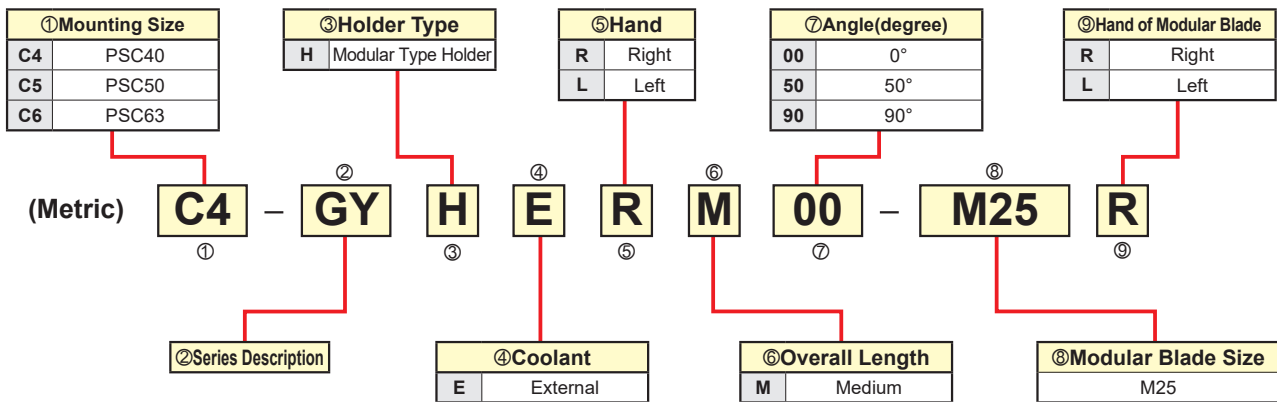
EXTERNAL



F

GROOVING / CUTTING OFF

EXTERNAL/FACE GROOVING/RECESSING



GY SERIES INSERTS

INSERTS

(inch)

Applications	Geometry	Order Number	Stock								Seat Size	CW			RER/L	CDX	*2 L			
			Coated				Cermet		Carbide			Cutting Width		Tolerance						
			NEW	NEW	NEW	NEW	NEW	NEW	NEW	NEW		inch	(mm)							
			MP9015	MP9025	VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020										
For Grooving / Cutting Off	GU Breaker (For gummy steel) 	GY2M0200D020N-GU			●	●	●					D	.079	(2.00)	±.0012	.008	.776	.815		
		GY2M0239E020N-GU			●	●	●					E	.094	(2.39)	±.0012	.008	.780	.815		
		GY2M0250E020N-GU			●	●	●					E	.098	(2.50)	±.0012	.008	.768	.815		
		GY2M0300F030N-GU			●	●	●					F	.118	(3.00)	±.0012	.012	.760	.815		
		GY2M0318F030N-GU			●	●	●					F	.125	(3.18)	±.0012	.012	.760	.815		
		GY2M0400G030N-GU			●	●	●					G	.157	(4.00)	±.0016	.016	.953	1.010		
		GY2M0475H040N-GU			●	●	●					H	.187	(4.75)	±.0016	.016	.953	1.010		
		GY2M0500H040N-GU			●	●	●					H	.197	(5.00)	±.0016	.016	.953	1.010		
		GY2M0600J040N-GU			●	●	●					J	.236	(6.00)	±.0016	.016	.953	1.010		
		GY2M0635J040N-GU			●	●	●					J	.250	(6.35)	±.0016	.016	.953	1.010		
	GS Breaker (Low feeds) 	NEW GY2M0120B010N-GS			●	●							B	.047	(1.20)	±.0012	.004	.480	.579	
		GY2M0150C010N-GS			●	●	●						C	.059	(1.50)	±.0012	.004	.528	.579	
		GY2M0200D020N-GS			●	●	●						D	.079	(2.00)	±.0012	.008	.736	.815	
		GY2M0239E020N-GS			●	●	●						E	.094	(2.39)	±.0012	.008	.728	.815	
		GY2M0250E020N-GS			●	●	●						E	.098	(2.50)	±.0012	.008	.728	.815	
		GY2M0300F020N-GS			●	●	●						F	.118	(3.00)	±.0012	.008	.728	.815	
		GY2M0318F020N-GS			●	●	●						F	.125	(3.18)	±.0012	.008	.728	.815	
		GY2M0400G020N-GS			●	●	●						G	.157	(4.00)	±.0016	.008	.941	1.010	
		GY2M0475H030N-GS			●	●	●						H	.187	(4.75)	±.0016	.012	.941	1.010	
		GY2M0500H030N-GS			●	●	●						H	.197	(5.00)	±.0016	.012	.945	1.010	
	GM Breaker (Medium feeds) 	GY1M0200D020N-GM	●	●	●	●	●						D	.079	(2.00)	±.0012	.008	—	.815	
		GY1M0250E020N-GM	●	●	●	●	●						E	.098	(2.50)	±.0012	.008	—	.815	
		GY1M0300F030N-GM	●	●	●	●	●						F	.118	(3.00)	±.0012	.012	—	.815	
		GY1M0400G030N-GM	●	●	●	●	●						G	.157	(4.00)	±.0016	.012	—	1.010	
		GY1M0500H040N-GM	●	●	●	●	●						H	.197	(5.00)	±.0016	.016	—	1.010	
		GM Breaker (Medium feeds) 	GY2M0150C020N-GM	●	●	●	●	●						C	.059	(1.50)	±.0012	.008	.547	.579
			GY2M0200D020N-GM	●	●	●	●	●						D	.079	(2.00)	±.0012	.008	.764	.815
			GY2M0239E020N-GM	●	●	●	●	●						E	.094	(2.39)	±.0012	.008	.764	.815
			GY2M0250E020N-GM	●	●	●	●	●						E	.098	(2.50)	±.0012	.008	.764	.815
			GY2M0300F030N-GM	●	●	●	●	●						F	.118	(3.00)	±.0012	.012	.764	.815
	GY2M0318F030N-GM		●	●	●	●	●						F	.125	(3.18)	±.0012	.012	.764	.815	
	GY2M0400G030N-GM		●	●	●	●	●						G	.157	(4.00)	±.0016	.012	.961	1.010	
	GY2M0475H040N-GM		●	●	●	●	●						H	.187	(4.75)	±.0016	.016	.957	1.010	
GY2M0500H040N-GM	●		●	●	●	●						H	.197	(5.00)	±.0016	.016	.957	1.010		
GY2M0600J040N-GM	●		●	●	●	●						J	.236	(6.00)	±.0016	.016	.957	1.010		
GL Breaker (For Aluminum Alloys) 	GY2G0200D005N-GL											D	.079	(2.00)	±.0008	.002	.768	.829		
	GY2G0250E005N-GL											E	.098	(2.50)	±.0008	.002	.752	.829		
	GY2G0300F005N-GL											F	.118	(3.00)	±.0008	.002	.744	.829		

*2 The dimension depends on the breaker. Refer to the F015 "L dimension tolerance conversion table".

● = NEW

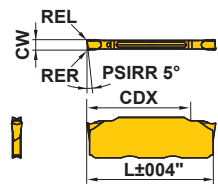
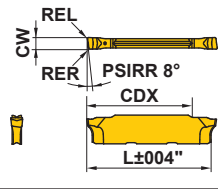
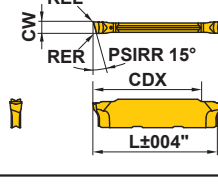
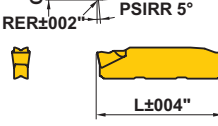
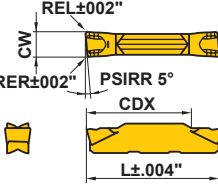
● : USA Stock
<10 inserts in one case>

F
GROOVING / CUTTING OFF

GY SERIES INSERTS

INSERTS

(inch)

Applications	Geometry	Order Number	Stock					Seat Size	CW		Corner R				CDX	*2 L	
			Coated						Cutting Width	Tolerance	REL	Tolerance	RER	Tolerance			
			NEW MP9015	NEW MP9025	VP10RT	VP20RT	MV5015										inch
			REL		RER		PSIRR		CDX		L						
For Cutting off	R05-GS Breaker NEW (Low feeds) 	GY2M0120B010R05-GS			●	●		B	.047	(1.20)	±.0012	.004	±.0020	.004	±.002	.481	.579
	R08-GS Breaker NEW (Low feeds) 	GY2G0150C010R08-GS			●	●		C	.059	(1.50)	±.0008	.004	±.0012	.004	—	.519	.600
		GY2G0200D020R08-GS			●	●		D	.079	(2.00)	±.0012	.008	±.0020	.008	—	.742	.840
		GY2G0250E020R08-GS			●	●		E	.098	(2.50)	±.0012	.008	±.0020	.008	—	.750	.845
		GY2G0300F020R08-GS			●	●		F	.118	(3.00)	±.0012	.008	±.0020	.008	—	.733	.848
	R15-GS Breaker NEW (Low feeds) 	GY2G0150C003R15-GS			●	●		C	.059	(1.50)	±.0008	.0012	+0.012, -0.008	.004	—	.519	.600
		GY2G0150C010R15-GS			●	●		C	.059	(1.50)	±.0008	.004	±.0012	.004	—	.519	.600
		GY2G0200D003R15-GS			●	●		D	.079	(2.00)	±.0012	.0012	+0.012, -0.008	.004	—	.742	.839
		GY2G0200D010R15-GS			●	●		D	.079	(2.00)	±.0012	.004	±.0012	.004	—	.742	.839
		GY2G0250E003R15-GS			●	●		E	.098	(2.50)	±.0012	.0012	+0.012, -0.008	.004	—	.750	.845
		GY2G0250E020R15-GS			●	●		E	.098	(2.50)	±.0012	.008	±.0020	.004	—	.750	.845
		GY2G0300F003R15-GS			●	●		F	.118	(3.00)	±.0012	.0012	+0.012, -0.008	.004	—	.733	.850
	R/L05-GM Breaker  Right hand insert shown.	GY1M0200D020R05-GM			●	●		D	.079	(2.00)	±.0012	.008	±.0020	.008	±.002	—	.819
		GY1M0200D020L05-GM			●	●		D	.079	(2.00)	±.0012	.008	±.0020	.008	±.002	—	.819
		GY1M0300F030R05-GM			●	●		F	.118	(3.00)	±.0012	.012	±.0020	.012	±.002	—	.821
GY1M0300F030L05-GM				●	●		F	.118	(3.00)	±.0012	.012	±.0020	.012	±.002	—	.821	
R/L05-GM Breaker  Right hand insert shown.	GY2M0200D020R05-GM			●	●		D	.079	(2.00)	±.0012	.008	±.0020	.008	±.002	.768	.819	
	GY2M0200D020L05-GM			●	●		D	.079	(2.00)	±.0012	.008	±.0020	.008	±.002	.768	.819	
	GY2M0250E020R05-GM			●	●		E	.098	(2.50)	±.0012	.008	±.0020	.008	±.002	.768	.820	
	GY2M0250E020L05-GM			●	●		E	.098	(2.50)	±.0012	.008	±.0020	.008	±.002	.768	.820	
	GY2M0300F030R05-GM			●	●		F	.118	(3.00)	±.0012	.012	±.0020	.012	±.002	.768	.821	
	GY2M0300F030L05-GM			●	●		F	.118	(3.00)	±.0012	.012	±.0020	.012	±.002	.768	.821	
	GY2M0400G030R05-GM			●	●		G	.157	(4.00)	±.0016	.012	±.0020	.012	±.002	.965	1.018	
	GY2M0400G030L05-GM			●	●		G	.157	(4.00)	±.0016	.012	±.0020	.012	±.002	.965	1.018	
	GY2M0500H040R05-GM			●	●		H	.197	(5.00)	±.0016	.016	±.0020	.016	±.002	.965	1.022	
GY2M0500H040L05-GM			●	●		H	.197	(5.00)	±.0016	.016	±.0020	.016	±.002	.965	1.022		

*2 The dimension depends on the breaker. Refer to the F015 "L dimension tolerance conversion table".

● = NEW

● : USA Stock

F012 <10 inserts in one case> <CBN inserts are available in 1 piece in one case.>

(inch)

Applications	Geometry	Order Number	Stock										Seat Size	CW			RER/L	CDX	*2 L	LE	
			Coated					Cermet		Carbide		CBN		Cutting Width	Tolerance						
			NEW	NEW	VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020	BC8110										
			MP9015	MP9025								inch				(mm)					
For Grooving	Flat Top (For Hardened Steel) 	GY1G0200D020N-GFGS										●	D	.079	(2.00)	±.0012	.008	—	.815	.106	
		GY1G0239E020N-GFGS											●	E	.094	(2.39)	±.0012	.008	—	.815	.106
		GY1G0250E020N-GFGS											●	E	.098	(2.50)	±.0012	.008	—	.815	.106
		GY1G0300F020N-GFGS											●	F	.118	(3.00)	±.0012	.008	—	.815	.106
		GY1G0318F020N-GFGS											●	F	.125	(3.18)	±.0012	.008	—	.815	.106
		GY1G0400G020N-GFGS											●	G	.157	(4.00)	±.0012	.008	—	1.010	.106
		GY1G0475H020N-GFGS											●	H	.187	(4.75)	±.0012	.008	—	1.010	.106
		GY1G0500H020N-GFGS											●	H	.197	(5.00)	±.0012	.008	—	1.010	.106
		GY1G0600J020N-GFGS											●	J	.236	(6.00)	±.0012	.008	—	1.010	.106
For Multifunctional Grooving	MF Breaker (Finishing) 	GY2G0200D020N-MF			●	●	●	●					D	.079	(2.00)	±.0008	.008	.768	.829	—	
		*1 GY2G0224D015N-MF			●	●	●	●						D	.088	(2.24)	±.0008	.006	.780	.829	—
		GY2G0239E020N-MF			●	●	●	●						E	.094	(2.39)	±.0008	.008	.756	.829	—
		GY2G0250E020N-MF			●	●	●	●						E	.098	(2.50)	±.0008	.008	.764	.829	—
		*1 GY2G0274E020N-MF			●	●	●	●						E	.108	(2.74)	±.0008	.008	.776	.829	—
		GY2G0300F020N-MF			●	●	●	●						F	.118	(3.00)	±.0008	.008	.768	.829	—
		GY2G0300F040N-MF			●	●	●	●						F	.118	(3.00)	±.0008	.016	.760	.829	—
		GY2G0318F020N-MF			●	●	●	●						F	.125	(3.18)	±.0008	.008	.768	.829	—
		GY2G0318F040N-MF			●	●	●	●						F	.125	(3.18)	±.0008	.016	.760	.829	—
		*1 GY2G0324F020N-MF			●	●	●	●						F	.128	(3.24)	±.0008	.008	.768	.829	—
		GY2G0400G020N-MF			●	●	●	●						G	.157	(4.00)	±.0008	.008	.980	1.022	—
		GY2G0400G040N-MF			●	●	●	●						G	.157	(4.00)	±.0008	.016	.972	1.022	—
		GY2G0400G080N-MF			●	●	●	●						G	.157	(4.00)	±.0008	.031	.957	1.022	—
		*1 GY2G0424G020N-MF			●	●	●	●						G	.167	(4.24)	±.0008	.008	.980	1.022	—
		GY2G0475H020N-MF			●	●	●	●						H	.187	(4.75)	±.0008	.008	.961	1.022	—
		GY2G0475H040N-MF			●	●	●	●						H	.187	(4.75)	±.0008	.016	.953	1.022	—
		GY2G0475H080N-MF			●	●	●	●						H	.187	(4.75)	±.0008	.031	.937	1.022	—
		GY2G0500H020N-MF			●	●	●	●						H	.197	(5.00)	±.0008	.008	.961	1.022	—
		GY2G0500H040N-MF			●	●	●	●						H	.197	(5.00)	±.0008	.016	.953	1.022	—
		GY2G0500H080N-MF			●	●	●	●						H	.197	(5.00)	±.0008	.031	.937	1.022	—
		*1 GY2G0524H020N-MF			●	●	●	●						H	.206	(5.24)	±.0008	.008	.961	1.022	—
		GY2G0600J020N-MF			●	●	●	●						J	.236	(6.00)	±.0008	.008	.961	1.022	—
		GY2G0600J040N-MF			●	●	●	●						J	.236	(6.00)	±.0008	.016	.953	1.022	—
		GY2G0600J080N-MF			●	●	●	●						J	.236	(6.00)	±.0008	.031	.937	1.022	—
		*1 GY2G0631J020N-MF			●	●	●	●						J	.248	(6.31)	±.0008	.008	.961	1.022	—
		GY2G0635J020N-MF			●	●	●	●						J	.250	(6.35)	±.0008	.008	.961	1.022	—
		GY2G0635J040N-MF			●	●	●	●						J	.250	(6.35)	±.0008	.016	.953	1.022	—
GY2G0635J080N-MF			●	●	●	●						J	.250	(6.35)	±.0008	.031	.937	1.022	—		
MS Breaker (Low feeds) 	GY2M0200D020N-MS			●	●	●	●					D	.079	(2.00)	±.0012	.008	.752	.815	—		
	GY2M0250E020N-MS			●	●	●	●						E	.098	(2.50)	±.0012	.008	.752	.815	—	
	GY2M0300F020N-MS			●	●	●	●						F	.118	(3.00)	±.0012	.008	.756	.815	—	
	GY2M0300F040N-MS			●	●	●	●						F	.118	(3.00)	±.0012	.016	.744	.815	—	
	GY2M0400G020N-MS			●	●	●	●						G	.157	(4.00)	±.0016	.008	.953	1.010	—	
	GY2M0400G040N-MS			●	●	●	●						G	.157	(4.00)	±.0016	.016	.941	1.010	—	
	GY2M0500H040N-MS			●	●	●	●						H	.197	(5.00)	±.0016	.016	.941	1.010	—	
	GY2M0500H080N-MS			●	●	●	●						H	.197	(5.00)	±.0016	.031	.925	1.010	—	
	GY2M0600J040N-MS			●	●	●	●						J	.236	(6.00)	±.0016	.016	.941	1.010	—	
	GY2M0600J080N-MS			●	●	●	●						J	.236	(6.00)	±.0016	.031	.925	1.010	—	
	GY2M0800K080N-MS			●	●	●							K	.315	(8.00)	±.0016	.031	1.122	1.201	—	

*1 Groove width corresponding to the circlip.

*2 The dimension depends on the breaker. Refer to the F015 "L dimension tolerance conversion table".

● = NEW

F
GROOVING / CUTTING OFF

GY SERIES INSERTS

INSERTS

(inch)

Applications	Geometry	Order Number	Stock								Seat Size	CW			RE RER/L	CDX	*2 L
			Coated				Cermet		Carbide			Cutting Width		Tolerance			
			NEW MP9015	NEW MP9025	VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020		inch	(mm)				
For Multifunctional Grooving		GY2M0200D020N-MM	●	●	●	●	●	●			D	.079	(2.00)	±.0012	.008	.752	.815
		GY2M0250E020N-MM	●	●	●	●	●	●			E	.098	(2.50)	±.0012	.008	.752	.815
		GY2M0300F020N-MM	●	●	●	●	●	●			F	.118	(3.00)	±.0012	.008	.752	.815
		GY2M0300F040N-MM	●	●	●	●	●	●			F	.118	(3.00)	±.0012	.016	.744	.815
		GY2M0300F080N-MM	●	●	●	●	●	●			F	.118	(3.00)	±.0012	.031	.728	.815
		GY2M0400G020N-MM	●	●	●	●	●	●			G	.157	(4.00)	±.0016	.008	.949	1.010
		GY2M0400G040N-MM	●	●	●	●	●	●			G	.157	(4.00)	±.0016	.016	.941	1.010
		GY2M0400G080N-MM	●	●	●	●	●	●			G	.157	(4.00)	±.0016	.031	.925	1.010
		GY2M0500H040N-MM	●	●	●	●	●	●			H	.197	(5.00)	±.0016	.016	.941	1.010
		GY2M0500H080N-MM	●	●	●	●	●	●			H	.197	(5.00)	±.0016	.031	.925	1.010
		GY2M0600J040N-MM	●	●	●	●	●	●			J	.236	(6.00)	±.0016	.016	.941	1.010
		GY2M0600J080N-MM	●	●	●	●	●	●			J	.236	(6.00)	±.0016	.031	.925	1.010
		GY2M0800K080N-MM	●	●	●	●	●	●			K	.315	(8.00)	±.0016	.031	1.122	1.201
		GY2M0800K120N-MM	●	●	●	●	●	●			K	.315	(8.00)	±.0016	.047	1.106	1.201
For Copying / For Receiving		GY2M0200D100N-BM	●	●	●	●	●			D	.079	(2.00)	±.0012	.039	.768	.815	
		GY2M0250E125N-BM	●	●	●	●	●	●			E	.098	(2.50)	±.0012	.049	.760	.815
		GY2M0300F150N-BM	●	●	●	●	●	●			F	.118	(3.00)	±.0012	.059	.748	.823
		GY2M0318F159N-BM	●	●	●	●	●	●			F	.125	(3.18)	±.0012	.063	.744	.823
		GY2M0400G200N-BM	●	●	●	●	●	●			G	.157	(4.00)	±.0016	.079	.921	1.016
		GY2M0475H238N-BM	●	●	●	●	●	●			H	.187	(4.75)	±.0016	.094	.902	1.016
		GY2M0500H250N-BM	●	●	●	●	●	●			H	.197	(5.00)	±.0016	.098	.898	1.016
		GY2M0600J300N-BM	●	●	●	●	●	●			J	.236	(6.00)	±.0016	.118	.886	1.020
		GY2M0635J318N-BM	●	●	●	●	●	●			J	.250	(6.35)	±.0016	.125	.878	1.020
		GY2M0800K400N-BM	●	●	●	●	●	●			K	.315	(8.00)	±.0016	.157	1.043	1.213

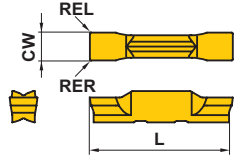
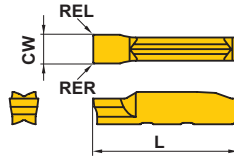
*2 The dimension depends on the breaker. Refer to the F015 "L dimension tolerance conversion table".

● = NEW

GROOVING / CUTTING OFF

F

(inch)

Applications	Geometry	Order Number	Stock			Seat Size	CW		Tolerance	RER/L	L
			Cermet		Carbide		Grooving Width				
			NX2525	RT9010	RT9020						
*1 Blank	2 Edge Type 	GY2B0220D020N	★	★	★	D	.087	(2.20)	± .0039	.008	.829
		GY2B0250D020N	★	★	★	D	.100	(2.55)	± .0039	.008	.838
		GY2B0270E020N	★	★	★	E	.106	(2.70)	± .0039	.008	.829
		GY2B0300E020N	★	★	★	E	.120	(3.05)	± .0039	.008	.838
		GY2B0340F020N	★	★	★	F	.134	(3.40)	± .0039	.008	.829
		GY2B0360F020N	★	★	★	F	.144	(3.65)	± .0039	.008	.838
		GY2B0420G020N	★	★	★	G	.165	(4.20)	± .0039	.008	1.024
		GY2B0460G020N	★	★	★	G	.183	(4.65)	± .0039	.008	1.031
		GY2B0520H020N	★	★	★	H	.205	(5.20)	± .0039	.008	1.024
		GY2B0560H020N	★	★	★	H	.222	(5.65)	± .0039	.008	1.031
		GY2B0655J020N	★	★	★	J	.258	(6.55)	± .0039	.008	1.025
		GY2B0680J020N	★	★	★	J	.270	(6.85)	± .0039	.008	1.031
		GY2B0880K020N	★	★	★	K	.348	(8.85)	± .0039	.008	1.216
			1 Edge Type 	GY1B0220D020N	★	★	★	D	.087	(2.20)	± .0039
GY1B0270E020N	★			★	★	E	.106	(2.70)	± .0039	.008	.831
GY1B0340F020N	★			★	★	F	.134	(3.40)	± .0039	.008	.827
GY1B0420G020N	★			★	★	G	.165	(4.20)	± .0039	.008	1.018
GY1B0520H020N	★			★	★	H	.205	(5.20)	± .0039	.008	1.020
GY1B0655J020N	★			★	★	J	.258	(6.55)	± .0039	.008	1.020

*1 Insert blank is not suitable for machining without grinding.

REFERENCE DATA

L dimension tolerance conversion table

Cutting Width CW	*1 Dimensions L	*2 Dimensional tolerance versus standard dimension (L) of each breaker									
		GU	GS/GM	MS/MM	R05-GS	R08/15-GS	R/L-GM	Flat Top	MF	BM	GL
.047", 1.20 mm	.579		0		0						
.059", 1.50 mm	.579		0			.020					
.079", 2.00 mm	.815	0	0	0		.024	.004	0	.014	.008	.014
.088", 2.24 mm	*3 (.815)								.014		
.094", 2.39 mm	.815	0	0					0	.014		
.098", 2.50 mm	.815	0	0	0		.031	.005	0	.014	.008	.014
.108", 2.74 mm	*3 (.815)								.014		
.118", 3.00 mm	.815	0	0	0		.031	.006	0	.014	.008	.014
.125", 3.18 mm	.815	0	0					0	.014	.008	
.128", 3.24 mm	*3 (.815)								.014		
.157", 4.00 mm	1.010	0	0	0			.008	0	.012	.006	
.167", 4.24 mm	*3 (1.010)								.012		
.187", 4.75 mm	1.010	0	0					0	.012	.006	
.197", 5.00 mm	1.010	0	0	0				.012	0	.012	.006
.206", 5.24 mm	*3 (1.010)								.012		
.236", 6.00 mm	1.010	0	0	0				0	.012	.010	
.248", 6.31 mm	*3 (1.010)								.012		
.250", 6.35 mm	1.010	0	0						.012	.010	
.315", 8.00 mm	1.201		0	0						.012	

*1 This value is used at the described holder dimension.

*2 ■ when there is no applicable breaker.

*3 The dimension is the value for approximate cutting width.

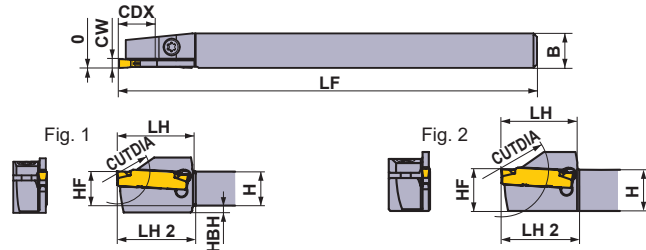
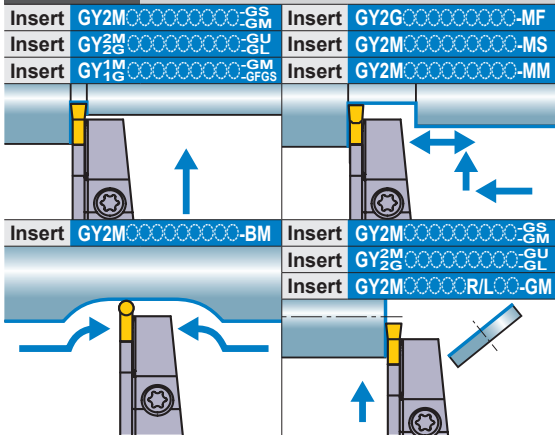
F

GROOVING / CUTTING OFF

GY SERIES (External for Swiss-type lathes)

1-1

00° type holder (Inch)



Right hand tool holder shown.

F

GROOVING / CUTTING OFF



Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number		Fig.
						Holder	Stock	
C	.059	.433	.866	Mono Block	R	GYSRUS06B00-C11	●	1
				Mono Block	L	GYSRUS06B00-C11	●	1
		.512	1.024	Mono Block	R	GYSRUS08B00-C13	●	2
				Mono Block	L	GYSRUS08B00-C13	●	2
		.669 *1	1.338 *2	Mono Block	R	GYSRUS10B00-C17	●	2
				Mono Block	L	GYSRUS10B00-C17	●	2
D	.079 .088	.433	.866	Mono Block	R	GYSRUS06B00-D11	●	1
				Mono Block	L	GYSRUS06B00-D11	●	1
		.512	1.024	Mono Block	R	GYSRUS08B00-D13	●	2
				Mono Block	L	GYSRUS08B00-D13	●	2
		.669 *1	1.338 *2	Mono Block	R	GYSRUS10B00-D17	●	2
				Mono Block	L	GYSRUS10B00-D17	●	2
E	.094 .098 .108	.433	.866	Mono Block	R	GYSRUS06B00-E11	●	1
				Mono Block	L	GYSRUS06B00-E11	●	1
		.512	1.024	Mono Block	R	GYSRUS08B00-E13	●	2
				Mono Block	L	GYSRUS08B00-E13	●	2
		.669 *1	1.338 *2	Mono Block	R	GYSRUS10B00-E17	●	2
				Mono Block	L	GYSRUS10B00-E17	●	2
.787 *1	1.574 *2	Mono Block	R	GYSRUS12B00-E17	●	2		
		Mono Block	L	GYSRUS12B00-E17	●	2		
F	.118 .125 .128	.512	1.024	Mono Block	R	GYSRUS08B00-F13	●	2
				Mono Block	L	GYSRUS08B00-F13	●	2
		.669 *1	1.338 *2	Mono Block	R	GYSRUS10B00-F17	●	2
				Mono Block	L	GYSRUS10B00-F17	●	2
		.787 *1	1.574 *2	Mono Block	R	GYSRUS12B00-F17	●	2
				Mono Block	L	GYSRUS12B00-F17	●	2
		Mono Block	R	GYSRUS10B00-F20	●	2		
		Mono Block	L	GYSRUS10B00-F20	●	2		

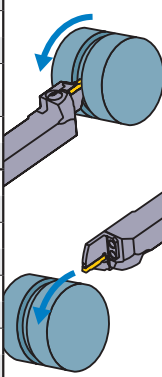
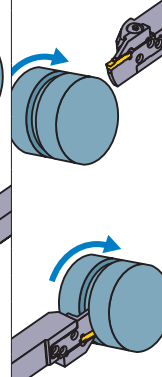
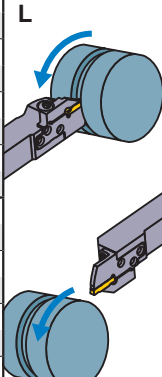
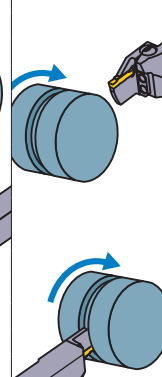
CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F199.

● : USA Stock

SPARE PARTS

Holder Number		
	Clamp Screw	Wrench
GYSR/LUS06B00-11	CS350990T (Clamp Torque : 22 lbf-in)	TKY10R
GYSR/LUS08B00-13		
GYSR/LUS10B00-18	TS4SBL (Clamp Torque : 31 lbf-in)	TKY15R
GYSR/LUS12B00-17		

	Dimensions (inch) *3							Cutting Mode	
	H	B	LF	LH	LH 2	HF	HBH	Clockwise	Anticlockwise
	.375	.375	4.500	.866	.620	.375	.125		
	.375	.375	4.500	.866	.620	.375	.125		
	.500	.500	4.500	.866	.620	.500	—		
	.500	.500	4.500	.866	.620	.500	—		
	.625	.625	4.500	1.063	.638	.625	—		
	.625	.625	4.500	1.063	.638	.625	—		
	.750	.750	4.500	1.102	.638	.750	—		
	.750	.750	4.500	1.102	.638	.750	—		
	.375	.375	4.500	.866	.899	.375	.125		
	.375	.375	4.500	.866	.899	.375	.125		
	.500	.500	4.500	.866	.899	.500	—		
	.500	.500	4.500	.866	.899	.500	—		
	.625	.625	4.500	1.063	.918	.625	—		
	.625	.625	4.500	1.063	.918	.625	—		
	.750	.750	4.500	1.102	.878	.750	—		
	.750	.750	4.500	1.102	.878	.750	—		
	.375	.375	4.500	.866	.901	.375	.125		
	.375	.375	4.500	.866	.901	.375	.125		
	.500	.500	4.500	.866	.901	.500	—		
	.500	.500	4.500	.866	.901	.500	—		
	.625	.625	4.500	1.063	.920	.625	—		
	.625	.625	4.500	1.063	.920	.625	—		
	.750	.750	4.500	1.102	.880	.750	—		
	.750	.750	4.500	1.102	.880	.750	—		
	.625	.625	4.500	1.220	.920	.625	—		
	.625	.625	4.500	1.220	.920	.625	—		
	.750	.750	4.500	1.220	.880	.750	—		
	.750	.750	4.500	1.220	.880	.750	—		
	.500	.500	4.500	.866	.903	.500	—		
	.500	.500	4.500	.866	.903	.500	—		
	.625	.625	4.500	1.063	.925	.625	—		
	.625	.625	4.500	1.063	.925	.625	—		
	.750	.750	4.500	1.102	.885	.750	—		
	.750	.750	4.500	1.102	.885	.750	—		
	.625	.625	4.500	1.220	.925	.625	—		
	.625	.625	4.500	1.220	.925	.625	—		
	.750	.750	4.500	1.220	.885	.750	—		
	.750	.750	4.500	1.220	.885	.750	—		

Select an Insert

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

		For Grooving/Cutting off > F011, F013				
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
C	.059", 1.50 mm	●	●	●	●	●
D	.079", 2.00 mm	●	●	●	●	●
E	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●

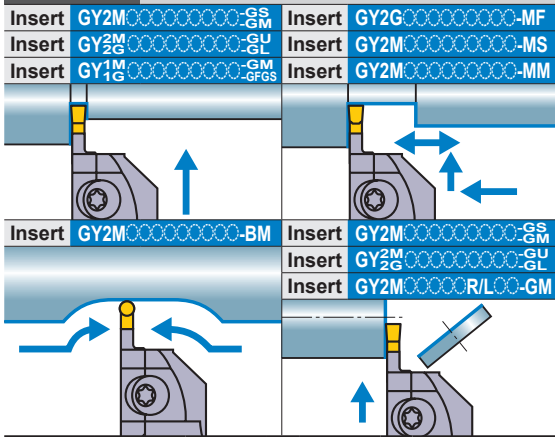
		For Cutting off > F012			
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
	CW	R	R	R	R/L
C	.059", 1.50 mm	●	●	●	●
D	.079", 2.00 mm	●	●	●	●
E	.098", 2.50 mm	●	●	●	●
F	.118", 3.00 mm	●	●	●	●

		For Multifunctional Grooving > F013, F014			
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
	CW				Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●
	.094", 2.39 mm	●	●	●	●
E	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●	●	●	●
F	.118", 3.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	.128", 3.24 mm	●	●	●	●

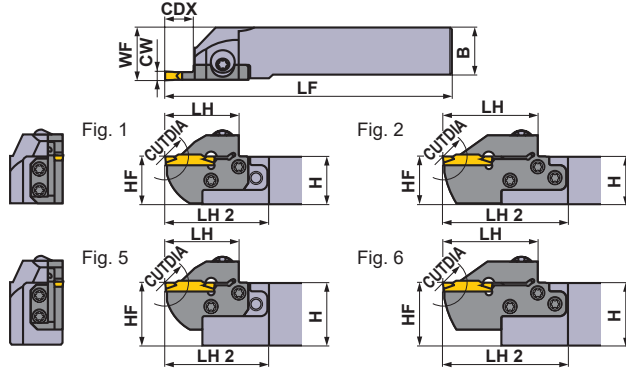
● : Gauge insert shown dimensions

GY SERIES (EXTERNAL)

1-1 00° type holder (Inch)



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



Right hand tool holder shown.

F

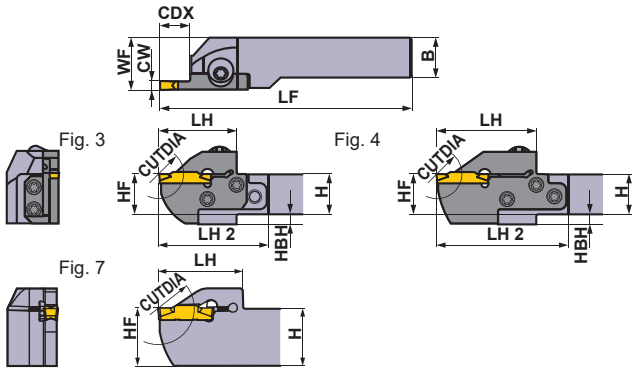
GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	.079 .088	.236	.472	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-D06	●	3
				Modular	L	GYHLUS10B00-M20L	●	GYM20LA-D06	●	3
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-D06	●	1
				Modular	L	GYHLUS12C00-M20L	●	GYM20LA-D06	●	1
				Modular	R	GYHRUS12C00-M25R	●	GYM25RA-D06	●	3
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-D06	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-D06	●	1
		Modular	L	GYHLUS16D00-M25L	●	GYM25LA-D06	●	1		
		Mono Block	R	GYQRUS16D00-D06	●	—	—	7		
		Mono Block	L	GYQLUS16D00-D06	●	—	—	7		
		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-D06	●	5		
		Modular	L	GYHLUS20D00-M25L	●	GYM25LA-D06	●	5		
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-D06	●	5		
		Modular	L	GYHLUS24E00-M25L	●	GYM25LA-D06	●	5		
	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-D10	●	3			
	Modular	L	GYHLUS10B00-M20L	●	GYM20LA-D10	●	3			
	Modular	R	GYHRUS12C00-M20R	●	GYM20RA-D10	●	1			
	Modular	L	GYHLUS12C00-M20L	●	GYM20LA-D10	●	1			
	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-D12	●	3			
	Modular	L	GYHLUS12C00-M25L	●	GYM25LA-D12	●	3			
	Modular	R	GYHRUS16D00-M25R	●	GYM25RA-D12	●	1			
	Modular	L	GYHLUS16D00-M25L	●	GYM25LA-D12	●	1			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RA-D12	●	5			
	Modular	L	GYHLUS20D00-M25L	●	GYM25LA-D12	●	5			
Modular	R	GYHRUS24E00-M25R	●	GYM25RA-D12	●	5				
Modular	L	GYHLUS24E00-M25L	●	GYM25LA-D12	●	5				
Modular	R	GYHRUS10B00-M20R	●	GYM20RB-D18	●	4				
Modular	L	GYHLUS10B00-M20L	●	GYM20LB-D18	●	4				
Modular	R	GYHRUS12C00-M20R	●	GYM20RB-D18	●	2				
Modular	L	GYHLUS12C00-M20L	●	GYM20LB-D18	●	2				
Modular	R	GYHRUS12C00-M25R	●	GYM25RA-D20	●	4				
Modular	L	GYHLUS12C00-M25L	●	GYM25LA-D20	●	4				
Mono Block	R	GYQRUS16D00-D20	●	—	—	7				
Mono Block	L	GYQLUS16D00-D20	●	—	—	7				
Modular	R	GYHRUS16D00-M25R	●	GYM25RA-D20	●	2				
Modular	L	GYHLUS16D00-M25L	●	GYM25LA-D20	●	2				
Modular	R	GYHRUS20D00-M25R	●	GYM25RA-D20	●	6				
Modular	L	GYHLUS20D00-M25L	●	GYM25LA-D20	●	6				
Modular	R	GYHRUS24E00-M25R	●	GYM25RA-D20	●	6				
Modular	L	GYHLUS24E00-M25L	●	GYM25LA-D20	●	6				

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
 *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○○○-M20R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/LUS○○○○○○○○-M25R/L	—	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (inch) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
.625	.625	4.264	1.102	1.761	.625	.812	.125	R	
.625	.625	4.264	1.102	1.761	.625	.812	.125		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	6.000	1.417	—	1.000	1.006	—		
1.000	1.000	6.000	1.417	—	1.000	1.006	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
.625	.625	4.500	1.339	1.997	.625	.812	.125	L	
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
1.000	1.000	6.000	1.614	—	1.000	1.004	—		
1.000	1.000	6.000	1.614	—	1.000	1.004	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW	R	R	R	R/L	
D	.079", 2.00 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW					Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●			

● : Gauge insert shown dimensions

F

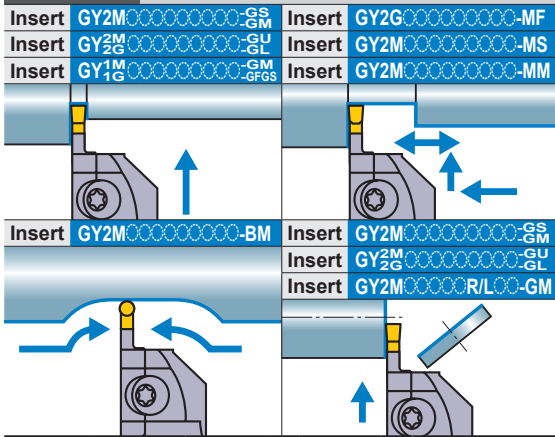
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL)

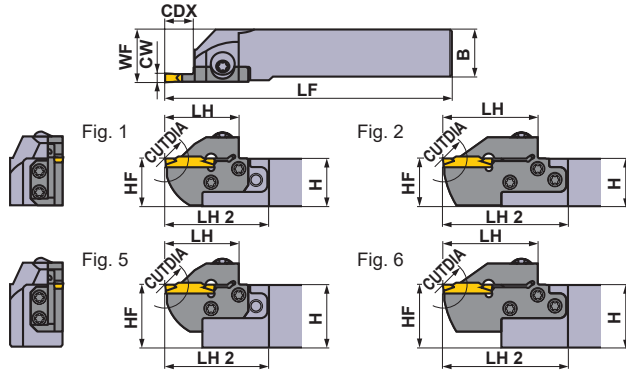
1-1

00° type holder (Inch)



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
E	.094 .098 .108	.236	.472	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-E06	●	3
					L	GYHLUS10B00-M20L	●	GYM20LA-E06	●	3
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-E06	●	1
					L	GYHLUS12C00-M20L	●	GYM20LA-E06	●	1
				Modular	R	GYHRUS12C00-M25R	●	GYM25RA-E06	●	3
					L	GYHLUS12C00-M25L	●	GYM25LA-E06	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-E06	●	1
			L	GYHLUS16D00-M25L	●	GYM25LA-E06	●	1		
		Mono Block	R	GYQRUS16D00-E06	●	—	—	7		
			L	GYQLUS16D00-E06	●	—	—	7		
		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-E06	●	5		
			L	GYHLUS20D00-M25L	●	GYM25LA-E06	●	5		
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-E06	●	5		
			L	GYHLUS24E00-M25L	●	GYM25LA-E06	●	5		
		.394	.787	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-E10	●	3
				L	GYHLUS10B00-M20L	●	GYM20LA-E10	●	3	
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-E10	●	1
					L	GYHLUS12C00-M20L	●	GYM20LA-E10	●	1
		.472	.945	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-E12	●	3
				L	GYHLUS12C00-M25L	●	GYM25LA-E12	●	3	
				R	GYHRUS16D00-M25R	●	GYM25RA-E12	●	1	
				L	GYHLUS16D00-M25L	●	GYM25LA-E12	●	1	
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-E12	●	5
					L	GYHLUS20D00-M25L	●	GYM25LA-E12	●	5
			Modular	R	GYHRUS24E00-M25R	●	GYM25RA-E12	●	5	
				L	GYHLUS24E00-M25L	●	GYM25LA-E12	●	5	
	.709 ^{*4}	1.417	Modular	R	GYHRUS10B00-M20R	●	GYM20RB-E18	●	4	
			L	GYHLUS10B00-M20L	●	GYM20LB-E18	●	4		
			R	GYHRUS12C00-M20R	●	GYM20RB-E18	●	2		
			L	GYHLUS12C00-M20L	●	GYM20LB-E18	●	2		
	.787 ^{*1}	1.575 ^{*2}	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-E20	●	4	
			L	GYHLUS12C00-M25L	●	GYM25LA-E20	●	4		
			Mono Block	R	GYQRUS16D00-E20	●	—	—	7	
				L	GYQLUS16D00-E20	●	—	—	7	
			R	GYHRUS16D00-M25R	●	GYM25RA-E20	●	2		
			L	GYHLUS16D00-M25L	●	GYM25LA-E20	●	2		
			Modular	R	GYHRUS20D00-M25R	●	GYM25RA-E20	●	6	
				L	GYHLUS20D00-M25L	●	GYM25LA-E20	●	6	
			Modular	R	GYHRUS24E00-M25R	●	GYM25RA-E20	●	6	
				L	GYHLUS24E00-M25L	●	GYM25LA-E20	●	6	

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

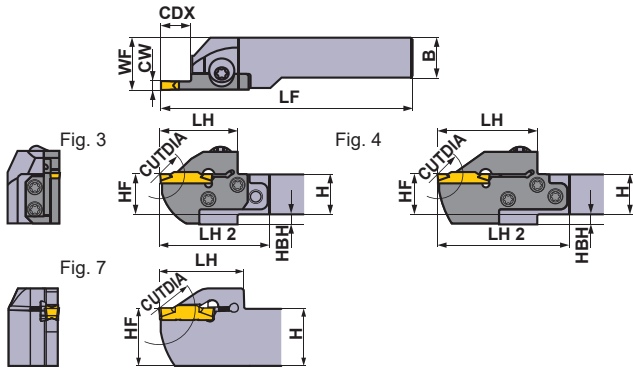
*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.

*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw

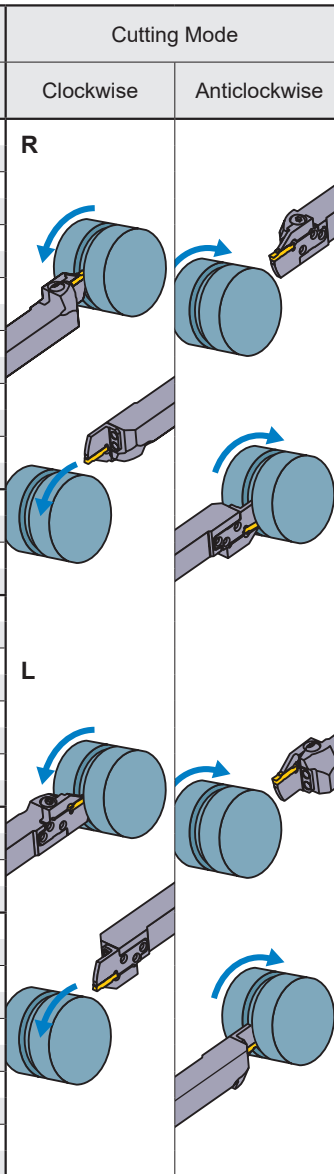


Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○○○-M20R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/LUS○○○○○○○○-M25R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (inch) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
.625	.625	4.264	1.102	1.761	.625	.812	.125	R	
.625	.625	4.264	1.102	1.761	.625	.812	.125		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	6.000	1.417	—	1.000	1.008	—		
1.000	1.000	6.000	1.417	—	1.000	1.008	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
1.000	1.000	6.000	1.614	—	1.000	1.004	—		
1.000	1.000	6.000	1.614	—	1.000	1.004	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		



Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW		Neutral	Neutral	Neutral	Neutral	Neutral
	.094", 2.39 mm	●	●	●	●	●
E	.098", 2.50 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW		R	R	R	R/L
	.098", 2.50 mm		●	●	●
E	.098", 2.50 mm		●	●	●

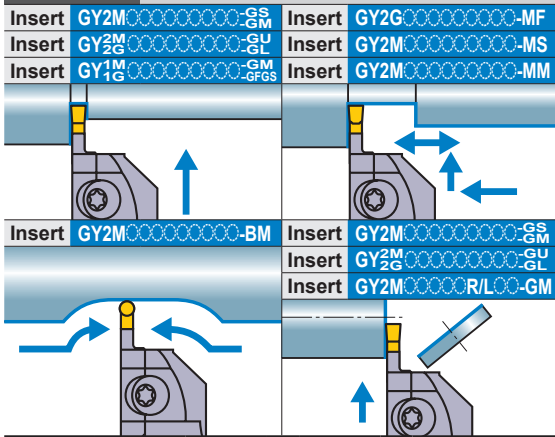
For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW					Ball nose
	.094", 2.39 mm	●	●	●	●
E	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

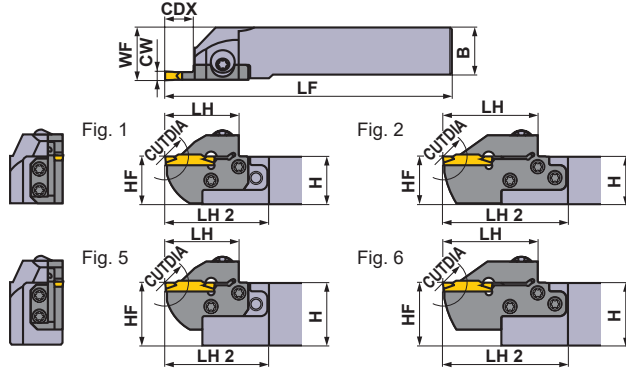
IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL)

1-1 00° type holder (Inch)



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



Right hand tool holder shown.

F

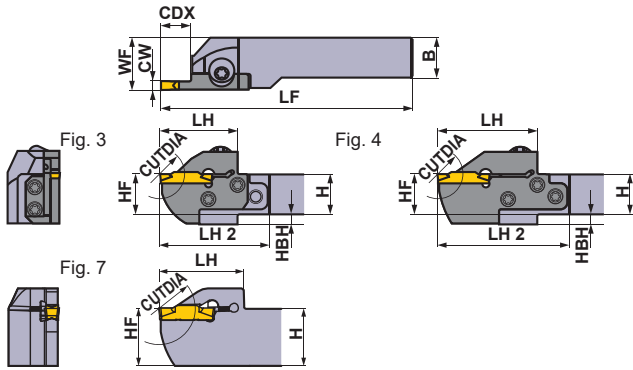
GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	.236	.472	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-F06	●	3
				Modular	L	GYHLUS10B00-M20L	●	GYM20LA-F06	●	3
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-F06	●	1
				Modular	L	GYHLUS12C00-M20L	●	GYM20LA-F06	●	1
				Modular	R	GYHRUS12C00-M25R	●	GYM25RA-F06	●	3
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-F06	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-F06	●	1
		Modular	L	GYHLUS16D00-M25L	●	GYM25LA-F06	●	1		
		Mono Block	R	GYQRUS16D00-F06	●	—	—	7		
		Mono Block	L	GYQLUS16D00-F06	●	—	—	7		
		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-F06	●	5		
		Modular	L	GYHLUS20D00-M25L	●	GYM25LA-F06	●	5		
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-F06	●	5		
		Modular	L	GYHLUS24E00-M25L	●	GYM25LA-F06	●	5		
	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-F10	●	3			
	Modular	L	GYHLUS10B00-M20L	●	GYM20LA-F10	●	3			
	Modular	R	GYHRUS12C00-M20R	●	GYM20RA-F10	●	1			
	Modular	L	GYHLUS12C00-M20L	●	GYM20LA-F10	●	1			
	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-F12	●	3			
	Modular	L	GYHLUS12C00-M25L	●	GYM25LA-F12	●	3			
	Modular	R	GYHRUS16D00-M25R	●	GYM25RA-F12	●	1			
	Modular	L	GYHLUS16D00-M25L	●	GYM25LA-F12	●	1			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RA-F12	●	5			
	Modular	L	GYHLUS20D00-M25L	●	GYM25LA-F12	●	5			
Modular	R	GYHRUS24E00-M25R	●	GYM25RA-F12	●	5				
Modular	L	GYHLUS24E00-M25L	●	GYM25LA-F12	●	5				
Modular	R	GYHRUS10B00-M20R	●	GYM20RB-F18	●	4				
Modular	L	GYHLUS10B00-M20L	●	GYM20LB-F18	●	4				
Modular	R	GYHRUS12C00-M20R	●	GYM20RB-F18	●	2				
Modular	L	GYHLUS12C00-M20L	●	GYM20LB-F18	●	2				
Modular	R	GYHRUS12C00-M25R	●	GYM25RA-F20	●	4				
Modular	L	GYHLUS12C00-M25L	●	GYM25LA-F20	●	4				
Mono Block	R	GYQRUS16D00-F20	●	—	—	7				
Mono Block	L	GYQLUS16D00-F20	●	—	—	7				
Modular	R	GYHRUS16D00-M25R	●	GYM25RA-F20	●	2				
Modular	L	GYHLUS16D00-M25L	●	GYM25LA-F20	●	2				
Modular	R	GYHRUS20D00-M25R	●	GYM25RA-F20	●	6				
Modular	L	GYHLUS20D00-M25L	●	GYM25LA-F20	●	6				
Modular	R	GYHRUS24E00-M25R	●	GYM25RA-F20	●	6				
Modular	L	GYHLUS24E00-M25L	●	GYM25LA-F20	●	6				

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
 *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○○○-M20R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/LUS○○○○○○○○-M25R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (inch) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
.625	.625	4.264	1.102	1.761	.625	.812	.125	R	
.625	.625	4.264	1.102	1.761	.625	.812	.125		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.764	1.102	1.698	.750	.875	—		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
.750	.750	4.685	1.220	2.060	.750	1.000	.250		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	5.685	1.220	1.934	1.000	1.125	—		
1.000	1.000	6.000	1.417	—	1.000	1.012	—		
1.000	1.000	6.000	1.417	—	1.000	1.012	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.250	1.250	5.685	1.220	1.942	1.250	1.375	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
1.500	1.500	6.685	1.220	1.926	1.500	1.625	—		
.625	.625	4.500	1.339	1.997	.625	.812	.125	L	
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.625	.625	4.736	1.575	2.233	.625	.812	.125		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.575	2.170	.750	.875	—		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
.750	.750	5.236	1.772	2.611	.750	1.000	.250		
1.000	1.000	6.000	1.614	—	1.000	1.010	—		
1.000	1.000	6.000	1.614	—	1.000	1.010	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.000	1.000	6.236	1.772	2.485	1.000	1.125	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.250	1.250	6.236	1.772	2.493	1.250	1.375	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW		Neutral	Neutral	Neutral	Neutral	Neutral
	.118", 3.00 mm	●	●	●	●	●
F	.125", 3.18 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW		R	R	R	R/L
	.118", 3.00 mm		●	●	●
F	.118", 3.00 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW					Ball nose
	.118", 3.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
F	.125", 3.18 mm			●	
	RE .008"	●			
	RE .016"	●			
F	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

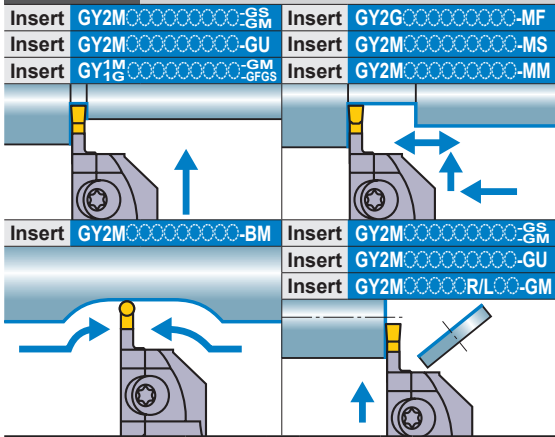
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GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)

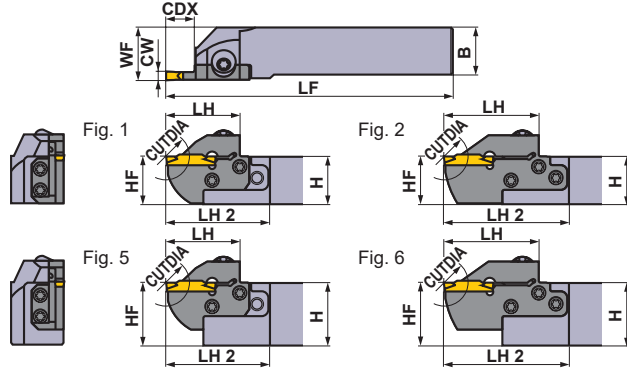
1-1

00° type holder (Inch)



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
G	.157 .167	.315	.630	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-G08	●	3
					L	GYHLUS12C00-M25L	●	GYM25LA-G08	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-G08	●	1
					L	GYHLUS16D00-M25L	●	GYM25LA-G08	●	1
				Mono Block	R	GYQRUS16D00-G08	●	—	—	7
					L	GYQLUS16D00-G08	●	—	—	7
		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-G08	●	5		
			L	GYHLUS20D00-M25L	●	GYM25LA-G08	●	5		
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-G08	●	5		
			L	GYHLUS24E00-M25L	●	GYM25LA-G08	●	5		
		.472	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-G12	●	3	
				L	GYHLUS10B00-M20L	●	GYM20LA-G12	●	3	
	Modular		R	GYHRUS12C00-M20R	●	GYM20RA-G12	●	1		
			L	GYHLUS12C00-M20L	●	GYM20LA-G12	●	1		
	Modular		R	GYHRUS12C00-M25R	●	GYM25RA-G14	●	3		
			L	GYHLUS12C00-M25L	●	GYM25LA-G14	●	3		
	.551	Modular	R	GYHRUS16D00-M25R	●	GYM25RA-G14	●	1		
			L	GYHLUS16D00-M25L	●	GYM25LA-G14	●	1		
		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-G14	●	5		
			L	GYHLUS20D00-M25L	●	GYM25LA-G14	●	5		
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-G14	●	5		
			L	GYHLUS24E00-M25L	●	GYM25LA-G14	●	5		
	.984*1	1.102	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-G25	●	4	
				L	GYHLUS12C00-M25L	●	GYM25LA-G25	●	4	
Mono Block			R	GYQRUS16D00-G25	●	—	—	7		
			L	GYQLUS16D00-G25	●	—	—	7		
Modular			R	GYHRUS16D00-M25R	●	GYM25RA-G25	●	2		
			L	GYHLUS16D00-M25L	●	GYM25LA-G25	●	2		
1.969*2		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-G25	●	6		
			L	GYHLUS20D00-M25L	●	GYM25LA-G25	●	6		
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-G25	●	6		
			L	GYHLUS24E00-M25L	●	GYM25LA-G25	●	6		

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

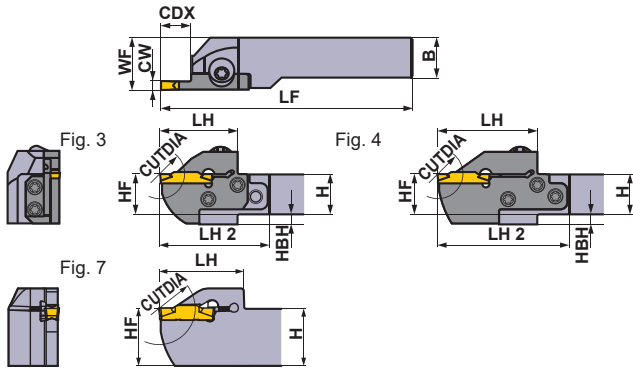
*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.

*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○○○-M20R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/LUS○○○○○○○○-M25R/L	—	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (inch) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
.750	.750	4.764	1.299	2.139	.750	1.000	.250	R	
.750	.750	4.764	1.299	2.139	.750	1.000	.250		
1.000	1.000	5.764	1.299	2.013	1.000	1.125	—	R	
1.000	1.000	5.764	1.299	2.013	1.000	1.125	—		
1.000	1.000	6.000	1.614	—	1.000	1.014	—	R	
1.000	1.000	6.000	1.614	—	1.000	1.014	—		
1.250	1.250	5.764	1.299	2.021	1.250	1.375	—	R	
1.250	1.250	5.764	1.299	2.021	1.250	1.375	—		
1.500	1.500	6.764	1.299	2.005	1.500	1.625	—	R	
1.500	1.500	6.764	1.299	2.005	1.500	1.625	—		
.625	.625	4.500	1.339	1.997	.625	.812	.125	L	
.625	.625	4.500	1.339	1.997	.625	.812	.125		
.750	.750	5.000	1.339	1.934	.750	.875	—	L	
.750	.750	5.000	1.339	1.934	.750	.875	—		
.750	.750	5.000	1.535	2.375	.750	1.000	.250	L	
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—	L	
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—	L	
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	L	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
.750	.750	5.433	1.969	2.808	.750	1.000	.250	L	
.750	.750	5.433	1.969	2.808	.750	1.000	.250		
1.000	1.000	6.000	1.811	—	1.000	1.014	—	L	
1.000	1.000	6.000	1.811	—	1.000	1.014	—		
1.000	1.000	6.433	1.969	2.682	1.000	1.125	—	L	
1.000	1.000	6.433	1.969	2.682	1.000	1.125	—		
1.250	1.250	6.433	1.969	2.690	1.250	1.375	—	L	
1.250	1.250	6.433	1.969	2.690	1.250	1.375	—		
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	L	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—		

Select an Insert

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

For Grooving/Cutting off > F011-F013					
Seat Size	Breaker	GU	GS	GM	GFGS 05-GM
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel) (Cutting off)
CW		Neutral	Neutral	Neutral	Hand
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW					Ball nose
G	.157", 4.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●		●	
	.167", 4.24 mm	●			

● : Gauge insert shown dimensions

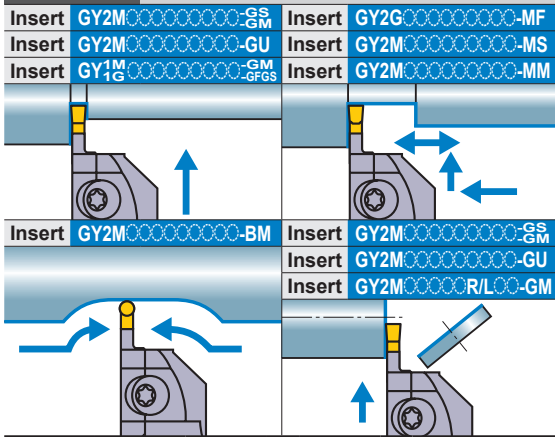
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GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

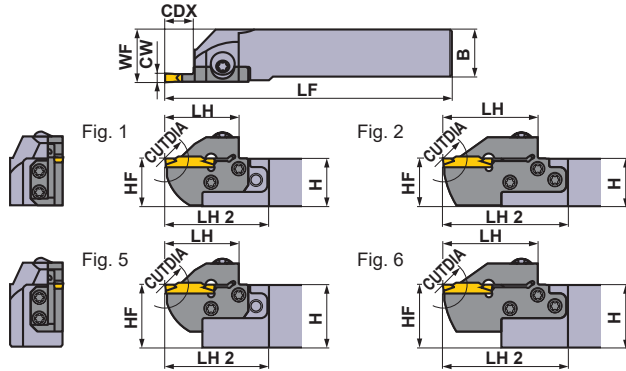
GY SERIES (EXTERNAL)

1-1 00° type holder (Inch)



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	.315	.630	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-H08	●	3
					L	GYHLUS12C00-M25L	●	GYM25LA-H08	●	3
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-H08	●	1
					L	GYHLUS16D00-M25L	●	GYM25LA-H08	●	1
				Mono Block	R	GYQRUS16D00-H08	●	—	—	7
					L	GYQLUS16D00-H08	●	—	—	7
		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-H08	●	5		
			L	GYHLUS20D00-M25L	●	GYM25LA-H08	●	5		
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-H08	●	5		
			L	GYHLUS24E00-M25L	●	GYM25LA-H08	●	5		
		.472	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-H12	●	3	
				L	GYHLUS10B00-M20L	●	GYM20LA-H12	●	3	
	Modular		R	GYHRUS12C00-M20R	●	GYM20RA-H12	●	1		
			L	GYHLUS12C00-M20L	●	GYM20LA-H12	●	1		
	Modular		R	GYHRUS12C00-M25R	●	GYM25RA-H14	●	3		
			L	GYHLUS12C00-M25L	●	GYM25LA-H14	●	3		
	.551	Modular	R	GYHRUS16D00-M25R	●	GYM25RA-H14	●	1		
			L	GYHLUS16D00-M25L	●	GYM25LA-H14	●	1		
		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-H14	●	5		
			L	GYHLUS20D00-M25L	●	GYM25LA-H14	●	5		
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-H14	●	5		
			L	GYHLUS24E00-M25L	●	GYM25LA-H14	●	5		
	.984 ^{*1}	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-H25	●	4		
			L	GYHLUS12C00-M25L	●	GYM25LA-H25	●	4		
Mono Block		R	GYQRUS16D00-H25	●	—	—	7			
		L	GYQLUS16D00-H25	●	—	—	7			
Modular		R	GYHRUS16D00-M25R	●	GYM25RA-H25	●	2			
		L	GYHLUS16D00-M25L	●	GYM25LA-H25	●	2			
Modular		R	GYHRUS20D00-M25R	●	GYM25RA-H25	●	6			
		L	GYHLUS20D00-M25L	●	GYM25LA-H25	●	6			
Modular	R	GYHRUS24E00-M25R	●	GYM25RA-H25	●	6				
	L	GYHLUS24E00-M25L	●	GYM25LA-H25	●	6				

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

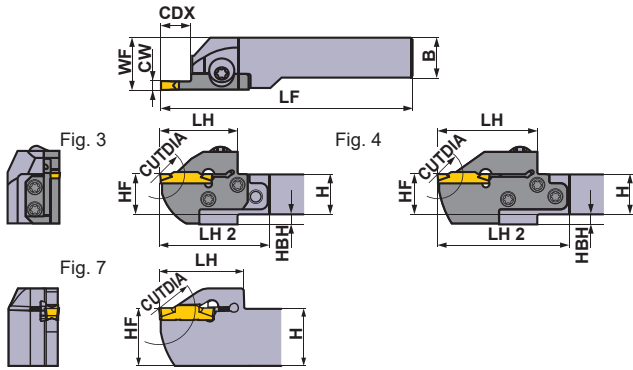
*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.

*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○○○-M20R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/LUS○○○○○○○○-M25R/L	—	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) *3								Cutting Mode	
	H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
	.750	.750	4.764	1.299	2.139	.750	1.000	.250	R	
	.750	.750	4.764	1.299	2.139	.750	1.000	.250		
	1.000	1.000	5.764	1.299	2.013	1.000	1.125	—	L	
	1.000	1.000	5.764	1.299	2.013	1.000	1.125	—		
	1.000	1.000	6.000	1.614	—	1.000	1.014	—	R	
	1.000	1.000	6.000	1.614	—	1.000	1.014	—		
	1.250	1.250	5.764	1.299	2.021	1.250	1.375	—	L	
	1.250	1.250	5.764	1.299	2.021	1.250	1.375	—		
	1.500	1.500	6.764	1.299	2.005	1.500	1.625	—	R	
	1.500	1.500	6.764	1.299	2.005	1.500	1.625	—		
	.625	.625	4.500	1.339	1.997	.625	.812	.125	L	
	.625	.625	4.500	1.339	1.997	.625	.812	.125		
	.750	.750	5.000	1.339	1.934	.750	.875	—	R	
	.750	.750	5.000	1.339	1.934	.750	.875	—		
	.750	.750	5.000	1.535	2.375	.750	1.000	.250	L	
	.750	.750	5.000	1.535	2.375	.750	1.000	.250		
	1.000	1.000	6.000	1.535	2.249	1.000	1.125	—	R	
	1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
	1.250	1.250	6.000	1.535	2.257	1.250	1.375	—	L	
	1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	R	
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
	.750	.750	5.433	1.969	2.808	.750	1.000	.250	L	
	.750	.750	5.433	1.969	2.808	.750	1.000	.250		
	1.000	1.000	6.000	1.811	—	1.000	1.014	—	R	
	1.000	1.000	6.000	1.811	—	1.000	1.014	—		
	1.000	1.000	6.433	1.969	2.682	1.000	1.125	—	L	
	1.000	1.000	6.433	1.969	2.682	1.000	1.125	—		
	1.250	1.250	6.433	1.969	2.690	1.250	1.375	—	R	
	1.250	1.250	6.433	1.969	2.690	1.250	1.375	—		
	1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	L	
	1.500	1.500	7.433	1.969	2.674	1.500	1.625	—		

Select an Insert

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

For Grooving/Cutting off > F011-F013						
Seat Size	Breaker	GU	GS	GM	GFGS	05-GM
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)	(Cutting off)
CW		Neutral	Neutral	Neutral	Neutral	Hand
	H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
H					Ball nose
	.187", 4.75 mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00 mm				●
H	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

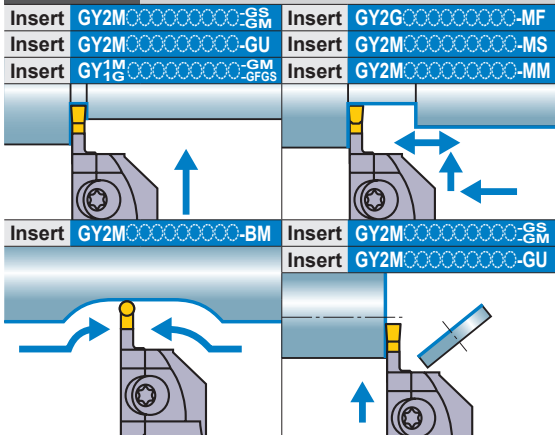
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GROOVING / CUTTING OFF

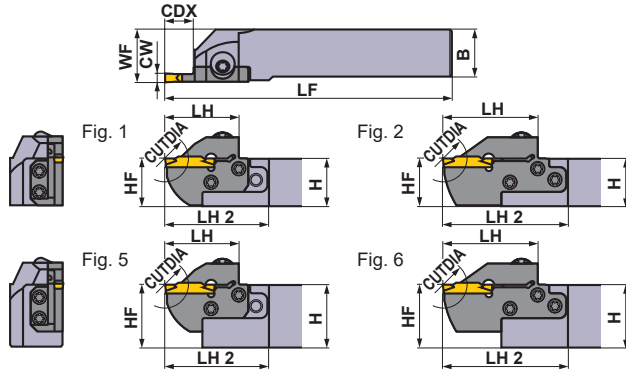
IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL)

1-1 00° type holder (Inch)



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



Right hand tool holder shown.

F

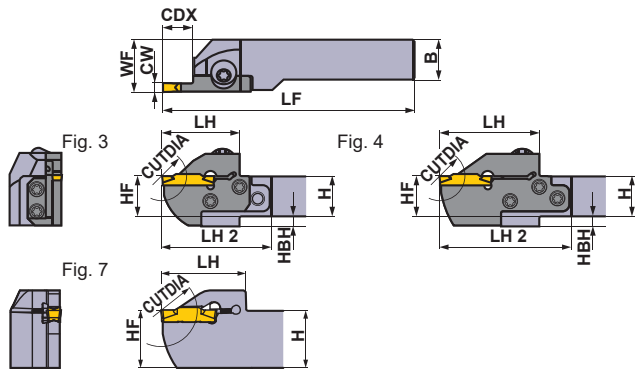
GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.			
						Holder	Stock	Modular Blade	Stock				
J	.236 .248 .250	.315	.630	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-J08	●	3			
					L	GYHLUS12C00-M25L	●	GYM25LA-J08	●	3			
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-J08	●	1			
					L	GYHLUS16D00-M25L	●	GYM25LA-J08	●	1			
				Mono Block	R	GYQRUS16D00-J08	●	—	—	7			
					L	GYQLUS16D00-J08	●	—	—	7			
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-J08	●	5			
					L	GYHLUS20D00-M25L	●	GYM25LA-J08	●	5			
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-J08	●	5			
					L	GYHLUS24E00-M25L	●	GYM25LA-J08	●	5			
	.551	.551	1.102	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-J14	●	3			
					L	GYHLUS12C00-M25L	●	GYM25LA-J14	●	3			
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-J14	●	1			
					L	GYHLUS16D00-M25L	●	GYM25LA-J14	●	1			
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-J14	●	5			
					L	GYHLUS20D00-M25L	●	GYM25LA-J14	●	5			
				Modular	R	GYHRUS24E00-M25R	●	GYM25RA-J14	●	5			
					L	GYHLUS24E00-M25L	●	GYM25LA-J14	●	5			
				.984 ^{*1}	.984	1.969 ^{*2}	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-J25	●	4
								L	GYHLUS12C00-M25L	●	GYM25LA-J25	●	4
Mono Block	R	GYQRUS16D00-J25	●				—	—	7				
	L	GYQLUS16D00-J25	●				—	—	7				
Modular	R	GYHRUS16D00-M25R	●				GYM25RA-J25	●	2				
	L	GYHLUS16D00-M25L	●				GYM25LA-J25	●	2				
Modular	R	GYHRUS20D00-M25R	●				GYM25RA-J25	●	6				
	L	GYHLUS20D00-M25L	●				GYM25LA-J25	●	6				
Modular	R	GYHRUS24E00-M25R	●	GYM25RA-J25	●	6							
	L	GYHLUS24E00-M25L	●	GYM25LA-J25	●	6							

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

● : USA Stock



Right hand tool holder shown.

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

SPARE PARTS			
Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/LUS○○○○○○○○○○	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/LUS○○○○○○-M25R/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (inch) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
.750	.750	4.764	1.299	2.139	.750	1.000	.250	R	
.750	.750	4.764	1.299	2.139	.750	1.000	.250		
1.000	1.000	5.764	1.299	2.013	1.000	1.125	—		
1.000	1.000	5.764	1.299	2.013	1.000	1.125	—		
1.000	1.000	6.000	1.614	—	1.000	1.014	—		
1.000	1.000	6.000	1.614	—	1.000	1.014	—		
1.250	1.250	5.764	1.299	2.021	1.250	1.375	—		
1.250	1.250	5.764	1.299	2.021	1.250	1.375	—		
1.500	1.500	6.764	1.299	2.005	1.500	1.625	—		
1.500	1.500	6.764	1.299	2.005	1.500	1.625	—		
.750	.750	5.000	1.535	2.375	.750	1.000	.250	L	
.750	.750	5.000	1.535	2.375	.750	1.000	.250		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.000	1.000	6.000	1.535	2.249	1.000	1.125	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.250	1.250	6.000	1.535	2.257	1.250	1.375	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—		
.750	.750	5.433	1.969	2.808	.750	1.000	.250	L	
.750	.750	5.433	1.969	2.808	.750	1.000	.250		
1.000	1.000	6.000	1.811	—	1.000	1.014	—		
1.000	1.000	6.000	1.811	—	1.000	1.014	—		
1.000	1.000	6.433	1.969	2.682	1.000	1.125	—		
1.000	1.000	6.433	1.969	2.682	1.000	1.125	—		
1.250	1.250	6.433	1.969	2.690	1.250	1.375	—		
1.250	1.250	6.433	1.969	2.690	1.250	1.375	—		
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—		
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GFGS	05-GM
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)	(Cutting off)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Hand
	J	236", 6.00 mm	●	●	●	●
J	250", 6.35 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Reversing)
J	236", 6.00 mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
J	248", 6.31 mm	●			
	250", 6.35 mm				●
	RE .008"	●			
	RE .016"	●			
J	RE .031"	●			

● : Gauge insert shown dimensions

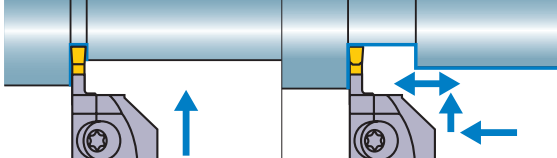
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GROOVING / CUTTING OFF

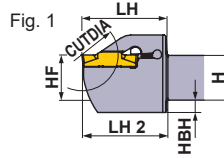
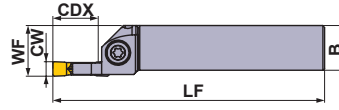
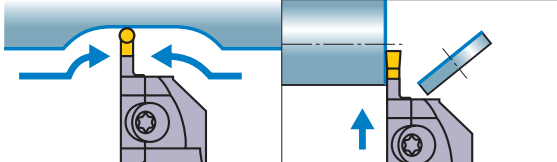
GY SERIES (EXTERNAL)

1-1 00° type holder (Inch)

Insert	GY2M ⁰⁰⁰⁰⁰⁰⁰⁰⁰⁰ -GS	Insert	GY2M ⁰⁰⁰⁰⁰⁰⁰⁰⁰⁰ -MS
Insert	GY2M ⁰⁰⁰⁰⁰⁰⁰⁰⁰⁰ -GM	Insert	GY2M ⁰⁰⁰⁰⁰⁰⁰⁰⁰⁰ -MM



Insert	GY2M ⁰⁰⁰⁰⁰⁰⁰⁰⁰⁰ -BM	Insert	GY2M ⁰⁰⁰⁰⁰⁰⁰⁰⁰⁰ -GS
Insert	GY2M ⁰⁰⁰⁰⁰⁰⁰⁰⁰⁰ -GS	Insert	GY2M ⁰⁰⁰⁰⁰⁰⁰⁰⁰⁰ -GM



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
K	.315	*1 .984	*2 1.968	Mono Block	R	GYPRUS16D00-K25	●	—	—	1
				Mono Block	L	GYPLUS16D00-K25	●	—	—	1
				Mono Block	R	GYPRUS20D00-K25	●	—	—	2
				Mono Block	L	GYPLUS20D00-K25	●	—	—	2

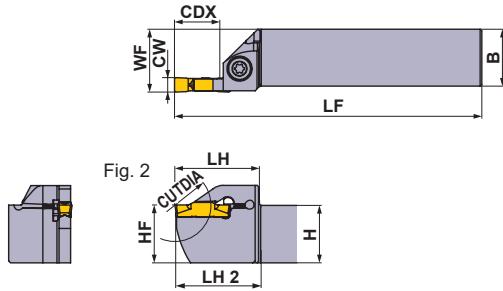
CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.

*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

● : USA Stock



Right hand tool holder shown.

SPARE PARTS		
Holder Number		
	Clamp Screw	Wrench
GYPR/LUS○○○○00-K25		GY06013M (Clamp Torque : 53 lbf-in) TKY30R

	Dimensions (inch) *3								Cutting Mode	
	H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
	1.000	1.000	6.000	1.850	1.875	1.000	1.161	.260		
	1.000	1.000	6.000	1.850	1.875	1.000	1.161	.260		
	1.250	1.250	7.000	1.850	2.875	1.250	1.377	—		
	1.250	1.250	7.000	1.850	2.875	1.250	1.377	—		

Select an Insert

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

For Grooving/Cutting off > F011						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)	05-GM (Cutting off)
	CW	Neutral	Neutral	Neutral	Neutral	Hand
K	.315", 8.00 mm		●	●		

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
	CW				
K	.315", 8.00 mm RE .031" RE .047"		●	●	●

● : Gauge insert shown dimensions

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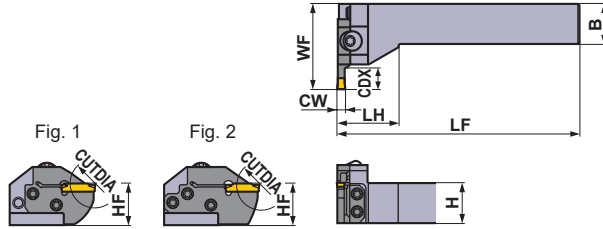
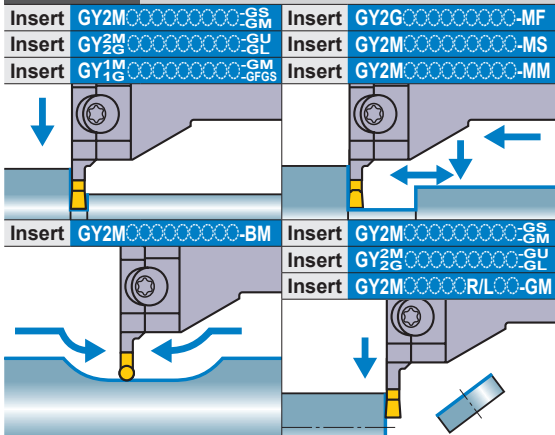
GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)

2-1 90° type holder (Inch)

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
D	.079	.236	.472	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-D06	●	1	
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-D06	●	1	
		.394	.787	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-D06	●	1	
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-D06	●	1	
		.472	.945	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-D10	●	1	
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-D10	●	1	
	.088	.709 *4	1.417	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-D12	●	1	
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-D12	●	1	
		.787 *1	1.575 *2	Modular	R	GYHRUS12C90-M20L	●	GYM20LB-D18	●	2	
				Modular	L	GYHLUS12C90-M20R	●	GYM20RB-D18	●	2	
					Modular	R	GYHRUS16D90-M25L	●	GYM25LA-D20	●	2
					Modular	L	GYHLUS16D90-M25R	●	GYM25RA-D20	●	2
E	.094	.236	.472	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-E06	●	1	
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-E06	●	1	
		.394	.787	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-E06	●	1	
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-E06	●	1	
		.472	.945	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-E10	●	1	
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-E10	●	1	
	.108	.709 *4	1.417	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-E12	●	1	
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-E12	●	1	
		.787 *1	1.575 *2	Modular	R	GYHRUS12C90-M20L	●	GYM20LB-E18	●	2	
				Modular	L	GYHLUS12C90-M20R	●	GYM20RB-E18	●	2	
					Modular	R	GYHRUS16D90-M25L	●	GYM25LA-E20	●	2
					Modular	L	GYHLUS16D90-M25R	●	GYM25RA-E20	●	2

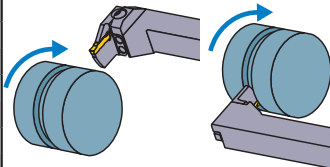
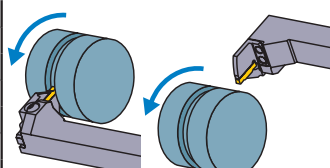
CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHRUS12C90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R
GYHLUS12C90-M20R			②TKY15D
GYHRUS16D90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R
GYHLUS16D90-M25R			②TKY25D

	Dimensions (inch) *3						Cutting Mode
	H	B	LF	LH	HF	WF	
	.750	.750	5.000	1.375	.750	1.545	 R
	.750	.750	5.000	1.375	.750	1.545	
	1.000	1.000	6.000	1.500	1.000	1.779	
	1.000	1.000	6.000	1.500	1.000	1.779	
	.750	.750	5.000	1.375	.750	1.781	
	.750	.750	5.000	1.375	.750	1.781	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	.750	.750	5.000	1.375	.750	2.017	
	.750	.750	5.000	1.375	.750	2.017	
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	2.330	
	.750	.750	5.000	1.375	.750	1.545	 L
	.750	.750	5.000	1.375	.750	1.545	
	1.000	1.000	6.000	1.500	1.000	1.779	
	1.000	1.000	6.000	1.500	1.000	1.779	
	.750	.750	5.000	1.375	.750	1.781	
	.750	.750	5.000	1.375	.750	1.781	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	.750	.750	5.000	1.375	.750	2.017	
	.750	.750	5.000	1.375	.750	2.017	
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	2.330	

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●
E	.094", 2.39 mm	●	●	●	●	●
		●	●	●	●	●
E	.098", 2.50 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
	CW	R	R	R	R/L
D	.079", 2.00 mm		●	●	●
E	.098", 2.50 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
	CW				Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●			
	.094", 2.39 mm	●			
E	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

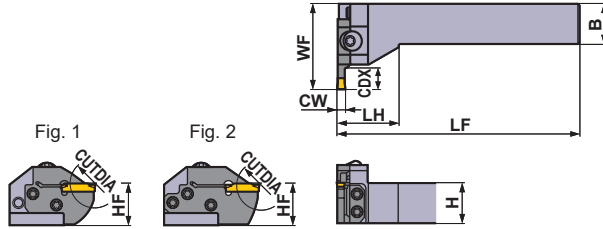
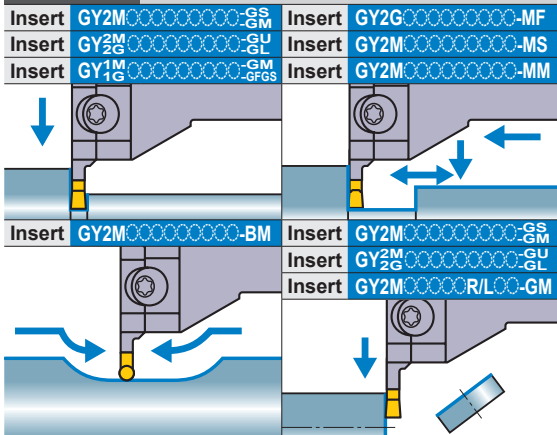
IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL)

2-1 90° type holder (Inch)

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	.236	.472	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-F06	●	1
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-F06	●	1
		.394	.787	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-F06	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-F06	●	1
		.472	.945	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-F10	●	1
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-F10	●	1
		.709 *4	1.417	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-F12	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-F12	●	1
		.787 *1	1.575 *2	Modular	R	GYHRUS12C90-M20L	●	GYM20LB-F18	●	2
				Modular	L	GYHLUS12C90-M20R	●	GYM20RB-F18	●	2
G	.157 .167	.315	.630	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-G08	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-G08	●	1
		.472	.945	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-G12	●	1
				Modular	L	GYHLUS12C90-M20R	●	GYM20RA-G12	●	1
		.551	1.102	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-G14	●	1
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-G14	●	1
		.984 *1	1.969 *2	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-G25	●	2
				Modular	L	GYHLUS16D90-M25R	●	GYM25RA-G25	●	2

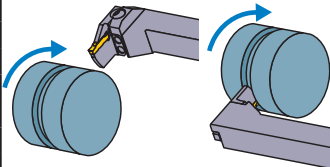
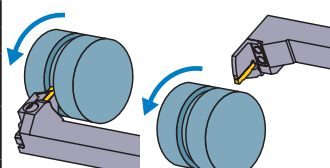
CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHRUS12C90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R
GYHLUS12C90-M20R			②TKY15D
GYHRUS16D90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R
GYHLUS16D90-M25R			②TKY25D

	Dimensions (inch) *3						Cutting Mode
	H	B	LF	LH	HF	WF	
	.750	.750	5.000	1.375	.750	1.545	 R
	.750	.750	5.000	1.375	.750	1.545	
	1.000	1.000	6.000	1.500	1.000	1.779	
	1.000	1.000	6.000	1.500	1.000	1.779	
	.750	.750	5.000	1.375	.750	1.781	
	.750	.750	5.000	1.375	.750	1.781	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	.750	.750	5.000	1.375	.750	2.017	
	.750	.750	5.000	1.375	.750	2.017	
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	2.330	
	1.000	1.000	6.000	1.500	1.000	1.857	 L
	1.000	1.000	6.000	1.500	1.000	1.857	
	.750	.750	5.000	1.375	.750	1.781	
	.750	.750	5.000	1.375	.750	1.781	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	

Select an Insert

Seat Size	Insert Number
F	GY0003000/0318/0324F0000-Breaker
G	GY0004000/0424G0000-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
		Neutral	Neutral	Neutral	Neutral	Neutral
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●
G	.157", 4.00 mm	●	●	●		●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
		R	R	R	R/L
F	.118", 3.00 mm		●	●	●
G	.157", 4.00 mm				●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
					Ball nose
F	.118", 3.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm				●
	RE .008"	●			
G	.128", 3.24 mm	●			
	.157", 4.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●		●	
	.167", 4.24 mm	●			

● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

F

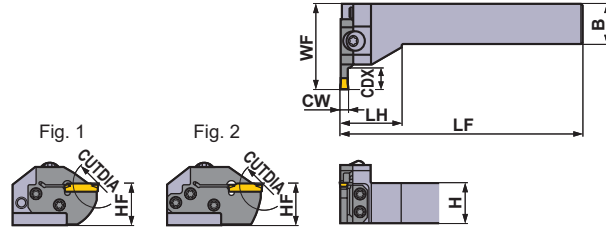
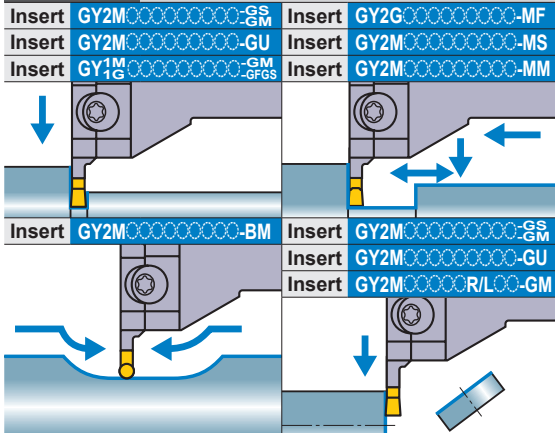
GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)

2-1 90° type holder (Inch)

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	.315	.630	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-H08	●	1
					L	GYHLUS16D90-M25R	●	GYM25RA-H08	●	1
		.472	.945	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-H12	●	1
					L	GYHLUS12C90-M20R	●	GYM20RA-H12	●	1
		.551	1.102	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-H14	●	1
					L	GYHLUS16D90-M25R	●	GYM25RA-H14	●	1
	.984 *1	1.969 *2	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-H25	●	2	
				L	GYHLUS16D90-M25R	●	GYM25RA-H25	●	2	
J	.236 .248 .250	.315	.630	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-J08	●	1
					L	GYHLUS16D90-M25R	●	GYM25RA-J08	●	1
		.551	1.102	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-J14	●	1
					L	GYHLUS16D90-M25R	●	GYM25RA-J14	●	1
		.984 *1	1.969 *2	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-J25	●	2
					L	GYHLUS16D90-M25R	●	GYM25RA-J25	●	2

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter




*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.

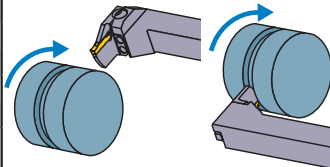
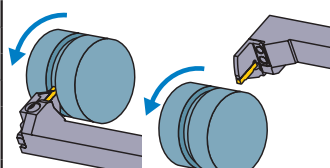
*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

● : USA Stock

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHRUS12C90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R
GYHLUS12C90-M20R			②TKY15D
GYHRUS16D90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R
GYHLUS16D90-M25R			②TKY25D

	Dimensions (inch) *3						Cutting Mode
	H	B	LF	LH	HF	WF	
	1.000	1.000	6.000	1.500	1.000	1.857	 R
	1.000	1.000	6.000	1.500	1.000	1.857	
	.750	.750	5.000	1.375	.750	1.781	
	.750	.750	5.000	1.375	.750	1.781	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	1.857	 L
	1.000	1.000	6.000	1.500	1.000	1.857	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.527	
	1.000	1.000	6.000	1.500	1.000	2.527	

Select an Insert

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

For Grooving/Cutting off > F011-F013						
Seat Size	Breaker	GU	GS	GM	GFGS	05-GM
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)	(Cutting off)
	CW	Neutral	Neutral	Neutral	Neutral	Hand
H	.187", 4.75 mm	●	●	●	●	●
	.197", 5.00 mm	●	●	●	●	●
J	.236", 6.00 mm	●	●	●	●	●
	.250", 6.35 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Reccessing)
	CW				Ball nose
	.187", 4.75 mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
H	.197", 5.00 mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24 mm	●			
	.236", 6.00 mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
J	.248", 6.31 mm	●			
	.250", 6.35 mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

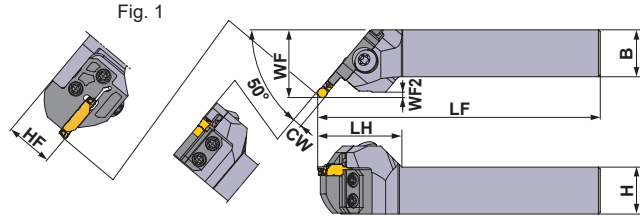
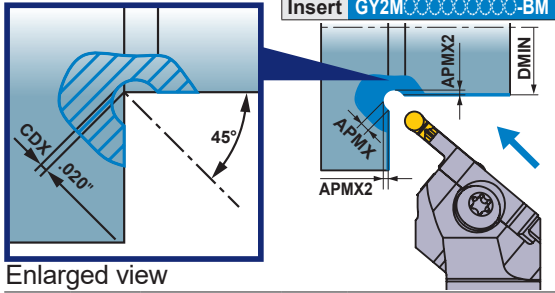
IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL RECESSING)

3-1 50° type holder (Inch)

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (inch)	CDX (inch)	DMIN (inch)	APMX (inch)	APMX2 (inch)	Type	Hand (R/L)	Order Number				Fig.
								Holder	Stock	Modular Blade	Stock	
D	.079	.020	1.181	.059	.025	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-D005	●	1
	L						GYHLUS12C50-M20R	●	GYM20RC-D005	●	1	
E	.094	.020	1.181	.069	.028	Modular	R	GYHRUS16D50-M25L	●	GYM25LC-D005	●	1
	L						GYHLUS16D50-M25R	●	GYM25RC-D005	●	1	
F	.118	.020	1.181	.082	.032	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-E005	●	1
	L						GYHLUS12C50-M20R	●	GYM20RC-E005	●	1	
G	.125	.020	1.181	.082	.032	Modular	R	GYHRUS16D50-M25L	●	GYM25LC-E005	●	1
	L						GYHLUS16D50-M25R	●	GYM25RC-E005	●	1	
H	.128	.020	1.181	.082	.032	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-F005	●	1
	L						GYHLUS12C50-M20R	●	GYM20RC-F005	●	1	
I	.157	.020	1.181	.098	.037	Modular	R	GYHRUS16D50-M25L	●	GYM25LC-F005	●	1
	L						GYHLUS16D50-M25R	●	GYM25RC-F005	●	1	
J	.167	.020	1.181	.098	.037	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-G005	●	1
	L						GYHLUS12C50-M20R	●	GYM20RC-G005	●	1	
K	.187	.020	1.181	.113	.041	Modular	R	GYHRUS16D50-M25L	●	GYM25LC-G005	●	1
	L						GYHLUS16D50-M25R	●	GYM25RC-G005	●	1	
L	.197	.020	1.181	.113	.041	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-H005	●	1
	L						GYHLUS12C50-M20R	●	GYM20RC-H005	●	1	
M	.206	.020	1.181	.113	.041	Modular	R	GYHRUS16D50-M25L	●	GYM25LC-H005	●	1
	L						GYHLUS16D50-M25R	●	GYM25RC-H005	●	1	
N	.236	.020	1.181	.144	.051	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-J005	●	1
	L						GYHLUS12C50-M20R	●	GYM20RC-J005	●	1	
O	.248	.020	1.181	.144	.051	Modular	R	GYHRUS16D50-M25L	●	GYM25LC-J005	●	1
	L						GYHLUS16D50-M25R	●	GYM25RC-J005	●	1	
P	.250	.020	1.181	.144	.051	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-K005	●	1
	L						GYHLUS12C50-M20R	●	GYM20RC-K005	●	1	

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

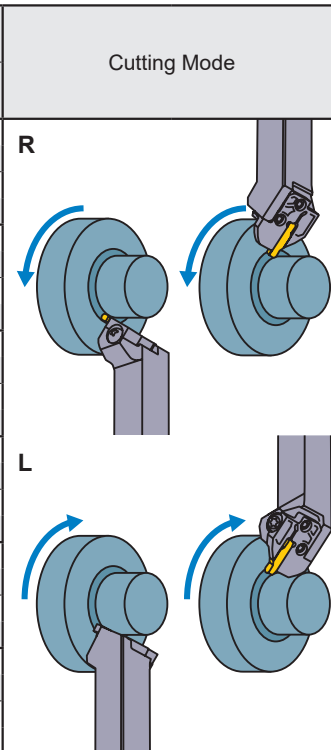
*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, WF and WF2 values may vary.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 4 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/LUS12C50-M20R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D50-M25R/L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) ★2						
	H	B	LF	LH	HF	WF	WF2
	.750	.750	5.007	1.632	.750	1.232	.076
	.750	.750	5.007	1.632	.750	1.232	.076
	1.000	1.000	6.007	1.819	1.000	1.357	.076
	1.000	1.000	6.007	1.819	1.000	1.357	.076
	.750	.750	5.003	1.628	.750	1.241	.084
	.750	.750	5.003	1.628	.750	1.241	.084
	1.000	1.000	6.003	1.815	1.000	1.366	.084
	1.000	1.000	6.003	1.815	1.000	1.366	.084
	.750	.750	5.000	1.625	.750	1.250	.094
	.750	.750	5.000	1.625	.750	1.250	.094
	1.000	1.000	6.000	1.813	1.000	1.375	.094
	1.000	1.000	6.000	1.813	1.000	1.375	.094
	.750	.750	4.989	1.614	.750	1.265	.109
	.750	.750	4.989	1.614	.750	1.265	.109
	1.000	1.000	5.989	1.802	1.000	1.390	.109
	1.000	1.000	5.989	1.802	1.000	1.390	.109
	.750	.750	4.980	1.605	.750	1.281	.125
	.750	.750	4.980	1.605	.750	1.281	.125
	1.000	1.000	5.980	1.792	1.000	1.406	.125
	1.000	1.000	5.980	1.792	1.000	1.406	.125
	1.000	1.000	5.978	1.791	1.000	1.429	.148
	1.000	1.000	5.978	1.791	1.000	1.429	.148



Select an Insert

Insert Number
GY2M○○○○○○○○○N-BM

For Multifunctional Grooving > F014		
Seat Size	Breaker	BM (Copying, Recessing)
	CW	Ball nose
D	.079", 2.00 mm	●
E	.098", 2.50 mm	●
F	.118", 3.00 mm	●
	.125", 3.18 mm	●
G	.157", 4.00 mm	●
H	.187", 4.75 mm	●
	.197", 5.00 mm	●
J	.236", 6.00 mm	●
	.250", 6.35 mm	●

● : Gauge insert shown dimensions

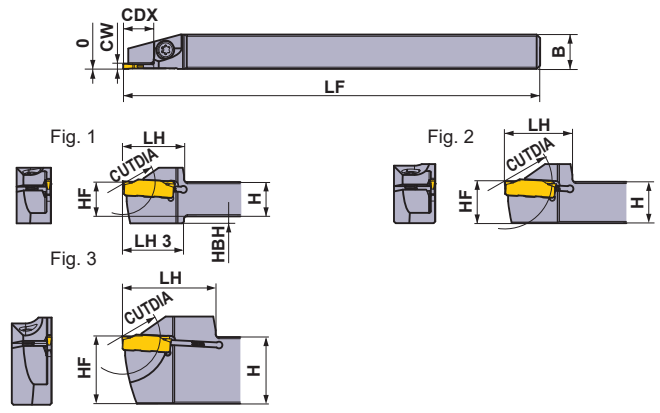
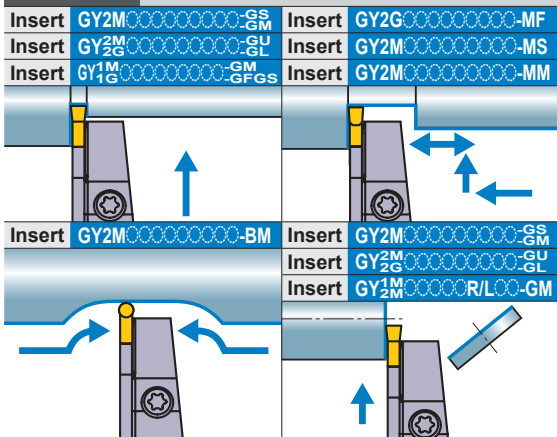
F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F200
 INSTRUCTION MANUAL > F200

GY SERIES (External for Swiss-type lathes)

1-2 00° type holder (Metric) **NEW**



Right hand tool holder shown.

F GROOVING / CUTTING OFF



Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number		Fig.	
						Holder	Stock		
B	1.20 .047"	8	16	Mono Block	R	GYSR1010JX00-B08	★	1	
				Mono Block	L	GYSL1010JX00-B08	★	1	
			24	Mono Block	R	GYSR1212JX00-B08	●	2	
				Mono Block	L	GYSL1212JX00-B08	●	2	
		13	16	Mono Block	R	GYSR1212JX00-B12	●	1	
				Mono Block	L	GYSL1212JX00-B12	●	1	
			26	Mono Block	R	GYSR1616JX00-B08	●	2	
				Mono Block	L	GYSL1616JX00-B08	●	2	
C	1.50	8	16	Mono Block	R	GYSR1010JX00-C08	★	1	
				Mono Block	L	GYSL1010JX00-C08	★	1	
			24	Mono Block	R	GYSR1212JX00-C08	★	2	
				Mono Block	L	GYSL1212JX00-C08	★	2	
		13	26	Mono Block	R	GYSR1212JX00-C12	★	1	
				Mono Block	L	GYSL1212JX00-C12	★	1	
			26	Mono Block	R	GYSR1616JX00-C13	★	2	
				Mono Block	L	GYSL1616JX00-C13	★	2	
		20	26	Mono Block	R	GYSR2012JX00-C13	★	3	
				Mono Block	L	GYSL2012JX00-C13	★	3	
			32	20	Mono Block	R	GYSR1010JX00-D10	★	1
					Mono Block	L	GYSL1010JX00-D10	★	1
24	Mono Block	R		GYSR1212JX00-D12	●	1			
	Mono Block	L		GYSL1212JX00-D12	●	1			
D	2.00 2.24	13	26	Mono Block	R	GYSR1616JX00-D13	●	2	
				Mono Block	L	GYSL1616JX00-D13	●	2	
			32	Mono Block	R	GYSR1616JX00-D16	●	2	
				Mono Block	L	GYSL1616JX00-D16	●	2	
		17	34	Mono Block	R	GYSR1915K00-D17	★	3	
				Mono Block	L	GYSL1915K00-D17	★	3	
			34	Mono Block	R	GYSR2012JX00-D17	●	3	
				Mono Block	L	GYSL2012JX00-D17	★	3	
		20	34	Mono Block	R	GYSR2020K00-D17	★	2	
				Mono Block	L	GYSL2020K00-D17	★	2	
			25	Mono Block	R	GYSR2525M00-D17	★	2	
				Mono Block	L	GYSL2525M00-D17	★	2	

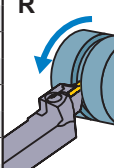
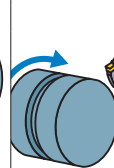
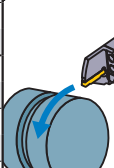
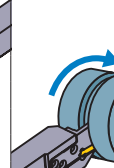



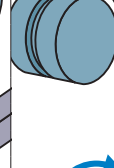
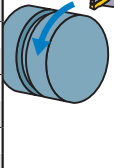
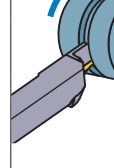




CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 3 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F197.

● : USA Stock ★ : Stocked in Japan

SPARE PARTS

Holder		
	Clamp Screw	Wrench
GYSR/L1010JX00	CS350990T	TKY10R
GYSR/L1212JX00		
GYSR/L1616JX00	TS4SBL	TKY15R
GYSR/L1915K00		
GYSR/L2012JX00	CS350990T	TKY10R
GYSR/L2020K00	HSC05018	TKY40R
GYSR/L2525K00		

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 3	HF	HBH		Clockwise	Anticlockwise
10	10	120	17.5	17.5	10	2	R		
10	10	120	17.5	17.5	10	2			
12	12	120	19.5	—	12	—	R		
12	12	120	19.5	—	12	—			
12	12	120	19.5	19.5	12	2	R		
12	12	120	19.5	19.5	12	2			
16	16	120	25	—	16	—	R		
16	16	120	25	—	16	—			
16	16	120	25	—	16	—	R		
16	16	120	25	—	16	—			
10	10	120	17.5	17.5	10	2	L		
10	10	120	17.5	17.5	10	2			
12	12	120	19.5	—	12	—	L		
12	12	120	19.5	—	12	—			
12	12	120	19.5	19.5	12	2	L		
12	12	120	19.5	19.5	12	2			
16	16	120	25	—	16	—	L		
16	16	120	25	—	16	—			
16	16	120	25	—	16	—	L		
16	16	120	25	—	16	—			
16	16	120	28	—	16	—	L		
16	16	120	28	—	16	—			
19.05	15.875	125	28	—	19.05	—	L		
19.05	15.875	125	28	—	19.05	—			
20	12	120	28	—	20	—	L		
20	12	120	28	—	20	—			
20	20	125	35	—	20	—	L		
20	20	125	35	—	20	—			
25	25	150	40	—	25	—	L		
25	25	150	40	—	25	—			

Select an Insert

Seat Size	Insert Number
B	GY○○○0120B○○○○○-Breaker
C	GY○○○0150C○○○○○-Breaker
D	GY○○○0200/0224D○○○○○-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
B	.047", 1.20 mm		●			
C	.059", 1.50 mm		●	●		
D	.079", 2.00 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW		R	R	R	R/L
B	.047", 1.20 mm	●			
C	.059", 1.50 mm		●	●	
D	.079", 2.00 mm		●	●	●

For multifunctional grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying)
CW					Ball shape
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●			

● : Gauge insert shown dimensions

F

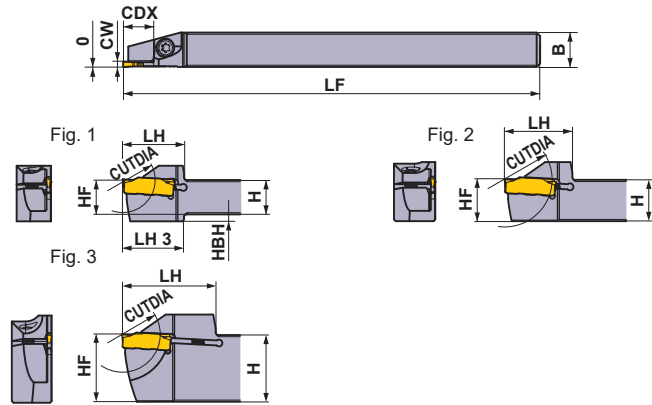
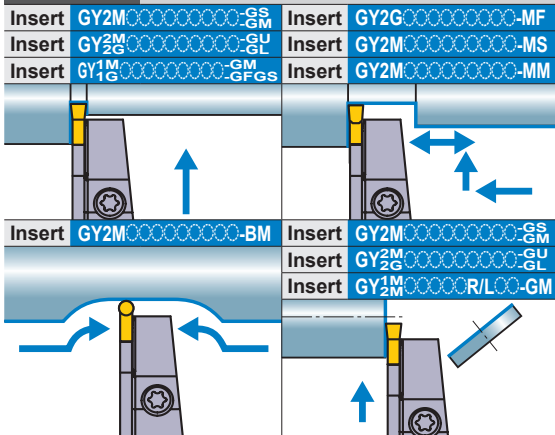
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

F041

GY SERIES (External for Swiss-type lathes)

1-2 00° type holder (Metric) **NEW**



Right hand tool holder shown.

F

GROOVING / CUTTING OFF



Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number		Fig.
						Holder	Stock	
E	2.39	10	20	Mono Block	R	GYSR1010JX00-E10	●	1
					L	GYSL1010JX00-E10	★	1
		12	24	Mono Block	R	GYSR1212JX00-E12	★	1
					L	GYSL1212JX00-E12	●	1
		13	26	Mono Block	R	GYSR1616JX00-E13	★	2
					L	GYSL1616JX00-E13	★	2
	16	32	Mono Block	R	GYSR1616JX00-E16	★	2	
				L	GYSL1616JX00-E16	★	2	
	2.50	17	34	Mono Block	R	GYSR1915K00-E17	★	3
					L	GYSL1915K00-E17	★	3
					R	GYSR2012JX00-E17	★	3
					L	GYSL2012JX00-E17	★	3
R					GYSR2020K00-E17	★	2	
L					GYSL2020K00-E17	★	2	
2.74	17	34	Mono Block	R	GYSR2525M00-E17	★	2	
				L	GYSL2525M00-E17	★	2	
				R	GYSR1212JX00-F12	●	1	
				L	GYSL1212JX00-F12	★	1	
				R	GYSR1616JX00-F13	●	2	
				L	GYSL1616JX00-F13	★	2	
F	3.00	17	34	R	GYSR1616JX00-F16	●	2	
				L	GYSL1616JX00-F16	●	2	
				R	GYSR1915K00-F17	★	3	
				L	GYSL1915K00-F17	★	3	
				R	GYSR2012JX00-F17	★	3	
				L	GYSL2012JX00-F17	★	3	
3.18	17	34	Mono Block	R	GYSR2012JX00-F17	★	3	
				L	GYSL2012JX00-F17	★	3	
				R	GYSR2012JX00-F17	★	3	
3.24	17	34	Mono Block	R	GYSR2012JX00-F17	★	3	
				L	GYSL2012JX00-F17	★	3	
				R	GYSR2012JX00-F17	★	3	

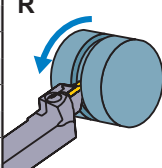
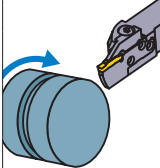
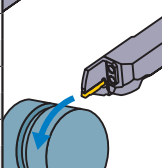
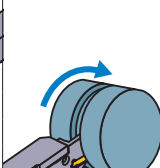
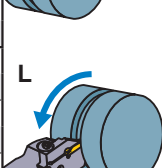
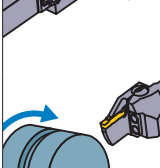
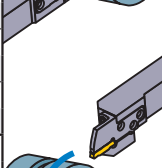
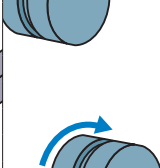
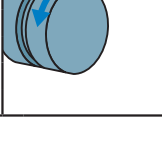
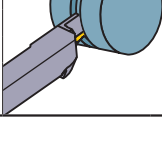






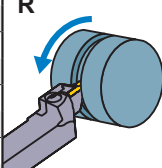
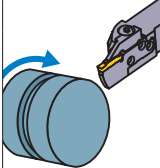
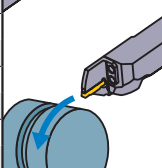
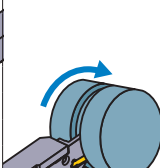
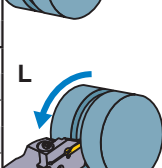
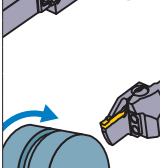
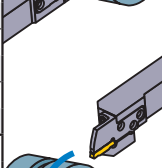
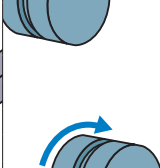
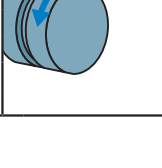
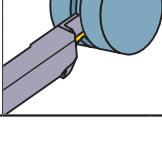
CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the standard insert is used. If other insert geometries are used then LF, LH and LH 3 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F197.

● : USA Stock ★ : Stocked in Japan

SPARE PARTS

Holder		
	Clamp Screw	Wrench
GYSR/L1010JX00	CS350990T	TKY10R
GYSR/L1212JX00		
GYSR/L1616JX00	TS4SBL	TKY15R
GYSR/L1915K00		
GYSR/L2012JX00	CS350990T	TKY10R
GYSR/L2020K00	HSC05018	TKY40R
GYSR/L2525K00		

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 3	HF	HBH		Clockwise	Anticlockwise
10	10	120	17.5	17.5	10	2	R		
10	10	120	17.5	17.5	10	2			
12	12	120	19.5	19.5	12	2	R		
12	12	120	19.5	19.5	12	2			
16	16	120	25	—	16	—	R		
16	16	120	25	—	16	—			
16	16	120	28	—	16	—	R		
16	16	120	28	—	16	—			
19.05	15.875	125	28	—	19.05	—	R		
19.05	15.875	125	28	—	19.05	—			
20	12	120	28	—	20	—	R		
20	12	120	28	—	20	—			
20	20	125	35	—	20	—	R		
20	20	125	35	—	20	—			
25	25	150	40	—	25	—	R		
25	25	150	40	—	25	—			
12	12	120	19.5	19.5	12	2	L		
12	12	120	19.5	19.5	12	2			
16	16	120	25	—	16	—	L		
16	16	120	25	—	16	—			
16	16	120	28	—	16	—	L		
16	16	120	28	—	16	—			
19.05	15.875	125	28	—	19.05	—	L		
19.05	15.875	125	28	—	19.05	—			
20	12	120	28	—	20	—	L		
20	12	120	28	—	20	—			

Select an Insert

Seat Size	Insert Number
E	GY○○○0239/0250/0274E○○○○○-Breaker
F	GY○○○0300/0318/0324F○○○○○-Breaker

		For Grooving/Cutting off > F011, F013				
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
	E	.094", 2.39 mm	●	●	●	●
F	.098", 2.50 mm	●	●	●	●	●
	.118", 3.00 mm	●	●	●	●	●
F	.125", 3.18 mm	●	●	●	●	●

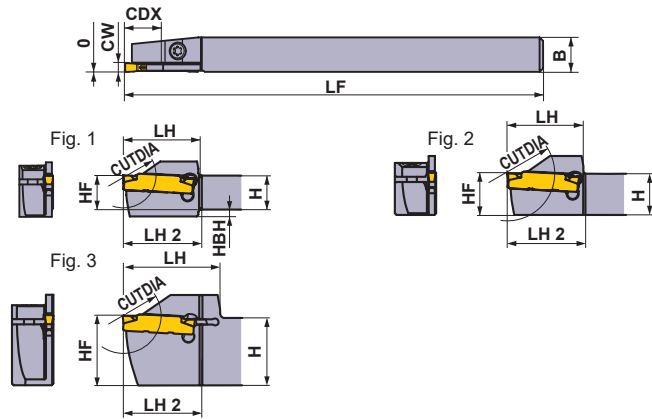
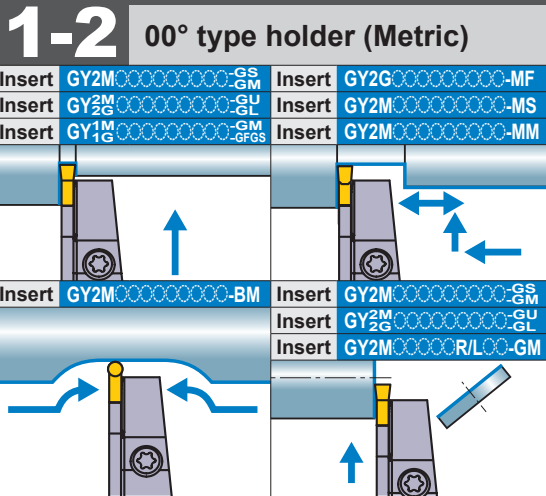
		For Cutting off > F012			
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW	R	R	R	R	R/L
	E	.098", 2.50 mm	●	●	●
F	.118", 3.00 mm	●	●	●	●

		For multifunctional grooving > F013, F014			
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying)
CW	Ball shape				
	E	.094", 2.39 mm	●	●	●
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●	●	●	●
F	.118", 3.00 mm	●	●	●	●
	RE .008", 0.2 mm	●	●	●	●
	RE .016", 0.4 mm	●	●	●	●
	RE .031", 0.8 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE .008", 0.2 mm	●	●	●	●
RE .016", 0.4 mm	●	●	●	●	
RE .031", 0.8 mm	●	●	●	●	

● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (External for Swiss-type lathes)



Right hand tool holder shown.

F

GROOVING / CUTTING OFF



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

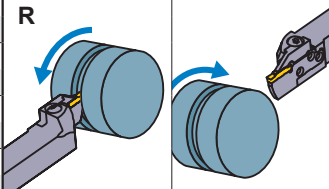
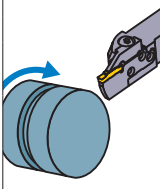
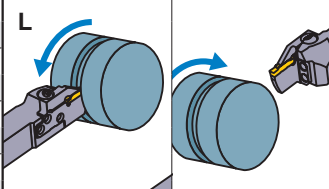
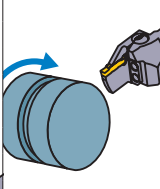
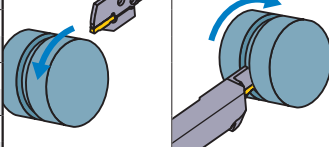
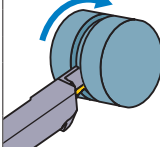
CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F199.

● : USA Stock

SPARE PARTS

Holder Number		
GYSR/L1010JX00-11	CS350990T (Clamp Torque : 22 lbf-in)	TKY10R
GYSR/L1212JX00-13		
GYSR/L2012JX00-18		
GYSR/L1616JX00-17	TS4SBL (Clamp Torque : 31 lbf-in)	TKY15R

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	HBH		Clockwise	Anticlockwise
10	10	120	22	16	10	2	R 		
10	10	120	22	16	10	2			
12	12	120	22	16	12	—			
12	12	120	22	16	12	—			
16	16	120	27	17	16	—			
16	16	120	27	17	16	—			
20	12	120	28	16	20	—			
20	12	120	28	16	20	—			
10	10	120	22	23	10	2			
10	10	120	22	23	10	2			
12	12	120	22	23	12	—	L 		
12	12	120	22	23	12	—			
16	16	120	27	24	16	—			
16	16	120	27	24	16	—			
20	12	120	28	23	20	—			
20	12	120	28	23	20	—			
10	10	120	22	23	10	2			
10	10	120	22	23	10	2			
12	12	120	22	23	12	—			
12	12	120	22	23	12	—			
16	16	120	27	24	16	—			
16	16	120	27	24	16	—			
20	12	120	28	23	20	—			
20	12	120	28	23	20	—			
10	10	120	22	23	10	2			
10	10	120	22	23	10	2			

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
C	.059", 1.50 mm		●	●		
D	.079", 2.00 mm	●	●	●	●	●
E	.094", 2.39 mm	●	●	●		●
	.098", 2.50 mm	●	●	●	●	●
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●		●

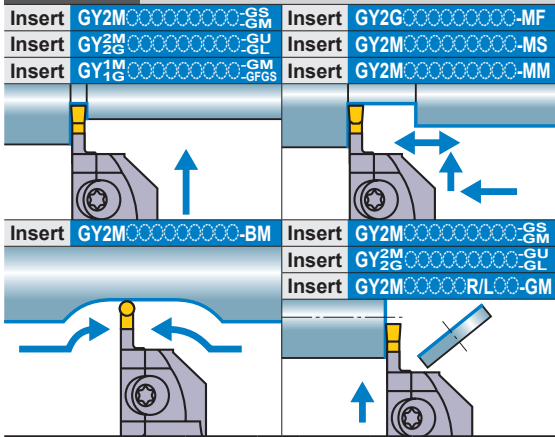
For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
	CW	R	R	R	R/L
C	.059", 1.50 mm		●	●	
D	.079", 2.00 mm		●	●	●
E	.098", 2.50 mm		●	●	●
F	.118", 3.00 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
	CW				Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●			
E	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			
F	.118", 3.00 mm				●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm			●	
	.125", 3.18 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	.128", 3.24 mm	●			

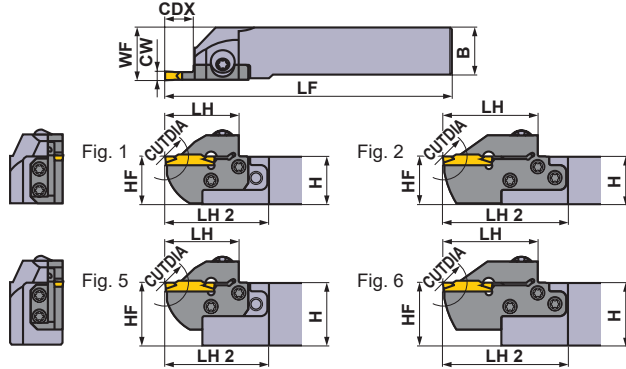
● : Gauge insert shown dimensions

GY SERIES (EXTERNAL)

1-2 00° type holder (Metric)



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



Right hand tool holder shown.

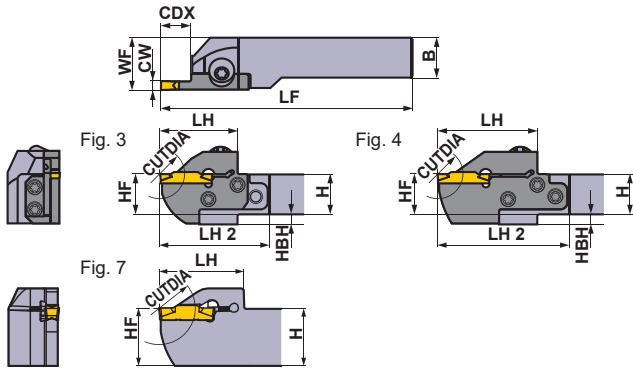
F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-D06	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-D06	●	3
				Mono Block	R	GYQR2020K00-D06	★	—	—	7
					L	GYQL2020K00-D06	★	—	—	7
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-D06	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-D06	●	1
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-D06	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-D06	●	3
				Mono Block	R	GYQR2525M00-D06	★	—	—	7
					L	GYQL2525M00-D06	★	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-D06	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-D06	●	1
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-D06	●	5		
			L	GYHL3225P00-M25L	★	GYM25LA-D06	●	5		
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-D06	●	5		
			L	GYHL3232P00-M25L	★	GYM25LA-D06	●	5		
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-D10	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-D10	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-D10	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-D10	●	1
		12	24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-D12	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-D12	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-D12	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-D12	●	1
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-D12	●	5
					L	GYHL3225P00-M25L	★	GYM25LA-D12	●	5
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-D12	●	5
					L	GYHL3232P00-M25L	★	GYM25LA-D12	●	5
18 *4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-D18	●	4		
			L	GYHL1616J00-M20L	●	GYM20LB-D18	●	4		
		Mono Block	R	GYQR2020K00-D18	★	—	—	7		
			L	GYQL2020K00-D18	★	—	—	7		
		Modular	R	GYHR2020K00-M20R	●	GYM20RB-D18	●	2		
			L	GYHL2020K00-M20L	●	GYM20LB-D18	●	2		
20 *1	40 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RA-D20	●	4		
			L	GYHL2020K00-M25L	●	GYM25LA-D20	●	4		
		Mono Block	R	GYQR2525M00-D20	★	—	—	7		
			L	GYQL2525M00-D20	★	—	—	7		
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-D20	●	2		
			L	GYHL2525M00-M25L	●	GYM25LA-D20	●	2		
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-D20	●	6		
			L	GYHL3225P00-M25L	★	GYM25LA-D20	●	6		
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-D20	●	6		
			L	GYHL3232P00-M25L	★	GYM25LA-D20	●	6		

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter
 *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
 *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/L	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
16	16	104	28	44	16	20	4	R	
16	16	104	28	44	16	20	4		
20	20	125	36	—	20	20.15	—		
20	20	125	36	—	20	20.15	—		
20	20	119	28	43	20	23	—		
20	20	119	28	43	20	23	—		
20	20	117	31	52	20	26	5		
20	20	117	31	52	20	26	5		
25	25	150	36	—	25	25.15	—		
25	25	150	36	—	25	25.15	—		
25	25	142	31	49	25	28	—		
25	25	142	31	49	25	28	—		
32	25	162	31	49	32	28	—		
32	25	162	31	49	32	28	—		
32	32	162	31	49	32	35	—		
32	32	162	31	49	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
16	16	116	40	56	16	20	4		
16	16	116	40	56	16	20	4		
20	20	125	39	—	20	20.10	—		
20	20	125	39	—	20	20.10	—		
20	20	131	40	55	20	23	—		
20	20	131	40	55	20	23	—		
20	20	131	45	66	20	26	5		
20	20	131	45	66	20	26	5		
25	25	150	41	—	25	25.10	—		
25	25	150	41	—	25	25.10	—		
25	25	156	45	63	25	28	—		
25	25	156	45	63	25	28	—		
32	25	176	45	63	32	28	—		
32	25	176	45	63	32	28	—		
32	32	176	45	63	32	35	—		
32	32	176	45	63	32	35	—		

Select an Insert

Seat Size	Insert Number
D	GY00200/0224D-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
	CW	R	R	R	R
D	.079", 2.00 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
	CW				
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●			

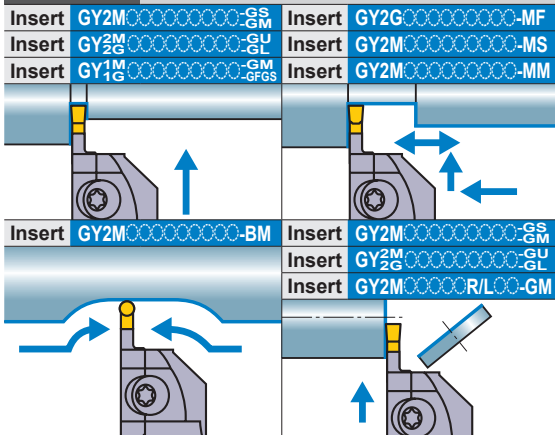
● : Gauge insert shown dimensions

F
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

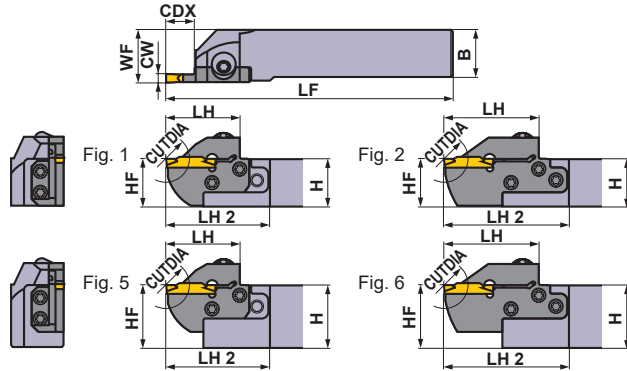
GY SERIES (EXTERNAL)

1-2 00° type holder (Metric)



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

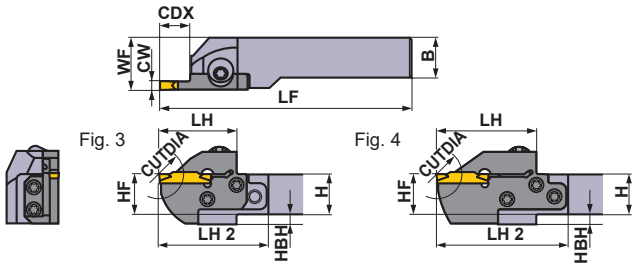
Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-E06	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-E06	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-E06	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-E06	●	1
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-E06	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-E06	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-E06	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-E06	●	1
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-E06	●	5
					L	GYHL3225P00-M25L	★	GYM25LA-E06	●	5
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-E06	●	5
					L	GYHL3232P00-M25L	★	GYM25LA-E06	●	5
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-E10	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-E10	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-E10	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-E10	●	1
		12	24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-E12	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-E12	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-E12	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-E12	●	1
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-E12	●	5
					L	GYHL3225P00-M25L	★	GYM25LA-E12	●	5
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-E12	●	5
					L	GYHL3232P00-M25L	★	GYM25LA-E12	●	5
18 *4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-E18	●	4		
			L	GYHL1616J00-M20L	●	GYM20LB-E18	●	4		
		Modular	R	GYHR2020K00-M20R	●	GYM20RB-E18	●	2		
			L	GYHL2020K00-M20L	●	GYM20LB-E18	●	2		
20 *1	40 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RA-E20	●	4		
			L	GYHL2020K00-M25L	●	GYM25LA-E20	●	4		
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-E20	●	2		
			L	GYHL2525M00-M25L	●	GYM25LA-E20	●	2		
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-E20	●	6		
			L	GYHL3225P00-M25L	★	GYM25LA-E20	●	6		
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-E20	●	6		
			L	GYHL3232P00-M25L	★	GYM25LA-E20	●	6		

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock ★ : Stocked in Japan

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench ★
GYQR/L	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *3								Cutting Mode	
	H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
	16	16	104	28	44	16	20	4	R	
	16	16	104	28	44	16	20	4		
	20	20	119	28	43	20	23	—	L	
	20	20	119	28	43	20	23	—		
	20	20	117	31	52	20	26	5	R	
	20	20	117	31	52	20	26	5		
	25	25	142	31	49	25	28	—	L	
	25	25	142	31	49	25	28	—		
	32	25	162	31	49	32	28	—	R	
	32	25	162	31	49	32	28	—		
	32	32	162	31	49	32	35	—	L	
	32	32	162	31	49	32	35	—		
	16	16	110	34	50	16	20	4	R	
	16	16	110	34	50	16	20	4		
	20	20	125	34	49	20	23	—	L	
	20	20	125	34	49	20	23	—		
	20	20	125	39	60	20	26	5	R	
	20	20	125	39	60	20	26	5		
	25	25	150	39	57	25	28	—	L	
	25	25	150	39	57	25	28	—		
	32	25	170	39	57	32	28	—	R	
	32	25	170	39	57	32	28	—		
	32	32	170	39	57	32	35	—	L	
	32	32	170	39	57	32	35	—		
	16	16	116	40	56	16	20	4	R	
	16	16	116	40	56	16	20	4		
	20	20	131	40	55	20	23	—	L	
	20	20	131	40	55	20	23	—		
	20	20	131	45	66	20	26	5	R	
	20	20	131	45	66	20	26	5		
	25	25	156	45	63	25	28	—	L	
	25	25	156	45	63	25	28	—		
	32	25	176	45	63	32	28	—	R	
	32	25	176	45	63	32	28	—		
	32	32	176	45	63	32	35	—	L	
	32	32	176	45	63	32	35	—		

Select an Insert

Seat Size	Insert Number
E	GY00239/0250/0274E0000-Breaker

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
	E	.094", 2.39 mm	●	●	●	●
	E	.098", 2.50 mm	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW	R	R	R	R/L	
	E	.098", 2.50 mm		●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW	Ball nose				
	E	.094", 2.39 mm	●	●	●
	E	.098", 2.50 mm	●	●	●
	E	.108", 2.74 mm	●		

● : Gauge insert shown dimensions

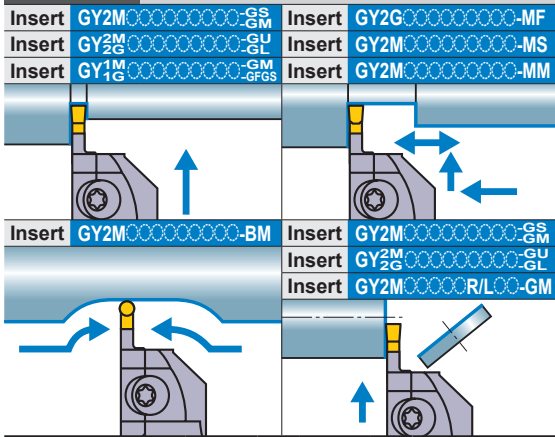
F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

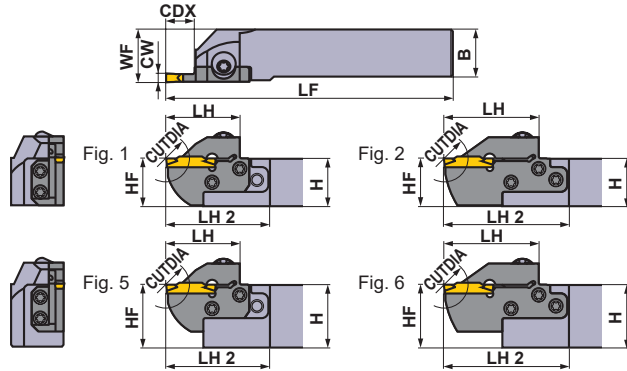
GY SERIES (EXTERNAL)

1-2 00° type holder (Metric)



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-F06	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-F06	●	3
				Mono Block	R	GYQR2020K00-F06	★	—	—	7
					L	GYQL2020K00-F06	★	—	—	7
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-F06	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-F06	●	1
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-F06	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-F06	●	3
				Mono Block	R	GYQR2525M00-F06	★	—	—	7
					L	GYQL2525M00-F06	★	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-F06	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-F06	●	1
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-F06	●	5		
			L	GYHL3225P00-M25L	★	GYM25LA-F06	●	5		
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-F06	●	5		
			L	GYHL3232P00-M25L	★	GYM25LA-F06	●	5		
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-F10	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-F10	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-F10	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-F10	●	1
		12	24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-F12	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-F12	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-F12	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-F12	●	1
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-F12	●	5
					L	GYHL3225P00-M25L	★	GYM25LA-F12	●	5
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-F12	●	5		
			L	GYHL3232P00-M25L	★	GYM25LA-F12	●	5		
18 *4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-F18	●	4		
			L	GYHL1616J00-M20L	●	GYM20LB-F18	●	4		
		Mono Block	R	GYQR2020K00-F18	★	—	—	7		
			L	GYQL2020K00-F18	★	—	—	7		
Modular	R	GYHR2020K00-M20R	●	GYM20RB-F18	●	2				
	L	GYHL2020K00-M20L	●	GYM20LB-F18	●	2				
20 *1	40 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RA-F20	●	4		
			L	GYHL2020K00-M25L	●	GYM25LA-F20	●	4		
		Mono Block	R	GYQR2525M00-F20	★	—	—	7		
			L	GYQL2525M00-F20	★	—	—	7		
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-F20	●	2		
			L	GYHL2525M00-M25L	●	GYM25LA-F20	●	2		
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-F20	●	6		
			L	GYHL3225P00-M25L	★	GYM25LA-F20	●	6		
Modular	R	GYHR3232P00-M25R	★	GYM25RA-F20	●	6				
	L	GYHL3232P00-M25L	★	GYM25LA-F20	●	6				

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

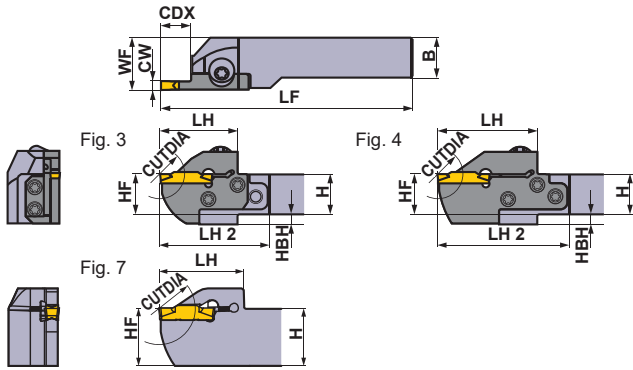
*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.

*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/L	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
16	16	104	28	44	16	20	4	R	
16	16	104	28	44	16	20	4		
20	20	125	36	—	20	20.30	—		
20	20	125	36	—	20	20.30	—		
20	20	119	28	43	20	23	—		
20	20	119	28	43	20	23	—		
20	20	117	31	52	20	26	5		
20	20	117	31	52	20	26	5		
25	25	150	36	—	25	25.30	—		
25	25	150	36	—	25	25.30	—		
25	25	142	31	49	25	28	—		
25	25	142	31	49	25	28	—		
32	25	162	31	49	32	28	—		
32	25	162	31	49	32	28	—		
32	32	162	31	49	32	35	—		
32	32	162	31	49	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
16	16	116	40	56	16	20	4		
16	16	116	40	56	16	20	4		
20	20	125	39	—	20	20.25	—		
20	20	125	39	—	20	20.25	—		
20	20	131	40	55	20	23	—		
20	20	131	40	55	20	23	—		
20	20	131	45	66	20	26	5		
20	20	131	45	66	20	26	5		
25	25	150	41	—	25	25.25	—		
25	25	150	41	—	25	25.25	—		
25	25	156	45	63	25	28	—		
25	25	156	45	63	25	28	—		
32	25	176	45	63	32	28	—		
32	25	176	45	63	32	28	—		
32	32	176	45	63	32	35	—		
32	32	176	45	63	32	35	—		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW		Neutral	Neutral	Neutral	Neutral	Neutral
	.118", 3.00 mm	●	●	●	●	●
F	.125", 3.18 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW		R	R	R	R/L
	.118", 3.00 mm		●	●	●
F			●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW					Ball nose
	.118", 3.00 mm				●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
F	RE 0.8 mm			●	
	.125", 3.18 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
F	.128", 3.24 mm	●			

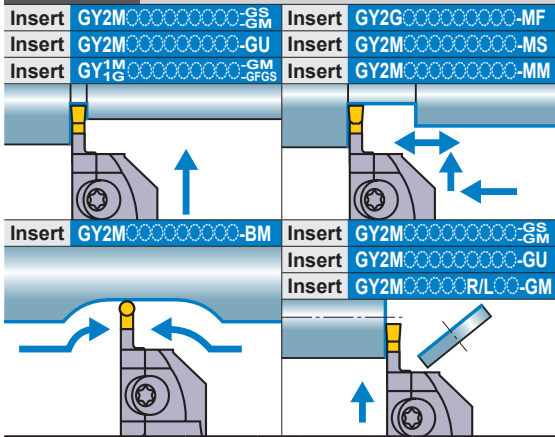
● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

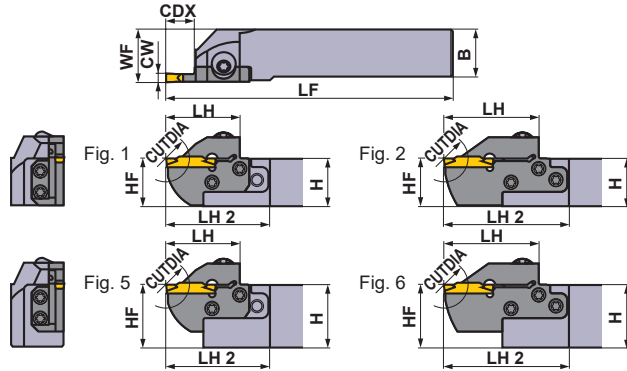
F GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)

1-2 00° type holder (Metric)



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

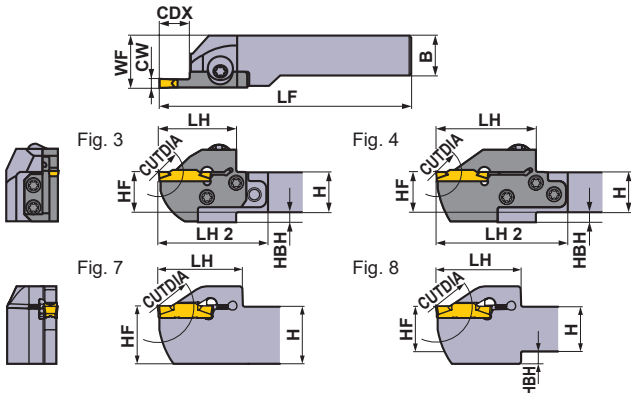
Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	8	16	Mono Block	R	GYQR2020K00-G08	★	—	—	7
					L	GYQL2020K00-G08	★	—	—	7
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-G08	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-G08	●	3
				Mono Block	R	GYQR2525M00-G08	★	—	—	7
					L	GYQL2525M00-G08	★	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-G08	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-G08	●	1
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-G08	●	5
					L	GYHL3225P00-M25L	★	GYM25LA-G08	●	5
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-G08	●	5
					L	GYHL3232P00-M25L	★	GYM25LA-G08	●	5
		12	24	Modular	R	GYHR1616J00-M20R	●	GYM20RA-G12	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-G12	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-G12	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-G12	●	1
		14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-G14	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-G14	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-G14	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-G14	●	1
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-G14	●	5
					L	GYHL3225P00-M25L	★	GYM25LA-G14	●	5
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-G14	●	5
					L	GYHL3232P00-M25L	★	GYM25LA-G14	●	5
25 *1	50 *2	Mono Block	R	GYQR2020K00-G25	★	—	—	8		
			L	GYQL2020K00-G25	★	—	—	8		
		Modular	R	GYHR2020K00-M25R	●	GYM25RA-G25	●	4		
			L	GYHL2020K00-M25L	●	GYM25LA-G25	●	4		
		Mono Block	R	GYQR2525M00-G25	★	—	—	7		
			L	GYQL2525M00-G25	★	—	—	7		
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-G25	●	2		
			L	GYHL2525M00-M25L	●	GYM25LA-G25	●	2		
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-G25	●	6		
			L	GYHL3225P00-M25L	★	GYM25LA-G25	●	6		
Modular	R	GYHR3232P00-M25R	★	GYM25RA-G25	●	6				
	L	GYHL3232P00-M25L	★	GYM25LA-G25	●	6				

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

● : USA Stock ★ : Stocked in Japan

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/L	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—	R	
20	20	125	41	—	20	20.35	—		
20	20	119	33	54	20	26	5		
20	20	119	33	54	20	26	5		
25	25	150	41	—	25	25.35	—		
25	25	150	41	—	25	25.35	—		
25	25	144	33	51	25	28	—		
25	25	144	33	51	25	28	—		
32	25	164	33	51	32	28	—		
32	25	164	33	51	32	28	—		
32	32	164	33	51	32	35	—		
32	32	164	33	51	32	35	—		
16	16	110	34	50	16	20	4		
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	125	46	—	20	20.35	4		
20	20	125	46	—	20	20.35	4		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	150	46	—	25	25.35	—		
25	25	150	46	—	25	25.35	—		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		

Select an Insert

Seat Size	Insert Number
G	GY000400/0424G0000-Breaker

For Grooving/Cutting off > F011-F013						
Seat Size	Breaker	GU	GS	GM	GFGS	05-GM
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)	(Cutting off)
CW		Neutral	Neutral	Neutral	Neutral	Hand
G	.157", 4.00 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW					Ball nose
G	.157", 4.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.167", 4.24 mm	●			

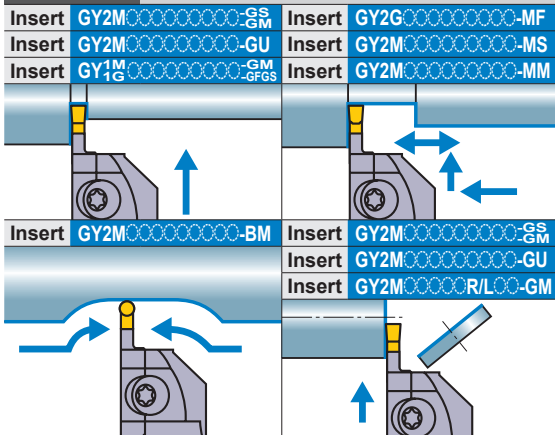
● : Gauge insert shown dimensions

F
GROOVING / CUTTING OFF

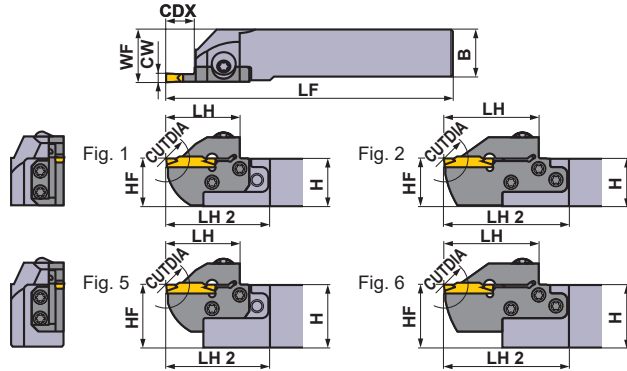
IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL)

1-2 00° type holder (Metric)



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

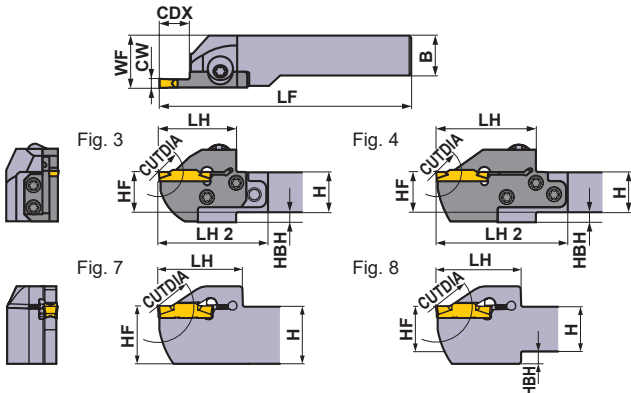
Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	8	16	Mono Block	R	GYQR2020K00-H08	★	—	—	7
					L	GYQL2020K00-H08	★	—	—	7
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-H08	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-H08	●	3
				Mono Block	R	GYQR2525M00-H08	★	—	—	7
					L	GYQL2525M00-H08	★	—	—	7
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-H08	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-H08	●	1
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-H08	●	5
					L	GYHL3225P00-M25L	★	GYM25LA-H08	●	5
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-H08	●	5
					L	GYHL3232P00-M25L	★	GYM25LA-H08	●	5
		12	24	Modular	R	GYHR1616J00-M20R	●	GYM20RA-H12	●	3
					L	GYHL1616J00-M20L	●	GYM20LA-H12	●	3
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-H12	●	1
					L	GYHL2020K00-M20L	●	GYM20LA-H12	●	1
		14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-H14	●	3
					L	GYHL2020K00-M25L	●	GYM25LA-H14	●	3
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-H14	●	1
					L	GYHL2525M00-M25L	●	GYM25LA-H14	●	1
				Modular	R	GYHR3225P00-M25R	★	GYM25RA-H14	●	5
					L	GYHL3225P00-M25L	★	GYM25LA-H14	●	5
				Modular	R	GYHR3232P00-M25R	★	GYM25RA-H14	●	5
					L	GYHL3232P00-M25L	★	GYM25LA-H14	●	5
25 *1	50 *2	Mono Block	R	GYQR2020K00-H25	★	—	—	8		
			L	GYQL2020K00-H25	★	—	—	8		
		Modular	R	GYHR2020K00-M25R	●	GYM25RA-H25	●	4		
			L	GYHL2020K00-M25L	●	GYM25LA-H25	●	4		
		Mono Block	R	GYQR2525M00-H25	★	—	—	7		
			L	GYQL2525M00-H25	★	—	—	7		
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-H25	●	2		
			L	GYHL2525M00-M25L	●	GYM25LA-H25	●	2		
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-H25	●	6		
			L	GYHL3225P00-M25L	★	GYM25LA-H25	●	6		
Modular	R	GYHR3232P00-M25R	★	GYM25RA-H25	●	6				
	L	GYHL3232P00-M25L	★	GYM25LA-H25	●	6				

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

● : USA Stock ★ : Stocked in Japan

★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 5 pcs.	① Wrench *
GYQR/L	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—	R	
20	20	125	41	—	20	20.35	—		
20	20	119	33	54	20	26	5		
20	20	119	33	54	20	26	5		
25	25	150	41	—	25	25.35	—		
25	25	150	41	—	25	25.35	—		
25	25	144	33	51	25	28	—		
25	25	144	33	51	25	28	—		
32	25	164	33	51	32	28	—		
32	25	164	33	51	32	28	—		
32	32	164	33	51	32	35	—		
32	32	164	33	51	32	35	—		
16	16	110	34	50	16	20	4	L	
16	16	110	34	50	16	20	4		
20	20	125	34	49	20	23	—		
20	20	125	34	49	20	23	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	125	46	—	20	20.35	4		
20	20	125	46	—	20	20.35	4		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	150	46	—	25	25.35	—		
25	25	150	46	—	25	25.35	—		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		

Select an Insert

Seat Size	Insert Number
H	GY00475/0500/0524H0000-Breaker

For Grooving/Cutting off > F011-F013						
Seat Size	Breaker	GU	GS	GM	GFGS	05-GM
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)	(Cutting off)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Hand
	H	.187", 4.75 mm	●	●	●	●
H	.197", 5.00 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW	.187", 4.75 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			
H	.197", 5.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
H	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

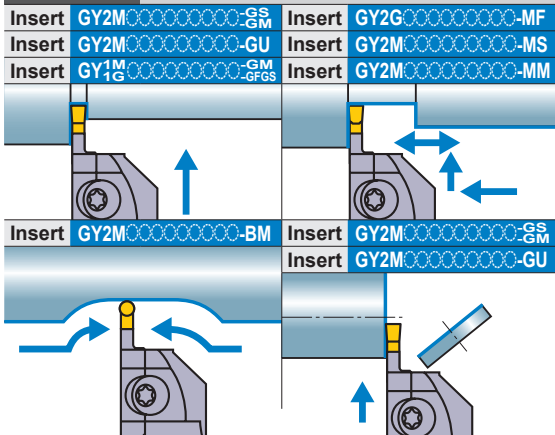
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GROOVING / CUTTING OFF

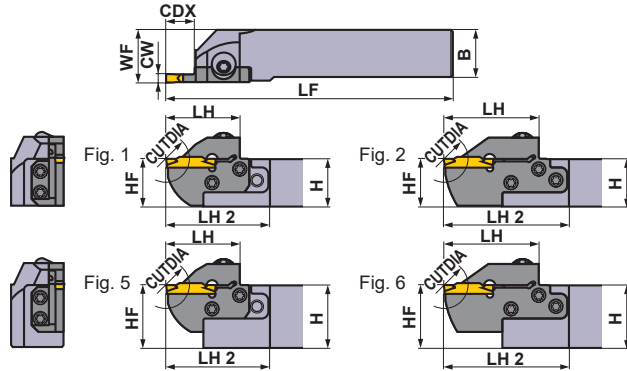
IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL)

1-2 00° type holder (Metric)



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



Right hand tool holder shown.

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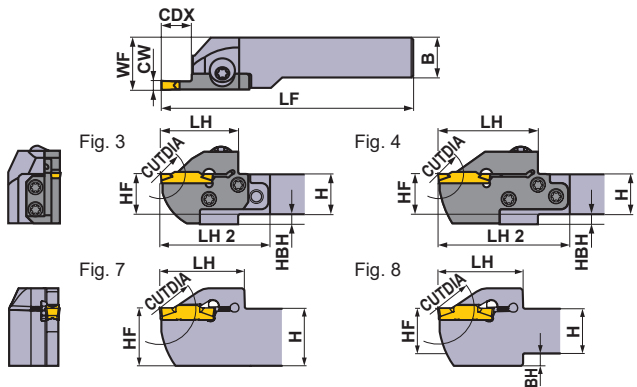
GROOVING / CUTTING OFF

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
J	6.00 6.31 6.35	8	16	Mono Block	R	GYQR2020K00-J08	★	—	—	7	
				Mono Block	L	GYQL2020K00-J08	★	—	—	7	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-J08	●	3	
				Modular	L	GYHL2020K00-M25L	●	GYM25LA-J08	●	3	
				Mono Block	R	GYQR2525M00-J08	★	—	—	7	
				Mono Block	L	GYQL2525M00-J08	★	—	—	7	
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-J08	●	1			
		Modular	L	GYHL2525M00-M25L	●	GYM25LA-J08	●	1			
		Modular	R	GYHR3225P00-M25R	★	GYM25RA-J08	●	5			
		Modular	L	GYHL3225P00-M25L	★	GYM25LA-J08	●	5			
		Modular	R	GYHR3232P00-M25R	★	GYM25RA-J08	●	5			
		Modular	L	GYHL3232P00-M25L	★	GYM25LA-J08	●	5			
	25 *1	50 *2	14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-J14	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LA-J14	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RA-J14	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LA-J14	●	1
			Modular	R	GYHR3225P00-M25R	★	GYM25RA-J14	●	5		
			Modular	L	GYHL3225P00-M25L	★	GYM25LA-J14	●	5		
			Modular	R	GYHR3232P00-M25R	★	GYM25RA-J14	●	5		
			Modular	L	GYHL3232P00-M25L	★	GYM25LA-J14	●	5		
25 *1	50 *2	25 *1	50 *2	Mono Block	R	GYQR2020K00-J25	★	—	—	8	
				Mono Block	L	GYQL2020K00-J25	★	—	—	8	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-J25	●	4	
				Modular	L	GYHL2020K00-M25L	●	GYM25LA-J25	●	4	
				Mono Block	R	GYQR2525M00-J25	★	—	—	7	
				Mono Block	L	GYQL2525M00-J25	★	—	—	7	
Modular	R	GYHR2525M00-M25R	●	GYM25RA-J25	●	2					
Modular	L	GYHL2525M00-M25L	●	GYM25LA-J25	●	2					
Modular	R	GYHR3225P00-M25R	★	GYM25RA-J25	●	6					
Modular	L	GYHL3225P00-M25L	★	GYM25LA-J25	●	6					
Modular	R	GYHR3232P00-M25R	★	GYM25RA-J25	●	6					
Modular	L	GYHL3232P00-M25L	★	GYM25LA-J25	●	6					

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

● : USA Stock ★ : Stocked in Japan



Right hand tool holder shown.

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

SPARE PARTS			
Holder Number	① Clamp Screw	② Blade Screw	① Wrench *
GYQR/L	①HSC05030 (Clamp Torque : 62 lbf-in)	—	HKY40R
GYHR/L	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (mm) *3								Cutting Mode	
H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—	R	
20	20	125	41	—	20	20.35	—		
20	20	119	33	54	20	26	5	R	
20	20	119	33	54	20	26	5		
25	25	150	41	—	25	25.35	—	R	
25	25	150	41	—	25	25.35	—		
25	25	144	33	51	25	28	—	R	
25	25	144	33	51	25	28	—		
32	25	164	33	51	32	28	—	R	
32	25	164	33	51	32	28	—		
32	32	164	33	51	32	35	—	R	
32	32	164	33	51	32	35	—		
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—		
20	20	125	46	—	20	20.35	4	L	
20	20	125	46	—	20	20.35	4		
20	20	136	50	71	20	26	5	L	
20	20	136	50	71	20	26	5		
25	25	150	46	—	25	25.35	—	L	
25	25	150	46	—	25	25.35	—		
25	25	161	50	68	25	28	—	L	
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—	L	
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—	L	
32	32	181	50	68	32	35	—		

Select an Insert

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

For Grooving/Cutting off > F011-F013						
Seat Size	Breaker	GU	GS	GM	GFGS	05-GM
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)	(Cutting off)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Hand
	236", 6.00 mm	●	●	●	●	
J	250", 6.35 mm	●	●	●		

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW	236", 6.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
J	248", 6.31 mm	●	●	●	
	250", 6.35 mm				●
	RE 0.2 mm	●			
J	RE 0.4 mm	●			
	RE 0.8 mm	●			

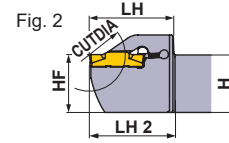
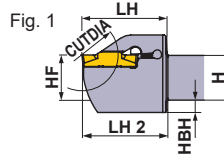
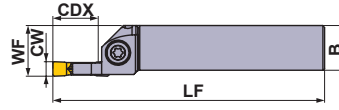
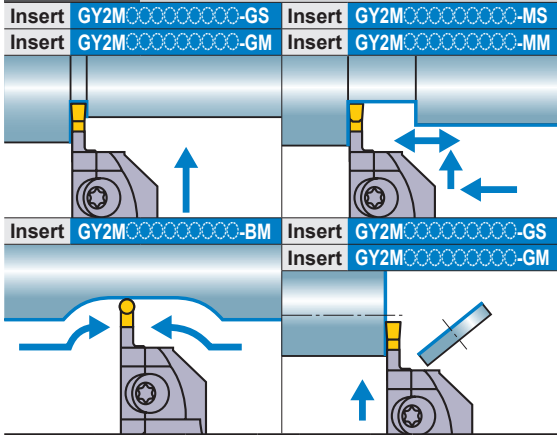
● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)

1-2 00° type holder (Metric)



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
K	8.00	25 *1	50 *2	Mono Block	R	GYPR2525M00-K25	●	—	—	1
				Mono Block	L	GYPL2525M00-K25	●	—	—	1
				Mono Block	R	GYPR3225P00-K25	●	—	—	2
				Mono Block	L	GYPL3225P00-K25	●	—	—	2
				Mono Block	R	GYPR3232P00-K25	●	—	—	3
				Mono Block	L	GYPL3232P00-K25	●	—	—	3

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.

*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

● : USA Stock

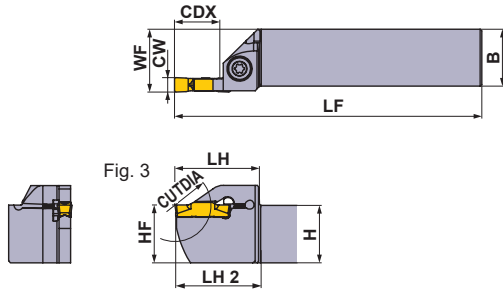


Fig. 3

Right hand tool holder shown.

SPARE PARTS		
Holder Number		
	Clamp Screw	Wrench
GYPR/L○○○○○○00-K25	GY06013M (Clamp Torque : 53 lbf-in)	TKY30R

	Dimensions (mm) *3								Cutting Mode	
	H	B	LF	LH	LH 2	HF	WF	HBH	Clockwise	Anticlockwise
	25	25	150	47	48	25	28	7		
	25	25	150	47	48	25	28	7		
	32	25	170	47	48	32	28	—		
	32	25	170	47	48	32	28	—		
	32	32	170	47	48	32	35	—		
	32	32	170	47	48	32	35	—		

Select an Insert

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

For Grooving/Cutting off > F011						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)	05-GM (Cutting off)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
K	.315", 8.00 mm		●	●		

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
	CW				
K	.315", 8.00 mm				●
	RE 0.8 mm		●		
	RE 1.2 mm			●	

● : Gauge insert shown dimensions

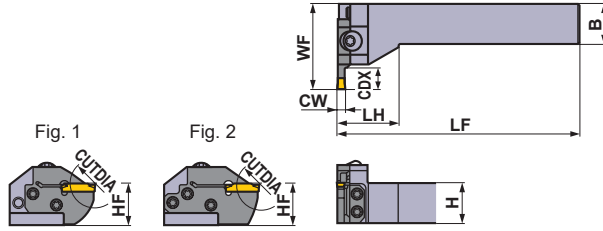
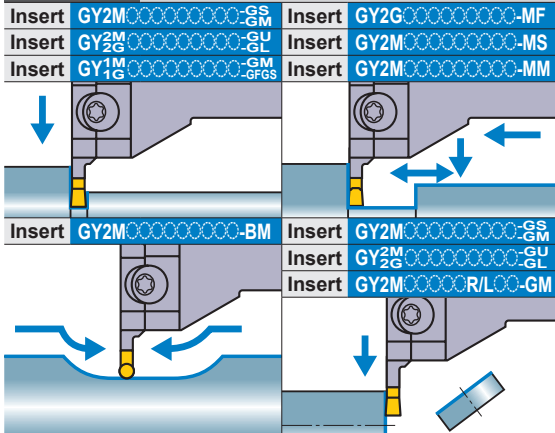
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GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)

2-2 90° type holder (Metric)

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
D	2.00 2.24	6	12	Modular	R	GYHR2020K90-M20L	●	GYM20LA-D06	●	1	
				Modular	L	GYHL2020K90-M20R	●	GYM20RA-D06	●	1	
		10	20	Modular	R	GYHR2020K90-M20L	●	GYM20LA-D10	●	1	
				Modular	L	GYHL2020K90-M20R	●	GYM20RA-D10	●	1	
		12	24	Modular	R	GYHR2525M90-M25L	●	GYM25LA-D12	●	1	
				Modular	L	GYHL2525M90-M25R	●	GYM25RA-D12	●	1	
	18 *4	36	36	Modular	R	GYHR2020K90-M20L	●	GYM20LB-D18	●	2	
				Modular	L	GYHL2020K90-M20R	●	GYM20RB-D18	●	2	
	20 *1	40 *2	40 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-D20	●	2	
				Modular	L	GYHL2525M90-M25R	●	GYM25RA-D20	●	2	
	E	2.39 2.50 2.74	6	12	Modular	R	GYHR2020K90-M20L	●	GYM20LA-E06	●	1
					Modular	L	GYHL2020K90-M20R	●	GYM20RA-E06	●	1
10			20	Modular	R	GYHR2525M90-M25L	●	GYM25LA-E06	●	1	
				Modular	L	GYHL2525M90-M25R	●	GYM25RA-E06	●	1	
12			24	Modular	R	GYHR2020K90-M20L	●	GYM20LA-E10	●	1	
				Modular	L	GYHL2020K90-M20R	●	GYM20RA-E10	●	1	
18 *4		36	36	Modular	R	GYHR2525M90-M25L	●	GYM25LA-E12	●	1	
				Modular	L	GYHL2525M90-M25R	●	GYM25RA-E12	●	1	
20 *1		40 *2	40 *2	Modular	R	GYHR2020K90-M20L	●	GYM20LB-E18	●	2	
				Modular	L	GYHL2020K90-M20R	●	GYM20RB-E18	●	2	
20 *1		40 *2	40 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-E20	●	2	
				Modular	L	GYHL2525M90-M25R	●	GYM25RA-E20	●	2	

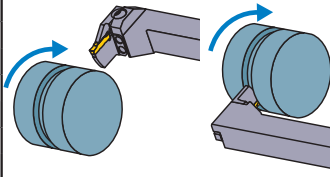
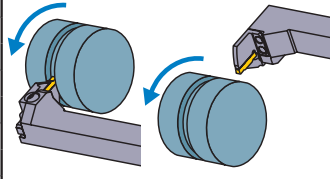
CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHR2020K90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R
GYHL2020K90-M20R			②TKY15D
GYHR2525M90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R
GYHL2525M90-M25R			②TKY25D

	Dimensions (mm) *3						Cutting Mode	
	H	B	LF	LH	HF	WF		
	20	20	125	35	20	39	R 	
	20	20	125	35	20	39		
	25	25	150	38	25	45		
	25	25	150	38	25	45		
	20	20	125	35	20	45		
	20	20	125	35	20	45		
	25	25	150	38	25	53		
	25	25	150	38	25	53		
	20	20	125	35	20	51		
	20	20	125	35	20	51		
	25	25	150	38	25	59		
	25	25	150	38	25	59		
	20	20	125	35	20	39		L 
	20	20	125	35	20	39		
	25	25	150	38	25	45		
	25	25	150	38	25	45		
	20	20	125	35	20	45		
	20	20	125	35	20	45		
	25	25	150	38	25	53		
	25	25	150	38	25	53		
	20	20	125	35	20	51		
	20	20	125	35	20	51		
	25	25	150	38	25	59		
	25	25	150	38	25	59		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●
E	.094", 2.39 mm	●	●	●	●	●
		●	●	●	●	●
E	.098", 2.50 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
	CW	R	R	R	R/L
D	.079", 2.00 mm		●	●	●
E	.098", 2.50 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
	CW				Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●			
	.094", 2.39 mm	●			
E	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

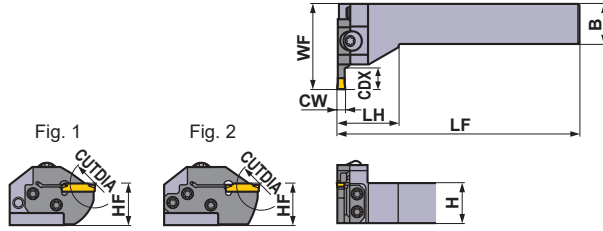
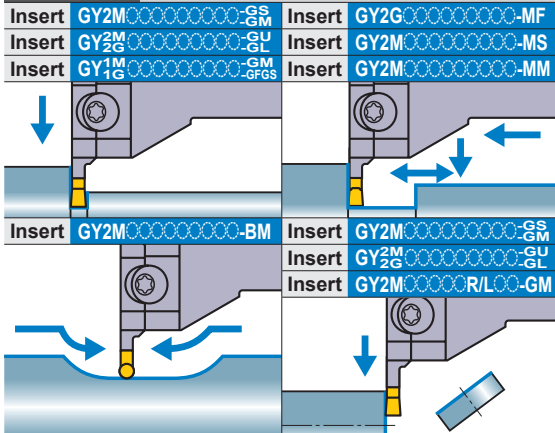
IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL)

2-2 90° type holder (Metric)

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF



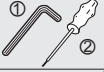
Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	6	12	Modular	R	GYHR2020K90-M20L	●	GYM20LA-F06	●	1
					L	GYHL2020K90-M20R	●	GYM20RA-F06	●	1
		10	20	Modular	R	GYHR2525M90-M25L	●	GYM25LA-F06	●	1
					L	GYHL2525M90-M25R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

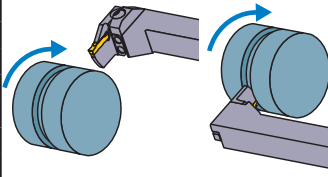
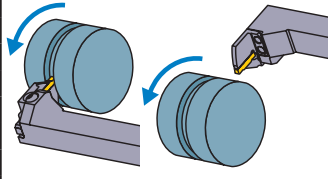
CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHR2020K90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R
GYHL2020K90-M20R			②TKY15D
GYHR2525M90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R
GYHL2525M90-M25R	②TKY25D		

	Dimensions (mm) *3						Cutting Mode	
	H	B	LF	LH	HF	WF		
	20	20	125	35	20	39		
	20	20	125	35	20	39		
	25	25	150	38	25	45		
	25	25	150	38	25	45		
	20	20	125	35	20	45		
	20	20	125	35	20	45		
	25	25	150	38	25	53		
	25	25	150	38	25	53		
	20	20	125	35	20	51		
	20	20	125	35	20	51		
	25	25	150	38	25	59		
	25	25	150	38	25	59		
	25	25	150	38	25	47		
	25	25	150	38	25	47		
	20	20	125	35	20	45		
	20	20	125	35	20	45		
	25	25	150	38	25	53		
	25	25	150	38	25	53		
	25	25	150	38	25	64		
	25	25	150	38	25	64		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
	CW	Neutral	Neutral	Neutral	Neutral	Neutral
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●
G	.157", 4.00 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
	CW	R	R	R	R/L
F	.118", 3.00 mm		●	●	●
G	.157", 4.00 mm				●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
	CW				Ball nose
F	.118", 3.00 mm				●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm			●	
	.125", 3.18 mm				●
	RE 0.2 mm	●			
G	RE 0.4 mm	●			
	RE 0.8 mm	●	●	●	
	.128", 3.24 mm	●			
	.157", 4.00 mm				●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●		●	
	.167", 4.24 mm	●			

● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

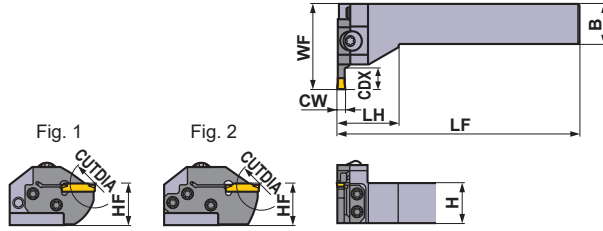
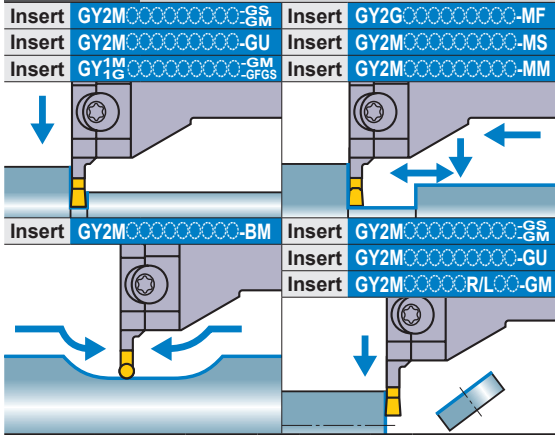
F
GROOVING / CUTTING OFF

GY SERIES (EXTERNAL)

2-2 90° type holder (Metric)

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

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

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter




*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.

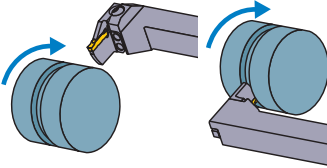
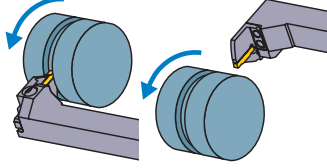
*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

● : USA Stock

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHR2020K90-M20L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R
GYHL2020K90-M20R			②TKY15D
GYHR2525M90-M25L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R
GYHL2525M90-M25R			②TKY25D

	Dimensions (mm) *3						Cutting Mode	
	H	B	LF	LH	HF	WF		
	25	25	150	38	25	47	R 	
	25	25	150	38	25	47		
	20	20	125	35	20	45		
	20	20	125	35	20	45		
	25	25	150	38	25	53		
	25	25	150	38	25	53		
	25	25	150	38	25	64		
	25	25	150	38	25	64		
	25	25	150	38	25	47		L 
	25	25	150	38	25	47		
	25	25	150	38	25	53		
	25	25	150	38	25	53		
	25	25	150	38	25	64		
	25	25	150	38	25	64		

Select an Insert

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

For Grooving/Cutting off > F011-F013						
Seat Size	Breaker	GU	GS	GM	GFGS	05-GM
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)	(Cutting off)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Hand
	H	.187", 4.75 mm	●	●	●	●
J	.197", 5.00 mm	●	●	●	●	●
	.236", 6.00 mm	●	●	●	●	●
J	.250", 6.35 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
H	CW	Ball nose			
	.187", 4.75 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			
	.197", 5.00 mm				●
J	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.206", 5.24 mm	●			
	.236", 6.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.248", 6.31 mm	●			
	.250", 6.35 mm				●
RE 0.2 mm	●				
RE 0.4 mm	●				
RE 0.8 mm	●				

● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

F

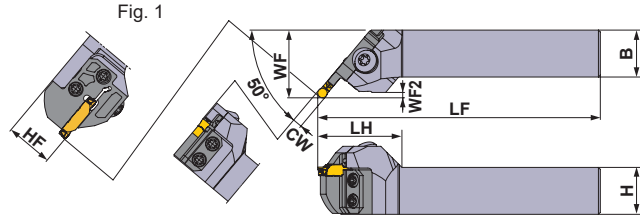
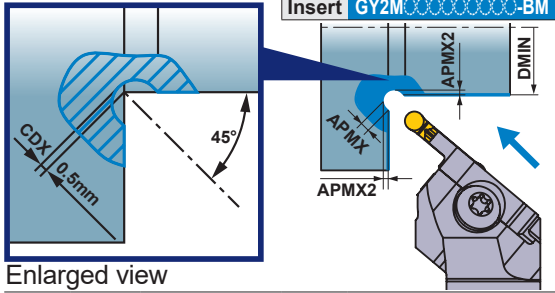
GROOVING / CUTTING OFF

GY SERIES (EXTERNAL RECESSING)

3-2 50° type holder (Metric)

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (mm)	CDX (mm)	DMIN (mm)	APMX (mm)	APMX2 (mm)	Type	Hand (R/L)	Order Number				Fig.
								Holder	Stock	Modular Blade	Stock	
D	2.00	0.5	30	1.5	0.646	Modular	R	GYHR2020K50-M20L	●	GYM20LC-D005	●	1
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-D005	●	1
E	2.50	0.5	30	1.75	0.72	Modular	R	GYHR2525M50-M25L	●	GYM25LC-D005	●	1
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-D005	●	1
F	3.00 3.18	0.5	30	2	0.793	Modular	R	GYHR2020K50-M20L	●	GYM20LC-E005	●	1
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-E005	●	1
G	4.00	0.5	30	2.5	0.939	Modular	R	GYHR2525M50-M25L	●	GYM25LC-E005	●	1
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-E005	●	1
H	4.75 5.00	0.5	20	2.5	0.939	Modular	R	GYHR2020K50-M20L	●	GYM20LC-F005	●	1
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-F005	●	1
I	5.00	0.5	20	2.88	1.049	Modular	R	GYHR2525M50-M25L	●	GYM25LC-F005	●	1
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-F005	●	1
J	6.00 6.35	0.5	20	3.5	1.232	Modular	R	GYHR2020K50-M20L	●	GYM20LC-G005	●	1
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-G005	●	1
K	6.35	0.5	20	2.88	1.049	Modular	R	GYHR2525M50-M25L	●	GYM25LC-G005	●	1
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-G005	●	1
L	6.35	0.5	20	3.5	1.232	Modular	R	GYHR2020K50-M20L	●	GYM20LC-H005	●	1
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-H005	●	1
M	6.35	0.5	20	2.88	1.049	Modular	R	GYHR2525M50-M25L	●	GYM25LC-H005	●	1
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-H005	●	1
N	6.35	0.5	20	3.5	1.232	Modular	R	GYHR2525M50-M25L	●	GYM25LC-F005	●	1
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-F005	●	1
O	6.35	0.5	20	3.5	1.232	Modular	R	GYHR2020K50-M20L	●	GYM20LC-J005	●	1
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-J005	●	1
P	6.35	0.5	20	3.5	1.232	Modular	R	GYHR2525M50-M25L	●	GYM25LC-J005	●	1
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-J005	●	1

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

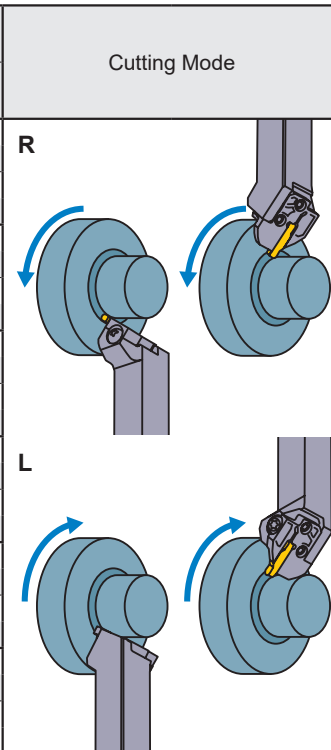
*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, WF and WF2 values may vary.

● : USA Stock

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

SPARE PARTS			
Holder Number		 4 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K50-M20R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY25D
GYHR/L2525M50-M25R/L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *2						
	H	B	LF	LH	HF	WF	WF2
	20	20	125	40	20	32	1.6
	20	20	125	40	20	32	1.6
	25	25	150	45	25	35	1.6
	25	25	150	45	25	35	1.6
	20	20	125	40	20	32	1.8
	20	20	125	40	20	32	1.8
	25	25	150	45	25	35	1.8
	25	25	150	45	25	35	1.8
	20	20	125	40	20	32	2.0
	20	20	125	40	20	32	2.0
	25	25	150	45	25	35	2.0
	25	25	150	45	25	35	2.0
	20	20	125	40	20	32	2.4
	20	20	125	40	20	32	2.4
	25	25	150	45	25	35	2.4
	25	25	150	45	25	35	2.4
	20	20	125	40	20	33	2.8
	20	20	125	40	20	33	2.8
	25	25	150	45	25	36	2.8
	25	25	150	45	25	36	2.8
	25	25	150	44	25	36	3.4
	25	25	150	44	25	36	3.4



Select an Insert

Insert Number	
GY2M○○○○○○○○○N-BM	

For Multifunctional Grooving > F014		
Seat Size	Breaker	BM (Copying, Recessing) Ball nose
	CW	
D	.079", 2.00 mm	●
E	.098", 2.50 mm	●
F	.118", 3.00 mm	●
	.125", 3.18 mm	●
G	.157", 4.00 mm	●
	.187", 4.75 mm	●
H	.197", 5.00 mm	●
	.236", 6.00 mm	●
J	.250", 6.35 mm	●

● : Gauge insert shown dimensions

F

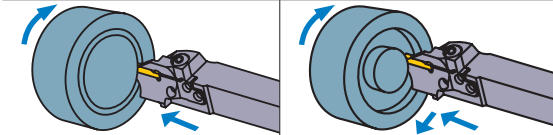
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F200
 INSTRUCTION MANUAL > F200

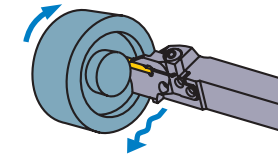
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GS}	Insert	GY2M ^{MM}



Insert GY2M^{BM}



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

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

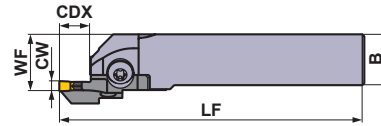


Fig. 1

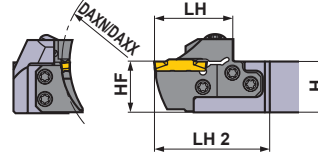
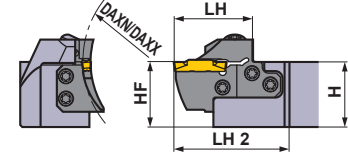


Fig. 2



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	.079 .088	1.575	1.969	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-040	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-040	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-040	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-040	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-040	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-040	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-040	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-040	●	2
		1.969	2.362	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-050	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-050	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-050	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-050	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-050	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-050	●	2
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-050	●	2
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-050	●	2
		2.362	2.953	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-060	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-060	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-060	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-060	●	1
Modular	R				GYHRUS20D00-M25R	●	GYM25RD-D12-060	●	2		
Modular	L				GYHLUS20D00-M25L	●	GYM25LD-D12-060	●	2		
Modular	R				GYHRUS24E00-M25R	●	GYM25RD-D12-060	●	2		
Modular	L				GYHLUS24E00-M25L	●	GYM25LD-D12-060	●	2		
2.953	3.937	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-075	●	3		
			Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-075	●	3		
			Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-075	●	1		
			Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-075	●	1		
			Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-075	●	2		
			Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-075	●	2		
			Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-075	●	2		
			Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-075	●	2		

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

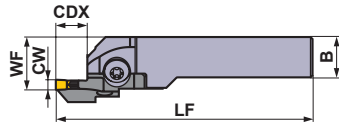
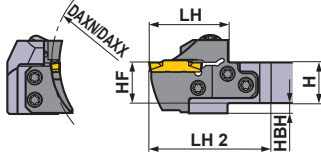


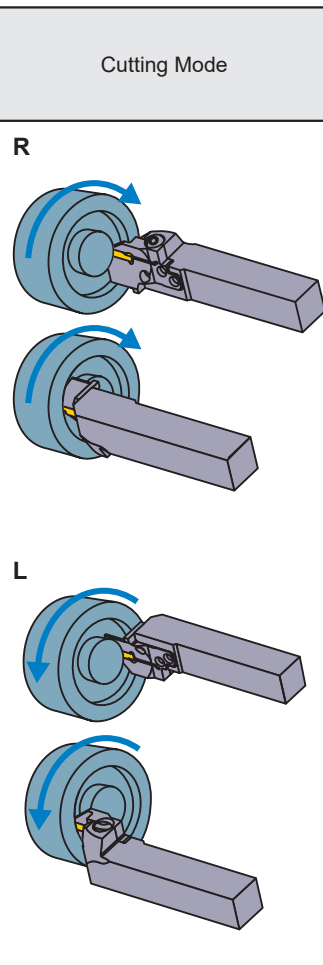
Fig. 3



Right hand tool holder shown.

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench ★
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Dimensions (inch) ★1								
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	R
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	L
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
D	.079", 2.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●

● : Gauge insert shown dimensions

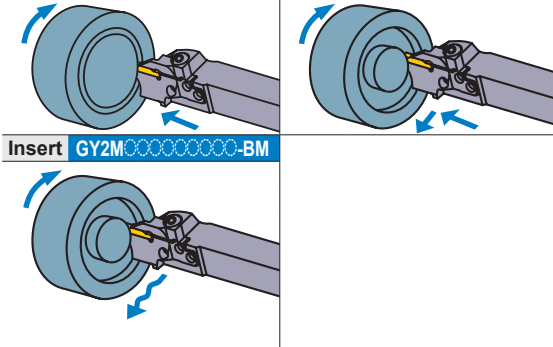
F
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

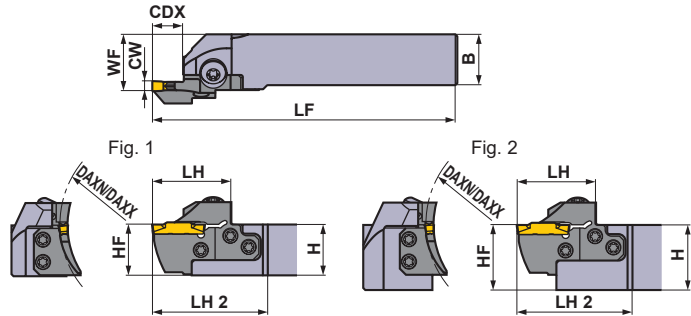
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{MM}



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



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	.079 .088	3.937	5.906	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-100	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-100	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-100	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-100	●	1
		Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-100	●	2			
		Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-100	●	2			
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-100	●	2			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-100	●	2			
	5.315	7.874	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-135	●	3	
				Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-135	●	3	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-135	●	1	
				Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-135	●	1	
	7.087	9.843	.472	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-135	●	2	
				Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-135	●	2	
				Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-135	●	2	
				Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-135	●	2	
			Modular	R	GYHRUS12C00-M25R	●	GYM25RD-D12-180	●	3		
			Modular	L	GYHLUS12C00-M25L	●	GYM25LD-D12-180	●	3		
			Modular	R	GYHRUS16D00-M25R	●	GYM25RD-D12-180	●	1		
			Modular	L	GYHLUS16D00-M25L	●	GYM25LD-D12-180	●	1		
			Modular	R	GYHRUS20D00-M25R	●	GYM25RD-D12-180	●	2		
			Modular	L	GYHLUS20D00-M25L	●	GYM25LD-D12-180	●	2		
			Modular	R	GYHRUS24E00-M25R	●	GYM25RD-D12-180	●	2		
			Modular	L	GYHLUS24E00-M25L	●	GYM25LD-D12-180	●	2		

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

F
GROOVING / CUTTING OFF

● : USA Stock

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

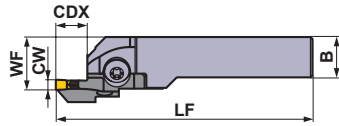
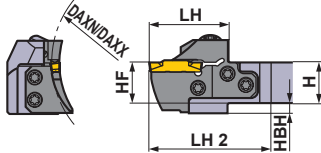


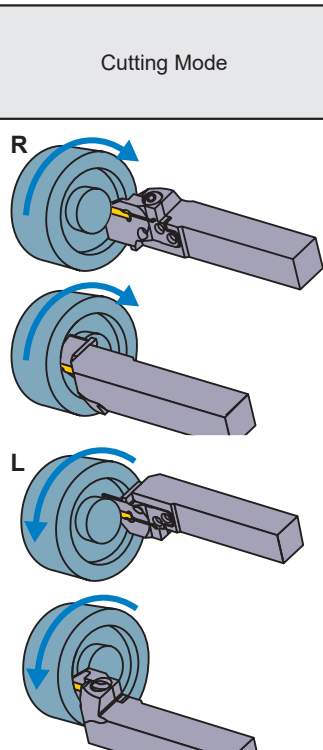
Fig. 3



Right hand tool holder shown.

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

	Dimensions (inch) *1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
D	.079", 2.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●

● : Gauge insert shown dimensions

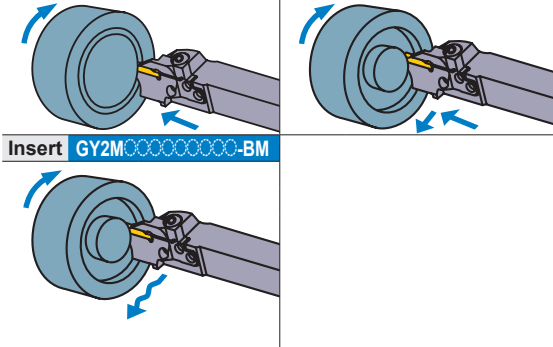
F
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{1G}	Insert	GY2M ^{MM}



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

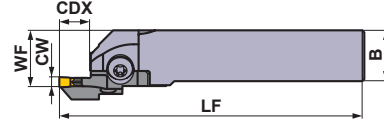


Fig. 1

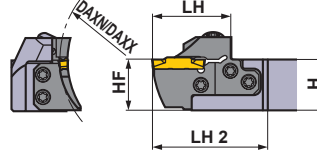
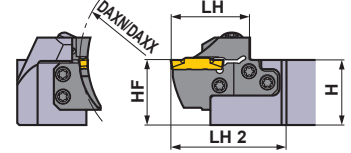


Fig. 2



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
E	.094	1.575	1.969	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-040	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-040	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-040	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-040	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-040	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-040	●	2
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-040	●	2			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-040	●	2			
		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-050	●	3			
		Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-050	●	3			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-050	●	1			
		Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-050	●	1			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-050	●	2				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-050	●	2				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-050	●	2				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-050	●	2				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-060	●	3				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-060	●	3				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-060	●	1				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-060	●	1				
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-060	●	2					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-060	●	2					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-060	●	2					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-060	●	2					
Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-075	●	3					
Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-075	●	3					
Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-075	●	1					
Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-075	●	1					
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-075	●	2					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-075	●	2					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-075	●	2					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-075	●	2					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

● : USA Stock

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

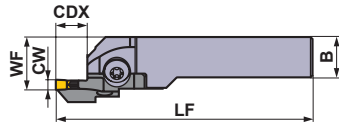
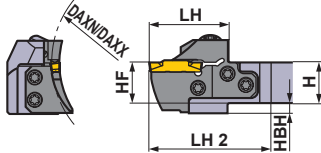


Fig. 3



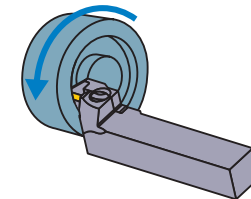
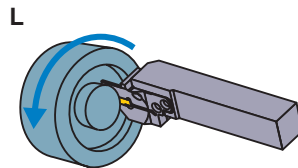
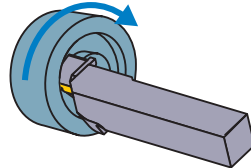
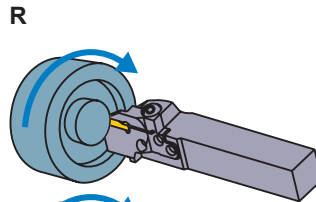
Right hand tool holder shown.

SPARE PARTS

Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Dimensions (inch) *1								
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	

Cutting Mode



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing) Ball nose
E	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

F

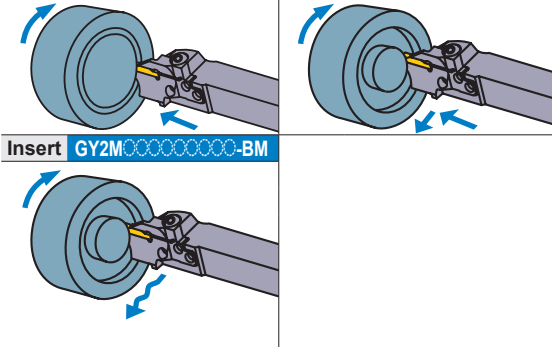
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
CUTTING CONDITIONS > F206
INSTRUCTION MANUAL > F208

GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{GM} -MF
Insert	GY2M ^{GU} _{GM}	Insert	GY2M ^{GU} _{GM} -MS
Insert	GY1M ^{GM} _{GFS}	Insert	GY2M ^{GM} _{GFS} -MM



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

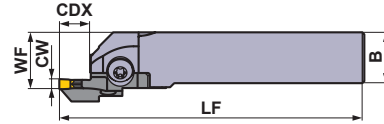
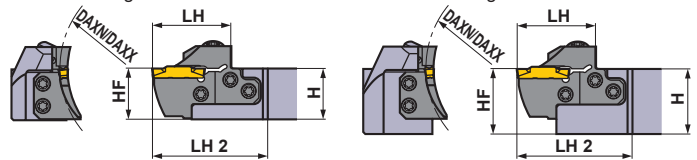


Fig. 1

Fig. 2



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
E	.094 .098 .108	3.937	5.906	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-100	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-100	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-100	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-100	●	1
		Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-100	●	2			
		Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-100	●	2			
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-100	●	2			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-100	●	2			
	5.315	7.874	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-135	●	3	
				Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-135	●	3	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-135	●	1	
				Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-135	●	1	
	7.087	9.843	.472	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-135	●	2	
				Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-135	●	2	
				Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-135	●	2	
				Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-135	●	2	
			Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-180	●	3		
			Modular	L	GYHLUS12C00-M25L	●	GYM25LD-E12-180	●	3		
			Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-180	●	1		
			Modular	L	GYHLUS16D00-M25L	●	GYM25LD-E12-180	●	1		
			Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-180	●	2		
			Modular	L	GYHLUS20D00-M25L	●	GYM25LD-E12-180	●	2		
			Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-180	●	2		
			Modular	L	GYHLUS24E00-M25L	●	GYM25LD-E12-180	●	2		

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

● : USA Stock

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

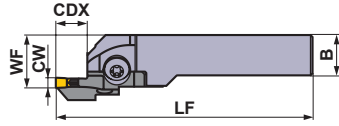
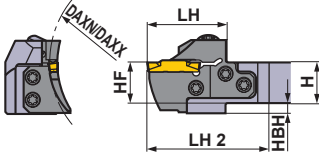


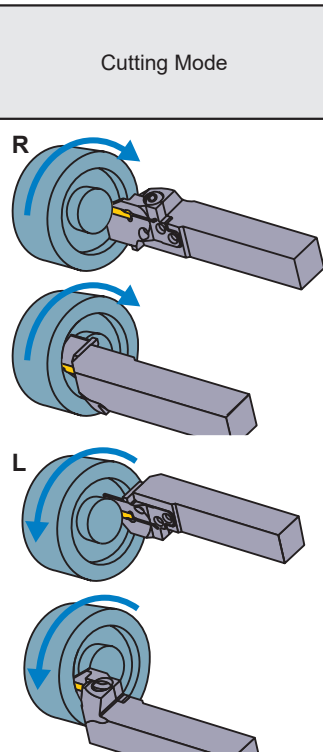
Fig. 3



Right hand tool holder shown.

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Dimensions (inch) *1								
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Reversing) Ball nose
E	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

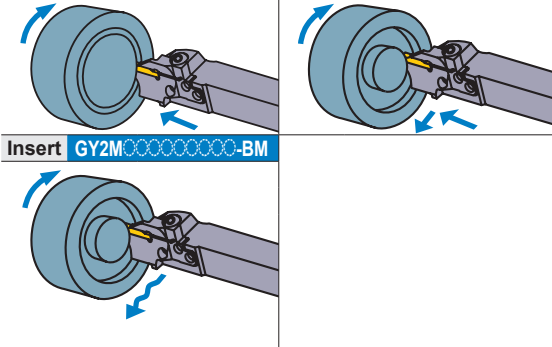
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GROOVING / CUTTING OFF

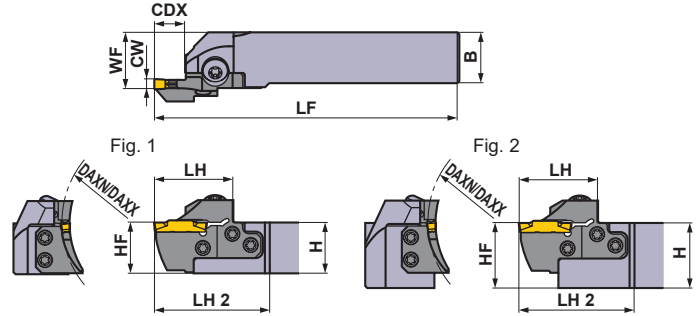
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{GM} -MF
Insert	GY2M ^{GU} _{GM}	Insert	GY2M ^{GU} _{GM} -MS
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{GM} _{GFS} -MM



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



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	1.378	1.575	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-035	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-035	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-035	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-035	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-035	●	2
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-035	●	2
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-035	●	2			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-035	●	2			
		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-040	●	3			
		Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-040	●	3			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-040	●	1			
		Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-040	●	1			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-040	●	2				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-040	●	2				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-040	●	2				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-040	●	2				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-050	●	3				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-050	●	3				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-050	●	1				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-050	●	1				
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-050	●	2					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-050	●	2					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-050	●	2					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-050	●	2					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

F

GROOVING / CUTTING OFF

● : USA Stock

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

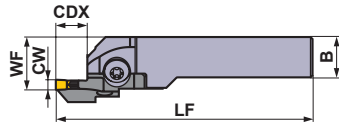
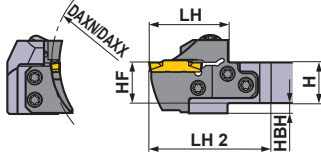


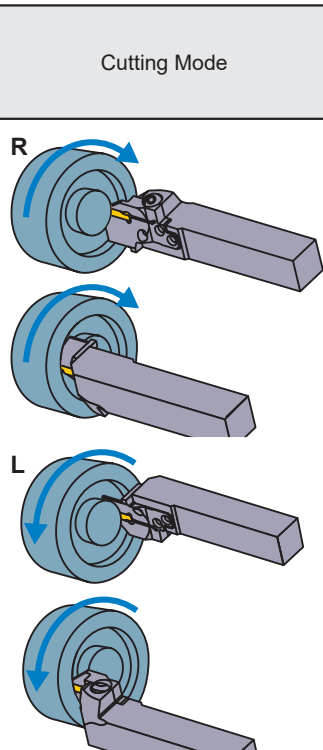
Fig. 3



Right hand tool holder shown.

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D00-M25R/L			
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

	Dimensions (inch) *1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	.750	.750	5.000	1.535	.241	.750	1.000	.250
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
	1.500	1.500	7.000	1.535	2.241	1.500	1.625	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing) Ball nose
F	.118", 3.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"		●	●	
	.125", 3.18 mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

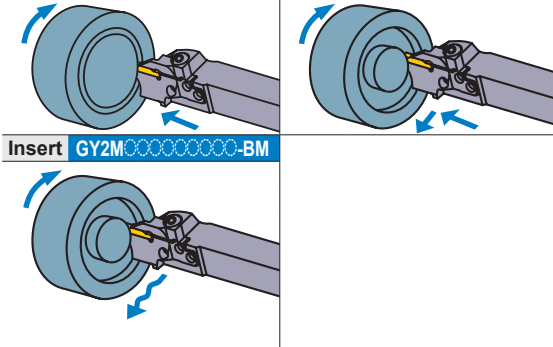
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GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

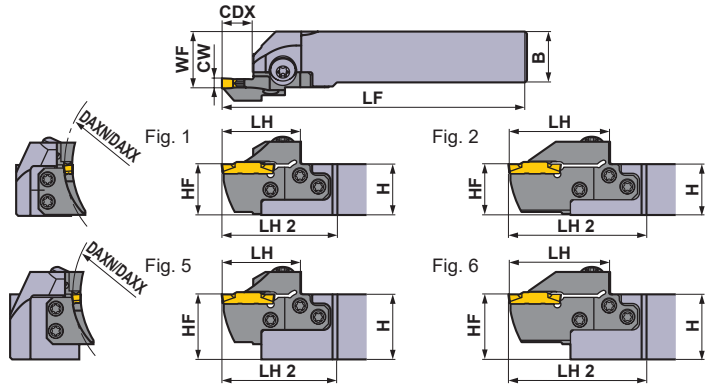
4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

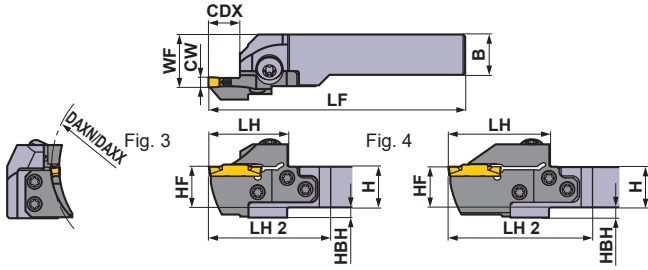
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	2.362	2.953	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-060	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-060	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-060	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-060	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-060	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-060	●	5
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-060	●	5			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-060	●	5			
		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-060	●	4			
		Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-060	●	4			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-060	●	2			
		Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-060	●	2			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-060	●	6				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-060	●	6				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-060	●	6				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-060	●	6				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-075	●	3				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-075	●	3				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-075	●	1				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-075	●	1				
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-075	●	5				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-075	●	5				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-075	●	5				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-075	●	5				
Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-075	●	4					
Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-075	●	4					
Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-075	●	2					
Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-075	●	2					
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-075	●	6					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-075	●	6					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-075	●	6					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-075	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

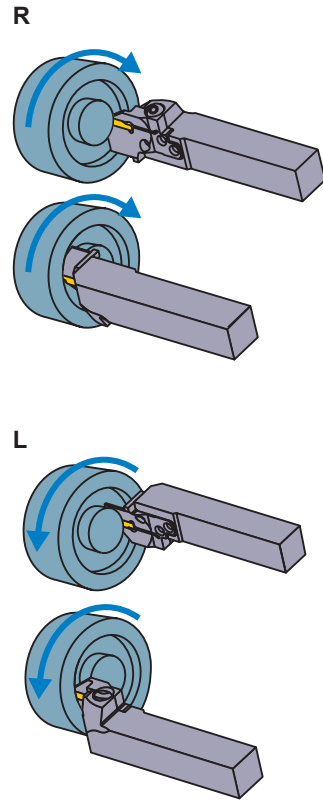


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		5 pcs.	① ②
	Clamp Screw	Blade Screw	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	R
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
.750	.750	5.236	1.772	.477	.750	1.000	.250	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing) Ball nose
F	.118", 3.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.125", 3.18 mm	●	●	●	●
	RE .016"	●	●	●	●

● : Gauge insert shown dimensions

F

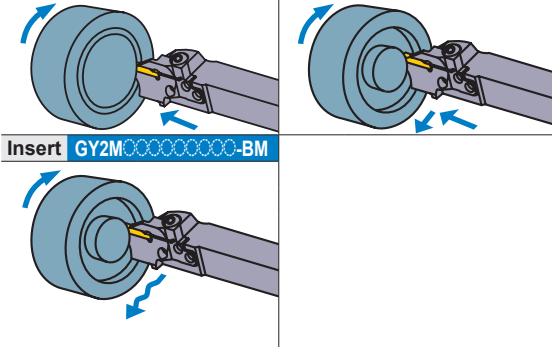
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

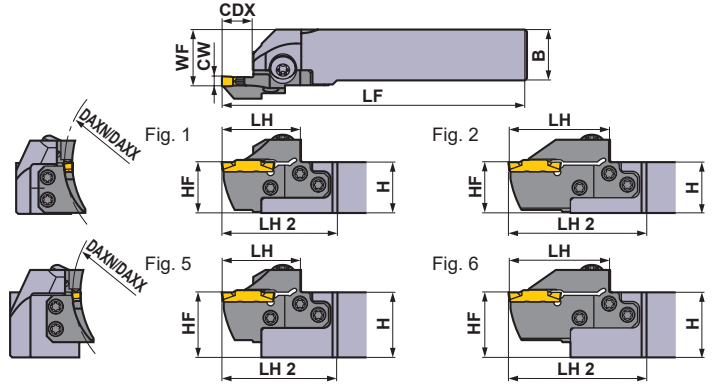
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{MM}



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



Right hand tool holder shown.

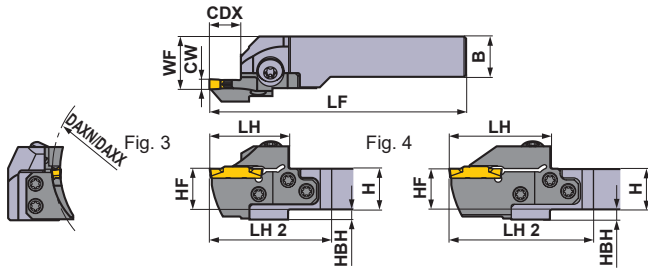
F
GROOVING / CUTTING OFF

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	3.937	5.906	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-100	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-100	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-100	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-100	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-100	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-100	●	5
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-100	●	5			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-100	●	5			
		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-100	●	4			
		Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-100	●	4			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-100	●	2			
		Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-100	●	2			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-100	●	6				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-100	●	6				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-100	●	6				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-100	●	6				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-135	●	3				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-135	●	3				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-135	●	1				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-135	●	1				
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-135	●	5				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-135	●	5				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-135	●	5				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-135	●	5				
Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-135	●	4					
Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-135	●	4					
Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-135	●	2					
Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-135	●	2					
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-135	●	6					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-135	●	6					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-135	●	6					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-135	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.
 *2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

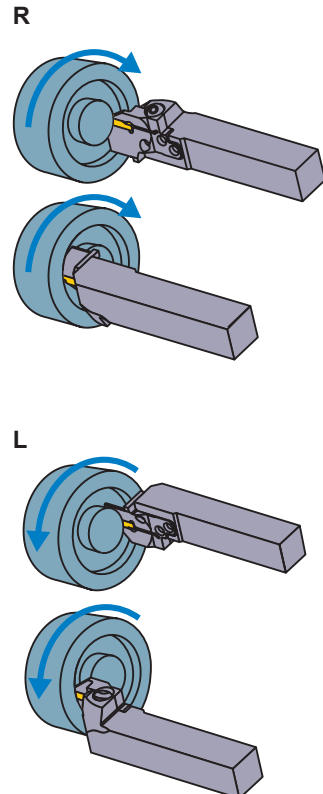


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	R
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	R
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	R
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	R
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.236	1.772	.477	.750	1.000	.250	L
.750	.750	5.236	1.772	.477	.750	1.000	.250	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	L
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	L
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	L
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	L
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	L
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	L
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	L
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.236	1.772	.477	.750	1.000	.250	L
.750	.750	5.236	1.772	.477	.750	1.000	.250	
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	L
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—	
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	L
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—	
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	L
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
F	.118", 3.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24 mm	●			

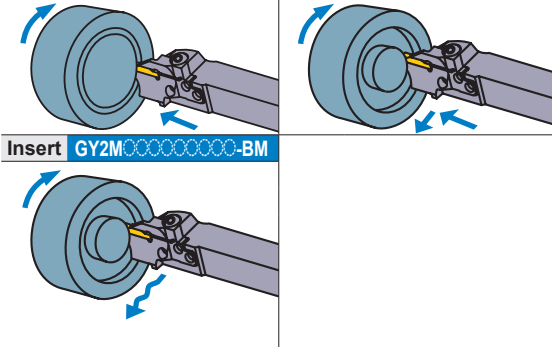
● : Gauge insert shown dimensions

F GROOVING / CUTTING OFF

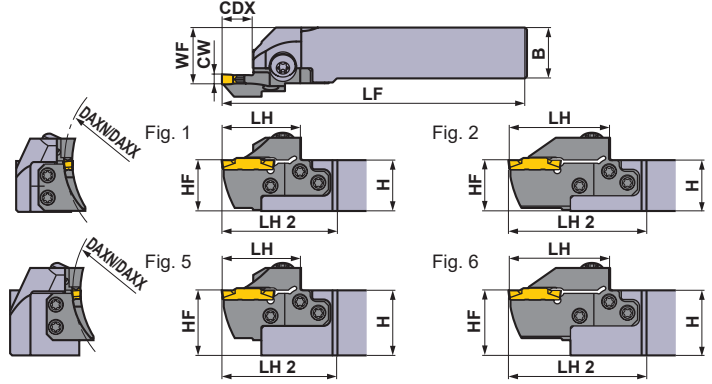
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{MM}



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

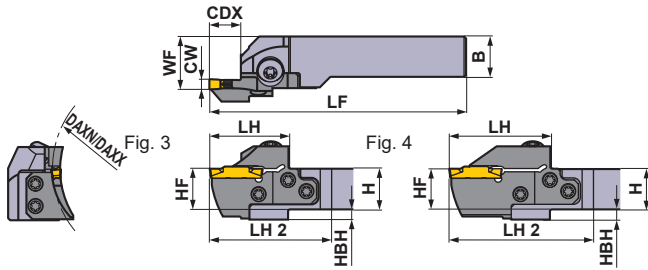
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	7.087	9.843	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-180	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-180	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-180	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-180	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-180	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-180	●	5
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-180	●	5			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-180	●	5			
		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-180	●	4			
		Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-180	●	4			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-180	●	2			
		Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-180	●	2			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-180	●	6				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-180	●	6				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-180	●	6				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-180	●	6				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-225	●	3				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-225	●	3				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-225	●	1				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-225	●	1				
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-225	●	5				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-225	●	5				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-225	●	5				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-225	●	5				
Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-225	●	4					
Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F20-225	●	4					
Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F20-225	●	2					
Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F20-225	●	2					
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F20-225	●	6					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F20-225	●	6					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F20-225	●	6					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F20-225	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

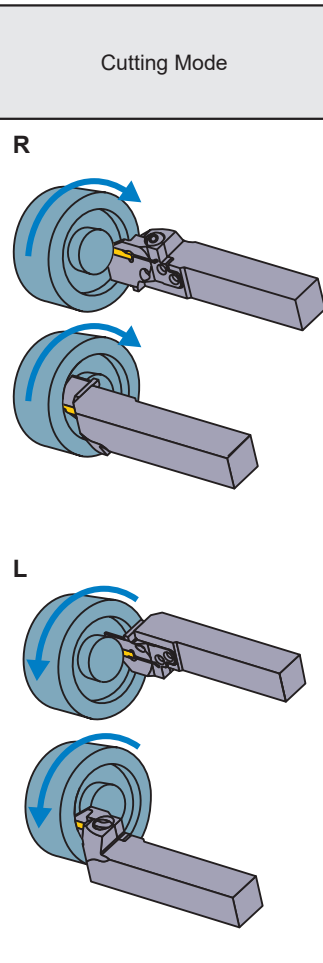


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1							
H	B	LF	LH	LH 2	HF	WF	HBH
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.236	1.772	.477	.750	1.000	.250
.750	.750	5.236	1.772	.477	.750	1.000	.250
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.236	1.772	.477	.750	1.000	.250
.750	.750	5.236	1.772	.477	.750	1.000	.250
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—
1.000	1.000	6.236	1.772	1.477	1.000	1.125	—
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—
1.250	1.250	6.236	1.772	1.477	1.250	1.375	—
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—
1.500	1.500	7.236	1.772	2.477	1.500	1.625	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
F	.118", 3.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

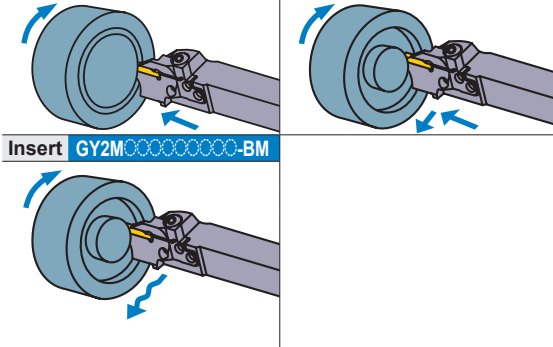
F

GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

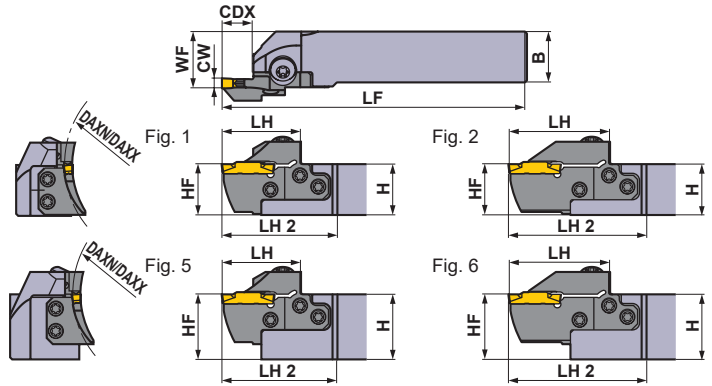
4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

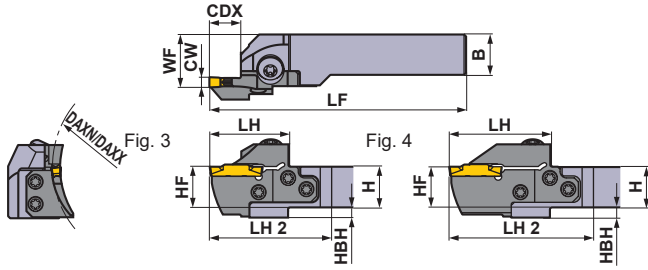
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	.157 .167	1.575	1.969	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-040	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-040	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-040	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-040	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-040	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-040	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-040	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-040	●	5
		1.969	2.362	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-050	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-050	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-050	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-050	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-050	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-050	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-050	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-050	●	5
		2.362	3.346	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-060	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-060	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-060	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-060	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-060	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-060	●	5
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-060	●	5
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-060	●	5
		.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G25-060	●	4		
			Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G25-060	●	4		
			Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G25-060	●	2		
			Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G25-060	●	2		
			Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G25-060	●	6		
			Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G25-060	●	6		
			Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G25-060	●	6		
			Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G25-060	●	6		

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

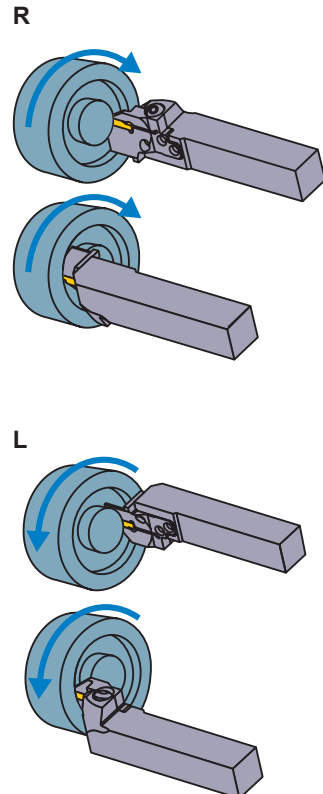


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	R
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
G	.157", 4.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.167", 4.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

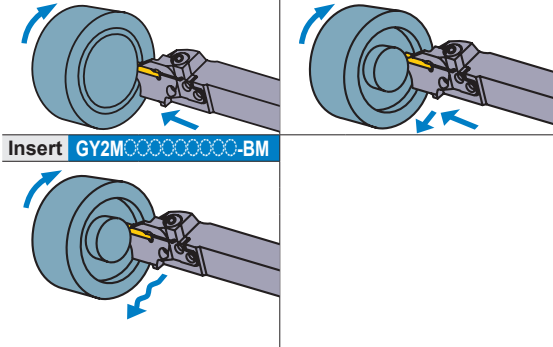
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

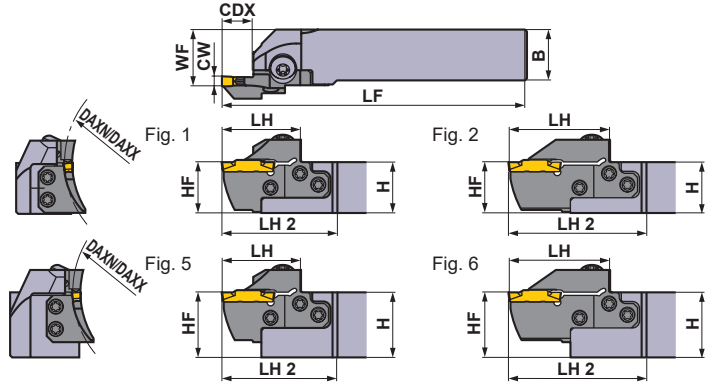
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{MM}



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

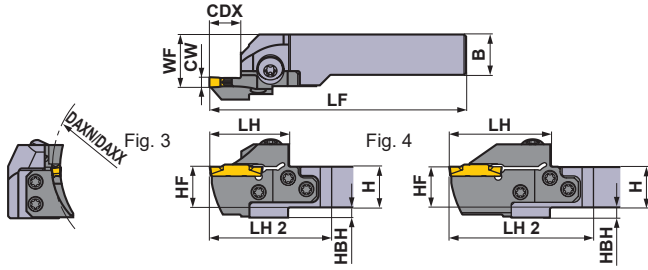
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	.157 .167	3.346	4.921	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-085	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-085	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-085	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-085	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-085	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-085	●	5
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-085	●	5			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-085	●	5			
		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G25-085	●	4			
		Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G25-085	●	4			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G25-085	●	2			
		Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G25-085	●	2			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G25-085	●	6				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G25-085	●	6				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G25-085	●	6				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G25-085	●	6				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-125	●	3				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-125	●	3				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-125	●	1				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-125	●	1				
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-125	●	5				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-125	●	5				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-125	●	5				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-125	●	5				
Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G25-125	●	4					
Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G25-125	●	4					
Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G25-125	●	2					
Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G25-125	●	2					
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G25-125	●	6					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G25-125	●	6					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G25-125	●	6					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G25-125	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

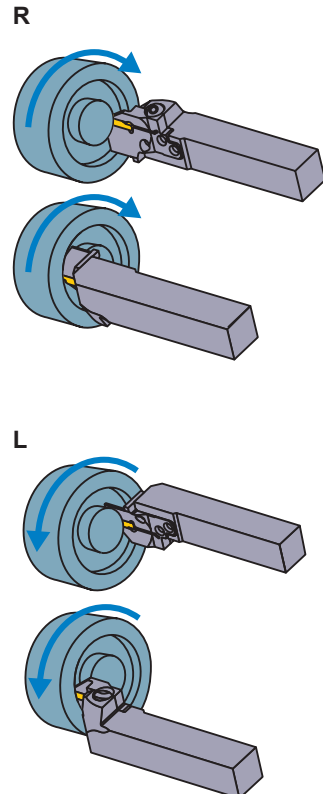


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	R
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	R
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	R
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	R
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.433	1.969	.674	.750	1.000	.250	L
.750	.750	5.433	1.969	.674	.750	1.000	.250	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	L
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	L
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	L
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	L
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	L
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	L
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	L
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.433	1.969	.674	.750	1.000	.250	L
.750	.750	5.433	1.969	.674	.750	1.000	.250	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	L
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	L
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	L
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
G	.157", 4.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.167", 4.24 mm	●	●	●	●

● : Gauge insert shown dimensions

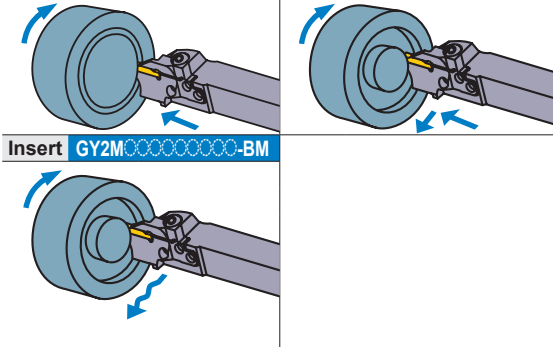
F

GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

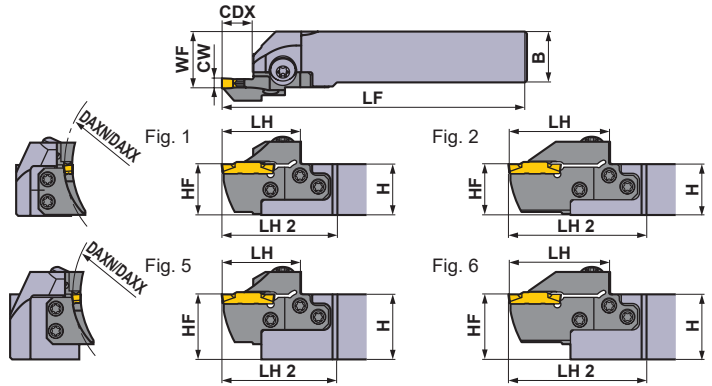
4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

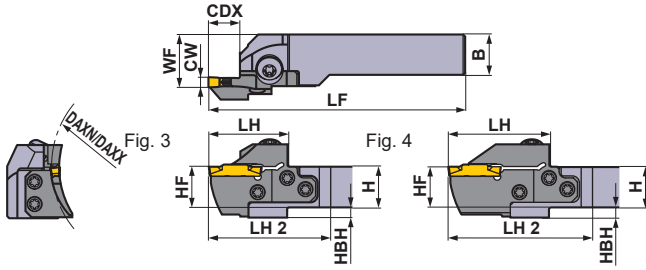
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	.157 .167	7.087	11.024	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-180	●	3
						L	GYHLUS12C00-M25L	●	GYM25LD-G14-180	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-180	●	1
						L	GYHLUS16D00-M25L	●	GYM25LD-G14-180	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-180	●	5
						L	GYHLUS20D00-M25L	●	GYM25LD-G14-180	●	5
					R	GYHRUS24E00-M25R	●	GYM25RD-G14-180	●	5	
					L	GYHLUS24E00-M25L	●	GYM25LD-G14-180	●	5	
					R	GYHRUS12C00-M25R	●	GYM25RD-G25-180	●	4	
					L	GYHLUS12C00-M25L	●	GYM25LD-G25-180	●	4	
					R	GYHRUS16D00-M25R	●	GYM25RD-G25-180	●	2	
					L	GYHLUS16D00-M25L	●	GYM25LD-G25-180	●	2	
		R	GYHRUS20D00-M25R	●	GYM25RD-G25-180	●	6				
		L	GYHLUS20D00-M25L	●	GYM25LD-G25-180	●	6				
		R	GYHRUS24E00-M25R	●	GYM25RD-G25-180	●	6				
		L	GYHLUS24E00-M25L	●	GYM25LD-G25-180	●	6				
		9.843	39.331	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-250	●	3
					L	GYHLUS12C00-M25L	●	GYM25LD-G14-250	●	3	
					R	GYHRUS16D00-M25R	●	GYM25RD-G14-250	●	1	
					L	GYHLUS16D00-M25L	●	GYM25LD-G14-250	●	1	
				R	GYHRUS20D00-M25R	●	GYM25RD-G14-250	●	5		
				L	GYHLUS20D00-M25L	●	GYM25LD-G14-250	●	5		
				R	GYHRUS24E00-M25R	●	GYM25RD-G14-250	●	5		
				L	GYHLUS24E00-M25L	●	GYM25LD-G14-250	●	5		
	.984*2		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G25-250	●	4		
		L	GYHLUS12C00-M25L	●	GYM25LD-G25-250	●	4				
		R	GYHRUS16D00-M25R	●	GYM25RD-G25-250	●	2				
		L	GYHLUS16D00-M25L	●	GYM25LD-G25-250	●	2				
	R	GYHRUS20D00-M25R	●	GYM25RD-G25-250	●	6					
	L	GYHLUS20D00-M25L	●	GYM25LD-G25-250	●	6					
	R	GYHRUS24E00-M25R	●	GYM25RD-G25-250	●	6					
	L	GYHLUS24E00-M25L	●	GYM25LD-G25-250	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

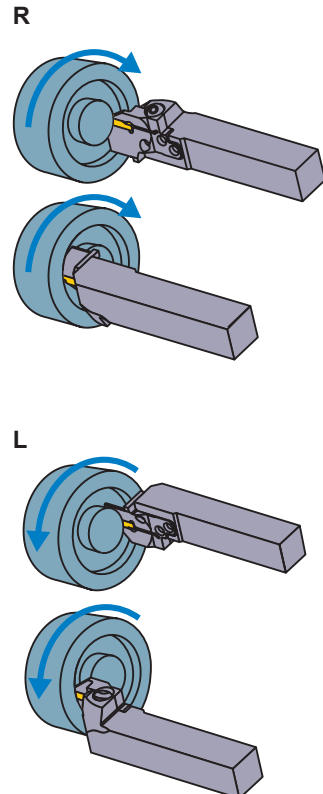


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	R
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	R
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	R
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	R
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.433	1.969	.674	.750	1.000	.250	L
.750	.750	5.433	1.969	.674	.750	1.000	.250	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	L
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	L
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	L
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	L
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	L
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	L
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	L
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.433	1.969	.674	.750	1.000	.250	L
.750	.750	5.433	1.969	.674	.750	1.000	.250	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	L
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	L
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	L
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
G	.157", 4.00 mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.167", 4.24 mm	●	●	●	●

● : Gauge insert shown dimensions

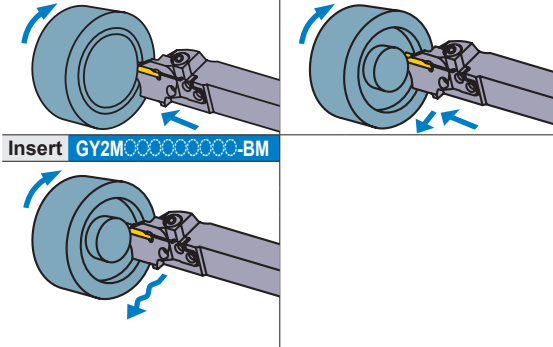
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GROOVING / CUTTING OFF

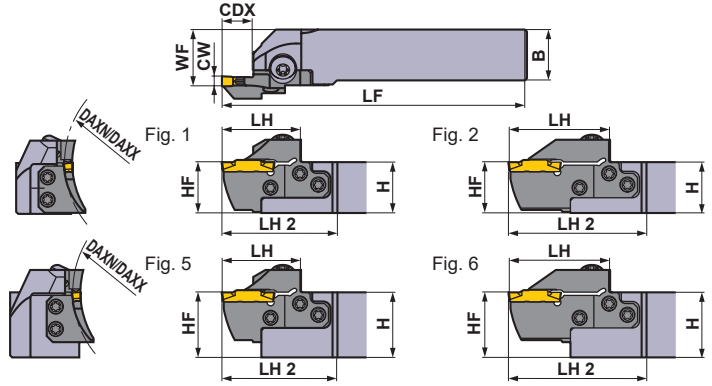
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{GM} -MF
Insert	GY2M ^{GU} _{GM}	Insert	GY2M ^{GU} _{GM} -MS
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{GM} _{GFS} -MM



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

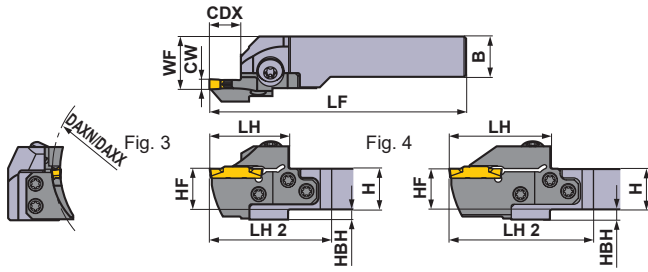
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	1.969	2.362	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-050	●	3
						L	GYHLUS12C00-M25L	●	GYM25LD-H14-050	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-050	●	1
						L	GYHLUS16D00-M25L	●	GYM25LD-H14-050	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-050	●	5
						L	GYHLUS20D00-M25L	●	GYM25LD-H14-050	●	5
			R	GYHRUS24E00-M25R	●	GYM25RD-H14-050	●	5			
			L	GYHLUS24E00-M25L	●	GYM25LD-H14-050	●	5			
			R	GYHRUS12C00-M25R	●	GYM25RD-H14-060	●	3			
			L	GYHLUS12C00-M25L	●	GYM25LD-H14-060	●	3			
			R	GYHRUS16D00-M25R	●	GYM25RD-H14-060	●	1			
			L	GYHLUS16D00-M25L	●	GYM25LD-H14-060	●	1			
		R	GYHRUS20D00-M25R	●	GYM25RD-H14-060	●	5				
		L	GYHLUS20D00-M25L	●	GYM25LD-H14-060	●	5				
		R	GYHRUS24E00-M25R	●	GYM25RD-H14-060	●	5				
		L	GYHLUS24E00-M25L	●	GYM25LD-H14-060	●	5				
		2.362	3.346	.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-060	●	4
					L	GYHLUS12C00-M25L	●	GYM25LD-H25-060	●	4	
					R	GYHRUS16D00-M25R	●	GYM25RD-H25-060	●	2	
					L	GYHLUS16D00-M25L	●	GYM25LD-H25-060	●	2	
	R	GYHRUS20D00-M25R	●		GYM25RD-H25-060	●	6				
	L	GYHLUS20D00-M25L	●		GYM25LD-H25-060	●	6				
	R	GYHRUS24E00-M25R	●		GYM25RD-H25-060	●	6				
	L	GYHLUS24E00-M25L	●		GYM25LD-H25-060	●	6				

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock



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

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	

Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
H	.187", 4.75 mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00 mm	●			●
	RE .008"	●			
H	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24 mm	●			
		●			

● : Gauge insert shown dimensions

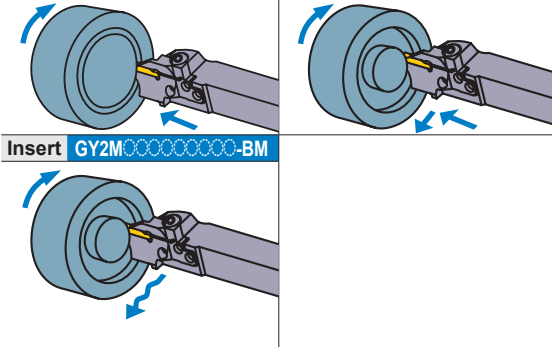
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GROOVING / CUTTING OFF

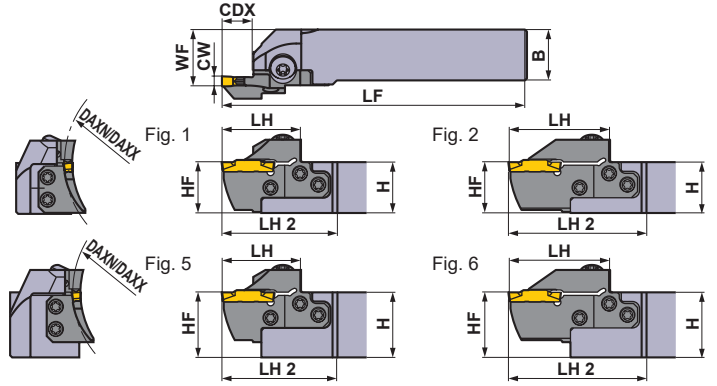
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{MM}



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

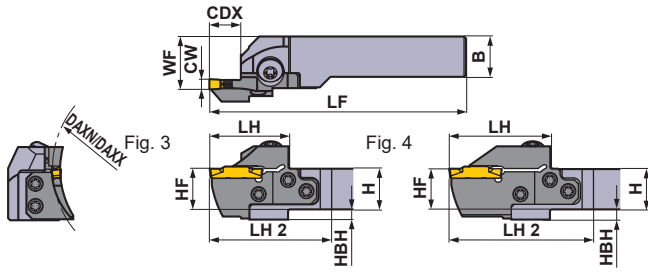
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	3.346	4.921	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-085	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H14-085	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-085	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H14-085	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-085	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H14-085	●	5
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-085	●	5			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H14-085	●	5			
		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-085	●	4			
		Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H25-085	●	4			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H25-085	●	2			
		Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H25-085	●	2			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H25-085	●	6				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H25-085	●	6				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H25-085	●	6				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H25-085	●	6				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-125	●	3				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H14-125	●	3				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-125	●	1				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H14-125	●	1				
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-125	●	5				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H14-125	●	5				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-125	●	5				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H14-125	●	5				
Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-125	●	4					
Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H25-125	●	4					
Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H25-125	●	2					
Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H25-125	●	2					
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H25-125	●	6					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H25-125	●	6					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H25-125	●	6					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H25-125	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

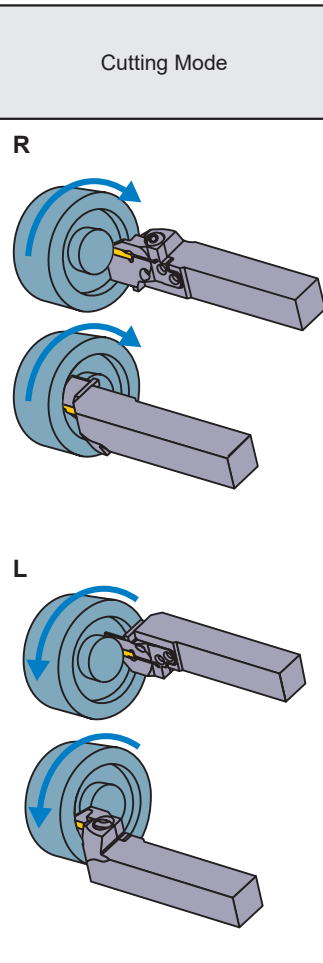


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1							
H	B	LF	LH	LH 2	HF	WF	HBH
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
H	.187", 4.75 mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00 mm	●			●
	.206", 5.24 mm	●		●	

● : Gauge insert shown dimensions

F

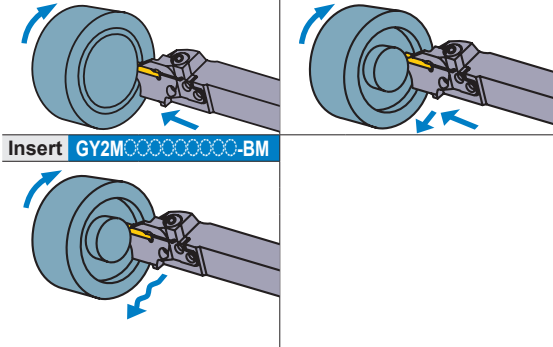
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

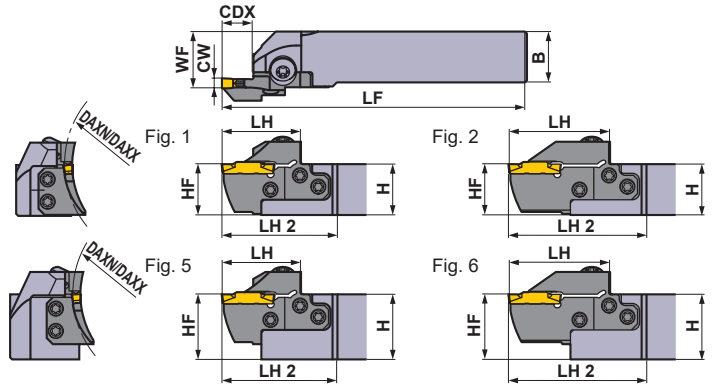
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{MM}



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



Right hand tool holder shown.

F
GROOVING / CUTTING OFF

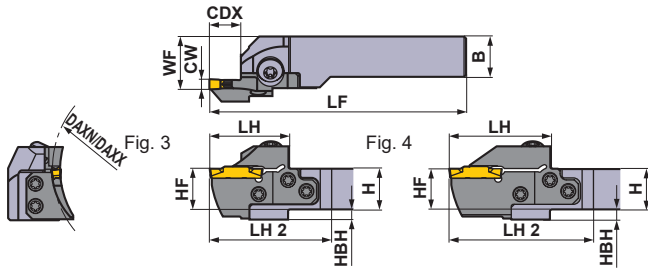
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	7.087	11.024	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-180	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H14-180	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-180	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H14-180	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-180	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H14-180	●	5
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-180	●	5			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H14-180	●	5			
		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-180	●	4			
		Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H25-180	●	4			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H25-180	●	2			
		Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H25-180	●	2			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H25-180	●	6				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H25-180	●	6				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H25-180	●	6				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H25-180	●	6				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-250	●	3				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H14-250	●	3				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-250	●	1				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H14-250	●	1				
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-250	●	5				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H14-250	●	5				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-250	●	5				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H14-250	●	5				
Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-250	●	4					
Modular	L	GYHLUS12C00-M25L	●	GYM25LD-H25-250	●	4					
Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H25-250	●	2					
Modular	L	GYHLUS16D00-M25L	●	GYM25LD-H25-250	●	2					
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H25-250	●	6					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-H25-250	●	6					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H25-250	●	6					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-H25-250	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

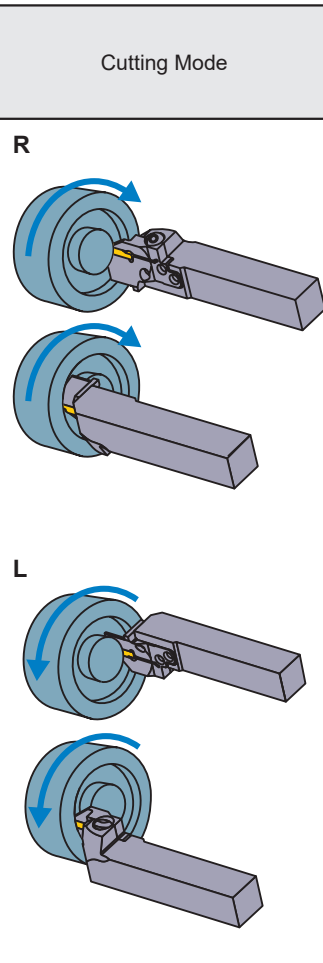


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1							
H	B	LF	LH	LH 2	HF	WF	HBH
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
H	.187", 4.75 mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	RE .008"	●	●	●	
	RE .016"	●	●	●	
H	.197", 5.00 mm				●
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

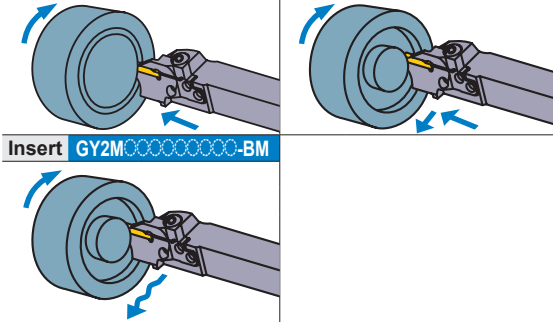
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GROOVING / CUTTING OFF

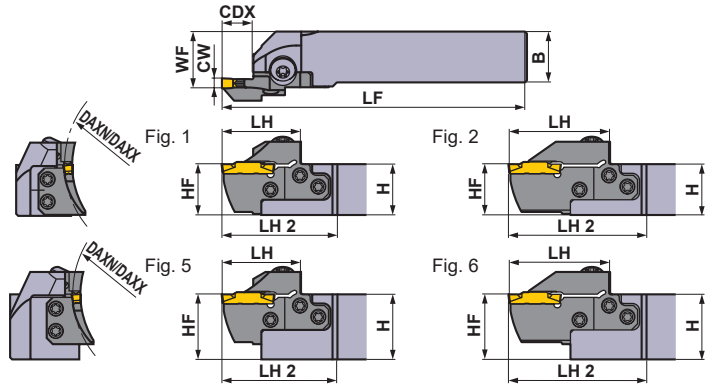
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{SS} _{GM}	Insert	GY2G ^{SS} _{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

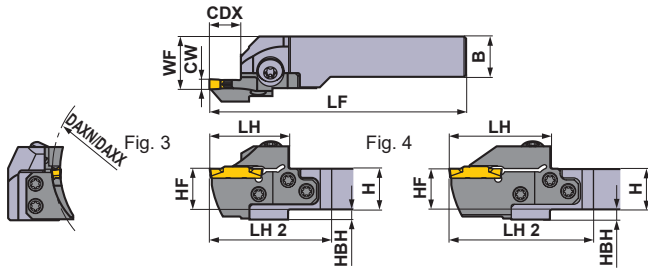
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	.236 .248 .250	1.969	2.756	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-050	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J14-050	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J14-050	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J14-050	●	1
		Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J14-050	●	5			
		Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J14-050	●	5			
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J14-050	●	5			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J14-050	●	5			
		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-070	●	3			
		Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J14-070	●	3			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J14-070	●	1			
		Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J14-070	●	1			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J14-070	●	5				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J14-070	●	5				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J14-070	●	5				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J14-070	●	5				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J25-070	●	4				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J25-070	●	4				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J25-070	●	2				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J25-070	●	2				
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J25-070	●	6				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J25-070	●	6				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J25-070	●	6				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J25-070	●	6				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-110	●	3				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J14-110	●	3				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J14-110	●	1				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J14-110	●	1				
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J14-110	●	5					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J14-110	●	5					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J14-110	●	5					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J14-110	●	5					
Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J25-110	●	4					
Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J25-110	●	4					
Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J25-110	●	2					
Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J25-110	●	2					
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J25-110	●	6					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J25-110	●	6					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J25-110	●	6					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J25-110	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

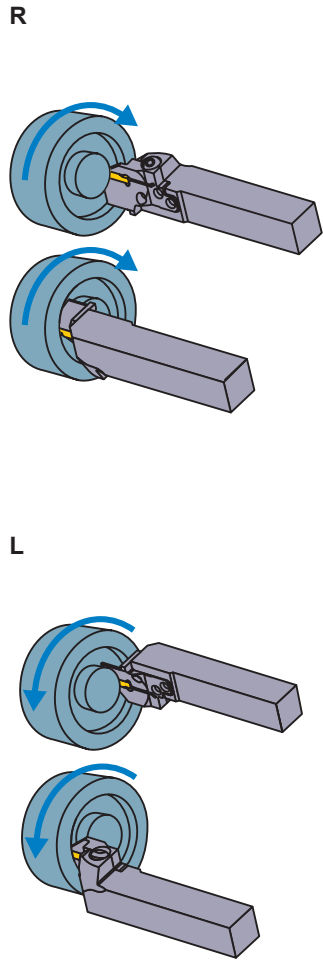


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1								Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH	
.750	.750	5.000	1.535	.241	.750	1.000	.250	R
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
.750	.750	5.000	1.535	.241	.750	1.000	.250	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
.750	.750	5.433	1.969	.674	.750	1.000	.250	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
J	236", 6.00 mm	●	●	●	●
	250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing) Ball nose
J	236", 6.00 mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	248", 6.31 mm	●			
	250", 6.35 mm				●
	RE .008"	●			
	RE .016"	●			
RE .031"	●				

● : Gauge insert shown dimensions

F

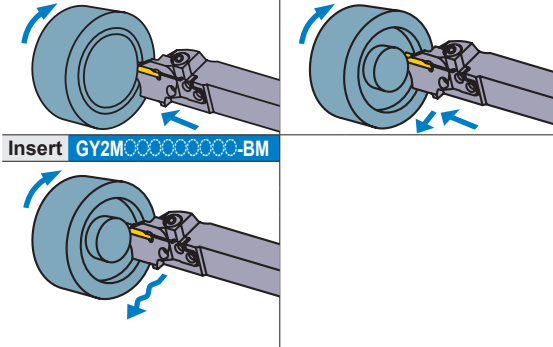
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

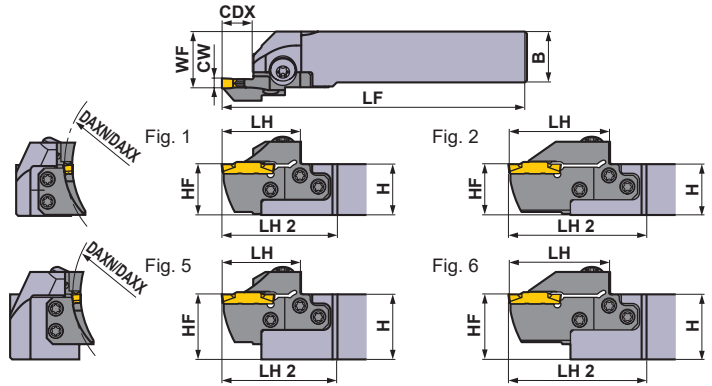
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{SS} _{GM}	Insert	GY2G ^{SS} _{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}



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



Right hand tool holder shown.

F
GROOVING / CUTTING OFF

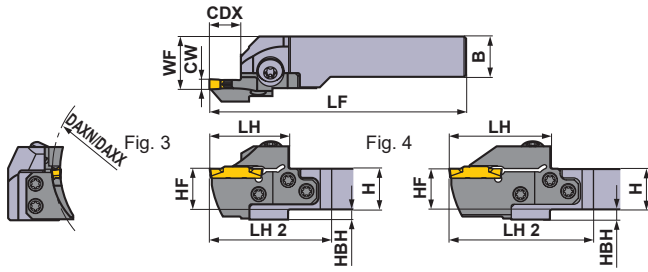
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	.236 .248 .250	6.693	11.024	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-170	●	3
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J14-170	●	3
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J14-170	●	1
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J14-170	●	1
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J14-170	●	5
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J14-170	●	5
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J14-170	●	5			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J14-170	●	5			
		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J25-170	●	4			
		Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J25-170	●	4			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J25-170	●	2			
		Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J25-170	●	2			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J25-170	●	6				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J25-170	●	6				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J25-170	●	6				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J25-170	●	6				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-250	●	3				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J14-250	●	3				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J14-250	●	1				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J14-250	●	1				
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J14-250	●	5				
	Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J14-250	●	5				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J14-250	●	5				
	Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J14-250	●	5				
Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J25-250	●	4					
Modular	L	GYHLUS12C00-M25L	●	GYM25LD-J25-250	●	4					
Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J25-250	●	2					
Modular	L	GYHLUS16D00-M25L	●	GYM25LD-J25-250	●	2					
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J25-250	●	6					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-J25-250	●	6					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-J25-250	●	6					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-J25-250	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

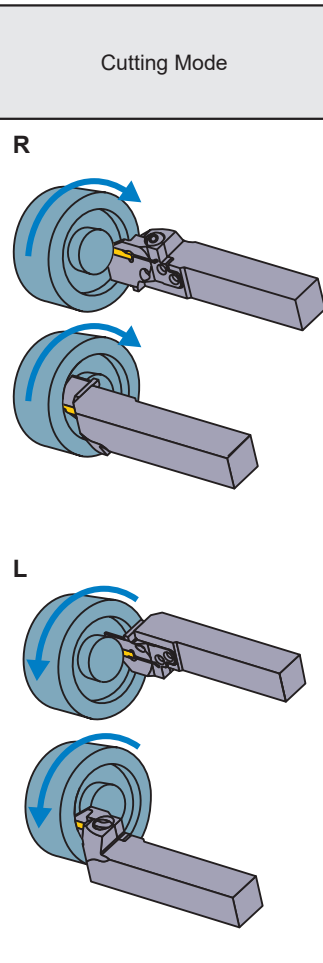


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/LUS12C00-M25R/L			
GYHR/LUS16D00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS20D00-M25R/L			
GYHR/LUS24E00-M25R/L			

Right hand tool holder shown.

Dimensions (inch) *1							
H	B	LF	LH	LH 2	HF	WF	HBH
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
.750	.750	5.000	1.535	.241	.750	1.000	.250
.750	.750	5.000	1.535	.241	.750	1.000	.250
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.000	1.000	6.000	1.535	1.241	1.000	1.125	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.250	1.250	6.000	1.535	1.241	1.250	1.375	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
1.500	1.500	7.000	1.535	2.241	1.500	1.625	—
.750	.750	5.433	1.969	.674	.750	1.000	.250
.750	.750	5.433	1.969	.674	.750	1.000	.250
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.000	1.000	6.433	1.969	1.674	1.000	1.125	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.250	1.250	6.433	1.969	1.674	1.250	1.375	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—
1.500	1.500	7.433	1.969	2.674	1.500	1.625	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
J	236", 6.00 mm	●	●	●	●
	250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing) Ball nose
J	236", 6.00 mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	248", 6.31 mm	●			
	250", 6.35 mm	●			●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

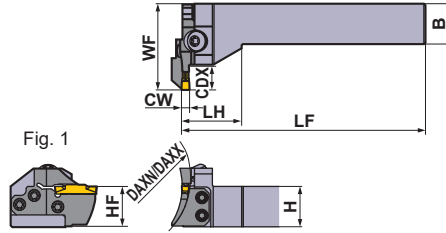
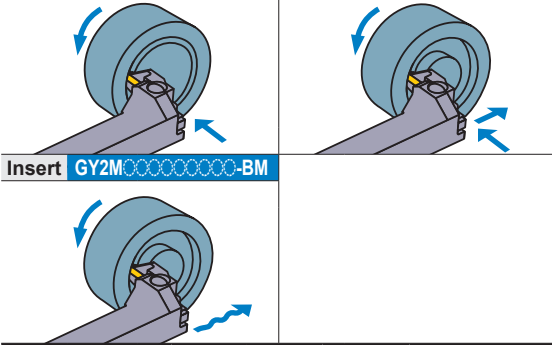
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{GM} -MF
Insert	GY2M ^{GU} _{GM}	Insert	GY2M ^{MS} _{GM}
Insert	GY1M ^{GM} _{GFS}	Insert	GY2M ^{MM} _{GM}

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	.079 .088	1.575	1.969	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-040	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-040	●	1
		1.969	2.362	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-050	●	1
		2.362	2.953	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-060	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-060	●	1
		2.953	3.937	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-075	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-075	●	1
		3.937	5.906	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-100	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-100	●	1
		5.315	7.874	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-135	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-135	●	1
		7.087	9.843	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-180	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-180	●	1
E	.094 .098 .108	1.575	1.969	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-040	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-040	●	1
		1.969	2.362	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-050	●	1
		2.362	2.953	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-060	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-060	●	1
		2.953	3.937	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-075	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-075	●	1
		3.937	5.906	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-100	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-100	●	1
		5.315	7.874	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-135	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-135	●	1
		7.087	9.843	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-E12-180	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-E12-180	●	1

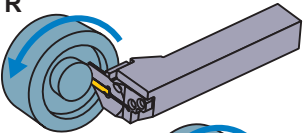

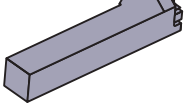
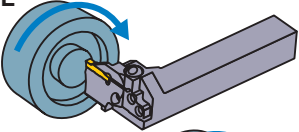
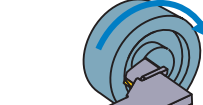
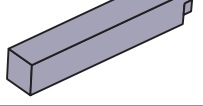
CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

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

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHRUS16D90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) *1						Cutting Mode
	H	B	LF	LH	HF	WF	
	1.000	1.000	6.000	1.500	1.000	2.094	R 
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	L 
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	
	1.000	1.000	6.000	1.500	1.000	2.094	

Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
D	.079", 2.00 mm	●	●	●	●
E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Reversing)
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●
E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●	●	●	●

● : Gauge insert shown dimensions



GROOVING / CUTTING OFF

IDENTIFICATION	> F008, F009
CUTTING CONDITIONS	> F206
INSTRUCTION MANUAL	> F208

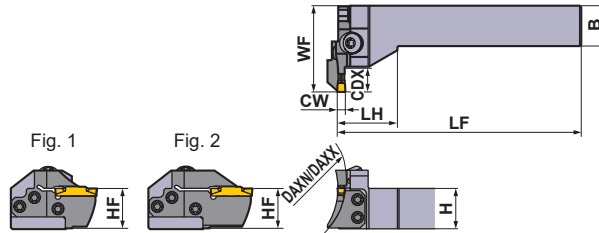
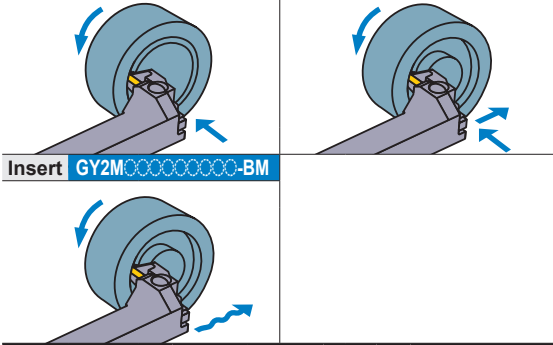
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{GM} -MF
Insert	GY2M ^{GU} _{GM}	Insert	GY2M ^{MS} _{GM}
Insert	GY1M ^{GM} _{GFS}	Insert	GY2M ^{MM} _{GM}

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	1.378	1.575	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-035	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-035	●	1
		1.575	1.969	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-040	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-040	●	1
		1.969	2.362	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-050	●	1
		2.362	2.953	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-060	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-060	●	1
		2.953	3.937	.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-060	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-F20-060	●	2
		3.937	5.906	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-075	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-075	●	1
		5.315	7.874	.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-075	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-F20-075	●	2
		7.087	9.843	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-100	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-100	●	1
		8.858	39.331	.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-100	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-F20-100	●	2
		7.087	9.843	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-135	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-135	●	1
8.858	39.331	.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-135	●	2		
				L	GYHLUS16D90-M25R	●	GYM25RD-F20-135	●	2		
7.087	9.843	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-180	●	1		
				L	GYHLUS16D90-M25R	●	GYM25RD-F12-180	●	1		
8.858	39.331	.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-180	●	2		
				L	GYHLUS16D90-M25R	●	GYM25RD-F20-180	●	2		
7.087	9.843	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-225	●	1		
				L	GYHLUS16D90-M25R	●	GYM25RD-F12-225	●	1		
8.858	39.331	.787*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F20-225	●	2		
				L	GYHLUS16D90-M25R	●	GYM25RD-F20-225	●	2		




CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

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

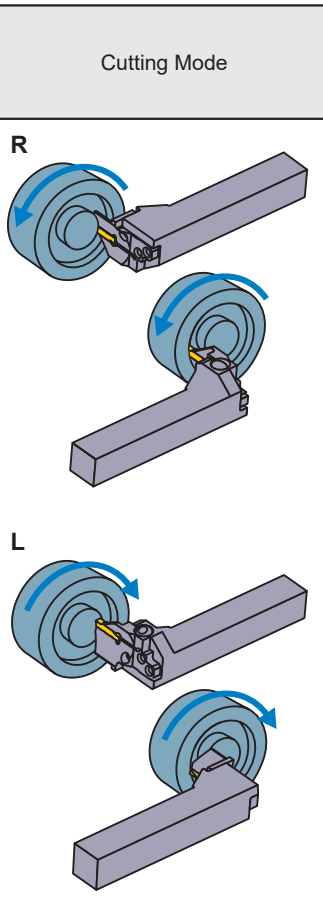
*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHRUS16D90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) *1					
	H	B	LF	LH	HF	WF
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.330
	1.000	1.000	6.000	1.500	1.000	2.330
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.330
	1.000	1.000	6.000	1.500	1.000	2.330
	1.000	1.000	6.000	1.500	1.000	2.330
	1.000	1.000	6.000	1.500	1.000	2.330
	1.000	1.000	6.000	1.500	1.000	2.330
	1.000	1.000	6.000	1.500	1.000	2.330
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.330
	1.000	1.000	6.000	1.500	1.000	2.330
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.330
	1.000	1.000	6.000	1.500	1.000	2.330



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
F	.118", 3.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions



GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

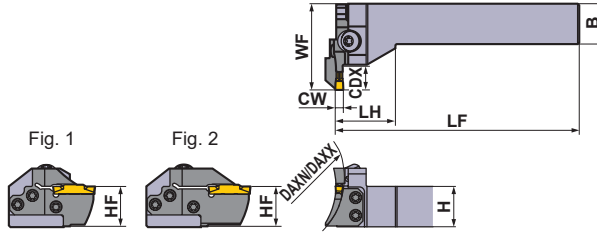
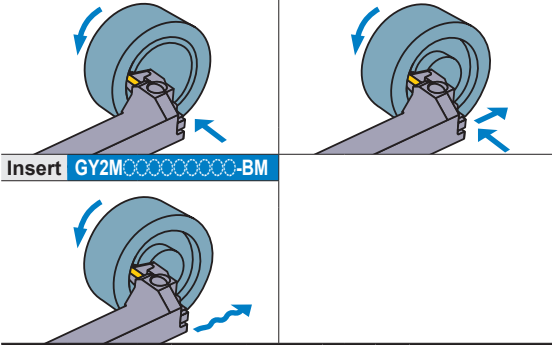
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1M ^{GM} _{GFS}	Insert	GY2M ^{MM}

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	.157 .167	1.575	1.969	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-040	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-040	●	1
		1.969	2.362	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-050	●	1
		2.362	3.346	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-060	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-060	●	1
		3.346	4.921	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G25-060	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-G25-060	●	2
				.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-085	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-085	●	1
		4.921	7.874	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G25-085	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-G25-085	●	2
				.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-125	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-125	●	1
		7.087	11.024	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G25-125	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-G25-125	●	2
				.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-180	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-180	●	1
		9.843	39.331	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G25-180	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-G25-180	●	2
				.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G14-250	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-G14-250	●	1
		.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-G25-250	●	2		
				L	GYHLUS16D90-M25R	●	GYM25RD-G25-250	●	2		




CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

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

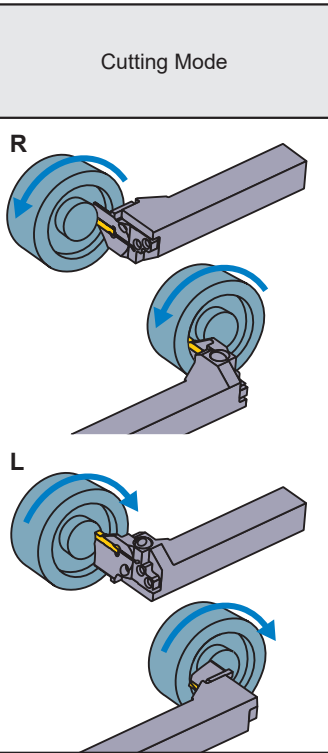
*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHRUS16D90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) *1					
	H	B	LF	LH	HF	WF
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.527



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
	G	.157", 4.00 mm	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
	G	.157", 4.00 mm			
RE .008"		●	●	●	
RE .016"		●	●	●	
RE .031"		●	●	●	
	.167", 4.24 mm	●			

● : Gauge insert shown dimensions

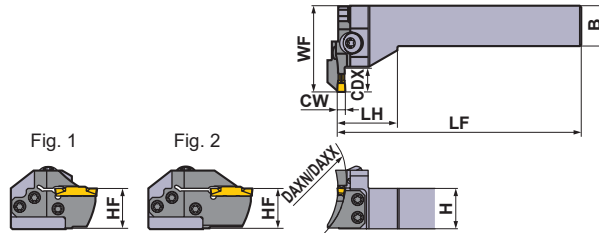
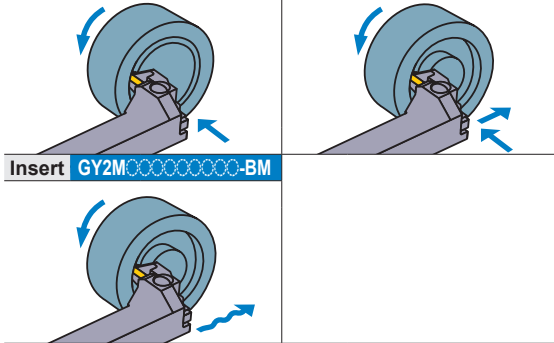
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

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

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

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1M ^{GM} _{GFS}	Insert	GY2M ^{MM}



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	1.969	2.362	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-050	●	1
		2.362	3.346	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-060	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-060	●	1
		3.346	4.921	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H25-060	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-H25-060	●	2
		4.921	7.874	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-085	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-085	●	1
		7.087	11.024	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H25-085	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-H25-085	●	2
		9.843	39.331	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-125	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-125	●	1
		9.843	39.331	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H25-125	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-H25-125	●	2
		9.843	39.331	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-180	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-180	●	1
		9.843	39.331	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H25-180	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-H25-180	●	2
		9.843	39.331	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H14-250	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-H14-250	●	1
		9.843	39.331	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-H25-250	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-H25-250	●	2




CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

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

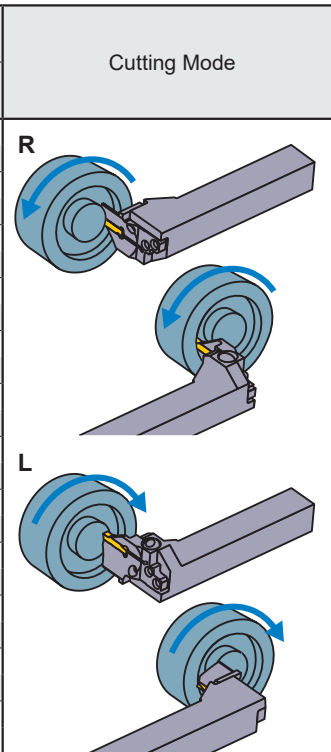
*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHRUS16D90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) *1					
	H	B	LF	LH	HF	WF
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.527



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescoring) Ball nose
H	.187", 4.75 mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00 mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

F
GROOVING / CUTTING OFF

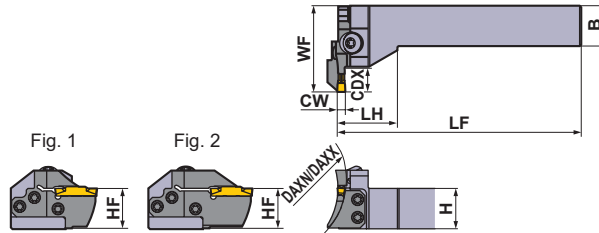
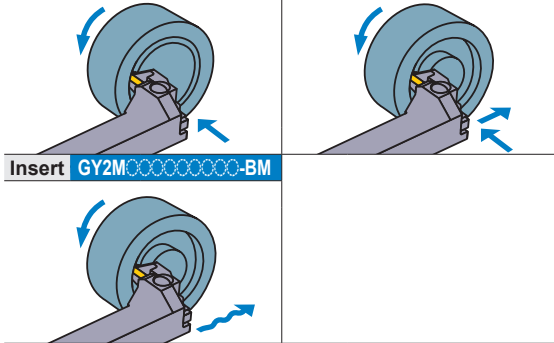
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

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

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

Insert	GY2M ^{SS} _{GM}	Insert	GY2G ^{SS} _{MF}
Insert	GY2M ^{SS} _{GU}	Insert	GY2M ^{SS} _{MS}
Insert	GY1G ^{SS} _{GFGS}	Insert	GY2M ^{SS} _{MM}



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	.236 .248 .250	1.969	2.756	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-050	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-J14-050	●	1
		2.756	4.331	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-070	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-J14-070	●	1
						R	GYHRUS16D90-M25L	●	GYM25LD-J25-070	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-J25-070	●	2
		4.331	7.874	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-110	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-J14-110	●	1
						R	GYHRUS16D90-M25L	●	GYM25LD-J25-110	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-J25-110	●	2
		6.693	11.024	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-170	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-J14-170	●	1
						R	GYHRUS16D90-M25L	●	GYM25LD-J25-170	●	2
						L	GYHLUS16D90-M25R	●	GYM25RD-J25-170	●	2
		9.843	39.331	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-250	●	1
						L	GYHLUS16D90-M25R	●	GYM25RD-J14-250	●	1
R	GYHRUS16D90-M25L					●	GYM25LD-J25-250	●	2		
L	GYHLUS16D90-M25R					●	GYM25RD-J25-250	●	2		




CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

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

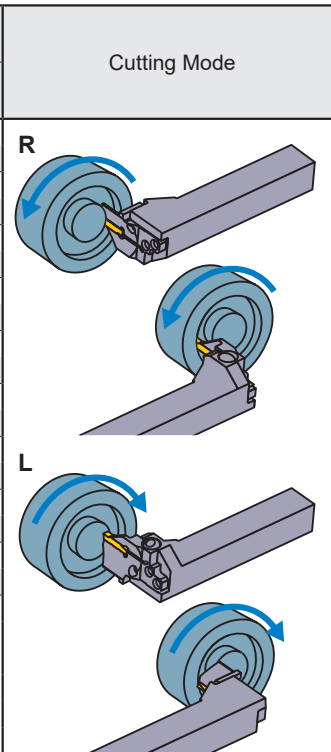
*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHRUS16D90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHLUS16D90-M25R			

	Dimensions (inch) ★1					
	H	B	LF	LH	HF	WF
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.094
	1.000	1.000	6.000	1.500	1.000	2.527
	1.000	1.000	6.000	1.500	1.000	2.527



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
J	236", 6.00 mm	●	●	●	●
	250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
J	236", 6.00 mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	248", 6.31 mm	●			
	250", 6.35 mm				●
	RE .008"	●			
	RE .016"	●			

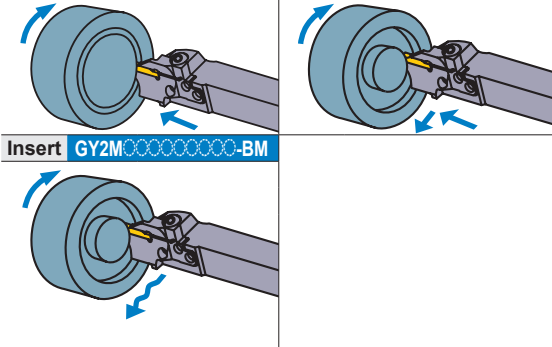
● : Gauge insert shown dimensions

F
GROOVING / CUTTING OFF

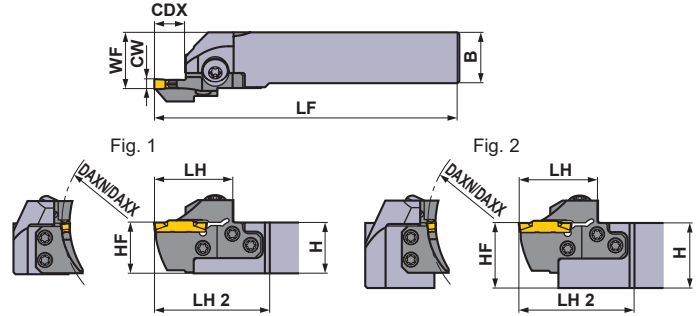
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{GS} -MF
Insert	GY2M ^{GL}	Insert	GY2M ^{GL} -MS
Insert	GY1M ^{GFGS}	Insert	GY2M ^{GFGS} -MM



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-040	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-040	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-040	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-040	●	1
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-040	●	2
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-D12-040	●	2
		Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-040	●	2			
		Modular	L	GYHL3232P00-M25L	●	GYM25LD-D12-040	●	2			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-050	●	3			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-050	●	3			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-050	●	1			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-050	●	1			
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-050	●	2				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-D12-050	●	2				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-050	●	2				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-D12-050	●	2				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-060	●	3				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-060	●	3				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-060	●	1				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-060	●	1				
Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-060	●	2					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-D12-060	●	2					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-060	●	2					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-D12-060	●	2					
Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-075	●	3					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-075	●	3					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-075	●	1					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-075	●	1					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-075	●	2					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-D12-075	●	2					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-075	●	2					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-D12-075	●	2					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

● : USA Stock ★ : Stocked in Japan

★ Wrench : ① : Clamp Screw, ② : Blade Screw

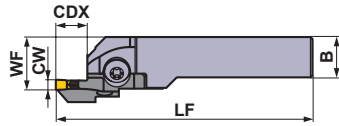
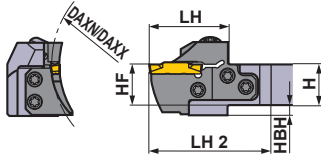





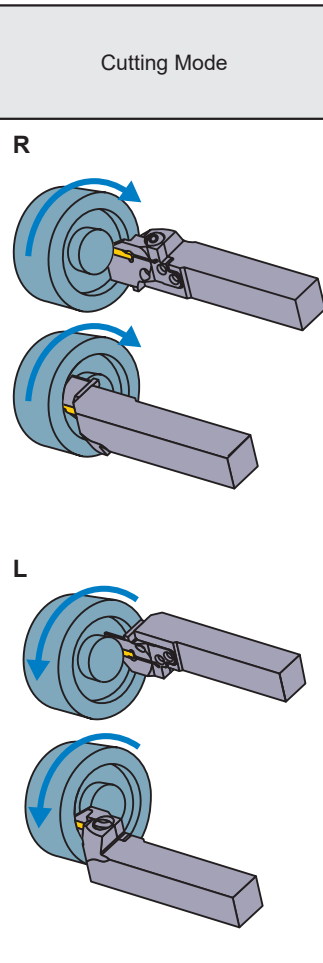
Fig. 3



Right hand tool holder shown.

SPARE PARTS			
Holder Number		 5 pcs.	 Wrench ★
	Clamp Screw	Blade Screw	
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) ★1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
D	.079", 2.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

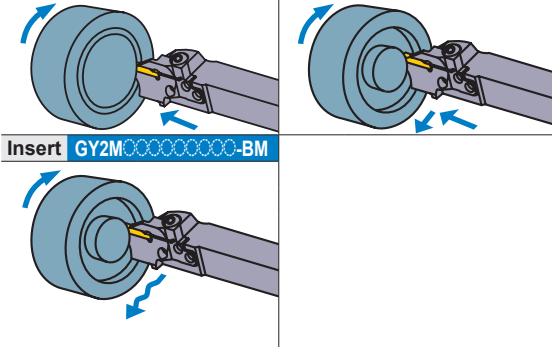
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

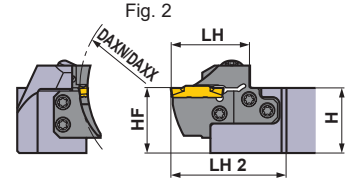
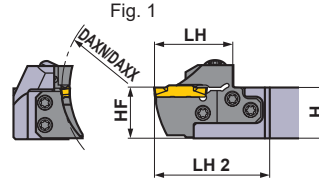
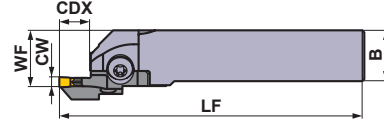
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{GS} -MF
Insert	GY2M ^{GL}	Insert	GY2M ^{GL} -MS
Insert	GY1M ^{GLS}	Insert	GY2M ^{GLS} -MM



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



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-100	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-D12-100	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-100	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-D12-100	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-100	●	2
						L	GYHL3225P00-M25L	★	GYM25LD-D12-100	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-100	●	2
						L	GYHL3232P00-M25L	★	GYM25LD-D12-100	●	2
	135	200	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-135	●	3	
					L	GYHL2020K00-M25L	●	GYM25LD-D12-135	●	3	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-135	●	1	
					L	GYHL2525M00-M25L	●	GYM25LD-D12-135	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-135	●	2	
					L	GYHL3225P00-M25L	★	GYM25LD-D12-135	●	2	
				Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-135	●	2	
					L	GYHL3232P00-M25L	★	GYM25LD-D12-135	●	2	
180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-180	●	3		
				L	GYHL2020K00-M25L	●	GYM25LD-D12-180	●	3		
			Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-180	●	1		
				L	GYHL2525M00-M25L	●	GYM25LD-D12-180	●	1		
			Modular	R	GYHR3225P00-M25R	★	GYM25RD-D12-180	●	2		
				L	GYHL3225P00-M25L	★	GYM25LD-D12-180	●	2		
			Modular	R	GYHR3232P00-M25R	★	GYM25RD-D12-180	●	2		
				L	GYHL3232P00-M25L	★	GYM25LD-D12-180	●	2		

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

F

GROOVING / CUTTING OFF

● : USA Stock ★ : Stocked in Japan

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

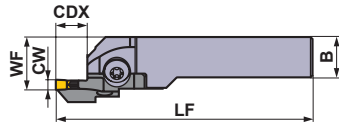
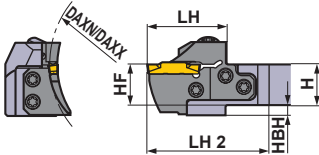


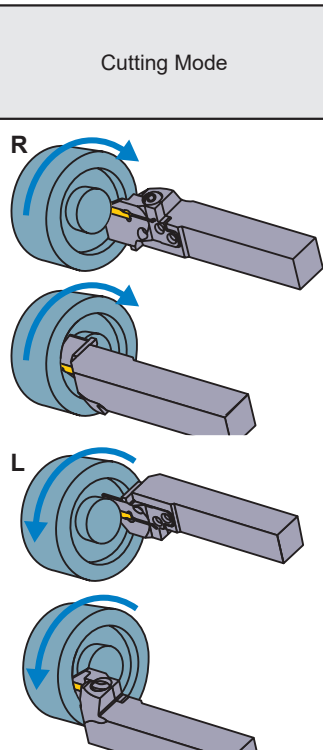
Fig. 3



Right hand tool holder shown.

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) *1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
D	.079", 2.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●

● : Gauge insert shown dimensions

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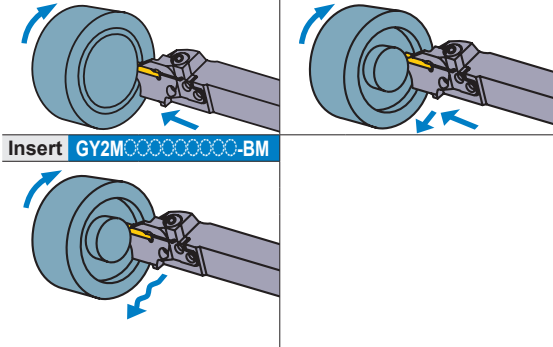
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

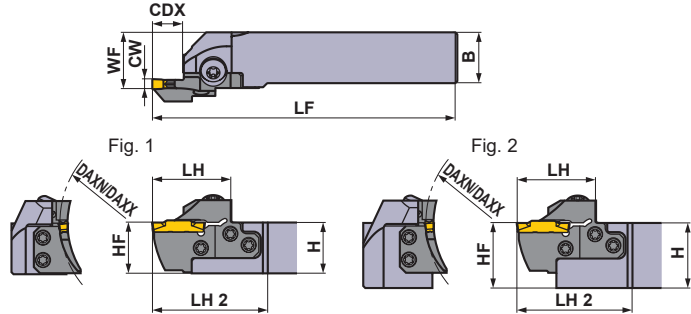
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{GS} -MF
Insert	GY2M ^{GL}	Insert	GY2M ^{GL} -MS
Insert	GY1M ^{GFS}	Insert	GY2M ^{GFS} -MM



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-040	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-E12-040	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-040	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-E12-040	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-E12-040	●	2
						L	GYHL3225P00-M25L	★	GYM25LD-E12-040	●	2
			R	GYHR3232P00-M25R	★	GYM25RD-E12-040	●	2			
			L	GYHL3232P00-M25L	★	GYM25LD-E12-040	●	2			
			R	GYHR2020K00-M25R	●	GYM25RD-E12-050	●	3			
			L	GYHL2020K00-M25L	●	GYM25LD-E12-050	●	3			
			R	GYHR2525M00-M25R	●	GYM25RD-E12-050	●	1			
			L	GYHL2525M00-M25L	●	GYM25LD-E12-050	●	1			
		R	GYHR3225P00-M25R	★	GYM25RD-E12-050	●	2				
		L	GYHL3225P00-M25L	★	GYM25LD-E12-050	●	2				
		R	GYHR3232P00-M25R	★	GYM25RD-E12-050	●	2				
		L	GYHL3232P00-M25L	★	GYM25LD-E12-050	●	2				
		R	GYHR2020K00-M25R	●	GYM25RD-E12-060	●	3				
		L	GYHL2020K00-M25L	●	GYM25LD-E12-060	●	3				
		R	GYHR2525M00-M25R	●	GYM25RD-E12-060	●	1				
		L	GYHL2525M00-M25L	●	GYM25LD-E12-060	●	1				
	R	GYHR3225P00-M25R	★	GYM25RD-E12-060	●	2					
	L	GYHL3225P00-M25L	★	GYM25LD-E12-060	●	2					
	R	GYHR3232P00-M25R	★	GYM25RD-E12-060	●	2					
	L	GYHL3232P00-M25L	★	GYM25LD-E12-060	●	2					
	R	GYHR2020K00-M25R	●	GYM25RD-E12-075	●	3					
	L	GYHL2020K00-M25L	●	GYM25LD-E12-075	●	3					
	R	GYHR2525M00-M25R	●	GYM25RD-E12-075	●	1					
	L	GYHL2525M00-M25L	●	GYM25LD-E12-075	●	1					
	R	GYHR3225P00-M25R	★	GYM25RD-E12-075	●	2					
	L	GYHL3225P00-M25L	★	GYM25LD-E12-075	●	2					
	R	GYHR3232P00-M25R	★	GYM25RD-E12-075	●	2					
	L	GYHL3232P00-M25L	★	GYM25LD-E12-075	●	2					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

● : USA Stock ★ : Stocked in Japan

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

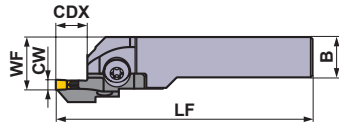
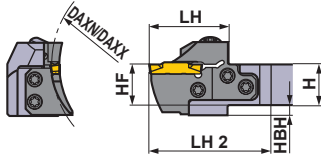


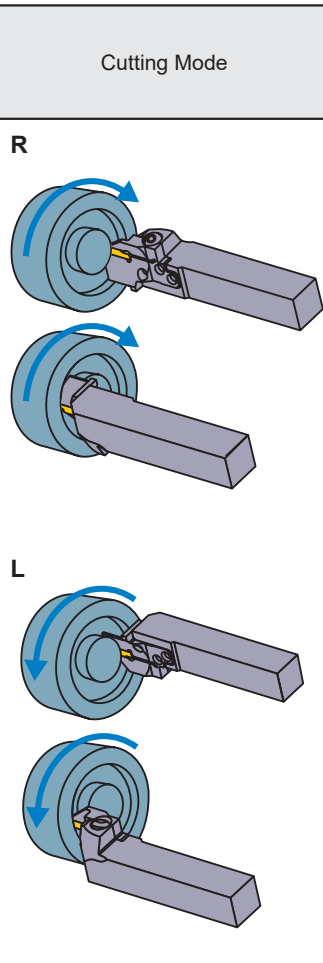
Fig. 3



Right hand tool holder shown.

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) *1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
E	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

F

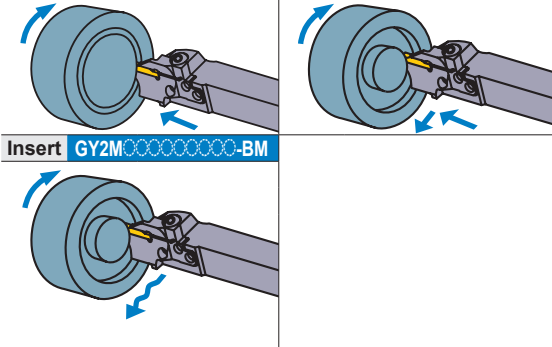
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

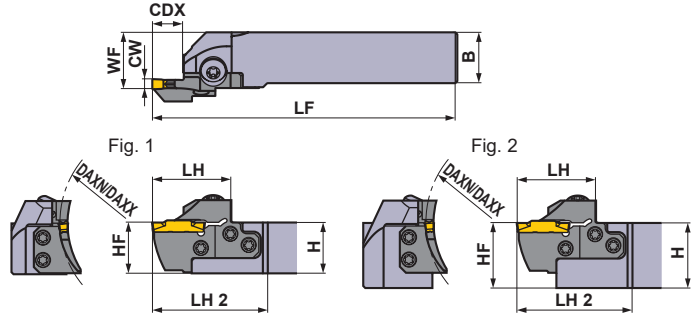
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{GM} -MF
Insert	GY2M ^{GU} _{GM}	Insert	GY2M ^{GU} _{GM} -MS
Insert	GY1 ^M _{1G} ^{GM} _{GFS}	Insert	GY2M ^{GM} _{GFS} -MM



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



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-100	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-E12-100	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-100	●	1
						L	GYHL2525M00-M25L	●	GYM25LD-E12-100	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-E12-100	●	2
						L	GYHL3225P00-M25L	★	GYM25LD-E12-100	●	2
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-E12-100	●	2
						L	GYHL3232P00-M25L	★	GYM25LD-E12-100	●	2
	135	200	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-135	●	3	
					L	GYHL2020K00-M25L	●	GYM25LD-E12-135	●	3	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-135	●	1	
					L	GYHL2525M00-M25L	●	GYM25LD-E12-135	●	1	
				Modular	R	GYHR3225P00-M25R	★	GYM25RD-E12-135	●	2	
					L	GYHL3225P00-M25L	★	GYM25LD-E12-135	●	2	
				Modular	R	GYHR3232P00-M25R	★	GYM25RD-E12-135	●	2	
					L	GYHL3232P00-M25L	★	GYM25LD-E12-135	●	2	
180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-180	●	3		
				L	GYHL2020K00-M25L	●	GYM25LD-E12-180	●	3		
			Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-180	●	1		
				L	GYHL2525M00-M25L	●	GYM25LD-E12-180	●	1		
			Modular	R	GYHR3225P00-M25R	★	GYM25RD-E12-180	●	2		
				L	GYHL3225P00-M25L	★	GYM25LD-E12-180	●	2		
			Modular	R	GYHR3232P00-M25R	★	GYM25RD-E12-180	●	2		
				L	GYHL3232P00-M25L	★	GYM25LD-E12-180	●	2		

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

F

GROOVING / CUTTING OFF

● : USA Stock ★ : Stocked in Japan

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

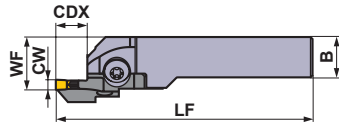
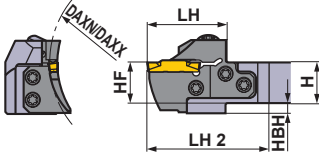


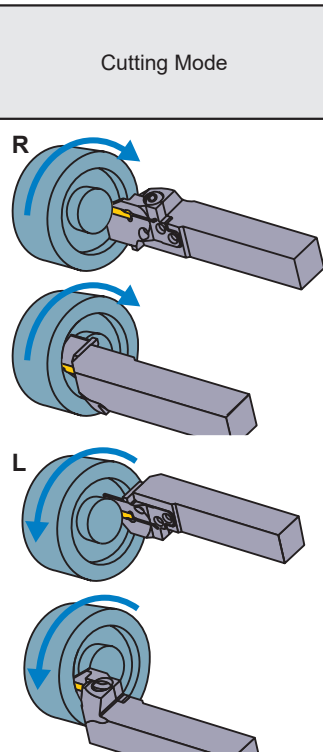
Fig. 3



Right hand tool holder shown.

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) *1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Reversing) Ball nose
E	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

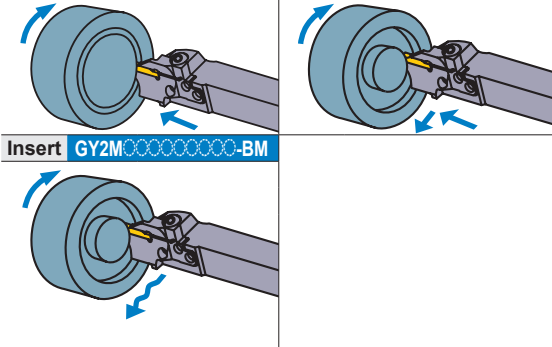
F

GROOVING / CUTTING OFF

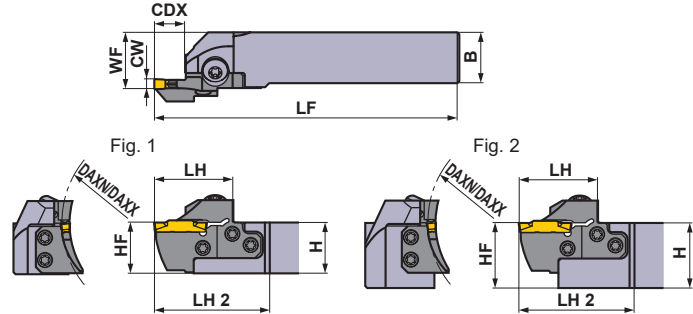
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{GM} -MF
Insert	GY2M ^{GU} _{GM}	Insert	GY2M ^{GU} _{GM} -MS
Insert	GY1 ^{GM} _{GFGS}	Insert	GY2M ^{GM} _{GFGS} -MM



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



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	35	40	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-035	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-035	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-035	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-035	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-035	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-035	●	2
		40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-040	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-040	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-040	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-040	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-040	●	2
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-040	●	2
	50	60	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-050	●	3	
				Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-050	●	3	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-050	●	1	
				Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-050	●	1	
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-050	●	2				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-050	●	2				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-050	●	2				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-050	●	2				

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

F

GROOVING / CUTTING OFF

● : USA Stock ★ : Stocked in Japan

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

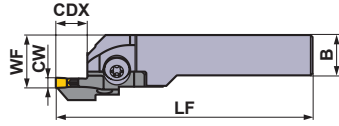
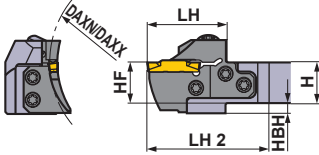


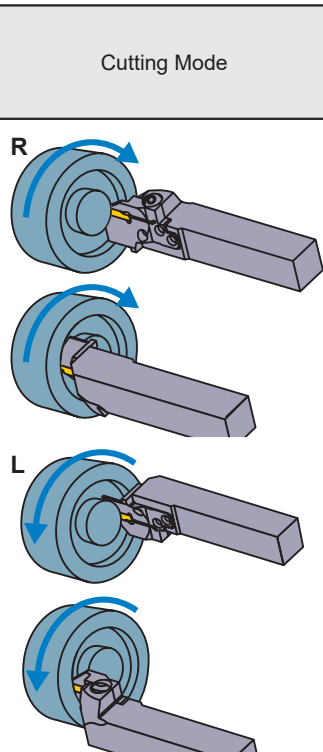
Fig. 3



Right hand tool holder shown.

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) *1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
F	.118", 3.00 mm				●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm		●	●	
	.125", 3.18 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

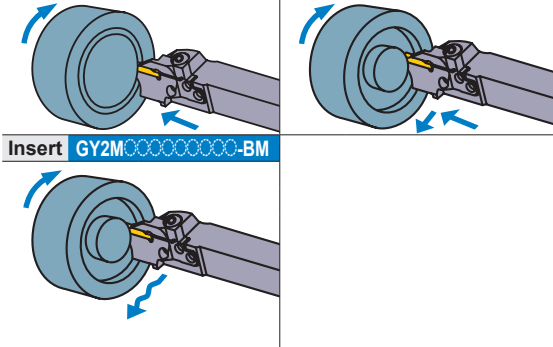
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GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

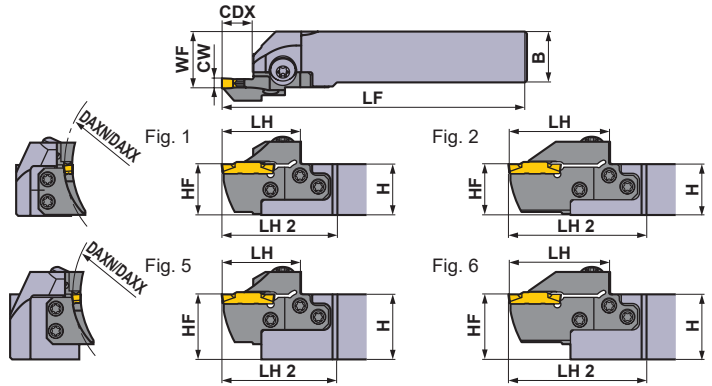
4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^M _{1G} ^{GM} _{GFS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

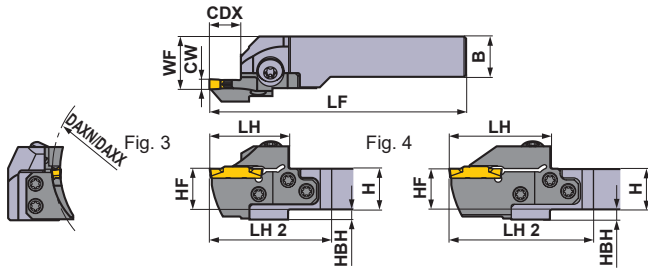
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	60	75	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-060	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-060	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-060	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-060	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-060	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-060	●	5
		Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-060	●	5			
		Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-060	●	5			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-060	●	4			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-060	●	4			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-060	●	2			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-060	●	2			
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-060	●	6				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-060	●	6				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-060	●	6				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-060	●	6				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-075	●	3				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-075	●	3				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-075	●	1				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-075	●	1				
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-075	●	5				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-075	●	5				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-075	●	5				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-075	●	5				
Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-075	●	4					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-075	●	4					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-075	●	2					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-075	●	2					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-075	●	6					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-075	●	6					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-075	●	6					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-075	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

★2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan

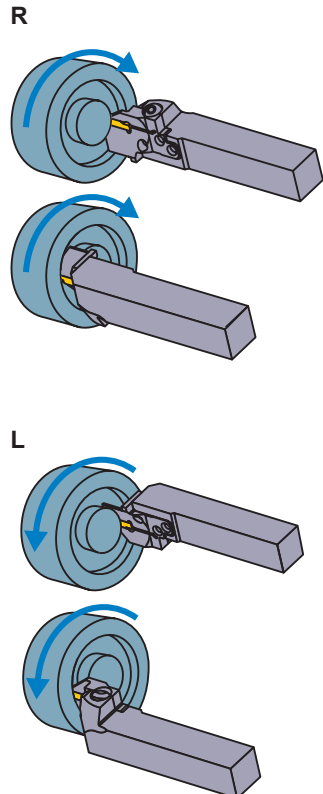


★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench ★
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) ★1									Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	131	45	66	20	26	5	R	
20	20	131	45	66	20	26	5	R	
25	25	156	45	63	25	28	—	R	
25	25	156	45	63	25	28	—	R	
32	25	176	45	63	32	28	—	R	
32	25	176	45	63	32	28	—	R	
32	32	176	45	63	32	35	—	R	
32	32	176	45	63	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	131	45	66	20	26	5	L	
20	20	131	45	66	20	26	5	L	
25	25	156	45	63	25	28	—	L	
25	25	156	45	63	25	28	—	L	
32	25	176	45	63	32	28	—	L	
32	25	176	45	63	32	28	—	L	
32	32	176	45	63	32	35	—	L	
32	32	176	45	63	32	35	—	L	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
F	.118", 3.00 mm				●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm		●	●	
	.125", 3.18 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

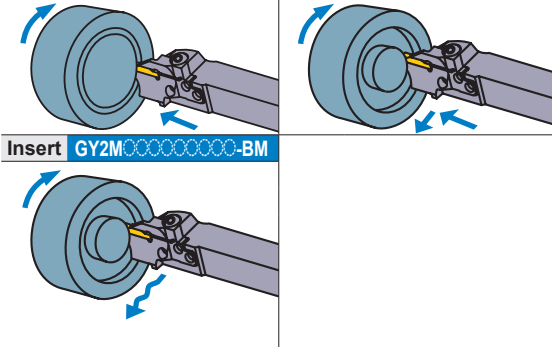
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GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

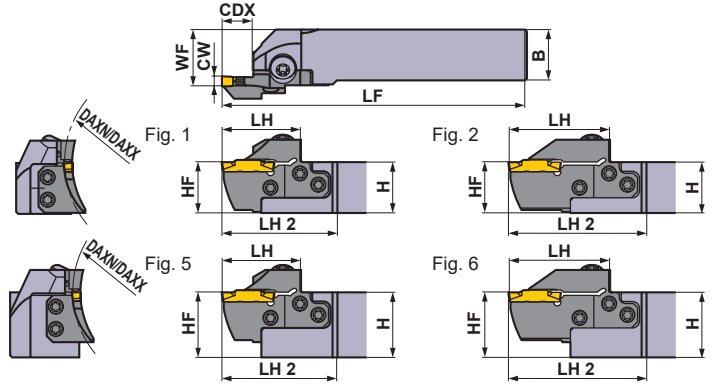
4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{1G}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

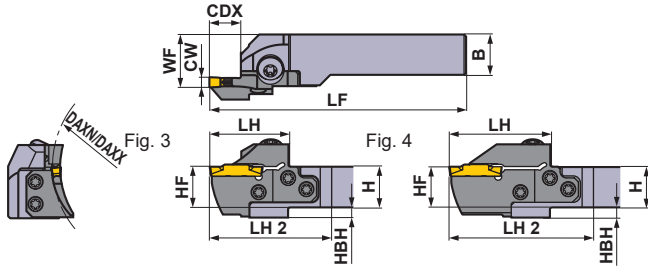
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-100	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-100	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-100	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-100	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-100	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-100	●	5
		Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-100	●	5			
		Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-100	●	5			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-100	●	4			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-100	●	4			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-100	●	2			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-100	●	2			
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-100	●	6				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-100	●	6				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-100	●	6				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-100	●	6				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-135	●	3				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-135	●	3				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-135	●	1				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-135	●	1				
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-135	●	5				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-135	●	5				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-135	●	5				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-135	●	5				
Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-135	●	4					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-135	●	4					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-135	●	2					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-135	●	2					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-135	●	6					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-135	●	6					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-135	●	6					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-135	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

★2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan

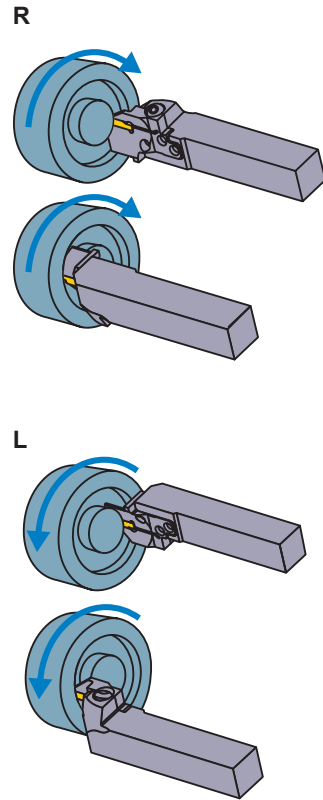


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH		
20	20	125	39	60	20	26	5	R	
20	20	125	39	60	20	26	5	R	
25	25	150	39	57	25	28	—	R	
25	25	150	39	57	25	28	—	R	
32	25	170	39	57	32	28	—	R	
32	25	170	39	57	32	28	—	R	
32	32	170	39	57	32	35	—	R	
32	32	170	39	57	32	35	—	R	
20	20	131	45	66	20	26	5	R	
20	20	131	45	66	20	26	5	R	
25	25	156	45	63	25	28	—	R	
25	25	156	45	63	25	28	—	R	
32	25	176	45	63	32	28	—	R	
32	25	176	45	63	32	28	—	R	
32	32	176	45	63	32	35	—	R	
32	32	176	45	63	32	35	—	R	
20	20	125	39	60	20	26	5	L	
20	20	125	39	60	20	26	5	L	
25	25	150	39	57	25	28	—	L	
25	25	150	39	57	25	28	—	L	
32	25	170	39	57	32	28	—	L	
32	25	170	39	57	32	28	—	L	
32	32	170	39	57	32	35	—	L	
32	32	170	39	57	32	35	—	L	
20	20	131	45	66	20	26	5	L	
20	20	131	45	66	20	26	5	L	
25	25	156	45	63	25	28	—	L	
25	25	156	45	63	25	28	—	L	
32	25	176	45	63	32	28	—	L	
32	25	176	45	63	32	28	—	L	
32	32	176	45	63	32	35	—	L	
32	32	176	45	63	32	35	—	L	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
F	.118", 3.00 mm				●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm			●	
	.125", 3.18 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

F

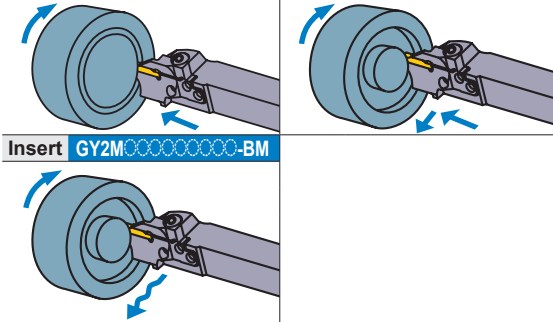
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

GY SERIES (FACE GROOVING)

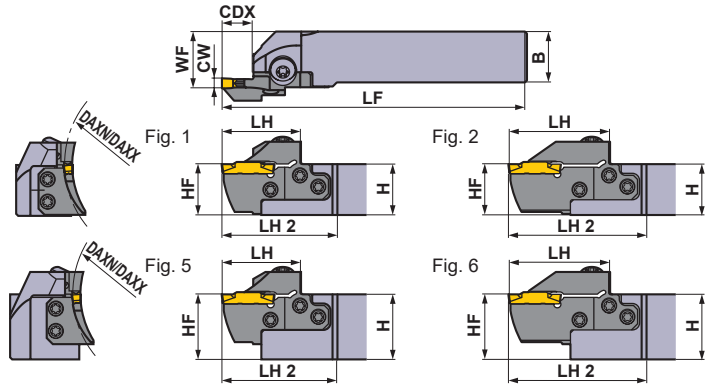
4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{1G}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

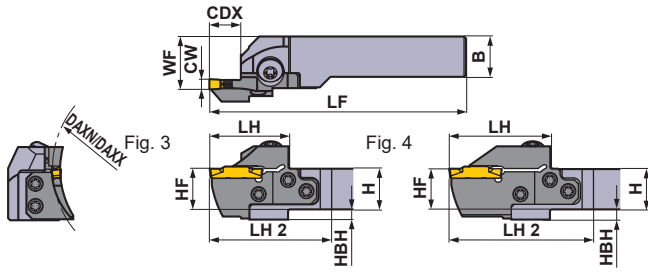
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-180	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-180	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-180	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-180	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-180	●	5
		Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-180	●	5			
		Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-180	●	5			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-180	●	4			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-180	●	4			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-180	●	2			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-180	●	2			
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-180	●	6				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-180	●	6				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-180	●	6				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-180	●	6				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-225	●	3				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-225	●	3				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-225	●	1				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-225	●	1				
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-F12-225	●	5				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-F12-225	●	5				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-F12-225	●	5				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-F12-225	●	5				
Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-225	●	4					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-225	●	4					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-225	●	2					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-225	●	2					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-F20-225	●	6					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-F20-225	●	6					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-F20-225	●	6					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-F20-225	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

★2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan

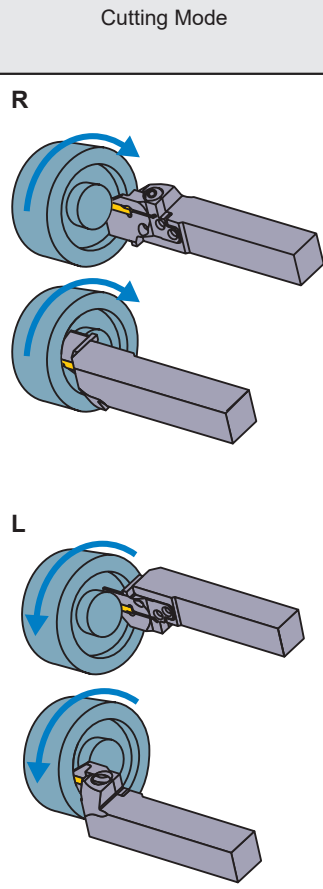


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1								
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	131	45	66	20	26	5	
20	20	131	45	66	20	26	5	
25	25	156	45	63	25	28	—	
25	25	156	45	63	25	28	—	
32	25	176	45	63	32	28	—	
32	25	176	45	63	32	28	—	
32	32	176	45	63	32	35	—	
32	32	176	45	63	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	131	45	66	20	26	5	
20	20	131	45	66	20	26	5	
25	25	156	45	63	25	28	—	
25	25	156	45	63	25	28	—	
32	25	176	45	63	32	28	—	
32	25	176	45	63	32	28	—	
32	32	176	45	63	32	35	—	
32	32	176	45	63	32	35	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
F	.118", 3.00 mm				●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm			●	
	.125", 3.18 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

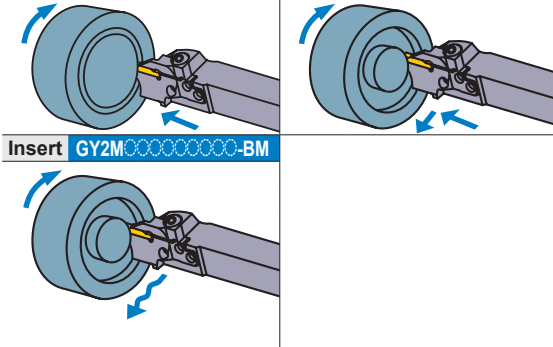
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GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

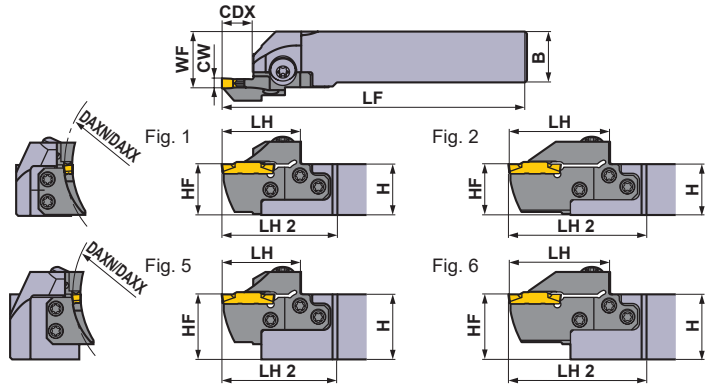
4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{1G}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

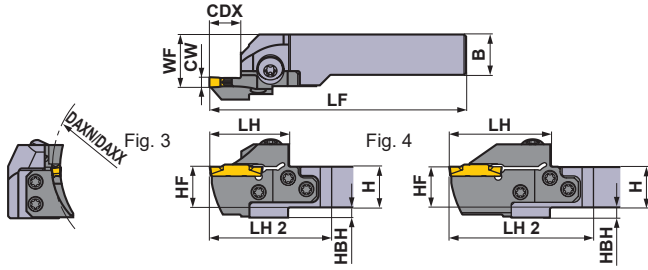
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.	
							Holder	Stock	Modular Blade	Stock		
G	4.00	40	50	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-040	●	3	
						L	GYHL2020K00-M25L	●	GYM25LD-G14-040	●	3	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-040	●	1	
						L	GYHL2525M00-M25L	●	GYM25LD-G14-040	●	1	
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-040	●	5	
						L	GYHL3225P00-M25L	★	GYM25LD-G14-040	●	5	
			50	60	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-050	●	3
						L	GYHL2020K00-M25L	●	GYM25LD-G14-050	●	3	
		Modular				R	GYHR2525M00-M25R	●	GYM25RD-G14-050	●	1	
						L	GYHL2525M00-M25L	●	GYM25LD-G14-050	●	1	
		Modular				R	GYHR3225P00-M25R	★	GYM25RD-G14-050	●	5	
						L	GYHL3225P00-M25L	★	GYM25LD-G14-050	●	5	
		60	85	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-060	●	3	
					L	GYHL2020K00-M25L	●	GYM25LD-G14-060	●	3		
	Modular				R	GYHR2525M00-M25R	●	GYM25RD-G14-060	●	1		
					L	GYHL2525M00-M25L	●	GYM25LD-G14-060	●	1		
				25 *2	Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-060	●	5	
					L	GYHL3225P00-M25L	★	GYM25LD-G14-060	●	5		
	Modular				R	GYHR3232P00-M25R	★	GYM25RD-G14-060	●	5		
					L	GYHL3232P00-M25L	★	GYM25LD-G14-060	●	5		
	25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-060	●	4				
		L	GYHL2020K00-M25L	●	GYM25LD-G25-060	●	4					
Modular		R	GYHR2525M00-M25R	●	GYM25RD-G25-060	●	2					
		L	GYHL2525M00-M25L	●	GYM25LD-G25-060	●	2					
	25 *2	Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-060	●	6				
		L	GYHL3225P00-M25L	★	GYM25LD-G25-060	●	6					
Modular		R	GYHR3232P00-M25R	★	GYM25RD-G25-060	●	6					
		L	GYHL3232P00-M25L	★	GYM25LD-G25-060	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan

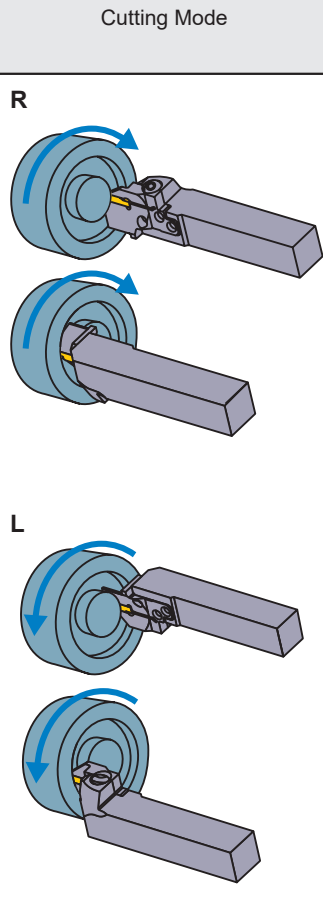


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) *1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing) Ball nose
G	.157", 4.00 mm				●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.167", 4.24 mm	●			

● : Gauge insert shown dimensions

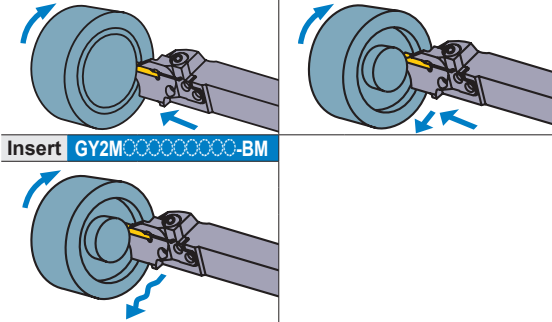
F

GROOVING / CUTTING OFF

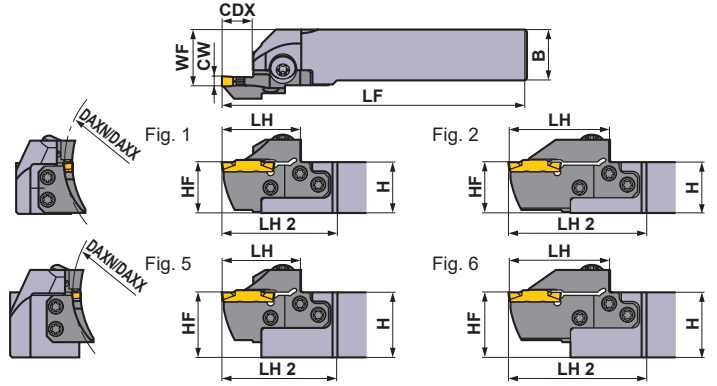
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{1G}	Insert	GY2M ^{MM}



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

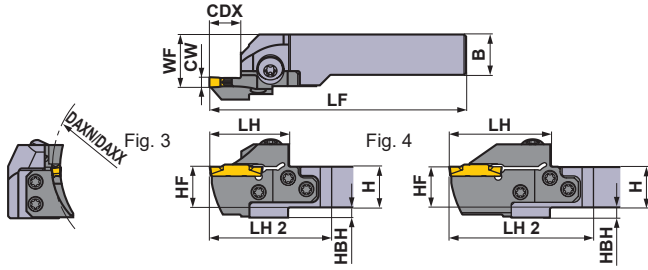
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.	
							Holder	Stock	Modular Blade	Stock		
G	4.00	85	125	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-085	●	3	
						L	GYHL2020K00-M25L	●	GYM25LD-G14-085	●	3	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-085	●	1	
						L	GYHL2525M00-M25L	●	GYM25LD-G14-085	●	1	
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-085	●	5	
						L	GYHL3225P00-M25L	★	GYM25LD-G14-085	●	5	
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-085	●	5	
						L	GYHL3232P00-M25L	★	GYM25LD-G14-085	●	5	
					25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-085	●	4
							L	GYHL2020K00-M25L	●	GYM25LD-G25-085	●	4
	Modular	R	GYHR2525M00-M25R	●		GYM25RD-G25-085	●	2				
		L	GYHL2525M00-M25L	●		GYM25LD-G25-085	●	2				
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-085	●	6					
		L	GYHL3225P00-M25L	★	GYM25LD-G25-085	●	6					
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-085	●	6					
		L	GYHL3232P00-M25L	★	GYM25LD-G25-085	●	6					
	4.24	125	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-125	●	3	
						L	GYHL2020K00-M25L	●	GYM25LD-G14-125	●	3	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-125	●	1	
						L	GYHL2525M00-M25L	●	GYM25LD-G14-125	●	1	
Modular					R	GYHR3225P00-M25R	★	GYM25RD-G14-125	●	5		
					L	GYHL3225P00-M25L	★	GYM25LD-G14-125	●	5		
Modular					R	GYHR3232P00-M25R	★	GYM25RD-G14-125	●	5		
					L	GYHL3232P00-M25L	★	GYM25LD-G14-125	●	5		
25 *2					Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-125	●	4	
						L	GYHL2020K00-M25L	●	GYM25LD-G25-125	●	4	
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-125	●	2					
		L	GYHL2525M00-M25L	●	GYM25LD-G25-125	●	2					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-125	●	6						
	L	GYHL3225P00-M25L	★	GYM25LD-G25-125	●	6						
Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-125	●	6						
	L	GYHL3232P00-M25L	★	GYM25LD-G25-125	●	6						

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan

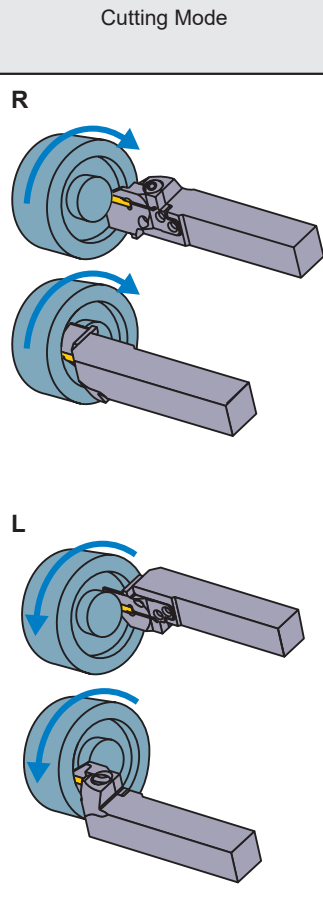


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) *1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
G	.157", 4.00 mm				●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.167", 4.24 mm	●			

● : Gauge insert shown dimensions

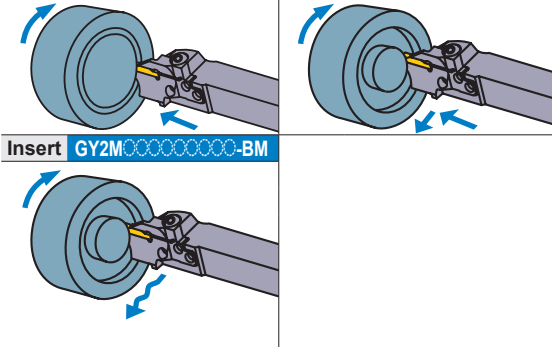
F

GROOVING / CUTTING OFF

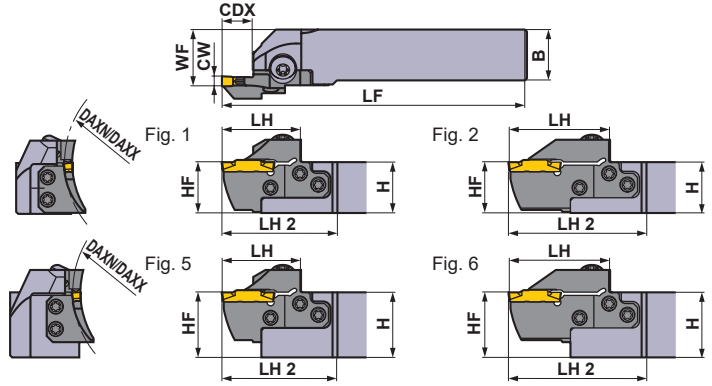
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^M _{1G} ^{GMS}	Insert	GY2M ^{MM}



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

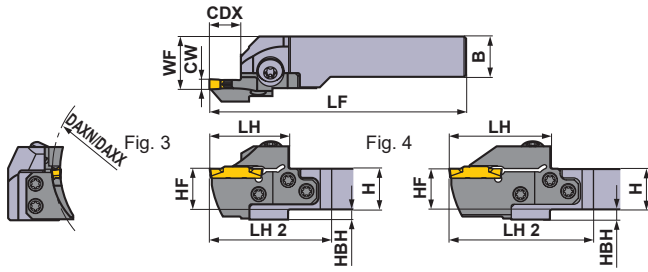
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	4.00	180	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-180	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-180	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-180	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-180	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-G14-180	●	5
				Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-180	●	5	
				Modular	L	GYHL3232P00-M25L	★	GYM25LD-G14-180	●	5	
				Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-180	●	4	
				Modular	L	GYHL2020K00-M25L	●	GYM25LD-G25-180	●	4	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-180	●	2	
				Modular	L	GYHL2525M00-M25L	●	GYM25LD-G25-180	●	2	
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-180	●	6				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-G25-180	●	6				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-180	●	6				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-G25-180	●	6				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-250	●	3				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-250	●	3				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-250	●	1				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-250	●	1				
Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-250	●	5					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-G14-250	●	5					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-250	●	5					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-G14-250	●	5					
Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-250	●	4					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-G25-250	●	4					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-250	●	2					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-G25-250	●	2					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-250	●	6					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-G25-250	●	6					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-250	●	6					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-G25-250	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

★2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan

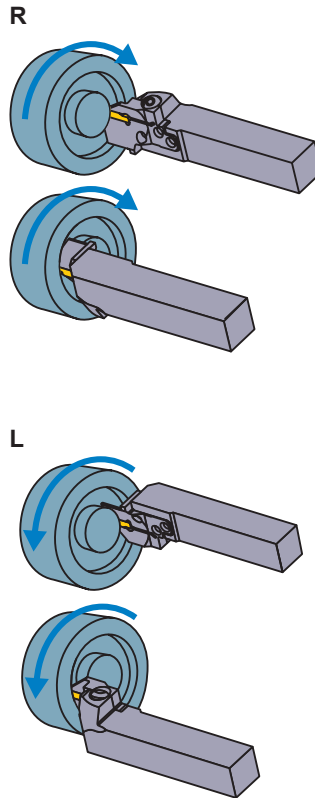


★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1									Cutting Mode
H	B	LF	LH	LH 2	HF	WF	HBH		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		
20	20	125	39	60	20	26	5		
20	20	125	39	60	20	26	5		
25	25	150	39	57	25	28	—		
25	25	150	39	57	25	28	—		
32	25	170	39	57	32	28	—		
32	25	170	39	57	32	28	—		
32	32	170	39	57	32	35	—		
32	32	170	39	57	32	35	—		
20	20	136	50	71	20	26	5		
20	20	136	50	71	20	26	5		
25	25	161	50	68	25	28	—		
25	25	161	50	68	25	28	—		
32	25	181	50	68	32	28	—		
32	25	181	50	68	32	28	—		
32	32	181	50	68	32	35	—		
32	32	181	50	68	32	35	—		



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing) Ball nose
G	.157", 4.00 mm	●	●	●	●
	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	RE 0.8 mm	●	●	●	●
	.167", 4.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

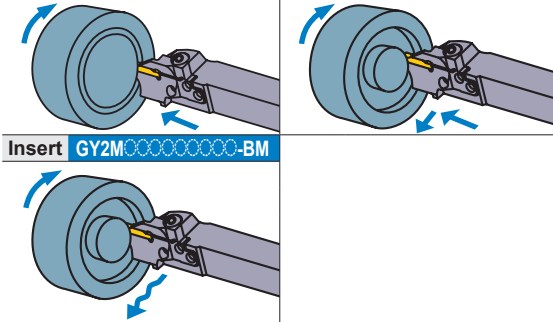
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

GY SERIES (FACE GROOVING)

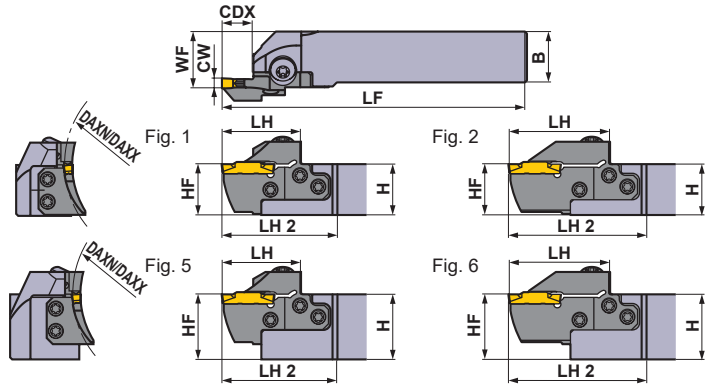
4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	50	60	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-050	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-050	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-050	●	1
		Modular	R	GYHR3225P00-M25R	★	GYM25RD-H14-050	●	5			
		Modular	L	GYHL3225P00-M25L	★	GYM25LD-H14-050	●	5			
		Modular	R	GYHR3232P00-M25R	★	GYM25RD-H14-050	●	5			
		Modular	L	GYHL3232P00-M25L	★	GYM25LD-H14-050	●	5			
	60	85	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-060	●	3	
				Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-060	●	3	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-060	●	1	
				Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-060	●	1	
		Modular	R	GYHR3225P00-M25R	★	GYM25RD-H14-060	●	5			
		Modular	L	GYHL3225P00-M25L	★	GYM25LD-H14-060	●	5			
		Modular	R	GYHR3232P00-M25R	★	GYM25RD-H14-060	●	5			
		Modular	L	GYHL3232P00-M25L	★	GYM25LD-H14-060	●	5			
25 *2			Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-060	●	4		
			Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-060	●	4		
			Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-060	●	2		
			Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-060	●	2		
Modular	R	GYHR3225P00-M25R	★	GYM25RD-H25-060	●	6					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-H25-060	●	6					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-H25-060	●	6					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-H25-060	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

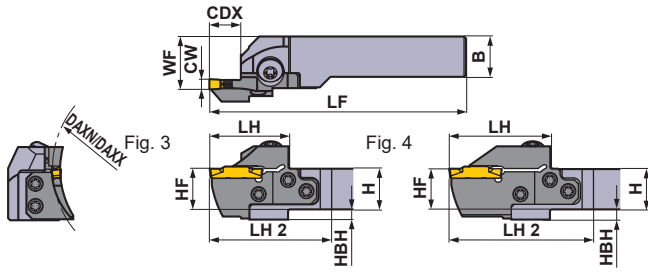
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

F

GROOVING / CUTTING OFF

● : USA Stock ★ : Stocked in Japan

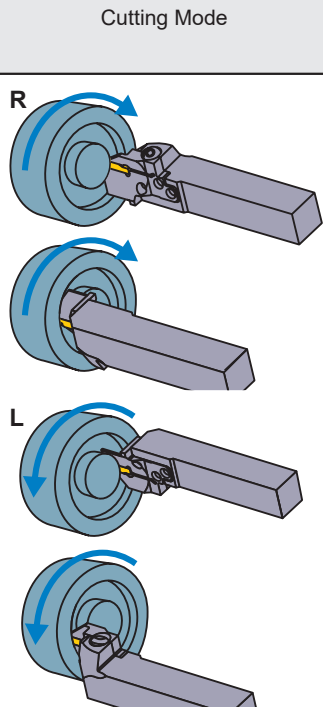


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) *1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing) Ball nose
H	.187", 4.75 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			
	.197", 5.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

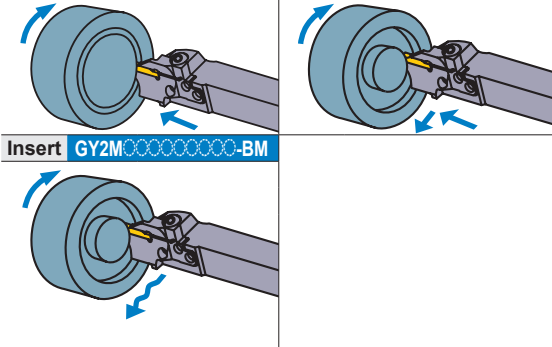
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GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

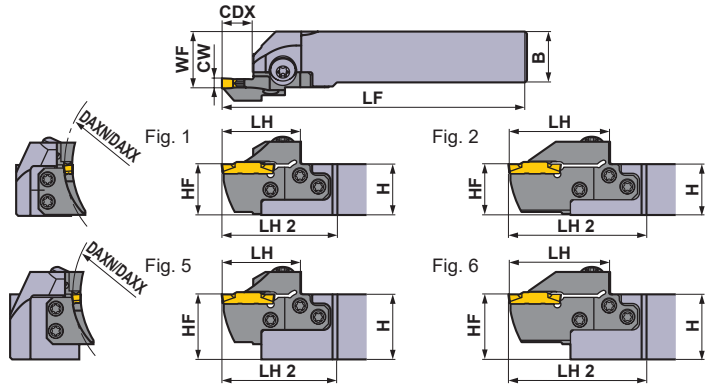
4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

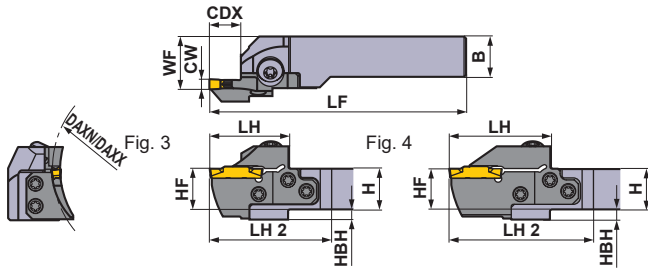
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	85	125	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-085	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-085	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-085	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-085	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-H14-085	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-H14-085	●	5
		Modular	R	GYHR3232P00-M25R	★	GYM25RD-H14-085	●	5			
		Modular	L	GYHL3232P00-M25L	★	GYM25LD-H14-085	●	5			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-085	●	4			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-085	●	4			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-085	●	2			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-085	●	2			
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-H25-085	●	6				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-H25-085	●	6				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-H25-085	●	6				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-H25-085	●	6				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-125	●	3				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-125	●	3				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-125	●	1				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-125	●	1				
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-H14-125	●	5				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-H14-125	●	5				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-H14-125	●	5				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-H14-125	●	5				
Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-125	●	4					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-125	●	4					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-125	●	2					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-125	●	2					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-H25-125	●	6					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-H25-125	●	6					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-H25-125	●	6					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-H25-125	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

★2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan

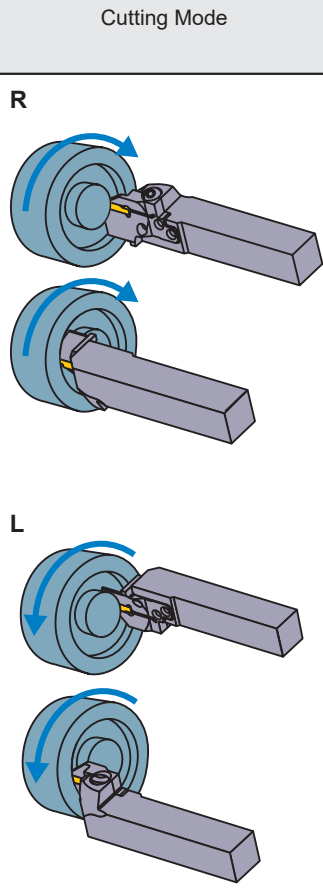


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1								
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
H	.187", 4.75 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			
	.197", 5.00 mm				●
	RE 0.2 mm	●			
H	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

F

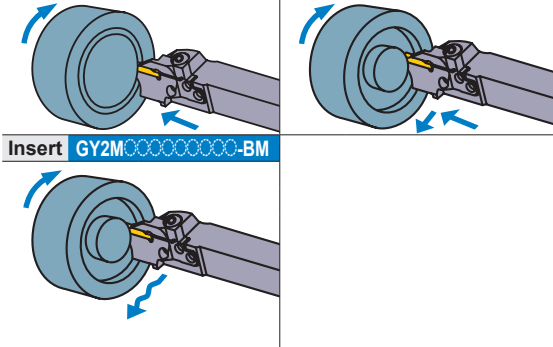
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

GY SERIES (FACE GROOVING)

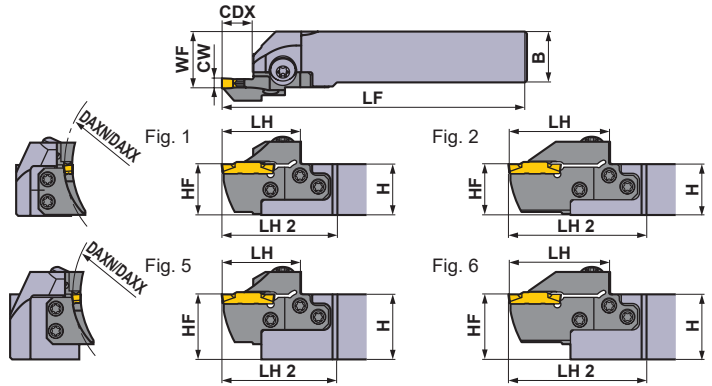
4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

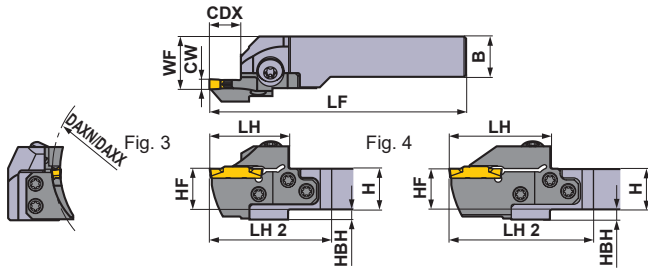
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	180	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-180	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-180	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-180	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-180	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-H14-180	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-H14-180	●	5
		Modular	R	GYHR3232P00-M25R	★	GYM25RD-H14-180	●	5			
		Modular	L	GYHL3232P00-M25L	★	GYM25LD-H14-180	●	5			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-180	●	4			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-180	●	4			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-180	●	2			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-180	●	2			
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-H25-180	●	6				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-H25-180	●	6				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-H25-180	●	6				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-H25-180	●	6				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-250	●	3				
	Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-250	●	3				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-250	●	1				
	Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-250	●	1				
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-H14-250	●	5				
	Modular	L	GYHL3225P00-M25L	★	GYM25LD-H14-250	●	5				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-H14-250	●	5				
	Modular	L	GYHL3232P00-M25L	★	GYM25LD-H14-250	●	5				
Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-250	●	4					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-250	●	4					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-250	●	2					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-250	●	2					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-H25-250	●	6					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-H25-250	●	6					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-H25-250	●	6					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-H25-250	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan

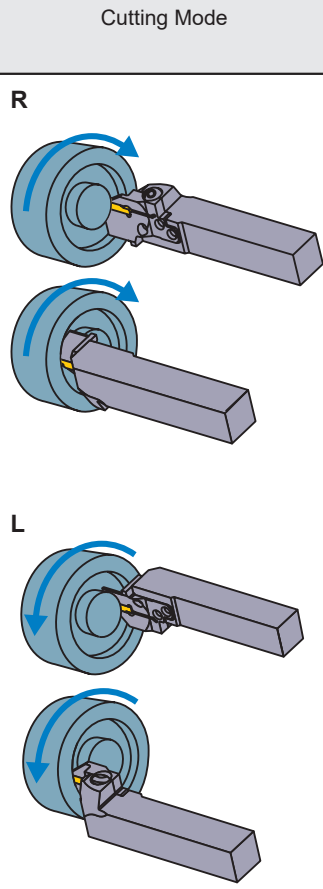


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1								
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
H	.187", 4.75 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			
	.197", 5.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	206", 5.24 mm	●			

● : Gauge insert shown dimensions

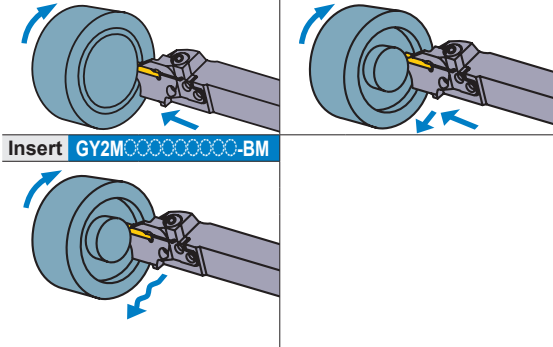
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GROOVING / CUTTING OFF

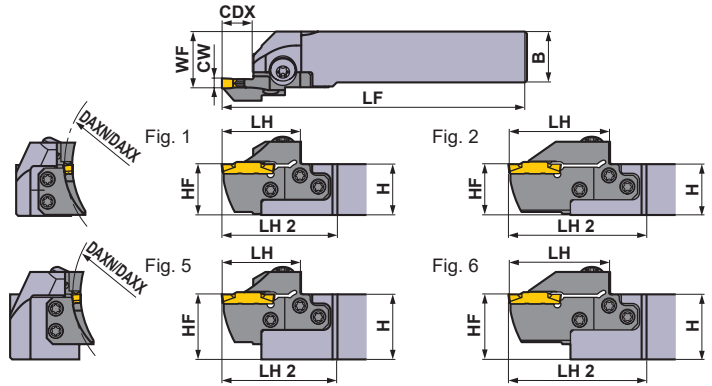
GY SERIES (FACE GROOVING)

4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

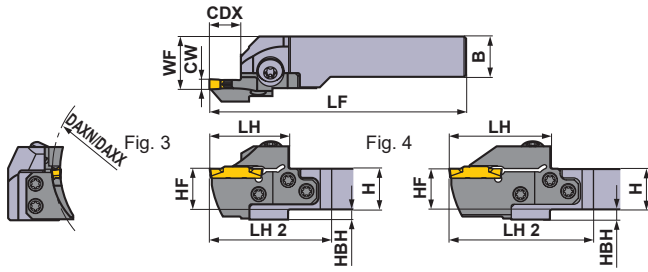
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	6.00 6.31 6.35	50	70	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-050	●	3
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-050	●	3
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-050	●	1
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-050	●	1
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-J14-050	●	5
					Modular	L	GYHL3225P00-M25L	★	GYM25LD-J14-050	●	5
				Modular	R	GYHR3232P00-M25R	★	GYM25RD-J14-050	●	5	
				Modular	L	GYHL3232P00-M25L	★	GYM25LD-J14-050	●	5	
				Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-070	●	3	
				Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-070	●	3	
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-070	●	1	
				Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-070	●	1	
		Modular	R	GYHR3225P00-M25R	★	GYM25RD-J14-070	●	5			
		Modular	L	GYHL3225P00-M25L	★	GYM25LD-J14-070	●	5			
		Modular	R	GYHR3232P00-M25R	★	GYM25RD-J14-070	●	5			
		Modular	L	GYHL3232P00-M25L	★	GYM25LD-J14-070	●	5			
		Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-070	●	4			
		Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-070	●	4			
		Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-070	●	2			
		Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-070	●	2			
		Modular	R	GYHR3225P00-M25R	★	GYM25RD-J25-070	●	6			
		Modular	L	GYHL3225P00-M25L	★	GYM25LD-J25-070	●	6			
		Modular	R	GYHR3232P00-M25R	★	GYM25RD-J25-070	●	6			
		Modular	L	GYHL3232P00-M25L	★	GYM25LD-J25-070	●	6			
Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-110	●	3					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-110	●	3					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-110	●	1					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-110	●	1					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-J14-110	●	5					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-J14-110	●	5					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-J14-110	●	5					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-J14-110	●	5					
Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-110	●	4					
Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-110	●	4					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-110	●	2					
Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-110	●	2					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-J25-110	●	6					
Modular	L	GYHL3225P00-M25L	★	GYM25LD-J25-110	●	6					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-J25-110	●	6					
Modular	L	GYHL3232P00-M25L	★	GYM25LD-J25-110	●	6					

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan

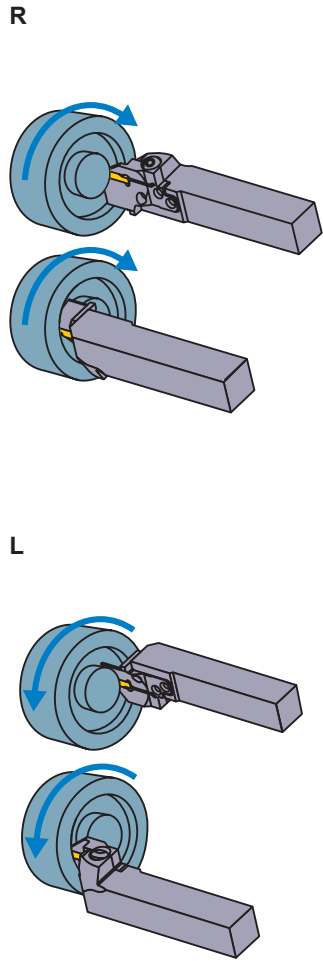


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

Dimensions (mm) *1								
H	B	LF	LH	LH 2	HF	WF	HBH	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	
20	20	125	39	60	20	26	5	
20	20	125	39	60	20	26	5	
25	25	150	39	57	25	28	—	
25	25	150	39	57	25	28	—	
32	25	170	39	57	32	28	—	
32	25	170	39	57	32	28	—	
32	32	170	39	57	32	35	—	
32	32	170	39	57	32	35	—	
20	20	136	50	71	20	26	5	
20	20	136	50	71	20	26	5	
25	25	161	50	68	25	28	—	
25	25	161	50	68	25	28	—	
32	25	181	50	68	32	28	—	
32	25	181	50	68	32	28	—	
32	32	181	50	68	32	35	—	
32	32	181	50	68	32	35	—	



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
J	236", 6.00 mm	●	●	●	●
	250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing) Ball nose
J	236", 6.00 mm	●			●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	248", 6.31 mm	●			
	250", 6.35 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			

● : Gauge insert shown dimensions

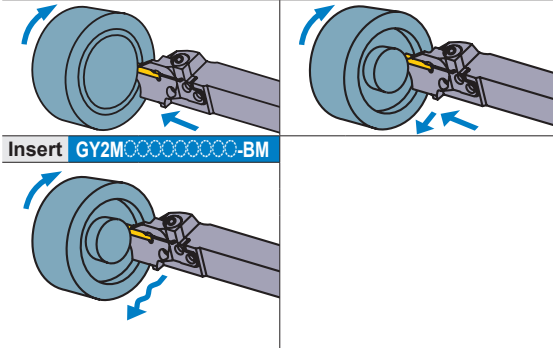
F

GROOVING / CUTTING OFF

GY SERIES (FACE GROOVING)

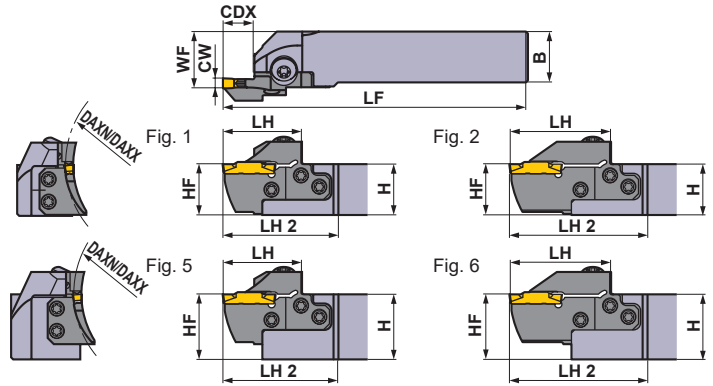
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFGS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

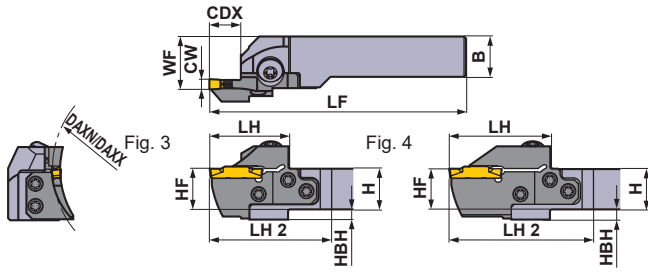
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.	
							Holder	Stock	Modular Blade	Stock		
J	6.00	170	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-170	●	3	
						L	GYHL2020K00-M25L	●	GYM25LD-J14-170	●	3	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-170	●	1	
						L	GYHL2525M00-M25L	●	GYM25LD-J14-170	●	1	
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-J14-170	●	5	
						L	GYHL3225P00-M25L	★	GYM25LD-J14-170	●	5	
					Modular	R	GYHR3232P00-M25R	★	GYM25RD-J14-170	●	5	
						L	GYHL3232P00-M25L	★	GYM25LD-J14-170	●	5	
					25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-170	●	4
							L	GYHL2020K00-M25L	●	GYM25LD-J25-170	●	4
	Modular	R	GYHR2525M00-M25R	●		GYM25RD-J25-170	●	2				
		L	GYHL2525M00-M25L	●		GYM25LD-J25-170	●	2				
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-J25-170	●	6					
		L	GYHL3225P00-M25L	★	GYM25LD-J25-170	●	6					
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-J25-170	●	6					
		L	GYHL3232P00-M25L	★	GYM25LD-J25-170	●	6					
	6.31	250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-250	●	3	
						L	GYHL2020K00-M25L	●	GYM25LD-J14-250	●	3	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-250	●	1	
						L	GYHL2525M00-M25L	●	GYM25LD-J14-250	●	1	
Modular					R	GYHR3225P00-M25R	★	GYM25RD-J14-250	●	5		
					L	GYHL3225P00-M25L	★	GYM25LD-J14-250	●	5		
Modular					R	GYHR3232P00-M25R	★	GYM25RD-J14-250	●	5		
					L	GYHL3232P00-M25L	★	GYM25LD-J14-250	●	5		
25 *2					Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-250	●	4	
						L	GYHL2020K00-M25L	●	GYM25LD-J25-250	●	4	
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-250	●	2					
		L	GYHL2525M00-M25L	●	GYM25LD-J25-250	●	2					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-J25-250	●	6						
	L	GYHL3225P00-M25L	★	GYM25LD-J25-250	●	6						
Modular	R	GYHR3232P00-M25R	★	GYM25RD-J25-250	●	6						
	L	GYHL3232P00-M25L	★	GYM25LD-J25-250	●	6						
6.35	250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-250	●	3		
					L	GYHL2020K00-M25L	●	GYM25LD-J14-250	●	3		
				Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-250	●	1		

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock ★ : Stocked in Japan

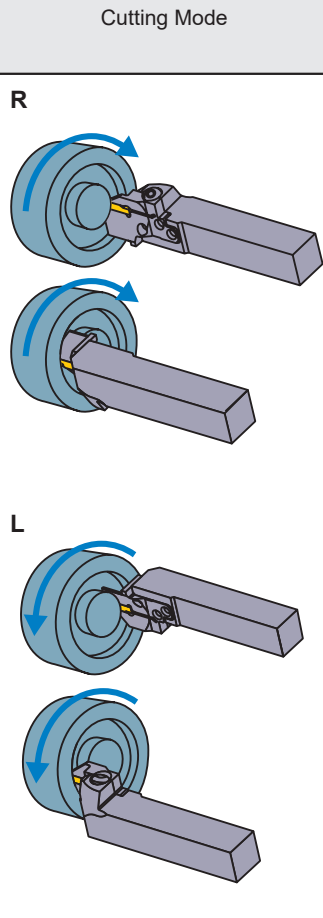


* Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number	Clamp Screw	Blade Screw 5 pcs.	Wrench *
GYHR/L2020K00-M25R/L			
GYHR/L2525M00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) *1							
	H	B	LF	LH	LH 2	HF	WF	HBH
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—
	20	20	125	39	60	20	26	5
	20	20	125	39	60	20	26	5
	25	25	150	39	57	25	28	—
	25	25	150	39	57	25	28	—
	32	25	170	39	57	32	28	—
	32	25	170	39	57	32	28	—
	32	32	170	39	57	32	35	—
	32	32	170	39	57	32	35	—
	20	20	136	50	71	20	26	5
	20	20	136	50	71	20	26	5
	25	25	161	50	68	25	28	—
	25	25	161	50	68	25	28	—
	32	25	181	50	68	32	28	—
	32	25	181	50	68	32	28	—
	32	32	181	50	68	32	35	—
	32	32	181	50	68	32	35	—



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
J	236", 6.00 mm	●	●	●	●
	250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing) Ball nose
J	236", 6.00 mm	●			●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	248", 6.31 mm	●			
	250", 6.35 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

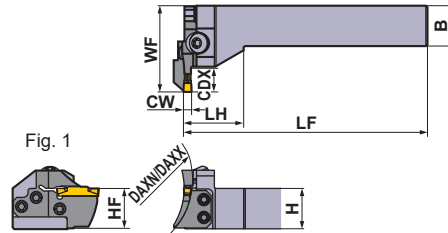
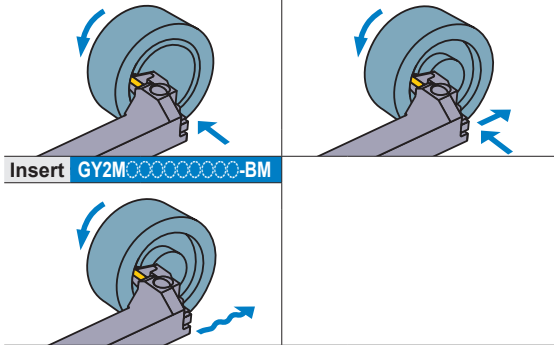
GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{GM} -MF
Insert	GY2M ^{GU} _{GM}	Insert	GY2M ^{GU} _{GM} -MS
Insert	GY1M ^{GM} _{GFS}	Insert	GY2M ^{GM} _{GFS} -MM

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	40	50	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-040	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-040	●	1
		50	60	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-050	●	1
		60	75	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-060	●	1
		75	100	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-075	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-075	●	1
		100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-100	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-100	●	1
		135	200	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-135	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-135	●	1
		180	250	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-180	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-D12-180	●	1
E	2.39 2.50 2.74	40	50	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-040	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-040	●	1
		50	60	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-050	●	1
		60	75	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-060	●	1
		75	100	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-075	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-075	●	1
		100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-100	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-100	●	1
		135	200	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-135	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-135	●	1
		180	250	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-180	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-E12-180	●	1

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

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

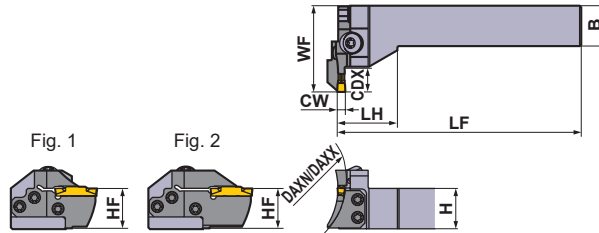
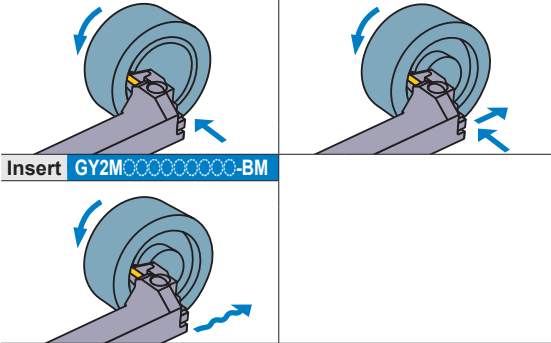
● : USA Stock

GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{GM} -MF
Insert	GY2M ^{GU} _{GM}	Insert	GY2M ^{GU} _{GM} -MS
Insert	GY1M ^{GM} _{GFGS}	Insert	GY2M ^{GM} _{GFGS} -MM

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	35	40	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-035	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-035	●	1
		40	50	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-040	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-040	●	1
		50	60	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-050	●	1
		60	75	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-060	●	1
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-060	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-060	●	2
		75	100	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-075	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-075	●	1
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-075	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-075	●	2
		100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-100	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-100	●	1
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-100	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-F20-100	●	2
		135	200	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-135	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-F12-135	●	1
20 *2	Modular			R	GYHR2525M90-M25L	●	GYM25LD-F20-135	●	2		
				L	GYHL2525M90-M25R	●	GYM25RD-F20-135	●	2		
180	250	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-180	●	1		
				L	GYHL2525M90-M25R	●	GYM25RD-F12-180	●	1		
		20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-180	●	2		
				L	GYHL2525M90-M25R	●	GYM25RD-F20-180	●	2		
225	999	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-225	●	1		
				L	GYHL2525M90-M25R	●	GYM25RD-F12-225	●	1		
		20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-225	●	2		
				L	GYHL2525M90-M25R	●	GYM25RD-F20-225	●	2		

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.
 *2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

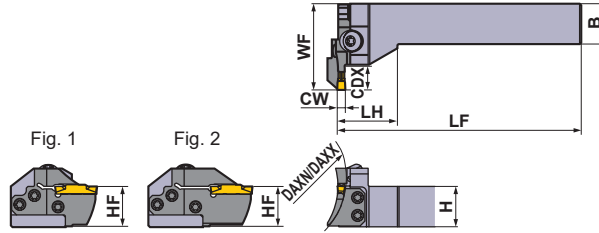
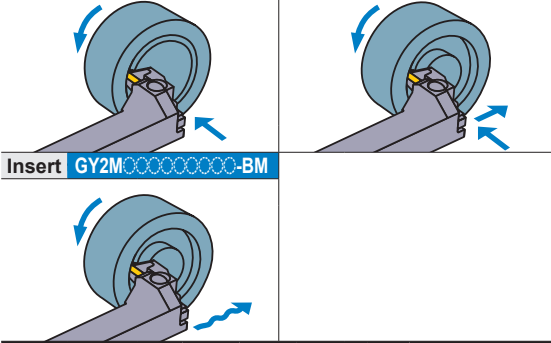
GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

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

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

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{GM} -MF
Insert	GY2M ^{GU} _{GM}	Insert	GY2M ^{GU} _{GM} -MS
Insert	GY1M ^{GM} _{GFS}	Insert	GY2M ^{GM} _{GFS} -MM



Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	40	50	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-040	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-040	●	1
		50	60	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-050	●	1
		60	85	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-060	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-060	●	1
		60	85	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-060	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-060	●	2
		85	125	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-085	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-085	●	1
		85	125	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-085	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-085	●	2
		125	200	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-125	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-125	●	1
		125	200	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-125	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-125	●	2
		180	280	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-180	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-G14-180	●	1
		180	280	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-180	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-G25-180	●	2
250	999	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-250	●	1		
				L	GYHL2525M90-M25R	●	GYM25RD-G14-250	●	1		
250	999	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-250	●	2		
				L	GYHL2525M90-M25R	●	GYM25RD-G25-250	●	2		

CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

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




*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

F

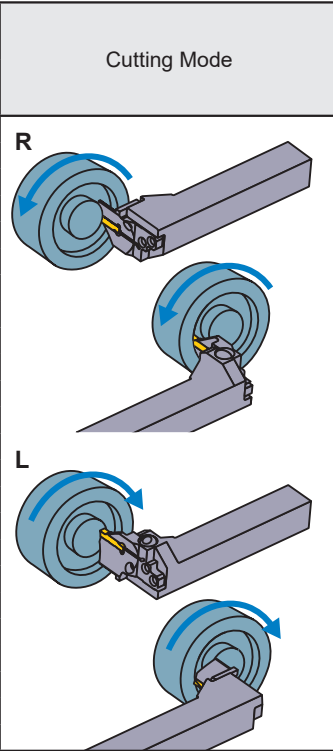
GROOVING / CUTTING OFF

● : USA Stock

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHR2525M90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) *1					
	H	B	LF	LH	HF	WF
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)
CW	.157", 4.00 mm	●	●	●	●
G	.157", 4.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing) Ball nose
CW	.157", 4.00 mm	●	●	●	●
G	RE 0.2 mm	●	●	●	●
	RE 0.4 mm	●	●	●	●
	RE 0.8 mm	●	●	●	●
G	.167", 4.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F
GROOVING / CUTTING OFF

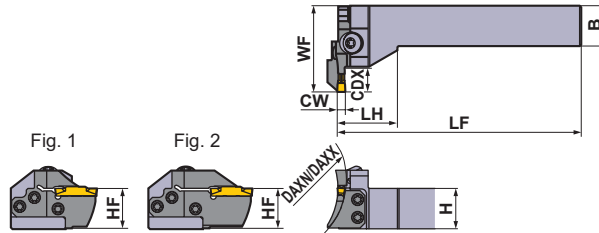
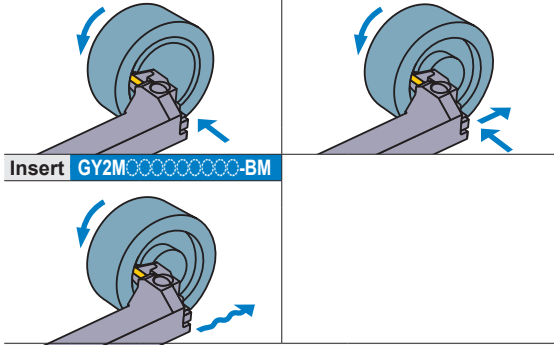
GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{GM} -MF
Insert	GY2M ^{GU} _{GM}	Insert	GY2M ^{MS} _{GM} -MS
Insert	GY1M ^{GM} _{GFGS}	Insert	GY2M ^{MM} _{GM} -MM

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	50	60	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-050	●	1
					L	GYHL2525M90-M25R	●	GYM25RD-H14-050	●	1	
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-060	●	1
					L	GYHL2525M90-M25R	●	GYM25RD-H14-060	●	1	
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-060	●	2
					L	GYHL2525M90-M25R	●	GYM25RD-H25-060	●	2	
		85	125	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-085	●	1
					L	GYHL2525M90-M25R	●	GYM25RD-H14-085	●	1	
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-085	●	2
					L	GYHL2525M90-M25R	●	GYM25RD-H25-085	●	2	
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-125	●	1
					L	GYHL2525M90-M25R	●	GYM25RD-H14-125	●	1	
		125	200	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-125	●	2
					L	GYHL2525M90-M25R	●	GYM25RD-H25-125	●	2	
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-180	●	1
					L	GYHL2525M90-M25R	●	GYM25RD-H14-180	●	1	
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-180	●	2
					L	GYHL2525M90-M25R	●	GYM25RD-H25-180	●	2	
		180	280	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-250	●	1
					L	GYHL2525M90-M25R	●	GYM25RD-H14-250	●	1	
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-250	●	2
					L	GYHL2525M90-M25R	●	GYM25RD-H25-250	●	2	
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-250	●	1
					L	GYHL2525M90-M25R	●	GYM25RD-H14-250	●	1	
250	999	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-250	●	2		
			L	GYHL2525M90-M25R	●	GYM25RD-H25-250	●	2			




CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

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

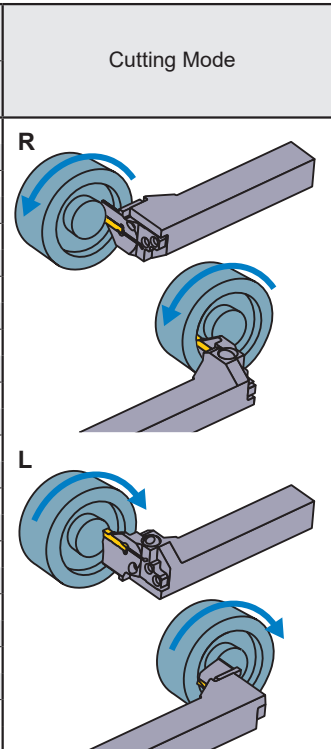
*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHR2525M90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) *1					
	H	B	LF	LH	HF	WF
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
H	.187", 4.75 mm	●	●	●	●
	.197", 5.00 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Rescuing)
H	.187", 4.75 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			
	.197", 5.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	.206", 5.24 mm	●			

● : Gauge insert shown dimensions

F
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F206
 INSTRUCTION MANUAL > F208

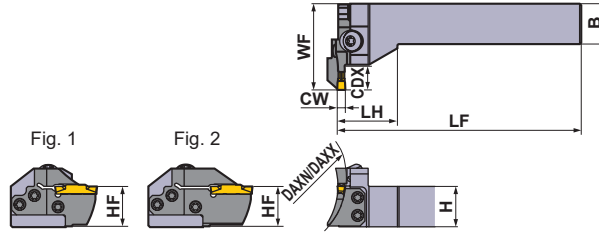
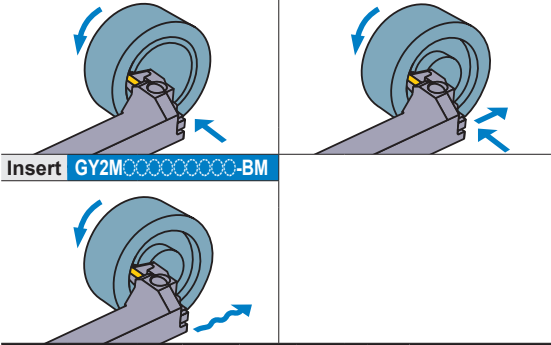
GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{GS} _{MF}
Insert	GY2M ^{GS} _{GU}	Insert	GY2M ^{GS} _{MS}
Insert	GY1G ^{GS} _{GFGS}	Insert	GY2M ^{GS} _{MM}

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	6.00 6.31 6.35	50	70	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-050	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-050	●	1
		70	110	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-070	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-070	●	1
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-070	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-J25-070	●	2
		110	200	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-110	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-110	●	1
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-110	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-J25-110	●	2
		170	280	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-170	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-170	●	1
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-170	●	2
						L	GYHL2525M90-M25R	●	GYM25RD-J25-170	●	2
		250	999	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-250	●	1
						L	GYHL2525M90-M25R	●	GYM25RD-J14-250	●	1
25 *2	Modular			R	GYHR2525M90-M25L	●	GYM25LD-J25-250	●	2		
				L	GYHL2525M90-M25R	●	GYM25RD-J25-250	●	2		




CW = Cutting Width DAXN = Axial groove outside diameter minimum DAXX = Axial groove outside diameter maximum CDX = Max. Groove Depth

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

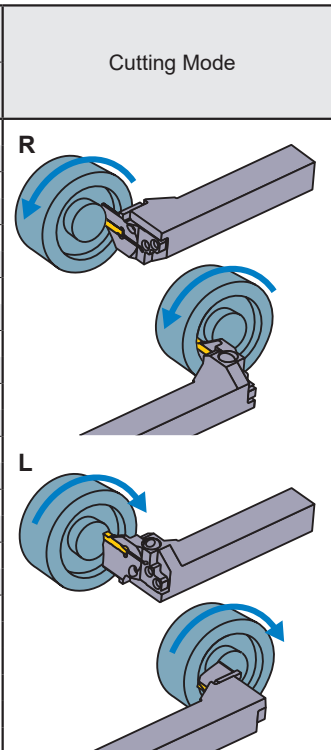
*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F011 to F015.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench ★
GYHR2525M90-M25L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) *1					
	H	B	LF	LH	HF	WF
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64



Select an Insert

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

For Grooving/Cutting off > F011, F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)
J	236", 6.00 mm	●	●	●	●
	250", 6.35 mm	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
J	236", 6.00 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●	●	●	
	RE 0.8 mm	●	●	●	
	248", 6.31 mm	●			●
J	250", 6.35 mm				●
	RE 0.2 mm	●			
	RE 0.4 mm	●			
	RE 0.8 mm	●			

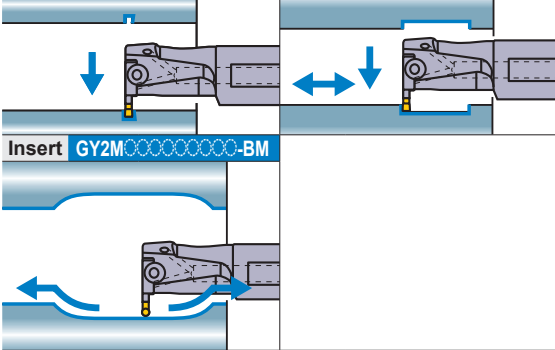
● : Gauge insert shown dimensions

F
GROOVING / CUTTING OFF

GY SERIES (INTERNAL GROOVING)

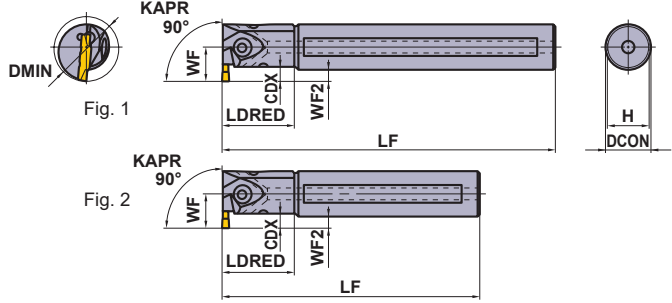
6-1 90° type holder (Inch)

Insert	GY2M ^{GS}	Insert	GY2G ^{GS} -MF
Insert	GY2M ^{GL}	Insert	GY2M ^{GL} -MS
Insert	GY1G ^{GFS}	Insert	GY2M ^{GFS} -MM



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

● Mono block type (Air / coolant through)



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch) *3	DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	.079 .088	.236	1.000	Mono Block	R	GYARUS12K90A-D06	●	—	—	2
				Mono Block	L	GYALUS12K90A-D06	●	—	—	2
			Mono Block	R	GYARUS12Q90A-D06	●	—	—	1	
			Mono Block	L	GYALUS12Q90A-D06	●	—	—	1	
		1.250	Mono Block	R	GYARUS16K90B-D06	●	—	—	—	2
			Mono Block	L	GYALUS16K90B-D06	●	—	—	—	2
			Mono Block	R	GYARUS16R90B-D06	●	—	—	—	1
			Mono Block	L	GYALUS16R90B-D06	●	—	—	—	1
		.157— .374 *1	1.625	Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-D10	●	4
				Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-D10	●	4
			Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-D10	●	3	
			Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-D10	●	3	
	.217— .374 *1	2.000	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-D10	●	4	
			Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-D10	●	4	
		Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-D10	●	3		
		Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-D10	●	3		
	.276— .453 *1	2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-D12	●	4	
			Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-D12	●	4	
		Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-D12	●	3		
		Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-D12	●	3		
2.750	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-D12	●	4			
	Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-D12	●	4			
Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-D12	●	3				
Modular	L	GYDLUS32T90F-M25R	●	GYM25RA-D12	●	3				

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

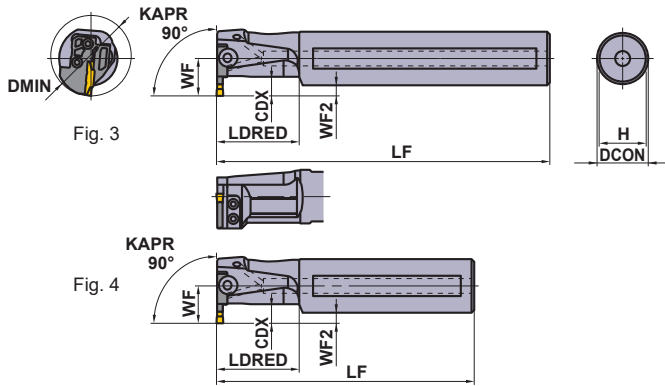
*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

● : USA Stock

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw

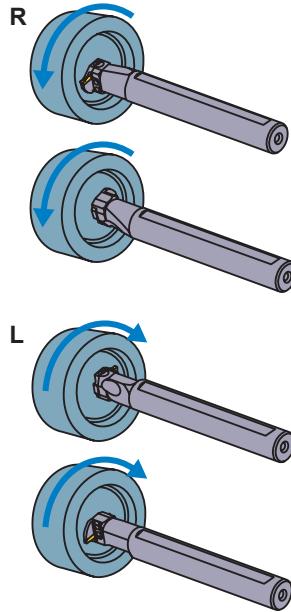


Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/LUS12○90A○06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/LUS16○90B○06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYDR/LUS20○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) *2						Cutting Mode
	DCON	LF	LDRED	WF	WF2	H	
	.750	5.000	1.250	.605	.230	.671	R
	.750	5.000	1.250	.605	.230	.671	
	.750	7.000	1.250	.605	.230	.671	R
	.750	7.000	1.250	.605	.230	.671	
	1.000	5.000	1.500	.730	.230	.921	L
	1.000	5.000	1.500	.730	.230	.921	
	1.000	8.000	1.500	.730	.230	.921	L
	1.000	8.000	1.500	.730	.230	.921	
	1.250	5.500	2.000	.875	.250	1.171	L
	1.250	5.500	2.000	.875	.250	1.171	
	1.250	10.000	2.000	.875	.250	1.171	L
	1.250	10.000	2.000	.875	.250	1.171	
	1.500	6.000	2.500	1.125	.375	1.382	L
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	
	1.500	6.000	2.500	1.125	.375	1.382	L
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	
	2.000	6.750	3.250	1.250	.250	1.882	L
	2.000	6.750	3.250	1.250	.250	1.882	
	2.000	12.000	3.250	1.250	.250	1.882	L
	2.000	12.000	3.250	1.250	.250	1.882	



Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
D	.079", 2.00 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
D	.079", 2.00 mm	●	●	●	●
D	.088", 2.24 mm	●	●	●	●

● : Gauge insert shown dimensions

F

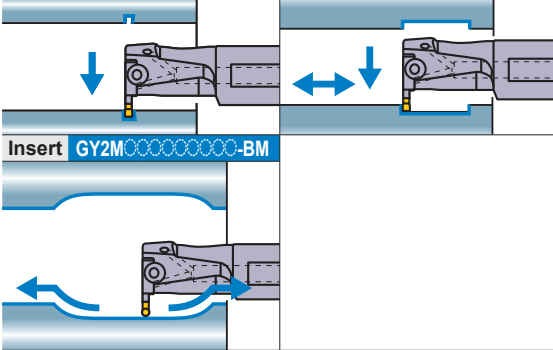
GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F213
 INSTRUCTION MANUAL > F215

GY SERIES (INTERNAL GROOVING)

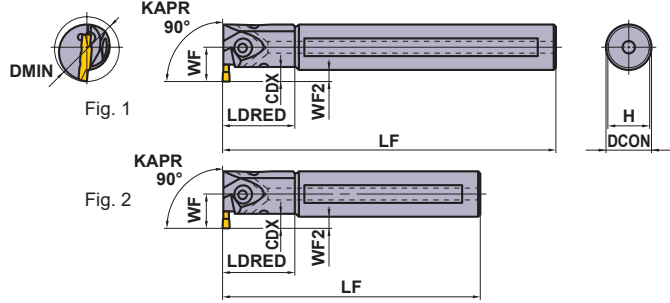
6-1 90° type holder (Inch)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GL}	Insert	GY2M ^{MS}
Insert	GY1G ^{GFS}	Insert	GY2M ^{MM}



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

● Mono block type (Air / coolant through)



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch) *3	DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
E	.094 .098 .108	.236	1.000	Mono Block	R	GYARUS12K90A-E06	●	—	—	2
				Mono Block	L	GYALUS12K90A-E06	●	—	—	2
			Mono Block	R	GYARUS12Q90A-E06	●	—	—	1	
			Mono Block	L	GYALUS12Q90A-E06	●	—	—	1	
		1.250	Mono Block	R	GYARUS16K90B-E06	●	—	—	—	2
			Mono Block	L	GYALUS16K90B-E06	●	—	—	—	2
			Mono Block	R	GYARUS16R90B-E06	●	—	—	—	1
			Mono Block	L	GYALUS16R90B-E06	●	—	—	—	1
		.157— .374 *1	1.625	Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-E10	●	4
				Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-E10	●	4
			Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-E10	●	3	
			Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-E10	●	3	
	.217— .374 *1	2.000	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-E10	●	4	
			Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-E10	●	4	
		Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-E10	●	3		
		Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-E10	●	3		
	.276— .453 *1	2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-E12	●	4	
			Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-E12	●	4	
		Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-E12	●	3		
		Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-E12	●	3		
2.750	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-E12	●	4			
	Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-E12	●	4			
				Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-E12	●	3
				Modular	L	GYDLUS32T90F-M25R	●	GYM25RA-E12	●	3

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

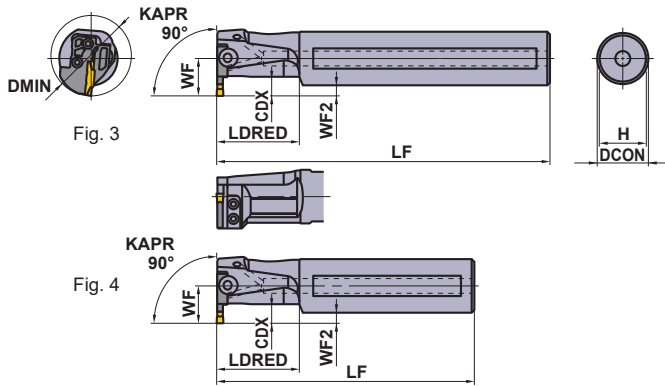
*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

● : USA Stock

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw

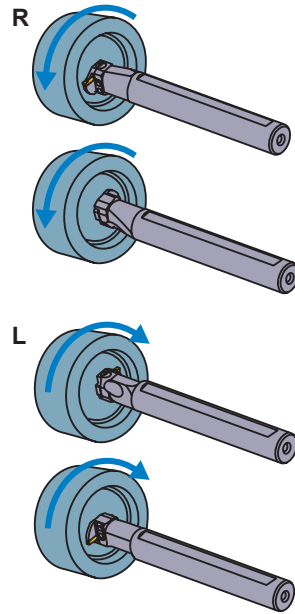


Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/LUS12 ○90A-○06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/LUS16 ○90B-○06	—	—	—
GYDR/LUS20 ○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24 ○90D-M20L/R	—	—	—
GYDR/LUS24 ○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32 ○90F-M25L/R	—	—	—

	Dimensions (inch) *2						Cutting Mode
	DCON	LF	LDRED	WF	WF2	H	
	.750	5.000	1.250	.605	.230	.671	R
	.750	5.000	1.250	.605	.230	.671	
	.750	7.000	1.250	.605	.230	.671	R
	.750	7.000	1.250	.605	.230	.671	
	1.000	5.000	1.500	.730	.230	.921	R
	1.000	5.000	1.500	.730	.230	.921	
	1.000	8.000	1.500	.730	.230	.921	R
	1.000	8.000	1.500	.730	.230	.921	
	1.250	5.500	2.000	.875	.250	1.171	R
	1.250	5.500	2.000	.875	.250	1.171	
	1.250	10.000	2.000	.875	.250	1.171	R
	1.250	10.000	2.000	.875	.250	1.171	
	1.500	6.000	2.500	1.125	.375	1.382	L
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	
	1.500	6.000	2.500	1.125	.375	1.382	L
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	
	2.000	6.750	3.250	1.250	.250	1.882	L
	2.000	6.750	3.250	1.250	.250	1.882	
	2.000	12.000	3.250	1.250	.250	1.882	L
	2.000	12.000	3.250	1.250	.250	1.882	



Select an Insert

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

		For Grooving/Cutting off > F011, F013				
Seat Size	Breaker CW	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
E	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●

		For Multifunctional Grooving > F013, F014			
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Reversing)
E	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

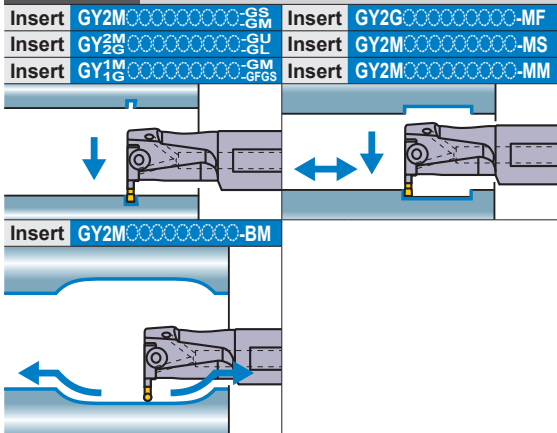
● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

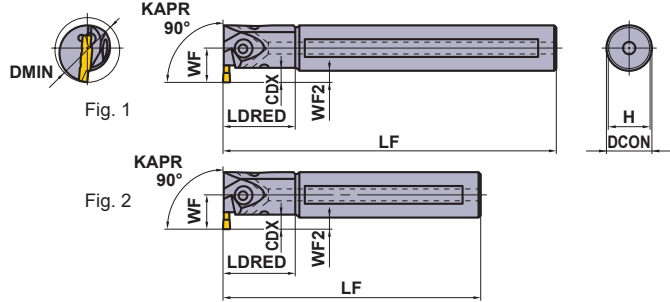
GY SERIES (INTERNAL GROOVING)

6-1 90° type holder (Inch)



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

● Mono block type (Air / coolant through)



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch) *3	DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
F	.118 .125 .128	.236	1.000	Mono Block	R	GYARUS12K90A-F06	●	—	—	2	
				Mono Block	L	GYALUS12K90A-F06	●	—	—	2	
			Mono Block	R	GYARUS12Q90A-F06	●	—	—	1		
			Mono Block	L	GYALUS12Q90A-F06	●	—	—	1		
		1.250	Mono Block	R	GYARUS16K90B-F06	●	—	—	2		
			Mono Block	L	GYALUS16K90B-F06	●	—	—	2		
		.157— .374 *1	1.625	Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-F10	●	4	
				Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-F10	●	4	
	2.000		Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-F10	●	3		
			Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-F10	●	3		
	.276— .453 *1		2.500	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-F10	●	4	
				Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-F10	●	4	
			2.750	Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-F10	●	3	
				Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-F10	●	3	
	G	.157 .167	.276	1.250	Mono Block	R	GYARUS16K90B-G07	●	—	—	2
					Mono Block	L	GYALUS16K90B-G07	●	—	—	2
1.625				Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-G12	●	4	
				Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-G12	●	4	
.197 - .453 *1			2.000	Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-G12	●	3	
				Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-G12	●	3	
			2.500	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-G12	●	4	
				Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-G12	●	4	
.236 - .453 *1			2.750	Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-G12	●	3	
				Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-G12	●	3	
			2.500	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-G14	●	4	
				Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-G14	●	4	
.295 - .512 *1		2.750	Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-G14	●	3		
			Modular	L	GYDLUS32T90F-M25R	●	GYM25RA-G14	●	3		
		2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-G14	●	4		
			Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-G14	●	4		
.315 - .512 *1	2.500	Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-G14	●	3			
		Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-G14	●	3			

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

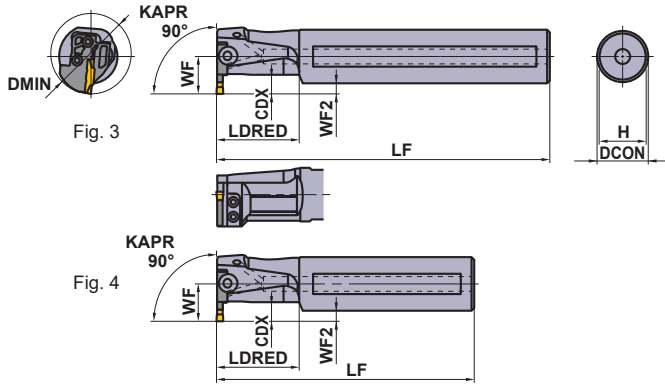
*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw



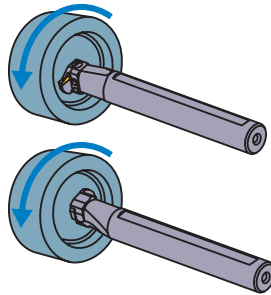
Right hand tool holder shown.

SPARE PARTS

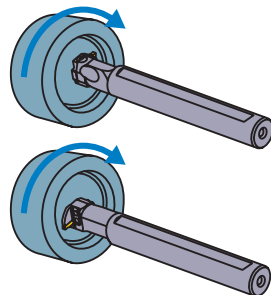
Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/LUS12○90A-F06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/LUS16○90B-○○○	—	—	—
GYDR/LUS20○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS24○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) *2						Cutting Mode
	DCON	LF	LDRED	WF	WF2	H	
	.750	5.000	1.250	.605	.230	.671	R
	.750	5.000	1.250	.605	.230	.671	
	.750	7.000	1.250	.605	.230	.671	R
	.750	7.000	1.250	.605	.230	.671	
	1.000	5.000	1.500	.730	.230	.921	R
	1.000	5.000	1.500	.730	.230	.921	
	1.000	8.000	1.500	.730	.230	.921	R
	1.000	8.000	1.500	.730	.230	.921	
	1.250	5.500	2.000	.875	.250	1.171	R
	1.250	5.500	2.000	.875	.250	1.171	
	1.250	10.000	2.000	.875	.250	1.171	R
	1.250	10.000	2.000	.875	.250	1.171	
	1.500	6.000	2.500	1.125	.375	1.382	R
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	R
	1.500	12.000	2.500	1.125	.375	1.382	
	1.500	6.000	2.500	1.125	.375	1.382	R
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	R
	1.500	12.000	2.500	1.125	.375	1.382	
	2.000	6.750	3.250	1.250	.250	1.882	R
	2.000	6.750	3.250	1.250	.250	1.882	
	2.000	12.000	3.250	1.250	.250	1.882	R
	2.000	12.000	3.250	1.250	.250	1.882	
	1.000	5.000	1.500	.730	.230	.921	L
	1.000	5.000	1.500	.730	.230	.921	
	1.000	8.000	1.500	.730	.230	.921	L
	1.000	8.000	1.500	.730	.230	.921	
	1.250	5.500	2.000	.875	.250	1.171	L
	1.250	5.500	2.000	.875	.250	1.171	
	1.250	10.000	2.000	.875	.250	1.171	L
	1.250	10.000	2.000	.875	.250	1.171	
	1.500	6.000	2.500	1.125	.375	1.382	L
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	
	2.000	6.750	3.250	1.250	.250	1.882	L
	2.000	6.750	3.250	1.250	.250	1.882	
	2.000	12.000	3.250	1.250	.250	1.882	L
	2.000	12.000	3.250	1.250	.250	1.882	
	1.500	6.000	2.500	1.125	.375	1.382	L
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	

R



L



Select an Insert

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

		For Grooving/Cutting off > F011, F013				
Seat Size	Breaker CW	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●
G	.157", 4.00 mm	●	●	●	●	●

		For Multifunctional Grooving > F013, F014			
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
F	.118", 3.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm				●
	RE .008"	●			
G	RE .016"	●	●	●	
	RE .031"	●		●	
	.157", 4.00 mm				●
	RE .008"	●	●	●	

● : Gauge insert shown dimensions

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F213
 INSTRUCTION MANUAL > F215

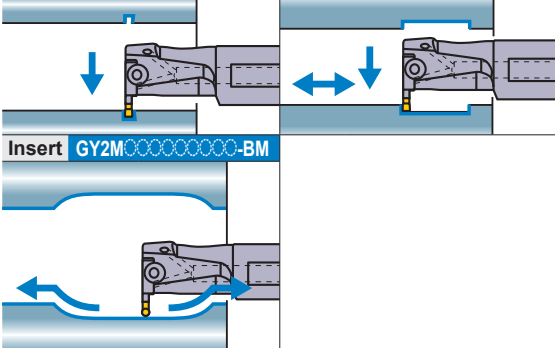
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GROOVING / CUTTING OFF

GY SERIES (INTERNAL GROOVING)

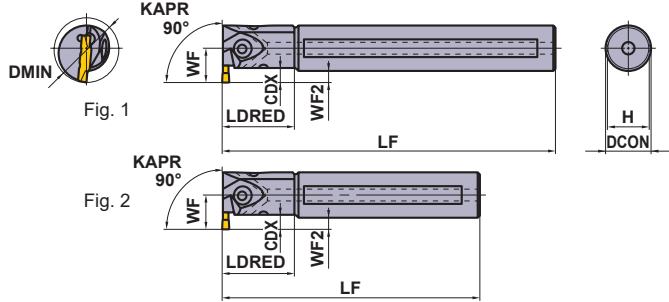
6-1 90° type holder (Inch)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1 ^{GM} _{GFS}	Insert	GY2M ^{MM}



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

● Mono block type (Air / coolant through)



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch) *3	DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	.276	1.250	Mono Block	R	GYARUS16K90B-H07	●	—	—	2
				Mono Block	L	GYALUS16K90B-H07	●	—	—	2
		.197 - .453 *1	1.625	Mono Block	R	GYARUS16R90B-H07	●	—	—	1
				Mono Block	L	GYALUS16R90B-H07	●	—	—	1
			Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-H12	●	4	
			Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-H12	●	4	
	.236 - .453 *1	2.000	Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-H12	●	3	
			Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-H12	●	3	
		Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-H12	●	4		
		Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-H12	●	4		
	.295 - .512 *1	2.750	Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-H12	●	3	
			Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-H12	●	3	
Modular		R	GYDRUS32P90F-M25L	●	GYM25LA-H14	●	4			
Modular		L	GYDLUS32P90F-M25R	●	GYM25RA-H14	●	4			
J	.236 .248 .250	.295 - .512 *1	2.750	Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-H14	●	3
				Modular	L	GYDLUS32T90F-M25R	●	GYM25RA-H14	●	3
		.315 - .512 *1	2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-H14	●	4
				Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-H14	●	4
			Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-H14	●	3	
			Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-H14	●	3	

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

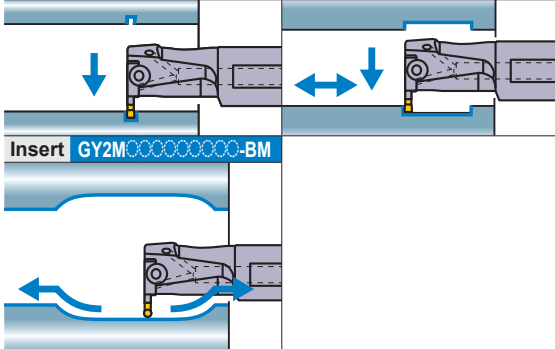
*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

GY SERIES (INTERNAL GROOVING)

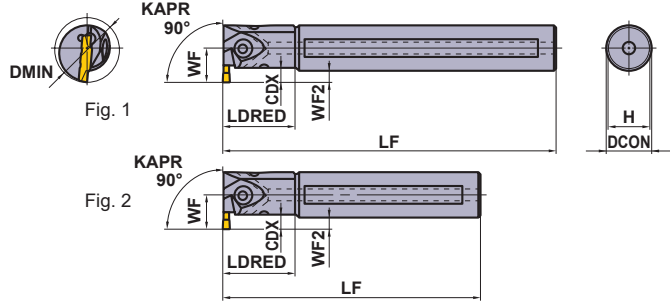
6-2 90° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{GM} -MF
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GMS}	Insert	GY2M ^{MM}



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

● Mono block type (Air / coolant through)



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	CDX (mm) *3	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	6	25	Mono Block	R	GYAR20K90A-D06	●	—	—	2
				Mono Block	L	GYAL20K90A-D06	●	—	—	2
			Mono Block	R	GYAR20Q90A-D06	●	—	—	1	
			Mono Block	L	GYAL20Q90A-D06	●	—	—	1	
			Mono Block	R	GYAR25K90B-D06	●	—	—	2	
			Mono Block	L	GYAL25K90B-D06	●	—	—	2	
		4—9.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-D10	●	4
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-D10	●	4
			Modular	R	GYDR32S90C-M20L	●	GYM20LA-D10	●	3	
			Modular	L	GYDL32S90C-M20R	●	GYM20RA-D10	●	3	
			50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-D10	●	4
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-D10	●	4
		7—11.5 *1	60	Modular	R	GYDR40T90D-M20L	●	GYM20LA-D10	●	3
				Modular	L	GYDL40T90D-M20R	●	GYM20RA-D10	●	3
			60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-D12	●	4
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-D12	●	4
			70	Modular	R	GYDR40T90D-M25L	●	GYM25LA-D12	●	3
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-D12	●	3
70	70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-D12	●	4		
		Modular	L	GYDL50P90F-M25R	●	GYM25RA-D12	●	4		
	70	Modular	R	GYDR50T90F-M25L	●	GYM25LA-D12	●	3		
		Modular	L	GYDL50T90F-M25R	●	GYM25RA-D12	●	3		

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

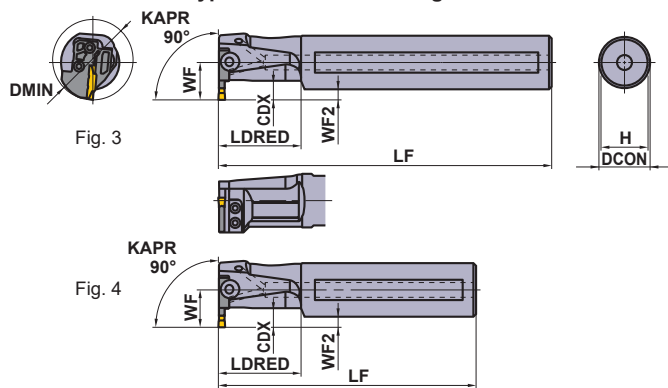
*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

● : USA Stock

●Modular blade type (Air / coolant through)

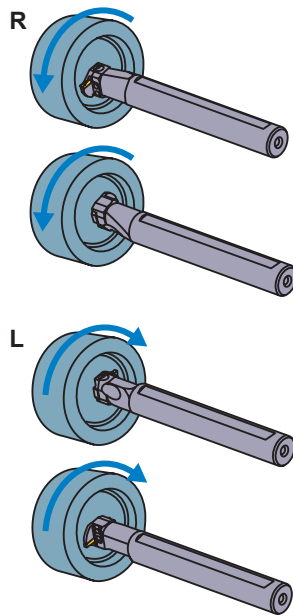
★ Wrench : ① : Clamp Screw, ② : Blade Screw



SPARE PARTS			
Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/L20○90A-○06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/L25○90B-○06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L50○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Right hand tool holder shown.

	Dimensions (mm) *2						Cutting Mode
	DCON	LF	LDRED	WF	WF2	H	
	20	125	30	14.5	4.5	18	R
	20	125	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	25	125	40	19.0	6.5	23	L
	25	125	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	
	32	140	50	22.0	6.0	30	L
	32	140	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	40	150	60	28.0	8.0	37	L
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	L
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	50	170	80	34.0	9.0	47	L
	50	170	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	



Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
D	.079", 2.00 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●	●	●	●

● : Gauge insert shown dimensions

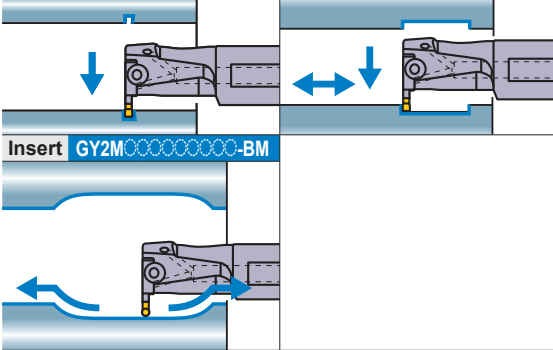
F

GROOVING / CUTTING OFF

GY SERIES (INTERNAL GROOVING)

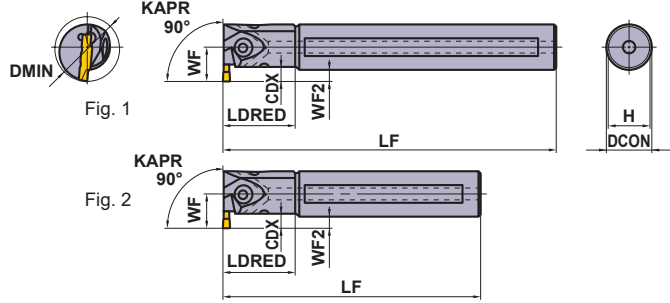
6-2 90° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G
Insert	GY2M ^{GU}	Insert	GY2M
Insert	GY1G ^{GMS}	Insert	GY2M



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

● Mono block type (Air / coolant through)



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	CDX (mm) *3	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	6	25	Mono Block	R	GYAR20K90A-E06	●	—	—	2
				Mono Block	L	GYAL20K90A-E06	●	—	—	2
			Mono Block	R	GYAR20Q90A-E06	●	—	—	1	
			Mono Block	L	GYAL20Q90A-E06	●	—	—	1	
			Mono Block	R	GYAR25K90B-E06	●	—	—	2	
			Mono Block	L	GYAL25K90B-E06	●	—	—	2	
		4—9.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-E10	●	4
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-E10	●	4
			Modular	R	GYDR32S90C-M20L	●	GYM20LA-E10	●	3	
			Modular	L	GYDL32S90C-M20R	●	GYM20RA-E10	●	3	
			50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-E10	●	4
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-E10	●	4
	7—11.5 *1	60	Modular	R	GYDR40T90D-M20L	●	GYM20LA-E10	●	3	
			Modular	L	GYDL40T90D-M20R	●	GYM20RA-E10	●	3	
		60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-E12	●	4	
			Modular	L	GYDL40M90D-M25R	●	GYM25RA-E12	●	4	
		70	Modular	R	GYDR40T90D-M25L	●	GYM25LA-E12	●	3	
			Modular	L	GYDL40T90D-M25R	●	GYM25RA-E12	●	3	
70	70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-E12	●	4		
		Modular	L	GYDL50P90F-M25R	●	GYM25RA-E12	●	4		
70	70	Modular	R	GYDR50T90F-M25L	●	GYM25LA-E12	●	3		
		Modular	L	GYDL50T90F-M25R	●	GYM25RA-E12	●	3		

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

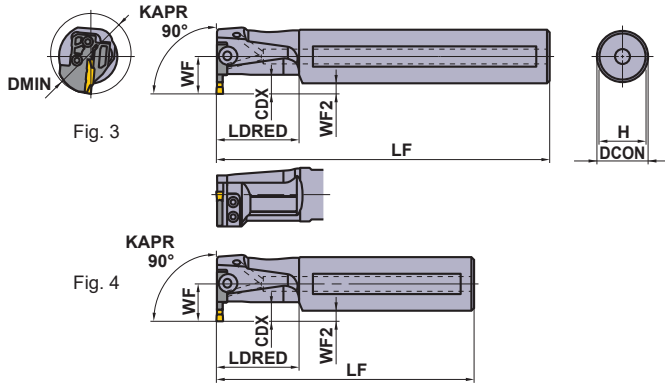
*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

● : USA Stock

●Modular blade type (Air / coolant through)

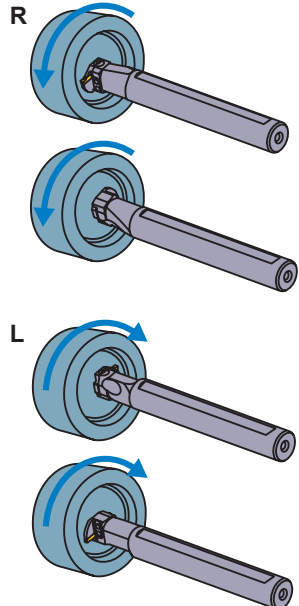
★ Wrench : ① : Clamp Screw, ② : Blade Screw



Right hand tool holder shown.

SPARE PARTS			
Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/L20○90A-○06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/L25○90B-○06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L50○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *2						Cutting Mode
	DCON	LF	LDRED	WF	WF2	H	
	20	125	30	14.5	4.5	18	R
	20	125	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	25	125	40	19.0	6.5	23	
	25	125	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	
	32	140	50	22.0	6.0	30	L
	32	140	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	40	150	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	50	170	80	34.0	9.0	47	
	50	170	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	



Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker CW	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
E	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Reversing)
E	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			

● : Gauge insert shown dimensions

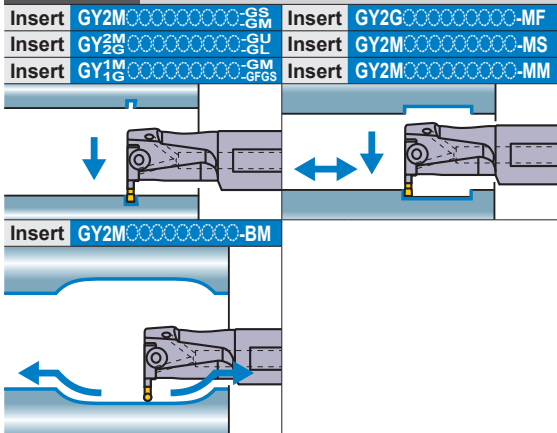
F

GROOVING / CUTTING OFF

IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F213
 INSTRUCTION MANUAL > F215

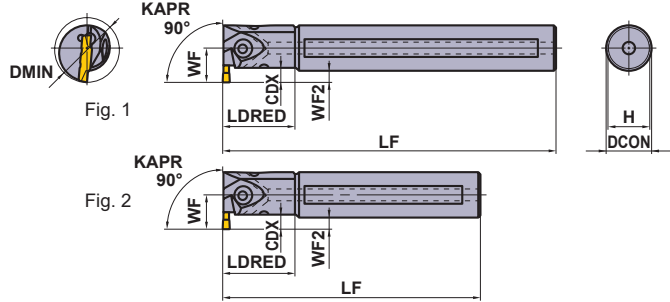
GY SERIES (INTERNAL GROOVING)

6-2 90° type holder (Metric)



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

● Mono block type (Air / coolant through)



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	CDX (mm) *3	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
F	3.00 3.18 3.24	6	25	Mono Block	R	GYAR20K90A-F06	●	—	—	2	
				Mono Block	L	GYAL20K90A-F06	●	—	—	2	
				Mono Block	R	GYAR20Q90A-F06	●	—	—	1	
				Mono Block	L	GYAL20Q90A-F06	●	—	—	1	
			Mono Block	R	GYAR25K90B-F06	●	—	—	2		
			Mono Block	L	GYAL25K90B-F06	●	—	—	2		
		4—9.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-F10	●	4	
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-F10	●	4	
				Modular	R	GYDR32S90C-M20L	●	GYM20LA-F10	●	3	
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-F10	●	3	
			5.5—9.5 *1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-F10	●	4
					Modular	L	GYDL40M90D-M20R	●	GYM20RA-F10	●	4
	Modular	R	GYDR40T90D-M20L		●	GYM20LA-F10	●	3			
	Modular	L	GYDL40T90D-M20R		●	GYM20RA-F10	●	3			
	7—11.5 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-F12	●	4		
			Modular	L	GYDL40M90D-M25R	●	GYM25RA-F12	●	4		
			Modular	R	GYDR40T90D-M25L	●	GYM25LA-F12	●	3		
			Modular	L	GYDL40T90D-M25R	●	GYM25RA-F12	●	3		
70		Modular	R	GYDR50P90F-M25L	●	GYM25LA-F12	●	4			
		Modular	L	GYDL50P90F-M25R	●	GYM25RA-F12	●	4			
G	4.00 4.24	7	32	Mono Block	R	GYAR25K90B-G07	●	—	—	2	
				Mono Block	L	GYAL25K90B-G07	●	—	—	2	
				Mono Block	R	GYAR25R90B-G07	●	—	—	1	
				Mono Block	L	GYAL25R90B-G07	●	—	—	1	
			4.5—11.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-G12	●	4
					Modular	L	GYDL32L90C-M20R	●	GYM20RA-G12	●	4
		Modular			R	GYDR32S90C-M20L	●	GYM20LA-G12	●	3	
		Modular			L	GYDL32S90C-M20R	●	GYM20RA-G12	●	3	
		6—11.5 *1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-G12	●	4	
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-G12	●	4	
				Modular	R	GYDR40T90D-M20L	●	GYM20LA-G12	●	3	
				Modular	L	GYDL40T90D-M20R	●	GYM20RA-G12	●	3	
	7.5—13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-G14	●	4		
			Modular	L	GYDL40M90D-M25R	●	GYM25RA-G14	●	4		
			Modular	R	GYDR40T90D-M25L	●	GYM25LA-G14	●	3		
			Modular	L	GYDL40T90D-M25R	●	GYM25RA-G14	●	3		
		70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-G14	●	4		
			Modular	L	GYDL50P90F-M25R	●	GYM25RA-G14	●	4		

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

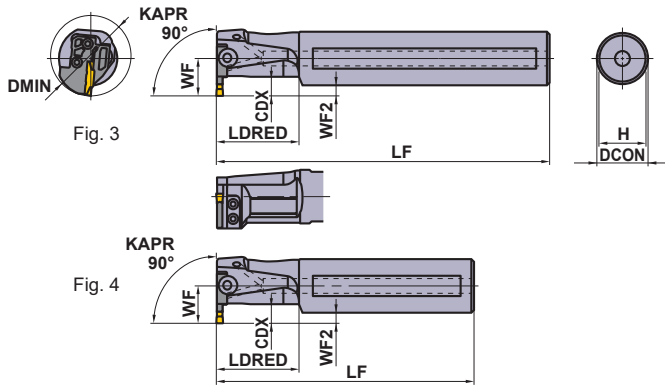
*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw



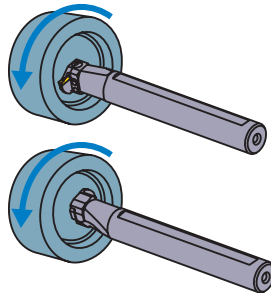
Right hand tool holder shown.

SPARE PARTS

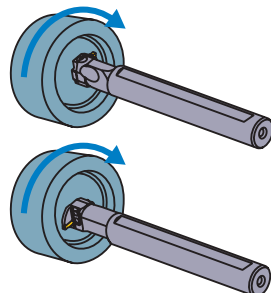
Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/L20○90A-F06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/L25○90B-○○○	—	—	—
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L50○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *2						Cutting Mode
	DCON	LF	LDRED	WF	WF2	H	
	20	125	30	14.5	4.5	18	R
	20	125	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	R
	20	180	30	14.5	4.5	18	
	25	125	40	19.0	6.5	23	R
	25	125	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	R
	25	200	40	19.0	6.5	23	
	32	140	50	22.0	6.0	30	R
	32	140	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	R
	32	250	50	22.0	6.0	30	
	40	150	60	28.0	8.0	37	R
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	R
	40	300	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	R
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	R
	40	300	60	28.0	8.0	37	
	50	170	80	34.0	9.0	47	R
	50	170	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	R
	50	300	80	34.0	9.0	47	
	25	125	40	19.0	6.5	23	L
	25	125	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	L
	25	200	40	19.0	6.5	23	
	32	140	50	22.0	6.0	30	L
	32	140	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	L
	32	250	50	22.0	6.0	30	
	40	150	60	28.0	8.0	37	L
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	L
	40	300	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	L
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	L
	40	300	60	28.0	8.0	37	
	50	170	80	34.0	9.0	47	L
	50	170	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	L
	50	300	80	34.0	9.0	47	

R



L



Select an Insert

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

		For Grooving/Cutting off > F011, F013				
Seat Size	Breaker CW	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●
G	.157", 4.00 mm	●	●	●	●	●

		For Multifunctional Grooving > F013, F014			
Seat Size	Breaker CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
F	.118", 3.00 mm				●
	RE 0.2 mm	●	●	●	
	RE 0.4 mm	●	●	●	
	RE 0.8 mm			●	
	.125", 3.18 mm				●
	RE 0.2 mm	●	●	●	
G	.128", 3.24 mm	●			
	.157", 4.00 mm				●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm	●		●	
	.167", 4.24 mm	●			

● : Gauge insert shown dimensions

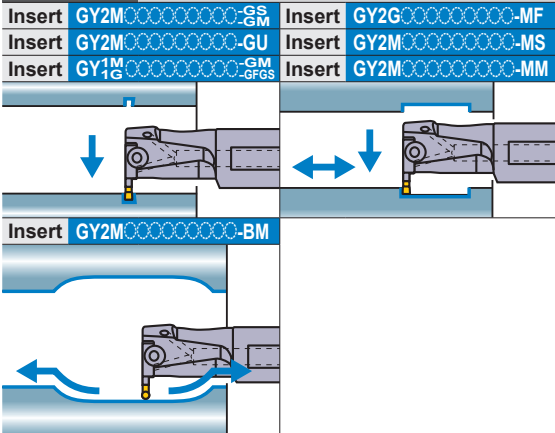
IDENTIFICATION > F008, F009
 CUTTING CONDITIONS > F213
 INSTRUCTION MANUAL > F215

F

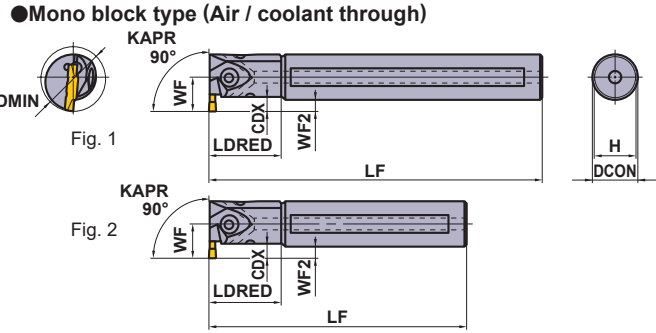
GROOVING / CUTTING OFF

GY SERIES (INTERNAL GROOVING)

6-2 90° type holder (Metric)



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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	CDX (mm) *3	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	7	32	Mono Block	R	GYAR25K90B-H07	●	—	—	2
				Mono Block	L	GYAL25K90B-H07	●	—	—	2
				Mono Block	R	GYAR25R90B-H07	●	—	—	1
				Mono Block	L	GYAL25R90B-H07	●	—	—	1
		4.5—11.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-H12	●	4
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-H12	●	4
				Modular	R	GYDR32S90C-M20L	●	GYM20LA-H12	●	3
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-H12	●	3
	6—11.5 *1		50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-H12	●	4
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-H12	●	4
			Modular	R	GYDR40T90D-M20L	●	GYM20LA-H12	●	3	
			Modular	L	GYDL40T90D-M20R	●	GYM20RA-H12	●	3	
	7.5—13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-H14	●	4	
			Modular	L	GYDL40M90D-M25R	●	GYM25RA-H14	●	4	
			Modular	R	GYDR40T90D-M25L	●	GYM25LA-H14	●	3	
			Modular	L	GYDL40T90D-M25R	●	GYM25RA-H14	●	3	
70		Modular	R	GYDR50P90F-M25L	●	GYM25LA-H14	●	4		
		Modular	L	GYDL50P90F-M25R	●	GYM25RA-H14	●	4		
		Modular	R	GYDR50T90F-M25L	●	GYM25LA-H14	●	3		
		Modular	L	GYDL50T90F-M25R	●	GYM25RA-H14	●	3		
J	6.00 6.31 6.35	7.5—13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-J14	●	4
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-J14	●	4
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-J14	●	3
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-J14	●	3
			70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-J14	●	4
				Modular	L	GYDL50P90F-M25R	●	GYM25RA-J14	●	4
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-J14	●	3
				Modular	L	GYDL50T90F-M25R	●	GYM25RA-J14	●	3

CW = Cutting Width CDX = Max. Groove Depth DMIN = Minimum cutting diameter

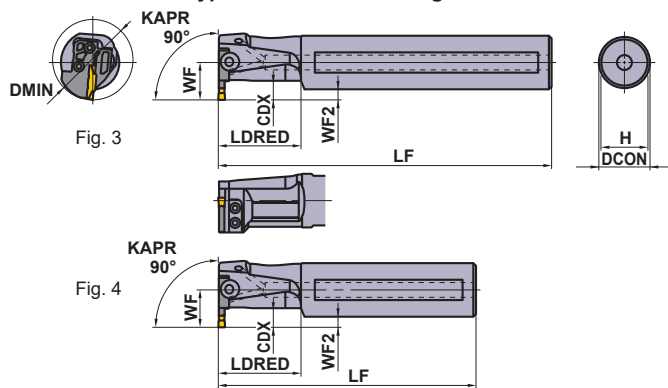
*1 The maximum groove depth (CDX) varies according to the cutting diameter (DMIN). For details, please refer to page F212.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and WF2 values may vary.

*3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

★ Wrench : ① : Clamp Screw, ② : Blade Screw

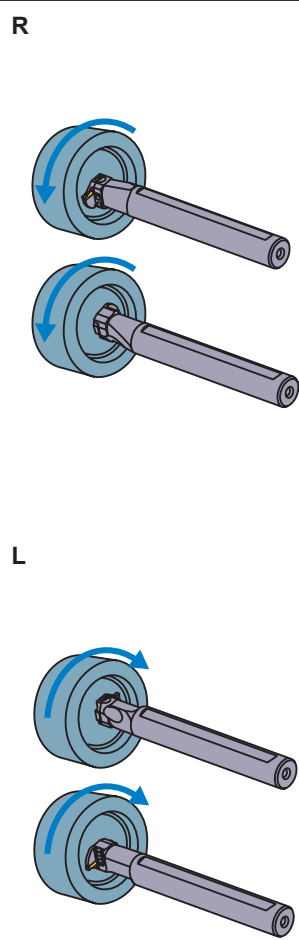


Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/L25○90B-○07	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L50○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *2						Cutting Mode
	DCON	LF	LDRED	WF	WF2	H	
	25	125	40	19	6.5	23	R
	25	125	40	19	6.5	23	
	25	200	40	19	6.5	23	
	25	200	40	19	6.5	23	
	32	140	50	22	6.0	30	L
	32	140	50	22	6.0	30	
	32	250	50	22	6.0	30	
	32	250	50	22	6.0	30	
	40	150	60	28	8.0	37	
	40	150	60	28	8.0	37	
	40	300	60	28	8.0	37	
	40	300	60	28	8.0	37	
	40	150	60	28	8.0	37	
	40	150	60	28	8.0	37	
	40	300	60	28	8.0	37	
	40	300	60	28	8.0	37	
	50	170	80	34	9.0	47	
	50	170	80	34	9.0	47	
	50	300	80	34	9.0	47	
	50	300	80	34	9.0	47	
	50	170	80	34	9.0	47	
	50	170	80	34	9.0	47	
	50	300	80	34	9.0	47	
	50	300	80	34	9.0	47	



Select an Insert

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

		For Grooving/Cutting off > F011, F013				
Seat Size	Breaker CW	GU	GS	GM	GFGS	
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)	
H	.187", 4.75 mm	●	●	●	●	
	.197", 5.00 mm	●	●	●	●	
J	.236", 6.00 mm	●	●	●	●	
	.250", 6.35 mm	●	●	●	●	

		For Multifunctional Grooving > F013, F014				
Seat Size	Breaker CW	MF	MS	MM	BM	
		(Finish)	(Low)	(Medium)	(Copying, Rescoring)	
H	.187", 4.75 mm	●			●	
	RE 0.2 mm	●				
	RE 0.4 mm	●				
	RE 0.8 mm	●				
	.197", 5.00 mm	●			●	
	RE 0.2 mm	●				
J	.206", 5.24 mm	●			●	
	RE 0.2 mm	●				
	RE 0.4 mm	●	●	●		
	RE 0.8 mm	●	●	●		
	.248", 6.31 mm	●			●	
	RE 0.2 mm	●				
J	.250", 6.35 mm	●			●	
	RE 0.2 mm	●				
	RE 0.8 mm	●				

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

GY SERIES (EXTERNAL GROOVING PSC TYPE)

7-1 00° type holder (Inch)

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

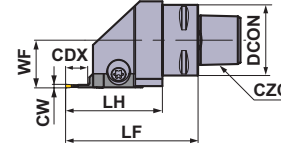
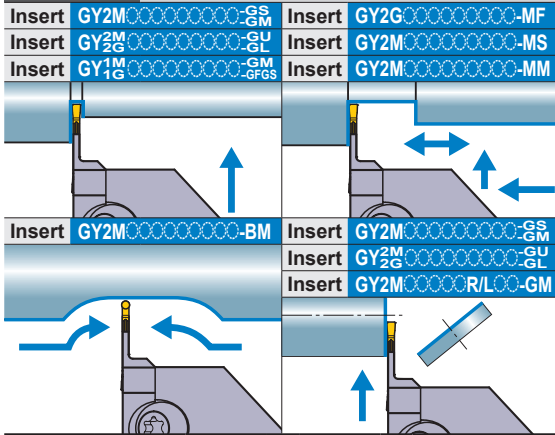
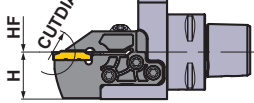
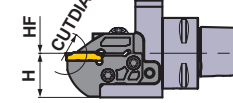
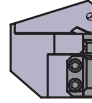


Fig. 1

Fig. 2



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
D	.079 .088	.236	.472	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-D06	●	1	C3
				L	C3-GYHLDX00-M20L	●	GYM20LA-D06	●	1		
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-D06	●	1	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-D06	●	1		
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-D06	●	1	C5
				L	C5-GYHLEX00-M25L	●	GYM25LA-D06	●	1		
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-D06	●	1	C6
				L	C6-GYHLF00-M25L	●	GYM25LA-D06	●	1		
		.394	.787	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-D10	●	1	C3
				L	C3-GYHLDX00-M20L	●	GYM20LA-D10	●	1		
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-D12	●	1	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-D12	●	1		
		.472	.945	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-D12	●	1	C5
				L	C5-GYHLEX00-M25L	●	GYM25LA-D12	●	1		
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-D12	●	1	C6
				L	C6-GYHLF00-M25L	●	GYM25LA-D12	●	1		
		.709*4	1.417	Modular	R	C3-GYHRDX00-M20R	●	GYM20RB-D18	●	2	C3
				L	C3-GYHLDX00-M20L	●	GYM20LB-D18	●	2		
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-D20	●	2	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-D20	●	2		
.787*1	1.575*2	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-D20	●	2	C5		
		L	C5-GYHLEX00-M25L	●	GYM25LA-D20	●	2				
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-D20	●	2	C6		
		L	C6-GYHLF00-M25L	●	GYM25LA-D20	●	2				

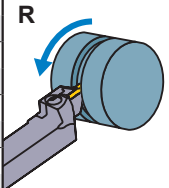
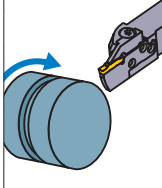
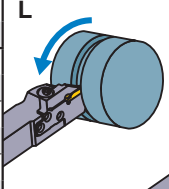
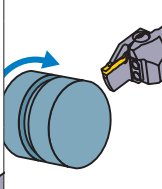




CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.260	2.323	1.724	.866	0	.787		
	1.260	2.323	1.724	.866	0	.787		
	1.575	2.638	1.843	1.063	0	.984		
	1.575	2.638	1.843	1.063	0	.984		
	1.969	2.638	1.843	1.378	0	1.063		
	1.969	2.638	1.843	1.378	0	1.063		
	2.480	2.835	1.961	1.772	0	1.378		
	2.480	2.835	1.961	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.260	2.795	2.197	.866	0	.787		
	1.260	2.795	2.197	.866	0	.787		
	1.575	3.189	2.394	1.063	0	.984		
	1.575	3.189	2.394	1.063	0	.984		
	1.969	3.189	2.394	1.378	0	1.063		
	1.969	3.189	2.394	1.378	0	1.063		
	2.480	3.386	2.512	1.772	0	1.378		
	2.480	3.386	2.512	1.772	0	1.378		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW	R	R	R	R/L	
D	.079", 2.00 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW					Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●			




● : Gauge insert shown dimensions

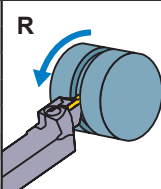
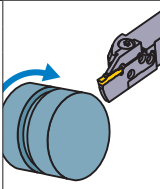
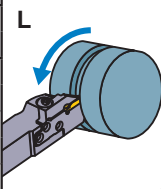
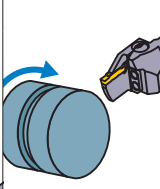




F

GROOVING / CUTTING OFF

IDENTIFICATION > F010
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.260	2.323	1.724	.866	0	.787		
	1.260	2.323	1.724	.866	0	.787		
	1.575	2.638	1.843	1.063	0	.984		
	1.575	2.638	1.843	1.063	0	.984		
	1.969	2.638	1.843	1.378	0	1.063		
	1.969	2.638	1.843	1.378	0	1.063		
	2.480	2.835	1.961	1.772	0	1.378		
	2.480	2.835	1.961	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.260	2.795	2.197	.866	0	.787		
	1.260	2.795	2.197	.866	0	.787		
	1.575	3.189	2.394	1.063	0	.984		
	1.575	3.189	2.394	1.063	0	.984		
	1.969	3.189	2.394	1.378	0	1.063		
	1.969	3.189	2.394	1.378	0	1.063		
	2.480	3.386	2.512	1.772	0	1.378		
	2.480	3.386	2.512	1.772	0	1.378		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW		Neutral	Neutral	Neutral	Neutral	Neutral
		Neutral	Neutral	Neutral	Neutral	Neutral
E	.094", 2.39 mm	●	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW		R	R	R	R/L
		R	R	R	R/L
E	.098", 2.50 mm		●	●	●

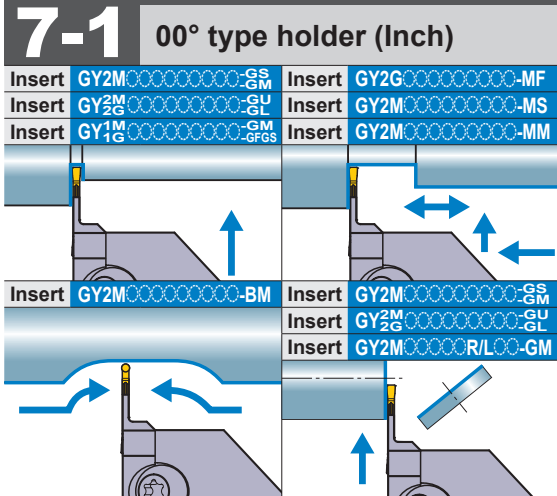
For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Reccessing)
CW					Ball nose
					Ball nose
E	.094", 2.39 mm	●			
	.098", 2.50 mm	●	●	●	●
E	.108", 2.74 mm	●			●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

GY SERIES (EXTERNAL GROOVING PSC TYPE)



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

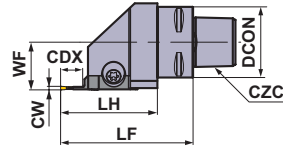
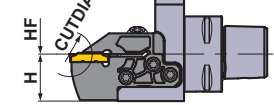
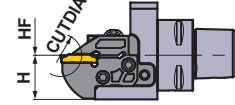
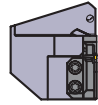


Fig. 1

Fig. 2



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
F	.118 .125 .128	.236	.472	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-F06	●	1	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-F06	●	1	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-F06	●	1	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-F06	●	1	
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-F06	●	1	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-F06	●	1	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-F06	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-F06	●	1	
		.394	.787	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-F10	●	1	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-F10	●	1	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-F12	●	1	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-F12	●	1	
		.472	.945	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-F12	●	1	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-F12	●	1	
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-F12	●	1	C6
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-F12	●	1	
		.709*4	1.417	Modular	R	C3-GYHRDX00-M20R	●	GYM20RB-F18	●	2	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LB-F18	●	2	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-F20	●	2	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-F20	●	2	
.787*1	1.575*2	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-F20	●	2	C5		
		Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-F20	●	2			
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-F20	●	2	C6		
		Modular	L	C6-GYHLF00-M25L	●	GYM25LA-F20	●	2			

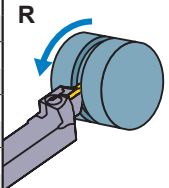
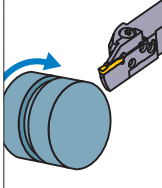
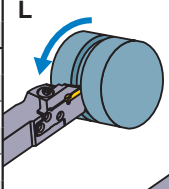
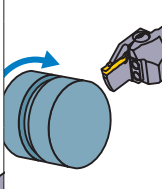
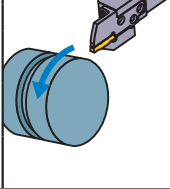
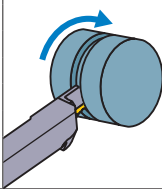


CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
 *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.260	2.323	1.724	.866	0	.787		
	1.260	2.323	1.724	.866	0	.787		
	1.575	2.638	1.843	1.063	0	.984		
	1.575	2.638	1.843	1.063	0	.984		
	1.969	2.638	1.843	1.378	0	1.063		
	1.969	2.638	1.843	1.378	0	1.063		
	2.480	2.835	1.961	1.772	0	1.378		
	2.480	2.835	1.961	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.260	2.795	2.197	.866	0	.787		
	1.260	2.795	2.197	.866	0	.787		
	1.575	3.189	2.394	1.063	0	.984		
	1.575	3.189	2.394	1.063	0	.984		
	1.969	3.189	2.394	1.378	0	1.063		
	1.969	3.189	2.394	1.378	0	1.063		
	2.480	3.386	2.512	1.772	0	1.378		
	2.480	3.386	2.512	1.772	0	1.378		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW		Neutral	Neutral	Neutral	Neutral	Neutral
	F	.118", 3.00 mm	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW		R	R	R	R/L
	F	.118", 3.00 mm		●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW					Ball nose
	F	.118", 3.00 mm			●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions

F GROOVING / CUTTING OFF

GY SERIES (EXTERNAL GROOVING PSC TYPE)

7-1 00° type holder (Inch)

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

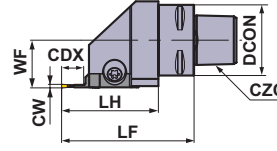
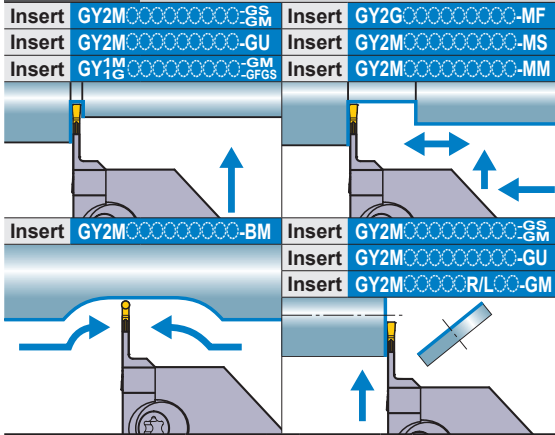


Fig. 1

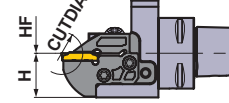
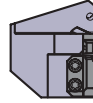


Fig. 2

Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC	
						Holder	Stock	Modular Blade	Stock			
G	.157 .167	.315	.630	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-G08	●	1	C4	
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-G08	●	1		
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-G08	●	1	C5	
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-G08	●	1		
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-G08	●	1	C6	
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-G08	●	1		
		.472	.945	.945	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-G12	●	1	C3
					Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-G12	●	1	
					Modular	R	C4-GYHREX00-M25R	●	GYM25RA-G14	●	1	C4
					Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-G14	●	1	
					Modular	R	C5-GYHREX00-M25R	●	GYM25RA-G14	●	1	C5
					Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-G14	●	1	
	.551	1.102	1.102	Modular	R	C6-GYHRF00-M25R	●	GYM25RA-G14	●	1	C6	
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-G14	●	1		
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-G25	●	2	C4	
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-G25	●	2		
Modular				R	C5-GYHREX00-M25R	●	GYM25RA-G25	●	2	C5		
Modular				L	C5-GYHLEX00-M25L	●	GYM25LA-G25	●	2			
.984*1	1.969*2	1.969*2	Modular	R	C6-GYHRF00-M25R	●	GYM25RA-G25	●	2	C6		
			Modular	L	C6-GYHLF00-M25L	●	GYM25LA-G25	●	2			
			Modular	R	C5-GYHREX00-M25R	●	GYM25RA-G25	●	2	C5		
			Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-G25	●	2			

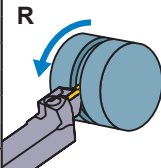
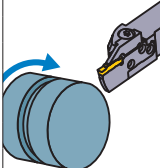
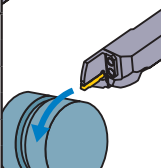
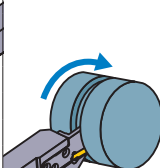
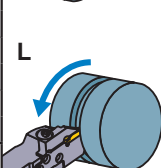
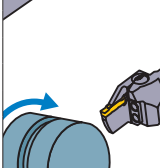
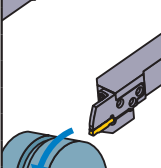
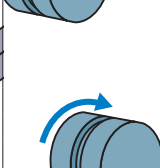
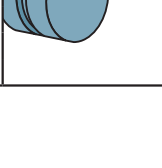
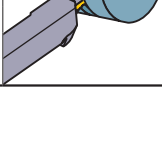




CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.575	2.717	1.921	1.063	0	.984		
	1.575	2.717	1.921	1.063	0	.984		
	1.969	2.717	1.921	1.378	0	1.063		
	1.969	2.717	1.921	1.378	0	1.063		
	2.480	2.913	2.039	1.772	0	1.378		
	2.480	2.913	2.039	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.575	3.386	2.591	1.063	0	.984		
	1.575	3.386	2.591	1.063	0	.984		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	2.480	3.583	2.709	1.772	0	1.378		
	2.480	3.583	2.709	1.772	0	1.378		

Select an Insert

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

For Grooving/Cutting off > F011-F013

Seat Size	Breaker	GU	GS	GM	GFGS	05-GM
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)	(Cutting off)
CW		Neutral	Neutral	Neutral	Neutral	Hand
G	.157", 4.00 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014

Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW					Ball nose
G	.157", 4.00 mm	●	●	●	●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.167", 4.24 mm	●			

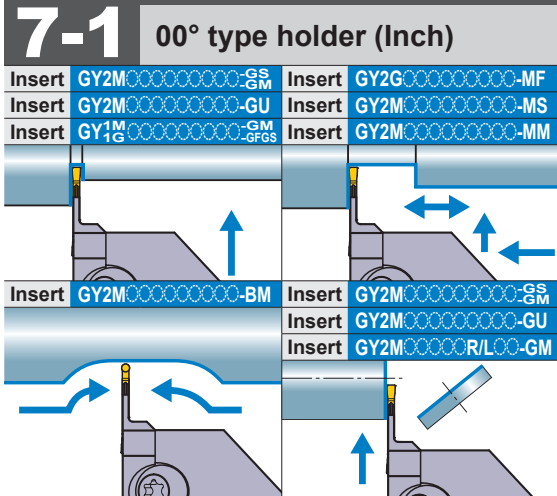
● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

IDENTIFICATION > F010
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL GROOVING PSC TYPE)



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

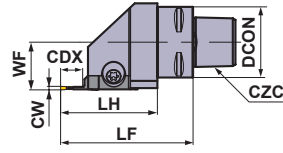
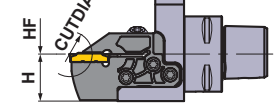
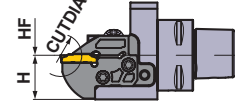
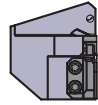


Fig. 1

Fig. 2



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC	
						Holder	Stock	Modular Blade	Stock			
H	.187 .197 .206	.315	.630	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-H08	●	1	C4	
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-H08	●	1		
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-H08	●	1	C5	
		Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-H08	●	1				
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-H08	●	1	C6			
		Modular	L	C6-GYHLF00-M25L	●	GYM25LA-H08	●	1				
	.472	.945	.551	1.102	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-H12	●	1	C3
					Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-H12	●	1	
					Modular	R	C4-GYHREX00-M25R	●	GYM25RA-H14	●	1	C4
					Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-H14	●	1	
					Modular	R	C5-GYHREX00-M25R	●	GYM25RA-H14	●	1	C5
					Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-H14	●	1	
.984*1	1.969*2	.551	1.102	Modular	R	C6-GYHRF00-M25R	●	GYM25RA-H14	●	1	C6	
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-H14	●	1		
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-H25	●	2	C4	
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-H25	●	2		
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-H25	●	2	C5	
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-H25	●	2		
J	.236 .248 .250	.315	.630	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-J08	●	1	C4	
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-J08	●	1		
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-J08	●	1	C5	
		Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-J08	●	1				
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-J08	●	1	C6			
		Modular	L	C6-GYHLF00-M25L	●	GYM25LA-J08	●	1				
	.984*1	1.969*2	.551	1.102	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-J14	●	1	C4
					Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-J14	●	1	
					Modular	R	C5-GYHREX00-M25R	●	GYM25RA-J14	●	1	C5
					Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-J14	●	1	
					Modular	R	C6-GYHRF00-M25R	●	GYM25RA-J14	●	1	C6
					Modular	L	C6-GYHLF00-M25L	●	GYM25LA-J14	●	1	
.984*1	1.969*2	.551	1.102	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-J25	●	2	C4	
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-J25	●	2		
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-J25	●	2	C5	
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-J25	●	2		
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-J25	●	2	C6	
				Modular	L	C6-GYHLF00-M25L	●	GYM25LA-J25	●	2		

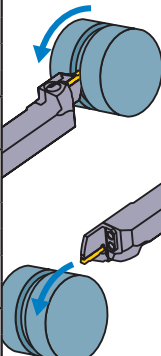
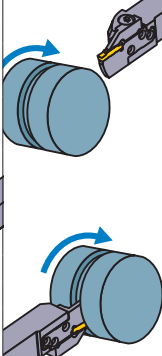
CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
 *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.575	2.717	1.921	1.063	0	.984		
	1.575	2.717	1.921	1.063	0	.984		
	1.969	2.717	1.921	1.378	0	1.063		
	1.969	2.717	1.921	1.378	0	1.063		
	2.480	2.913	2.039	1.772	0	1.378		
	2.480	2.913	2.039	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.575	3.386	2.591	1.063	0	.984		
	1.575	3.386	2.591	1.063	0	.984		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	2.480	3.583	2.709	1.772	0	1.378		
	2.480	3.583	2.709	1.772	0	1.378		
	1.575	2.717	1.921	1.063	0	.984		
	1.575	2.717	1.921	1.063	0	.984		
	1.969	2.717	1.921	1.378	0	1.063		
	1.969	2.717	1.921	1.378	0	1.063		
	2.480	2.913	2.039	1.772	0	1.378		
	2.480	2.913	2.039	1.772	0	1.378		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.575	3.386	2.591	1.063	0	.984		
	1.575	3.386	2.591	1.063	0	.984		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	2.480	3.583	2.709	1.772	0	1.378		
	2.480	3.583	2.709	1.772	0	1.378		

Select an Insert

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

For Grooving/Cutting off > F011-F013						
Seat Size	Breaker	GU	GS	GM	GFGS	05-GM
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)	(Cutting off)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Hand
	.187", 4.75 mm	●	●	●	●	●
H	.197", 5.00 mm	●	●	●	●	●
J	.236", 6.00 mm	●	●	●	●	●
	.250", 6.35 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW	Neutral				
	.187", 4.75 mm	●			●
	RE .008"	●			
	RE .016"	●			
H	.197", 5.00 mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
J	.206", 5.24 mm	●			●
	.236", 6.00 mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
J	.248", 6.31 mm	●			●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			

● : Gauge insert shown dimensions

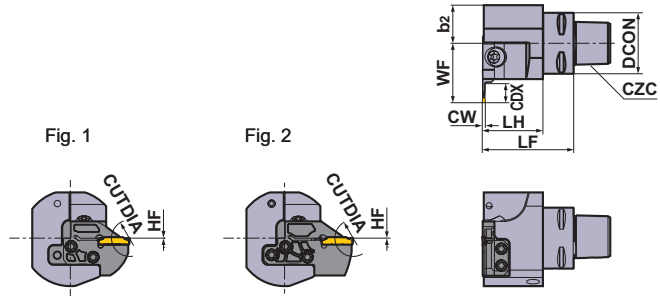
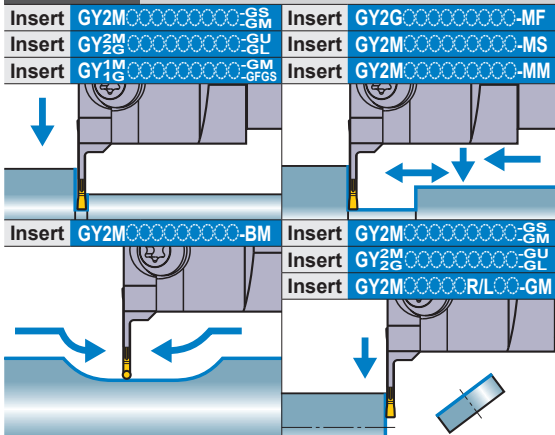
IDENTIFICATION > F010
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL GROOVING PSC TYPE)

8-1 90° type holder (Inch)

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
D	.079 .088	.236	.472	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-D06	●	1	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-D06	●	1		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-D06	●	1	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-D06	●	1		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-D06	●	1	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-D06	●	1		
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-D06	●	1	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-D06	●	1		
		.394	.787	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-D10	●	1	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-D10	●	1		
		.472	.945	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-D12	●	1	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-D12	●	1		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-D12	●	1	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-D12	●	1		
		.709*4	1.417	Modular	R	C3-GYHRCX90-M20L	●	GYM20LB-D18	●	2	C3
				L	C3-GYHLCX90-M20R	●	GYM20RB-D18	●	2		
		.787*1	1.575*2	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-D20	●	2	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-D20	●	2		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-D20	●	2	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-D20	●	2		
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-D20	●	2	C6		
		L	C6-GYHLE90-M25R	●	GYM25RA-D20	●	2				

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.




*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.

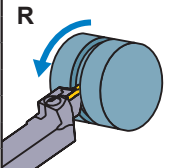
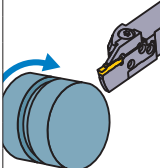
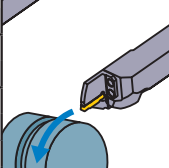
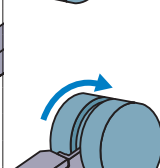
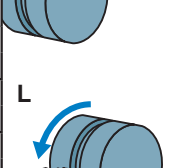
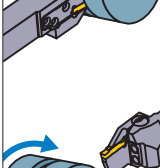
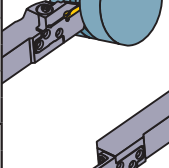
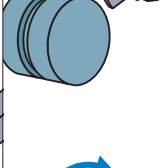
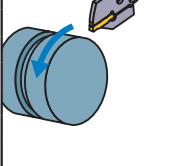
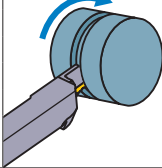






*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LCX90-M20L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	b ₂	Clockwise	Anticlockwise
	1.260	2.165	1.567	1.024	0	.787		
	1.260	2.165	1.567	1.024	0	.787		
	1.575	2.362	1.567	1.220	0	.984		
	1.575	2.362	1.567	1.220	0	.984		
	1.969	2.362	1.567	1.299	0	1.024		
	1.969	2.362	1.567	1.299	0	1.024		
	2.480	2.756	1.882	1.575	0	1.319		
	2.480	2.756	1.882	1.575	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.260	2.165	1.567	1.496	0	.787		
	1.260	2.165	1.567	1.496	0	.787		
	1.575	2.362	1.567	1.772	0	.984		
	1.575	2.362	1.567	1.772	0	.984		
	1.969	2.362	1.567	1.850	0	1.024		
	1.969	2.362	1.567	1.850	0	1.024		
	2.480	2.756	1.882	2.126	0	1.319		
	2.480	2.756	1.882	2.126	0	1.319		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
D	.079", 2.00 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW	R	R	R	R/L	
D	.079", 2.00 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW					Ball nose
D	.079", 2.00 mm	●	●	●	●
	.088", 2.24 mm	●			

● : Gauge insert shown dimensions

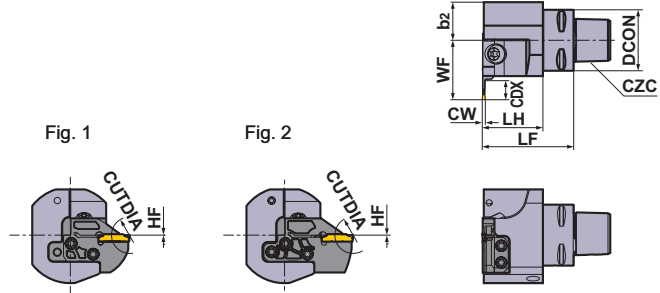
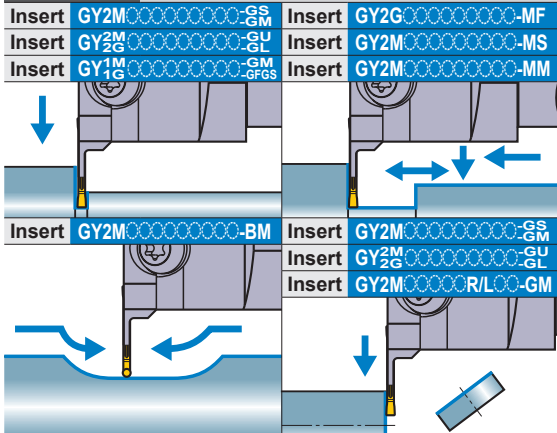
F

GROOVING / CUTTING OFF

GY SERIES (EXTERNAL GROOVING PSC TYPE)

8-1 90° type holder (Inch)

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
E	.094 .098 .108	.236	.472	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-E06	●	1	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-E06	●	1		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-E06	●	1	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-E06	●	1		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-E06	●	1	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-E06	●	1		
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-E06	●	1	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-E06	●	1		
		.394	.787	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-E10	●	1	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-E10	●	1		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-E12	●	1	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-E12	●	1		
		.472	.945	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-E12	●	1	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-E12	●	1		
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-E12	●	1	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-E12	●	1		
		.709*4	1.417	Modular	R	C3-GYHRCX90-M20L	●	GYM20LB-E18	●	2	C3
				L	C3-GYHLCX90-M20R	●	GYM20RB-E18	●	2		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-E20	●	2	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-E20	●	2		
.787*1	1.575*2	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-E20	●	2	C5		
		L	C5-GYHLD90-M25R	●	GYM25RA-E20	●	2				
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-E20	●	2	C6		
		L	C6-GYHLE90-M25R	●	GYM25RA-E20	●	2				

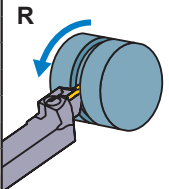
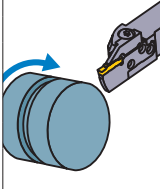
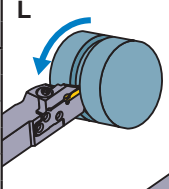
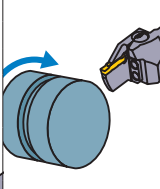
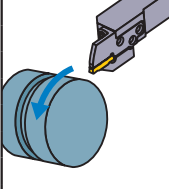
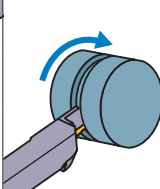


CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LCX90-M20L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	b ₂	Clockwise	Anticlockwise
	1.260	2.165	1.567	1.024	0	.787		
	1.260	2.165	1.567	1.024	0	.787		
	1.575	2.362	1.567	1.220	0	.984		
	1.575	2.362	1.567	1.220	0	.984		
	1.969	2.362	1.567	1.299	0	1.024		
	1.969	2.362	1.567	1.299	0	1.024		
	2.480	2.756	1.882	1.575	0	1.319		
	2.480	2.756	1.882	1.575	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.260	2.165	1.567	1.496	0	.787		
	1.260	2.165	1.567	1.496	0	.787		
	1.575	2.362	1.567	1.772	0	.984		
	1.575	2.362	1.567	1.772	0	.984		
	1.969	2.362	1.567	1.850	0	1.024		
	1.969	2.362	1.567	1.850	0	1.024		
	2.480	2.756	1.882	2.126	0	1.319		
	2.480	2.756	1.882	2.126	0	1.319		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU	GS	GM	GL	GFGS
		(Gummy Steel)	(Low)	(Medium)	(Aluminum Alloy)	(Hardened steel)
CW		Neutral	Neutral	Neutral	Neutral	Neutral
	E	.094", 2.39 mm	●	●	●	●
	.098", 2.50 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
CW		R	R	R	R/L
	E	.098", 2.50 mm	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying, Recessing)
CW					Ball nose
	E	.094", 2.39 mm	●	●	●
	.098", 2.50 mm	●	●	●	●
	.108", 2.74 mm	●			●

● : Gauge insert shown dimensions

F

GROOVING / CUTTING OFF

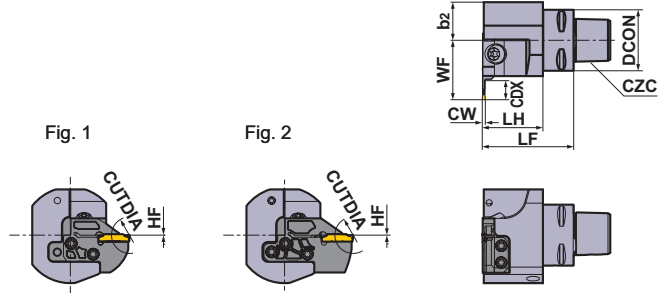
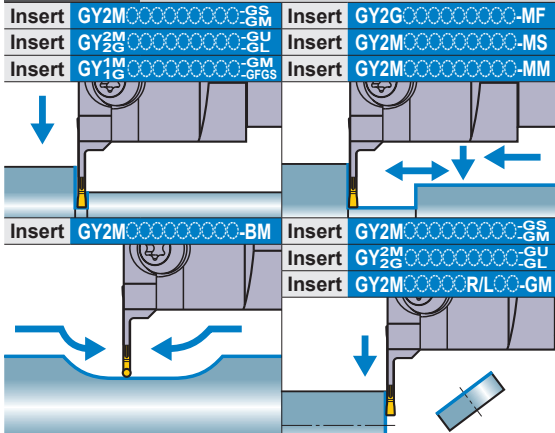
IDENTIFICATION > F010
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL GROOVING PSC TYPE)

8-1 90° type holder (Inch)

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

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
F	.118 .125 .128	.236	.472	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-F06	●	1	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-F06	●	1		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-F06	●	1	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-F06	●	1		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-F06	●	1	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-F06	●	1		
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-F06	●	1	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-F06	●	1		
		.394	.787	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-F10	●	1	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-F10	●	1		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-F12	●	1	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-F12	●	1		
		.472	.945	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-F12	●	1	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-F12	●	1		
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-F12	●	1	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-F12	●	1		
		.709*4	1.417	Modular	R	C3-GYHRCX90-M20L	●	GYM20LB-F18	●	2	C3
				L	C3-GYHLCX90-M20R	●	GYM20RB-F18	●	2		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-F20	●	2	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-F20	●	2		
.787*1	1.575*2	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-F20	●	2	C5		
		L	C5-GYHLD90-M25R	●	GYM25RA-F20	●	2				
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-F20	●	2	C6		
		L	C6-GYHLE90-M25R	●	GYM25RA-F20	●	2				

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

*1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.




*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.

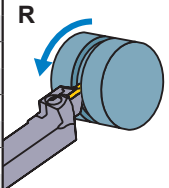
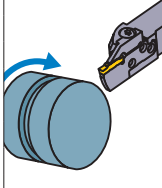
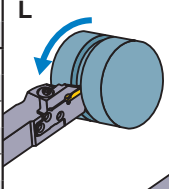
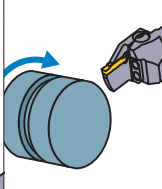
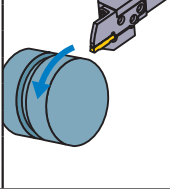
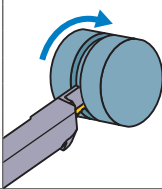


*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.

*4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LCX90-M20L/R		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	b ₂	Clockwise	Anticlockwise
	1.260	2.165	1.567	1.024	0	.787		
	1.260	2.165	1.567	1.024	0	.787		
	1.575	2.362	1.567	1.220	0	.984		
	1.575	2.362	1.567	1.220	0	.984		
	1.969	2.362	1.567	1.299	0	1.024		
	1.969	2.362	1.567	1.299	0	1.024		
	2.480	2.756	1.882	1.575	0	1.319		
	2.480	2.756	1.882	1.575	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.260	2.165	1.567	1.496	0	.787		
	1.260	2.165	1.567	1.496	0	.787		
	1.575	2.362	1.567	1.772	0	.984		
	1.575	2.362	1.567	1.772	0	.984		
	1.969	2.362	1.567	1.850	0	1.024		
	1.969	2.362	1.567	1.850	0	1.024		
	2.480	2.756	1.882	2.126	0	1.319		
	2.480	2.756	1.882	2.126	0	1.319		

Select an Insert

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

For Grooving/Cutting off > F011, F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GL (Aluminum Alloy)	GFGS (Hardened steel)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Neutral
F	.118", 3.00 mm	●	●	●	●	●
	.125", 3.18 mm	●	●	●	●	●

For Cutting off > F012					
Seat Size	Breaker	05-GS (Low)	08-GS (Low)	15-GS (Low)	05-GM (Medium)
CW	R	R	R	R	R/L
F	.118", 3.00 mm		●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
CW					Ball nose
F	.118", 3.00 mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18 mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24 mm	●			

● : Gauge insert shown dimensions



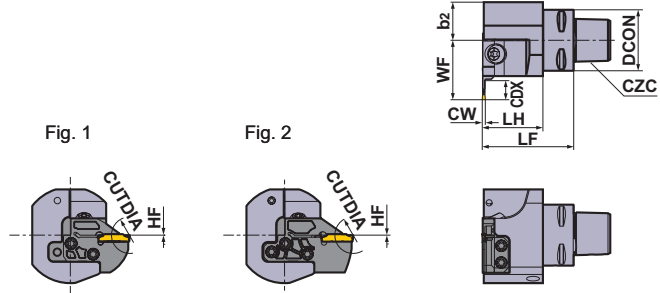
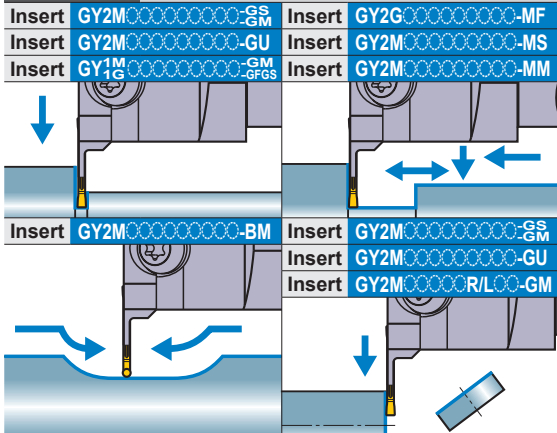
GROOVING / CUTTING OFF

IDENTIFICATION > F010
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL GROOVING PSC TYPE)

8-1 90° type holder (Inch)

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
G	.157 .167	.315	.630	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-G08	●	1	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-G08	●	1		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-G08	●	1	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-G08	●	1		
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-G08	●	1	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-G08	●	1		
		.472	.945	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-G12	●	1	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-G12	●	1		
		.551	1.102	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-G14	●	1	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-G14	●	1		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-G14	●	1	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-G14	●	1		
	Modular			R	C6-GYHRE90-M25L	●	GYM25LA-G14	●	1	C6	
	L			C6-GYHLE90-M25R	●	GYM25RA-G14	●	1			
	.984*1	1.969*2	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-G25	●	2	C4	
			L	C4-GYHLD90-M25R	●	GYM25RA-G25	●	2			
			Modular	R	C5-GYHRD90-M25L	●	GYM25LA-G25	●	2	C5	
			L	C5-GYHLD90-M25R	●	GYM25RA-G25	●	2			
Modular			R	C6-GYHRE90-M25L	●	GYM25LA-G25	●	2	C6		
L			C6-GYHLE90-M25R	●	GYM25RA-G25	●	2				

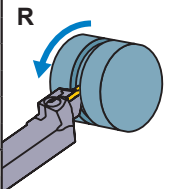
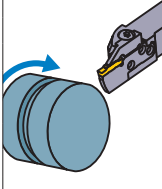
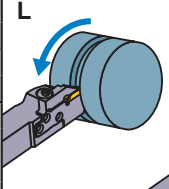
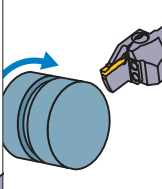




CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LCX90-M20L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	b ₂	Clockwise	Anticlockwise
	1.575	2.362	1.567	1.299	0	.984		
	1.575	2.362	1.567	1.299	0	.984		
	1.969	2.362	1.567	1.378	0	1.024		
	1.969	2.362	1.567	1.378	0	1.024		
	2.480	2.756	1.882	1.654	0	1.319		
	2.480	2.756	1.882	1.654	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.575	2.362	1.567	1.969	0	.984		
	1.575	2.362	1.567	1.969	0	.984		
	1.969	2.362	1.567	2.047	0	1.024		
	1.969	2.362	1.567	2.047	0	1.024		
	2.480	2.756	1.882	2.323	0	1.319		
	2.480	2.756	1.882	2.323	0	1.319		

Select an Insert

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

For Grooving/Cutting off > F011-F013						
Seat Size	Breaker	GU (Gummy Steel)	GS (Low)	GM (Medium)	GFGS (Hardened steel)	05-GM (Cutting off)
	CW	Neutral	Neutral	Neutral	Neutral	Hand
G	.157", 4.00 mm	●	●	●	●	●

For Multifunctional Grooving > F013, F014					
Seat Size	Breaker	MF (Finish)	MS (Low)	MM (Medium)	BM (Copying, Recessing)
	CW				
G	.157", 4.00 mm	●	●	●	●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.167", 4.24 mm	●			

● : Gauge insert shown dimensions

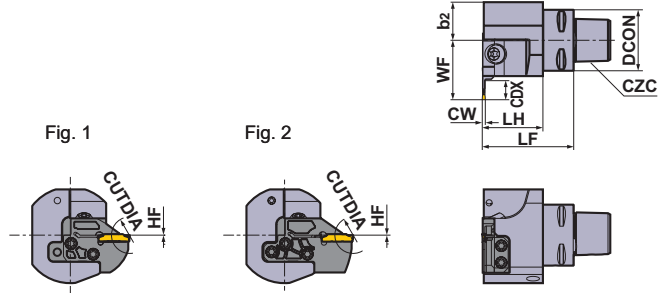
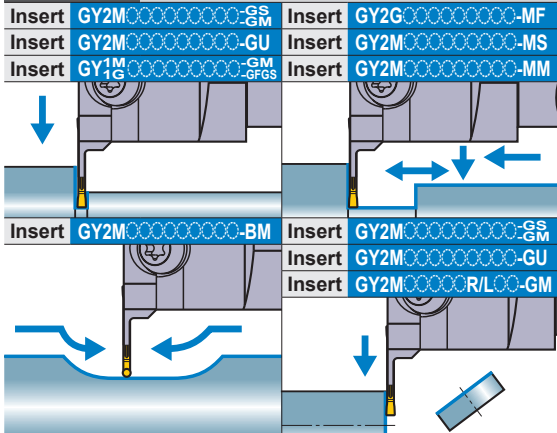
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GROOVING / CUTTING OFF

IDENTIFICATION > F010
CUTTING CONDITIONS > F194
INSTRUCTION MANUAL > F201

GY SERIES (EXTERNAL GROOVING PSC TYPE)

8-1 90° type holder (Inch)

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



Right hand tool holder shown.

F

GROOVING / CUTTING OFF




Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
H	.187 .197 .206	.315	.630	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-H08	●	1	C4
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-H08	●	1	
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-H08	●	1	C5
		Modular	L	C5-GYHLD90-M25R	●	GYM25RA-H08	●	1			
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-H08	●	1	C6		
		Modular	L	C6-GYHLE90-M25R	●	GYM25RA-H08	●	1			
	.472 .551	.472	.945	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-H12	●	1	C3
				Modular	L	C3-GYHLCX90-M20R	●	GYM20RA-H12	●	1	
		.551	1.102	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-H14	●	1	C4
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-H14	●	1	
			Modular	R	C5-GYHRD90-M25L	●	GYM25LA-H14	●	1	C5	
			Modular	L	C5-GYHLD90-M25R	●	GYM25RA-H14	●	1		
.984*1	1.969*2	Modular	R	C6-GYHRE90-M25L	●	GYM25LA-H14	●	1	C6		
		Modular	L	C6-GYHLE90-M25R	●	GYM25RA-H14	●	1			
		Modular	R	C4-GYHRD90-M25L	●	GYM25LA-H25	●	2	C4		
	Modular	L	C4-GYHLD90-M25R	●	GYM25RA-H25	●	2				
	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-H25	●	2	C5			
	Modular	L	C5-GYHLD90-M25R	●	GYM25RA-H25	●	2				
J	.236 .248 .250	.315	.630	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-H25	●	2	C6
				Modular	L	C4-GYHLE90-M25R	●	GYM25RA-H25	●	2	
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-J08	●	1	C4
		Modular	L	C4-GYHLD90-M25R	●	GYM25RA-J08	●	1			
		.551	1.102	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-J08	●	1	C5
				Modular	L	C5-GYHLD90-M25R	●	GYM25RA-J08	●	1	
	Modular			R	C6-GYHRE90-M25L	●	GYM25LA-J08	●	1	C6	
	Modular	L	C6-GYHLE90-M25R	●	GYM25RA-J08	●	1				
	.984*1	1.969*2	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-J14	●	1	C4	
			Modular	L	C4-GYHLD90-M25R	●	GYM25RA-J14	●	1		
			Modular	R	C5-GYHRD90-M25L	●	GYM25LA-J14	●	1	C5	
		Modular	L	C5-GYHLD90-M25R	●	GYM25RA-J14	●	1			
Modular		R	C6-GYHRE90-M25L	●	GYM25LA-J14	●	1	C6			
Modular		L	C6-GYHLE90-M25R	●	GYM25RA-J14	●	1				
.984*1	1.969*2	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-J25	●	2	C4		
		Modular	L	C4-GYHLD90-M25R	●	GYM25RA-J25	●	2			
		Modular	R	C5-GYHRD90-M25L	●	GYM25LA-J25	●	2	C5		
Modular	L	C5-GYHLD90-M25R	●	GYM25RA-J25	●	2					
Modular	R	C6-GYHRE90-M25L	●	GYM25LA-J25	●	2	C6				
Modular	L	C6-GYHLE90-M25R	●	GYM25RA-J25	●	2					

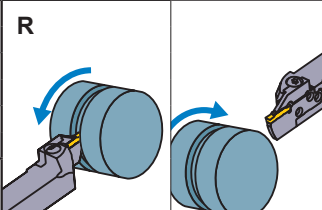
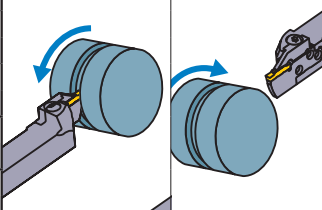
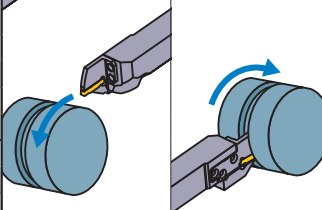
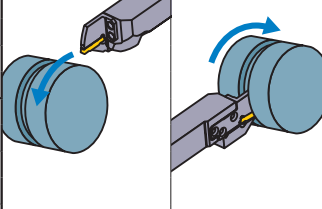
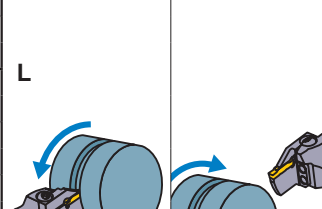
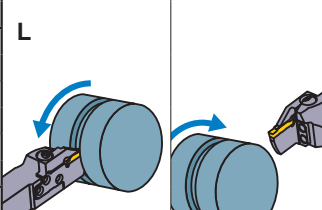
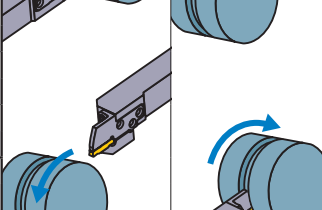
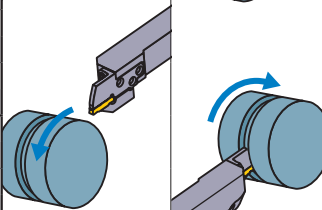
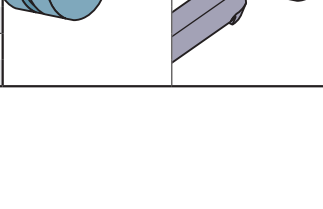
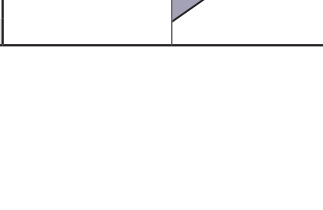


CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

- *1 The maximum groove depth (CDX) varies according to the insert used. Please refer to the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F011 to F015.
- *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
- *4 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to page F196.

● : USA Stock

★ Wrench : ① : Clamp Screw, ② : Blade Screw

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LCX90-M20L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	b ₂	Clockwise	Anticlockwise
	1.575	2.362	1.567	1.299	0	.984		
	1.575	2.362	1.567	1.299	0	.984		
	1.969	2.362	1.567	1.378	0	1.024		
	1.969	2.362	1.567	1.378	0	1.024		
	2.480	2.756	1.882	1.654	0	1.319		
	2.480	2.756	1.882	1.654	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.575	2.362	1.567	1.969	0	.984		
	1.575	2.362	1.567	1.969	0	.984		
	1.969	2.362	1.567	2.047	0	1.024		
	1.969	2.362	1.567	2.047	0	1.024		
	2.480	2.756	1.882	2.323	0	1.319		
	2.480	2.756	1.882	2.323	0	1.319		
	1.575	2.362	1.567	1.299	0	.984		
	1.575	2.362	1.567	1.299	0	.984		
	1.969	2.362	1.567	1.378	0	1.024		
	1.969	2.362	1.567	1.378	0	1.024		
	2.480	2.756	1.882	1.654	0	1.319		
	2.480	2.756	1.882	1.654	0	1.319		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.575	2.362	1.567	1.969	0	.984		
	1.575	2.362	1.567	1.969	0	.984		
	1.969	2.362	1.567	2.047	0	1.024		
	1.969	2.362	1.567	2.047	0	1.024		
	2.480	2.756	1.882	2.323	0	1.319		
	2.480	2.756	1.882	2.323	0	1.319		

Select an Insert

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

		For Grooving/Cutting off > F011-F013				
Seat Size	Breaker	GU	GS	GM	GFGS	05-GM
		(Gummy Steel)	(Low)	(Medium)	(Hardened steel)	(Cutting off)
CW	Neutral	Neutral	Neutral	Neutral	Neutral	Hand
	H	.187", 4.75 mm	●	●	●	●
J	.197", 5.00 mm	●	●	●	●	●
	.236", 6.00 mm	●	●	●	●	●
J	.250", 6.35 mm	●	●	●	●	●

		For Multifunctional Grooving > F013, F014				
Seat Size	Breaker	MF	MS	MM	BM	
		(Finish)	(Low)	(Medium)	(Copying, Recessing)	
CW	Neutral	Neutral	Neutral	Neutral	Ball nose	
	H	.187", 4.75 mm	●	●	●	●
	RE .008"	●	●	●	●	●
	RE .016"	●	●	●	●	●
H	RE .031"	●	●	●	●	●
	.197", 5.00 mm	●	●	●	●	●
	RE .008"	●	●	●	●	●
	RE .016"	●	●	●	●	●
J	RE .031"	●	●	●	●	●
	.206", 5.24 mm	●	●	●	●	●
	.236", 6.00 mm	●	●	●	●	●
	RE .008"	●	●	●	●	●
J	RE .016"	●	●	●	●	●
	RE .031"	●	●	●	●	●
	.248", 6.31 mm	●	●	●	●	●
	.250", 6.35 mm	●	●	●	●	●
J	RE .008"	●	●	●	●	●
	RE .016"	●	●	●	●	●
	RE .031"	●	●	●	●	●

● : Gauge insert shown dimensions

IDENTIFICATION > F010
 CUTTING CONDITIONS > F194
 INSTRUCTION MANUAL > F201

F

GROOVING / CUTTING OFF

GY SERIES (EXTERNAL / FACE GROOVING PSC TYPE)

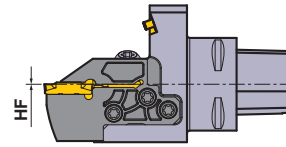
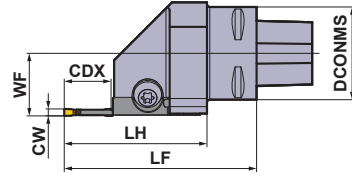
7-2

00° type holder (Metric)

NEW

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

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



Right hand tool holder shown.

(mm)

F

GROOVING / CUTTING OFF

Order Number	Stock	Hand (R/L)	Coolant	Mounting Size	DCONMS	CW
C4-GYHERM00-M25R	●	R	External	PSC40	40	2.0-6.35
C4-GYHELM00-M25L	●	L	External	PSC40	40	2.0-6.35
C5-GYHERM00-M25R	●	R	External	PSC50	50	2.0-6.35
C5-GYHELM00-M25L	●	L	External	PSC50	50	2.0-6.35
C6-GYHERM00-M25R	●	R	External	PSC63	63	2.0-6.35
C6-GYHELM00-M25L	●	L	External	PSC63	63	2.0-6.35

Set Dimensions with Modular Blades

Holder Type	Modular Blade Type	Standard CW	CDX	WF	HF	LF	LH
C4-GYHER/LM00-M25R/L	GYM25R/L○D06	2.0	6	27.0	0	69	47.6
C4-GYHER/LM00-M25R/L	GYM25R/L○D12	2.0	12	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○D20	2.0	20	27.0	0	83	61.6
C4-GYHER/LM00-M25R/L	GYM25R/L○E06	2.5	6	27.0	0	69	47.6
C4-GYHER/LM00-M25R/L	GYM25R/L○E12	2.5	12	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○E20	2.5	20	27.0	0	83	61.6
C4-GYHER/LM00-M25R/L	GYM25R/L○F06	3.0	6	27.0	0	69	47.6
C4-GYHER/LM00-M25R/L	GYM25R/L○F12	3.0	12	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○F20	3.0	20	27.0	0	83	61.6
C4-GYHER/LM00-M25R/L	GYM25R/L○G08	4.0	8	27.0	0	71	49.6
C4-GYHER/LM00-M25R/L	GYM25R/L○G14	4.0	14	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○G25	4.0	25	27.0	0	88	66.6
C4-GYHER/LM00-M25R/L	GYM25R/L○H08	5.0	8	27.0	0	71	49.6
C4-GYHER/LM00-M25R/L	GYM25R/L○H14	5.0	14	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○H25	5.0	25	27.0	0	88	66.6
C4-GYHER/LM00-M25R/L	GYM25R/L○J08	6.0	8	27.0	0	71	49.6
C4-GYHER/LM00-M25R/L	GYM25R/L○J14	6.0	14	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/L○J25	6.0	25	27.0	0	88	66.6

*Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter. Example) GYM25RD-D12-040

The "○" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining.

Note 1) The indicated dimensions are values for standard inserts (GM breakers). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from "TOOL NEWS B255A-G GYGW Inserts".

● : USA Stock

(mm)







Holder Type	Modular Blade Type	Standard CW	CDX	WF	HF	LF	LH
C5-GYHER/LM00-M25R/L	GYM25R/L○-D06	2.0	6	35.0	0	69	47.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-D12	2.0	12	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-D20	2.0	20	35.0	0	83	61.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-E06	2.5	6	35.0	0	69	47.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-E12	2.5	12	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-E20	2.5	20	35.0	0	83	61.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-F06	3.0	6	35.0	0	69	47.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-F12	3.0	12	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-F20	3.0	20	35.0	0	83	61.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-G08	4.0	8	35.0	0	71	49.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-G14	4.0	14	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-G25	4.0	25	35.0	0	88	66.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-H08	5.0	8	35.0	0	71	49.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-H14	5.0	14	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-H25	5.0	25	35.0	0	88	66.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-J08	6.0	8	35.0	0	71	49.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-J14	6.0	14	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/L○-J25	6.0	25	35.0	0	88	66.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-D06	2.0	6	45.0	0	71	47.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-D12	2.0	12	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-D20	2.0	20	45.0	0	85	61.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-E06	2.5	6	45.0	0	71	47.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-E12	2.5	12	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-E20	2.5	20	45.0	0	85	61.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-F06	3.0	6	45.0	0	71	47.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-F12	3.0	12	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-F20	3.0	20	45.0	0	85	61.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-G08	4.0	8	45.0	0	73	49.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-G14	4.0	14	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-G25	4.0	25	45.0	0	90	66.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-H08	5.0	8	45.0	0	73	49.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-H14	5.0	14	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-H25	5.0	25	45.0	0	90	66.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-J08	6.0	8	45.0	0	73	49.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-J14	6.0	14	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/L○-J25	6.0	25	45.0	0	90	66.6

*Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter. Example) GYM25RD-D12-040

The "○" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining.

Note 1) The indicated dimensions are values for standard inserts (GM breakers). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from "TOOL NEWS B255A-G GYGW Inserts".

SPARE PARTS

											
Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number	Order Number		
GY06013M	1	TS55	5	HSD05004S	1	NZ22042080S	1	TKY25D	TKY30R		

* Clamp Torque (lbf-in) : GY06013M=53, TS55=44

Nozzle Exchange Key : NZKH050S

IDENTIFICATION	➤ F010
INSERTS	➤ F011 – F015
CUTTING CONDITIONS	➤ F194, F206
INSTRUCTION MANUAL	➤ F201, F208

GY SERIES (EXTERNAL / FACE GROOVING PSC TYPE)

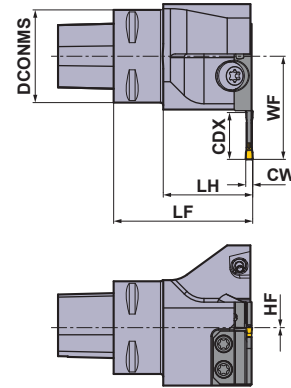
8-2

00° type holder (Metric)

NEW

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

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



Left hand tool holder shown.

(mm)

Order Number	Stock	Hand (R/L)	Coolant	Mounting Size	DCONMS	CW
C4-GYHERM90-M25L	●	R	External	PSC40	40	2.0-6.35
C4-GYHELM90-M25R	●	L	External	PSC40	40	2.0-6.35
C5-GYHERM90-M25L	★	R	External	PSC50	50	2.0-6.35
C5-GYHELM90-M25R	★	L	External	PSC50	50	2.0-6.35
C6-GYHERM90-M25L	★	R	External	PSC63	63	2.0-6.35
C6-GYHELM90-M25R	★	L	External	PSC63	63	2.0-6.35

GROOVING / CUTTING OFF

F

Set Dimensions with Modular Blades

Holder Type	Modular Blade Type	Standard CW	CDX	WF	HF	LF	LH
C4-GYHER/LM90-M25L/R	GYM25L/R-○D06	2.0	6	30.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○D12	2.0	12	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○D20	2.0	20	44.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○E06	2.5	6	30.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○E12	2.5	12	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○E20	2.5	20	44.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○F06	3.0	6	30.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○F12	3.0	12	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○F20	3.0	20	44.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○G08	4.0	8	32.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○G14	4.0	14	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○G25	4.0	25	49.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○H08	5.0	8	32.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○H14	5.0	14	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○H25	5.0	25	49.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○J08	6.0	8	32.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○J14	6.0	14	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/R-○J25	6.0	25	49.5	0	60	38.6

*Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter. Example) GYM25RD-D12-040

The "○" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining.

Note 1) The indicated dimensions are values for standard inserts (GM breakers). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from "TOOL NEWS B255A-G GYGW Inserts".

● : USA Stock ★ : Stocked in Japan

(mm)







Holder Type	Modular Blade Type	Standard CW	CDX	WF	HF	LF	LH
C5-GYHER/LM90-M25L/R	GYM25L/R-D06	2.0	6	33.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-D12	2.0	12	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-D20	2.0	20	47.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-E06	2.5	6	33.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-E12	2.5	12	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-E20	2.5	20	47.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-F06	3.0	6	33.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-F12	3.0	12	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-F20	3.0	20	47.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-G08	4.0	8	35.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-G14	4.0	14	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-G25	4.0	25	52.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-H08	5.0	8	35.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-H14	5.0	14	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-H25	5.0	25	52.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-J08	6.0	8	35.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-J14	6.0	14	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/R-J25	6.0	25	52.0	0	60	38.6
C6-GYHER/LM90-M25L/R	GYM25L/R-D06	2.0	6	40.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-D12	2.0	12	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-D20	2.0	20	54.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-E06	2.5	6	40.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-E12	2.5	12	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-E20	2.5	20	54.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-F06	3.0	6	40.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-F12	3.0	12	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-F20	3.0	20	54.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-G08	4.0	8	42.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-G14	4.0	14	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-G25	4.0	25	59.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-H08	5.0	8	42.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-H14	5.0	14	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-H25	5.0	25	59.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-J08	6.0	8	42.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-J14	6.0	14	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/R-J25	6.0	25	59.0	0	70	46.6

*Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter. Example) GYM25RD-D12-040

The "○" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining.

Note 1) The indicated dimensions are values for standard inserts (GM breakers). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from "TOOL NEWS B255A-G GYGW Inserts".

SPARE PARTS

											
Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number	Order Number		
GY06013M	1	TS55	5	HSD05004S	1	NZ22042080S	1	TKY25D	TKY30R		

* Clamp Torque (lbf-in) : GY06013M=53, TS55=44

Nozzle Exchange Key : NZKH050S

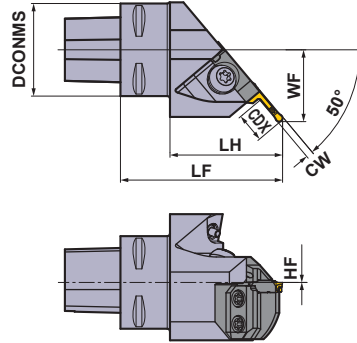
IDENTIFICATION	> F010
INSERTS	> F011 – F015
CUTTING CONDITIONS	> F194, F206
INSTRUCTION MANUAL	> F201, F208

GY SERIES (EXTERNAL RECESSING PSC TYPE)

9-2 50° type holder (Metric) **NEW**

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

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



Left hand tool holder shown.

F

GROOVING / CUTTING OFF

(mm)

Order Number	Stock	Hand (R/L)	Coolant	Mounting Size	DCONMS	CW
C4-GYHERM50-M25L	●	R	External	PSC40	40	2.0-6.35
C4-GYHELM50-M25R	●	L	External	PSC40	40	2.0-6.35
C5-GYHERM50-M25L	★	R	External	PSC50	50	2.0-6.35
C5-GYHELM50-M25R	★	L	External	PSC50	50	2.0-6.35
C6-GYHERM50-M25L	★	R	External	PSC63	63	2.0-6.35
C6-GYHELM50-M25R	★	L	External	PSC63	63	2.0-6.35

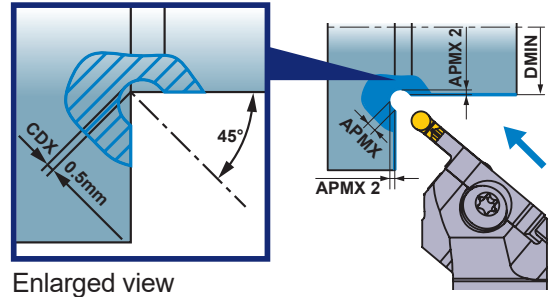
SPARE PARTS

*		*									
Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number	Pcs.	Order Number	Order Number		
GY06013M	1	TS55	4	HSD05004S	1	NZ22042080S	1	TKY25D	TKY30R		

* Clamp Torque (lbf-in) : GY06013M=53, TS55=44

Nozzle Exchange Key : NZKH050S

● : USA Stock ★ : Stocked in Japan



Set Dimensions with Modular Blades

(mm)

Holder Type	Modular Blade Type	Standard CW	CDX	DMIN	APMX	APMX2	WF	HF	LF	LH
C4-GYHER/LM50-M25L/R	GYM25L/RC-D005	2.0	0.5	30	1.50	0.646	30.6	0	70.2	48.8
C4-GYHER/LM50-M25L/R	GYM25L/RC-E005	2.5	0.5	30	1.75	0.720	30.8	0	70.1	48.7
C4-GYHER/LM50-M25L/R	GYM25L/RC-F005	3.0	0.5	30	2.00	0.793	31.0	0	70.0	48.6
C4-GYHER/LM50-M25L/R	GYM25L/RC-G005	4.0	0.5	20	2.50	0.939	31.4	0	69.8	48.4
C4-GYHER/LM50-M25L/R	GYM25L/RC-H005	5.0	0.5	20	2.88	1.049	31.8	0	69.6	48.2
C4-GYHER/LM50-M25L/R	GYM25L/RC-J005	6.0	0.5	20	3.50	1.232	32.4	0	69.4	48.0
C5-GYHER/LM50-M25L/R	GYM25L/RC-D005	2.0	0.5	30	1.50	0.646	32.6	0	70.2	48.8
C5-GYHER/LM50-M25L/R	GYM25L/RC-E005	2.5	0.5	30	1.75	0.720	32.8	0	70.1	48.7
C5-GYHER/LM50-M25L/R	GYM25L/RC-F005	3.0	0.5	30	2.00	0.793	33.0	0	70.0	48.6
C5-GYHER/LM50-M25L/R	GYM25L/RC-G005	4.0	0.5	20	2.50	0.939	33.4	0	69.8	48.4
C5-GYHER/LM50-M25L/R	GYM25L/RC-H005	5.0	0.5	20	2.88	1.049	33.8	0	69.6	48.2
C5-GYHER/LM50-M25L/R	GYM25L/RC-J005	6.0	0.5	20	3.50	1.232	34.4	0	69.4	48.0
C6-GYHER/LM50-M25L/R	GYM25L/RC-D005	2.0	0.5	30	1.50	0.646	39.6	0	70.2	46.8
C6-GYHER/LM50-M25L/R	GYM25L/RC-E005	2.5	0.5	30	1.75	0.720	39.8	0	70.1	46.7
C6-GYHER/LM50-M25L/R	GYM25L/RC-F005	3.0	0.5	30	2.00	0.793	40.0	0	70.0	46.6
C6-GYHER/LM50-M25L/R	GYM25L/RC-G005	4.0	0.5	20	2.50	0.939	40.4	0	69.8	46.4
C6-GYHER/LM50-M25L/R	GYM25L/RC-H005	5.0	0.5	20	2.88	1.049	40.8	0	69.6	46.2
C6-GYHER/LM50-M25L/R	GYM25L/RC-J005	6.0	0.5	20	3.50	1.232	41.4	0	69.4	46.0

DMIN = Min. Cut Diameter

*Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter. Example) GYM25RD-D12-040

The "○" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining.

Note 1) The indicated dimensions are values for standard inserts (BM breakers). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from "TOOL NEWS B255A-G GYGW Inserts".

GROOVING / CUTTING OFF

IDENTIFICATION > F010
 INSERTS > F014
 CUTTING CONDITIONS > F200
 INSTRUCTION MANUAL > F200

GROOVING / CUTTING OFF

RECOMMENDED CUTTING SPEED (SFM) [For External Grooving / Cutting Off]

Work Material	Hardness	Grade	Cutting Speed (SFM)								
			165	330	490	655	820	985	1640		
P Mild Steel	≤160HB	VP20RT		330		720					
		VP10RT		360		755					
		NX2525		295		690					
	Carbon Steel Alloy Steel	160–280HB	VP20RT		260		590				
			VP10RT		295		620				
			MY5015		360		820				
		≥280HB	NX2525		230		560				
			VP20RT		195		460				
			VP10RT		230		490				
Stainless Steel	≤270HB	MY5015		295		690					
		NX2525		180		440					
		VP20RT		195		460					
M K Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT		195		460					
		VP10RT		230		490					
		MY5015		460		985					
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT		195		460				
			VP10RT		230		490				
			MY5015		295		690				
S Heat Resistant Alloy Titanium Alloy	-	MP9015		130		330					
		MP9025		100		295					
		VP20RT		100		195					
		VP10RT / RT9010		130		230					
H Hardened steel	≥50HRC	BC8110		260		395					
N Aluminum Alloy	Content Si<5%	RT9010				655			1640		
	Content 5%≤Si≤10%	RT9010				655			1640		
	Content Si>10%	RT9010		330		655					

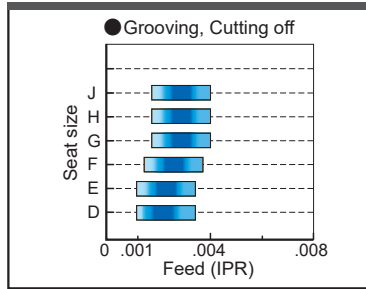
Note 1) For MP9015, MP9025, VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For External Grooving / Cutting Off]

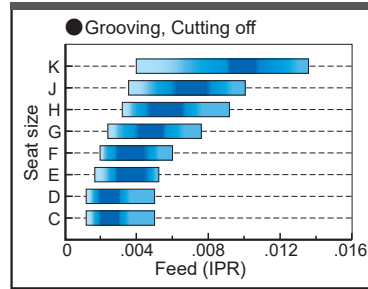
*Below are the recommended cutting conditions when using the modular type holder GYHR/L2525M00/90-M25R/L with the modular blade GYM25R/LA-○○○.

Recommended feed rate and depth of cut

GU BREAKER



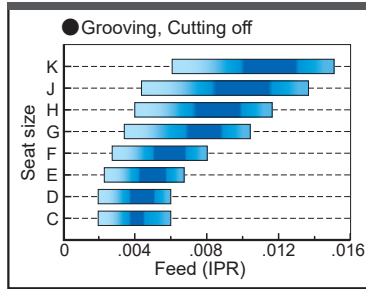
GS BREAKER



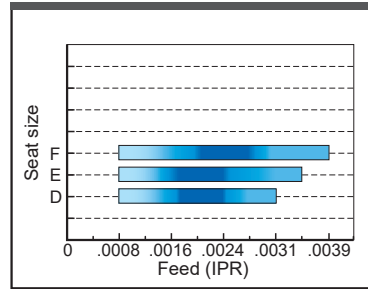
■ : 1st recommended area

Seat Size			
	Insert Width		Insert Width
C	.059", 1.50 mm	G	.157", 4.00 mm
			.167", 4.24 mm
D	.079", 2.00 mm	H	.187", 4.75 mm
	.088", 2.24 mm		.197", 5.00 mm
E	.094", 2.39 mm	J	.236", 6.00 mm
	.098", 2.50 mm		.248", 6.31 mm
	.108", 2.74 mm		.250", 6.35 mm
F	.118", 3.00 mm	K	.315", 8.00 mm
	.125", 3.18 mm		
	.128", 3.24 mm		

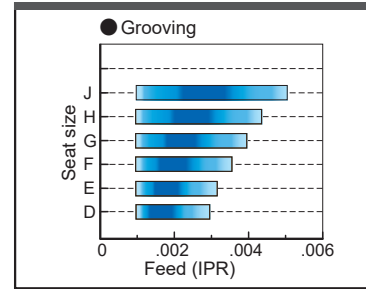
GM BREAKER



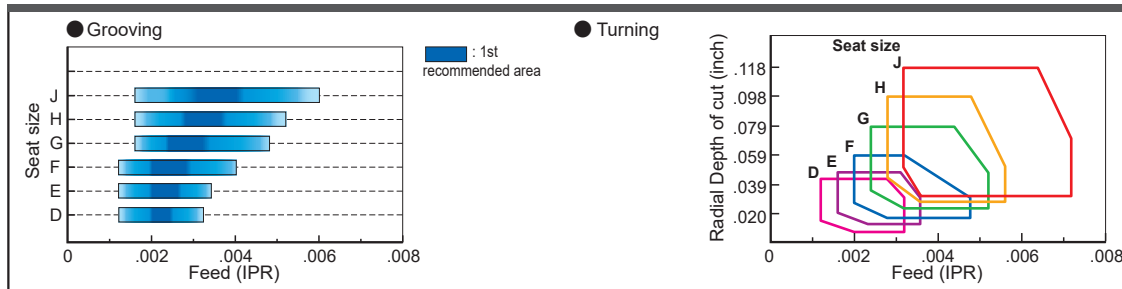
GL BREAKER



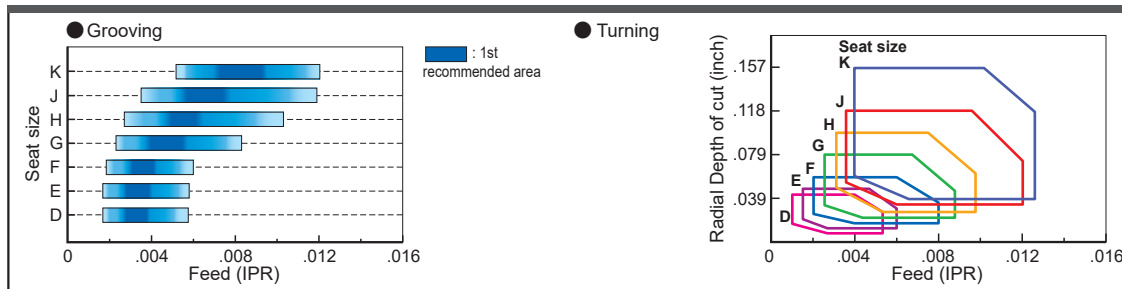
FLAT TOP GFGS (CBN)



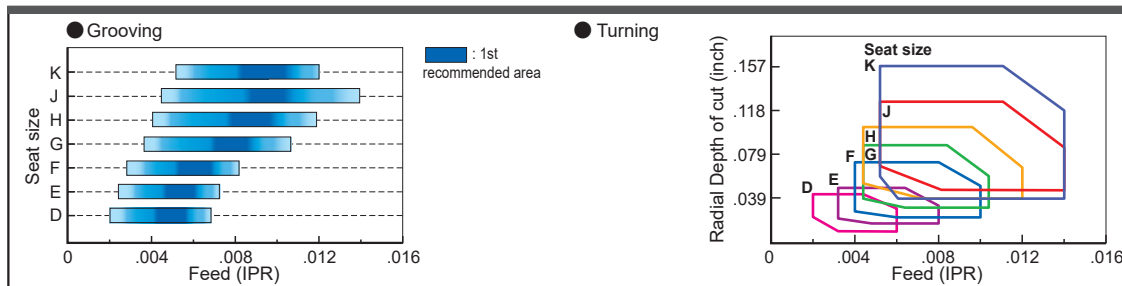
MF BREAKER



MS BREAKER



MM BREAKER



F

GROOVING / CUTTING OFF

GROOVING / CUTTING OFF

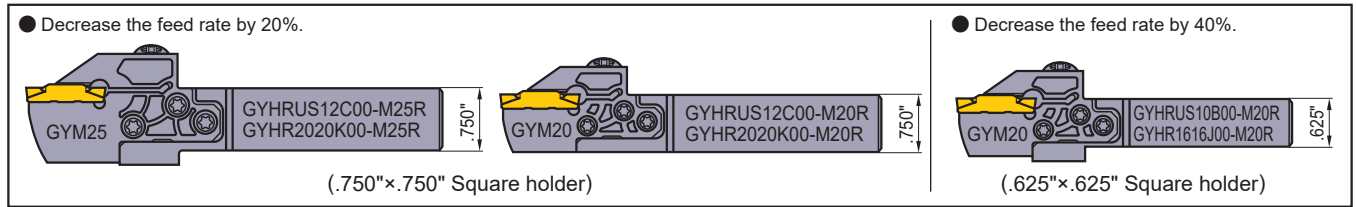
Recommended feed rate and depth of cut

BM BREAKER



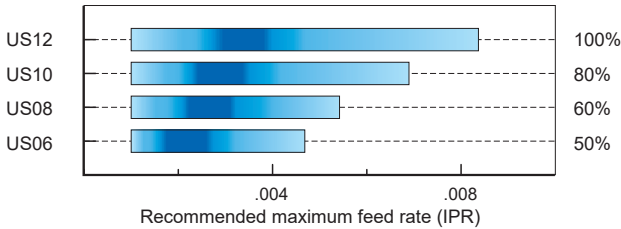
Seat Size	
Insert Width	
C	.059", 1.50 mm
D	.079", 2.00 mm .088", 2.24 mm
E	.094", 2.39 mm .098", 2.50 mm .108", 2.74 mm
F	.118", 3.00 mm .125", 3.18 mm .128", 3.24 mm
G	.157", 4.00 mm .167", 4.24 mm
H	.187", 4.75 mm .197", 5.00 mm .206", 5.24 mm
J	.236", 6.00 mm .248", 6.31 mm .250", 6.35 mm
K	.315", 8.00 mm

Note 1) When using a combination as shown below, decrease the recommended feed rate by 20% and 40% respectively.



F

For Swiss-type lathes mono block holder

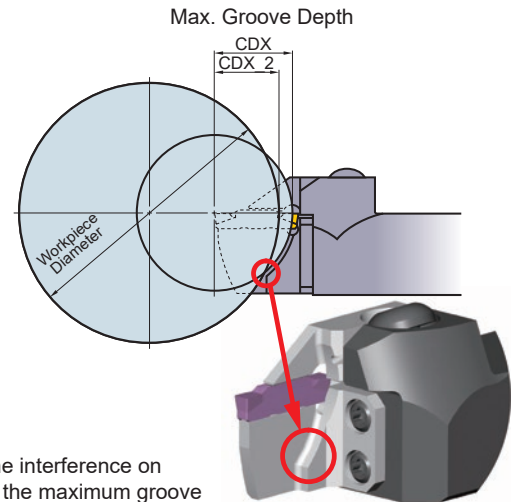
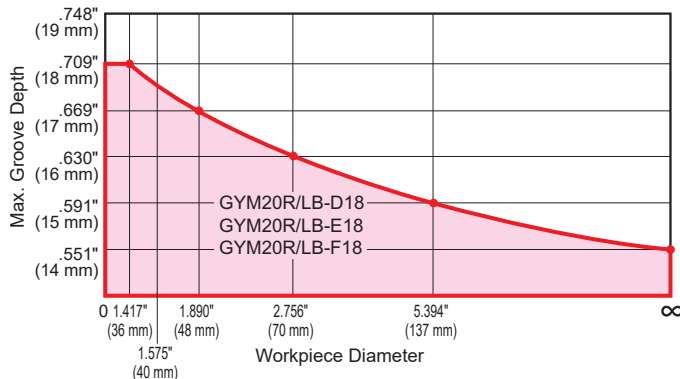


Please refer to the tables of recommended cutting conditions for external grooving. Apply the percentage ratio shown of each shank size to the values in those tables.

GROOVING / CUTTING OFF

LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

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

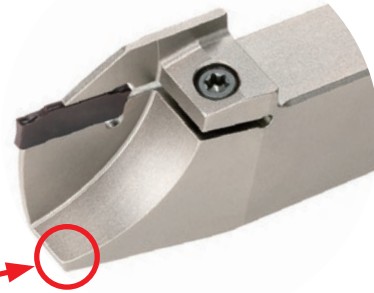
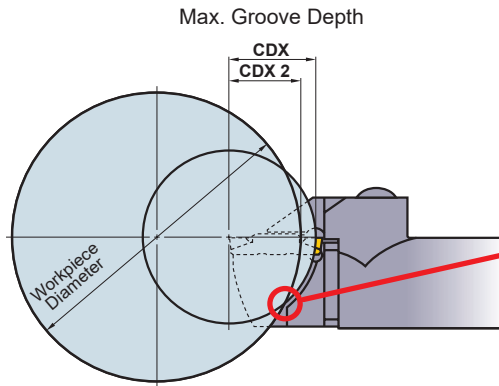


Due to the interference on this part, the maximum groove depth is limited by the workpiece diameter.

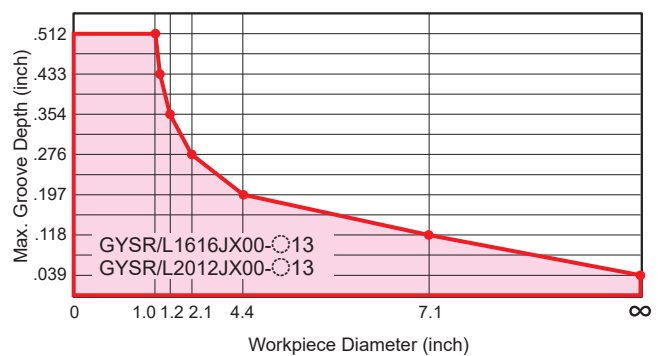
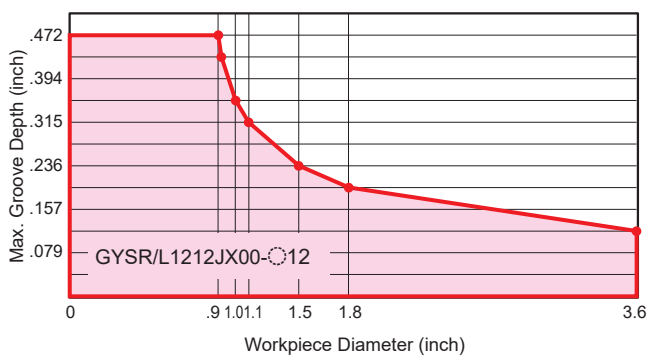
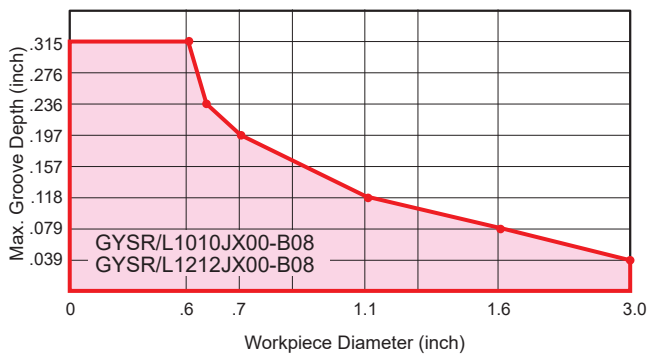
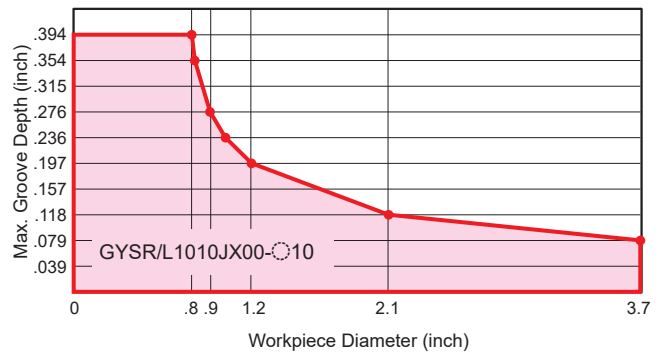
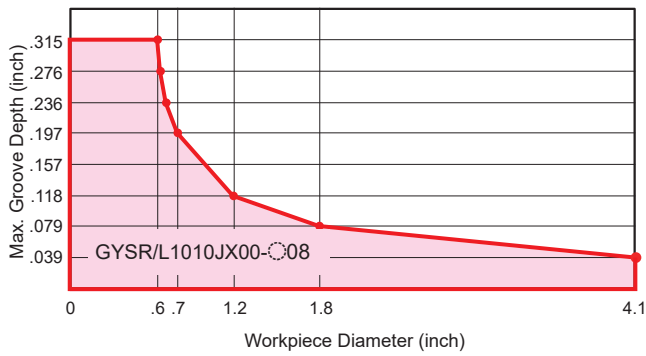
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

•In The Case of Mono Block Type Holder for Swiss-Type Lathes

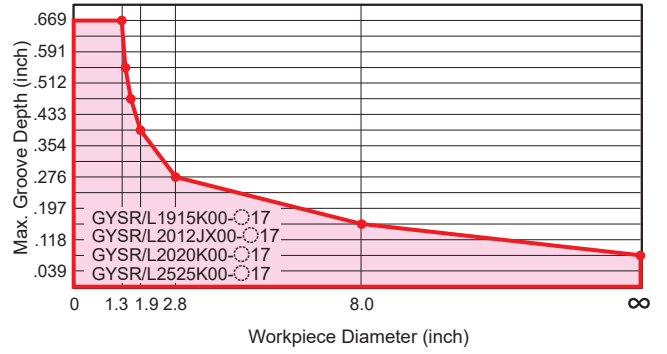
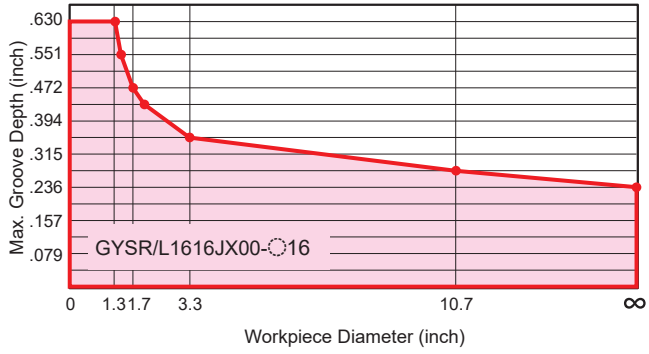
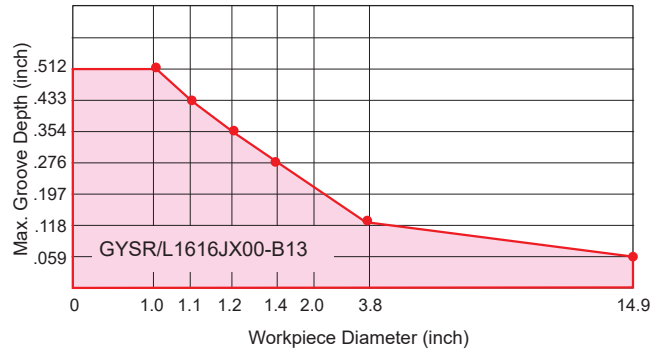
The maximum groove depth is limited by the workpiece diameter.



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



GROOVING / CUTTING OFF



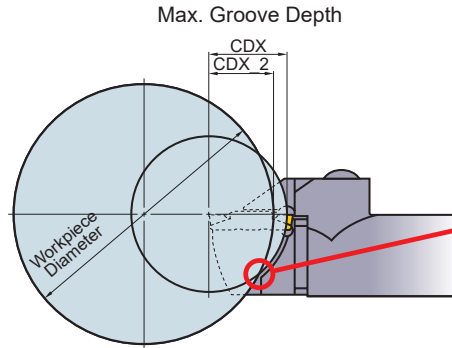
F

GROOVING / CUTTING OFF

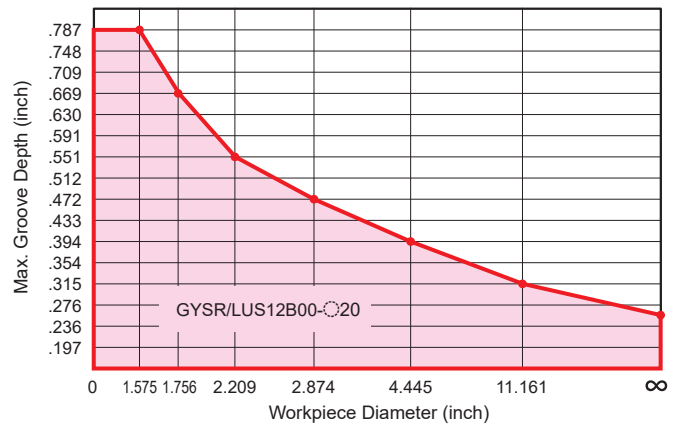
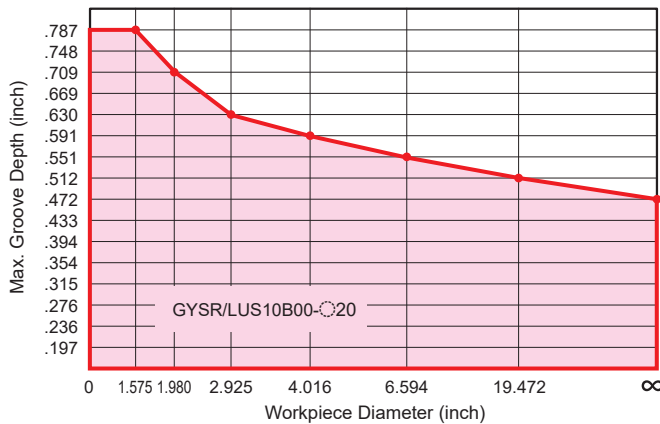
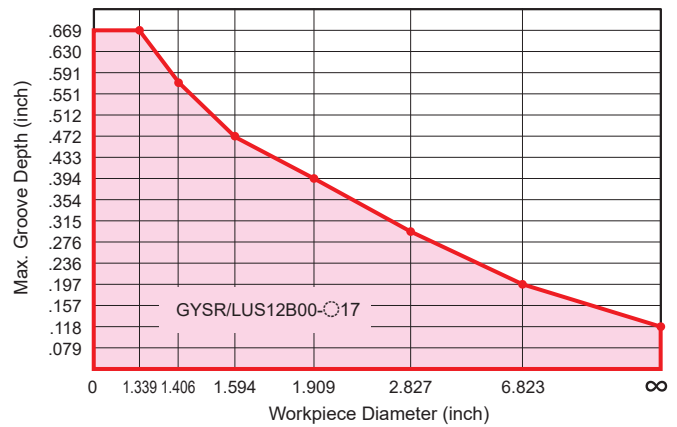
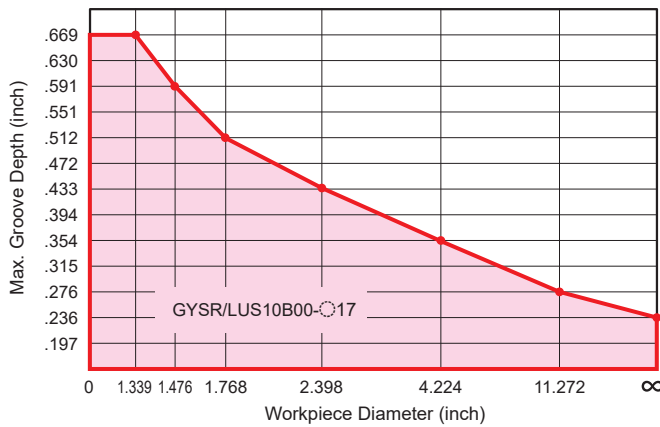
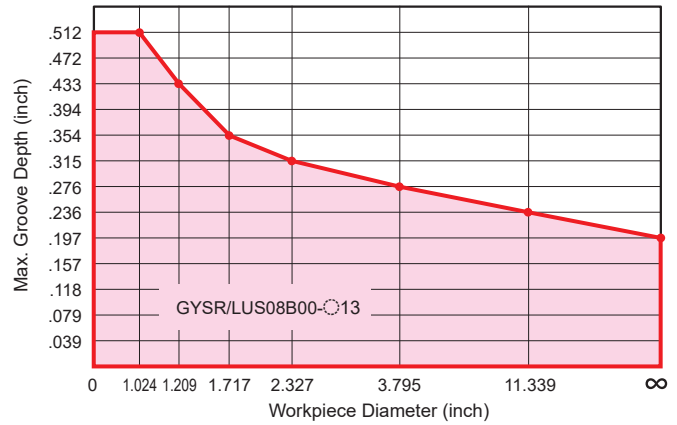
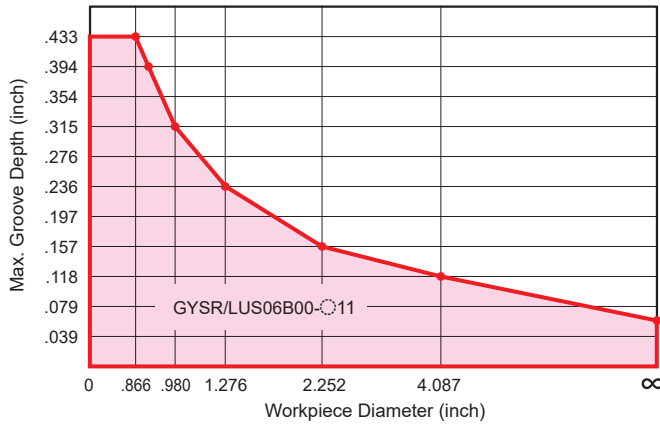
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

•For Swiss-type lathes mono block holder

The maximum groove depth is limited by the workpiece diameter.



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



F

GROOVING / CUTTING OFF

GROOVING / CUTTING OFF

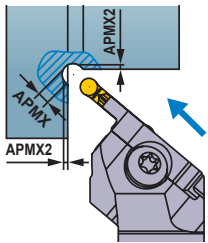
RECOMMENDED CUTTING SPEED (SFM) [For External Recessing]

Work Material	Hardness	Grade	Cutting Speed (SFM)				
			165	330	490	655	820
P Mild Steel Carbon Steel Alloy Steel	≤180HB	VP20RT		260	590		
		VP10RT		295	620		
	180–280HB	VP20RT	195	460			
		VP10RT	230	490			
		MY5015		295	690		
		NX2525	180	440			
	280–350HB	VP20RT	165	360			
		VP10RT	195	395			
MY5015			260	525			
NX2525		150	345				
M Stainless Steel	≤350HB	VP20RT	165	360			
		VP10RT	195	395			
K Gray Cast Iron Ductile Cast Iron	Tensile Strength ≤350MPa	VP20RT	195	460			
		VP10RT	230	490			
		MY5015		295	690		
	Tensile Strength ≤800MPa	VP20RT	165	360			
		VP10RT	195	395			
		MY5015		260	525		
S Heat Resistant Alloy Titanium Alloy	-	MP9015	130	330			
		MP9025	100	295			
		VP20RT	100	195			
		VP10RT	130	230			

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

GROOVING / CUTTING OFF

DISTANCE FROM THE WORKPIECE TO THE RECESS DEPTH

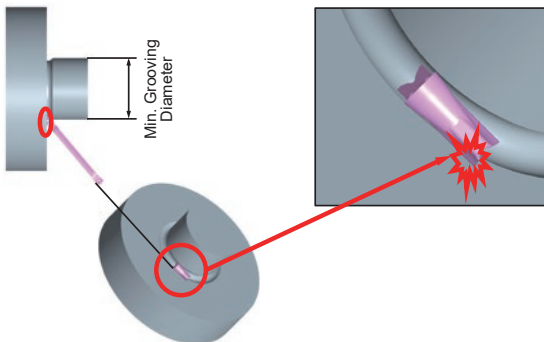


Cutting Width CW	Recessing Depth APMX	Distance workpiece to the recess depth APMX2
.079", 2.00 mm	.059", 1.50 mm	.025", 0.646 mm
.098", 2.50 mm	.069", 1.75 mm	.028", 0.720 mm
.118", 3.00 mm	.079", 2.00 mm	.031", 0.793 mm
.125", 3.18 mm	.082", 2.09 mm	.032", 0.819 mm
.157", 4.00 mm	.098", 2.50 mm	.037", 0.939 mm
.187", 4.75 mm	.113", 2.88 mm	.041", 1.049 mm
.197", 5.00 mm	.118", 3.00 mm	.043", 1.086 mm
.236", 6.00 mm	.138", 3.50 mm	.049", 1.232 mm
.250", 6.35 mm	.145", 3.68 mm	.051", 1.283 mm

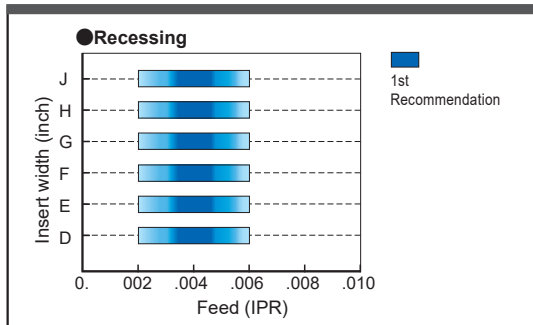
BM BREAKER

Minimum grooving diameter

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



Recommended feed rate and depth of cut



TOOL SELECTION

Notes when selecting the tool body

Modular holder

GYM25 GYHRUS16D00-M25R 1.000"

Modular holder

GYM25 GYHRUS12C00-M25R .750"

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

Modular blade (1)

GYM25 GYHRUS12C00-M25R .750"

Modular holder

GYM20 GYHRUS12C00-M20R .750"

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

Modular blade (2)

● Select the shortest possible blade suitable for the application.

Modular blade (3)

● Select the shortest possible blade suitable for the application.

✓: Recommended.

Notes when setting the tool

Setting of cutting edge height

<Grooving/Cross-feed machining>
Set the cutting edge height to ± 0.004 " parallel to the central axis.

<Cutting off>
Set the cutting edge height to $0 - +0.008$ " parallel to the central axis.

Tool body setting angle

90° 90°

● Set the insert perpendicular to the central axis.

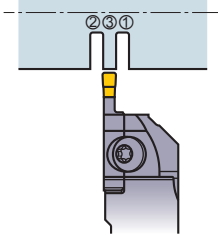
Overhang

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

MACHINING RECOMMENDATIONS

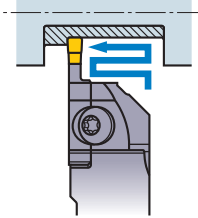
Notes on multi-functional machining (MF·MS and MM breakers)

Machining narrow grooves



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

Machining wide grooves



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

Machining wide grooves

Roughing

- ① Carry out grooving.
- ② Retract the tool approx .004".
- ③ Carry out cross feed machining.
- ④ Retract the tool approx .004".
- ⑤ Carry out grooving.
- ⑥ Retract the tool approx .004".

* Repeat the steps ①-⑥.

Finishing

- ⑦ Carry out grooving to the end point of the corner radius.
- ⑧ Machining of the wall surface, corner radius and bottom face should be carried out in one process.

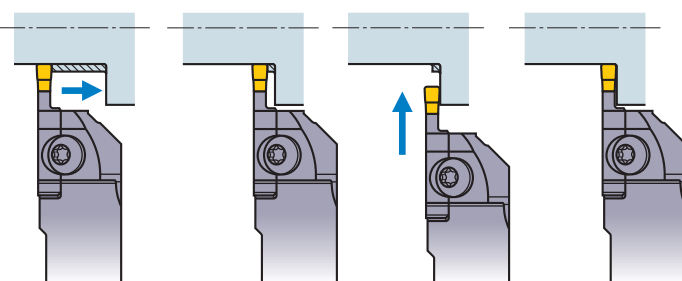
Finishing

- ⑨ Stop at the bottom of the corner radius.
- ⑩ Machine the counter wall to the corner radius in one process.
- ⑪ Finish machining.

Precautions when finishing walls

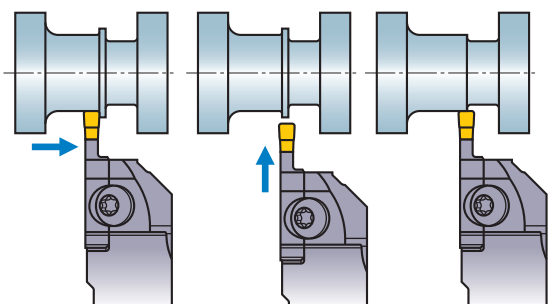
- To produce high accuracy walls using MS or MM breaker insert, do not carry out back turning. Plunging is recommended.

Wall machining



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

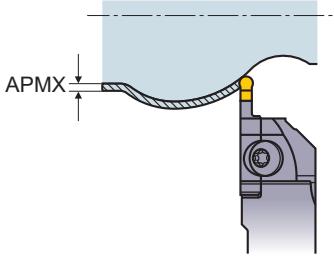
Machining of a ring section



- When a ring remains in a cross feed end process, finish cross feed machining .040"-.059" short of the end point, then remove the ring by plunging.

Notes on multi-functional machining (BM breaker)

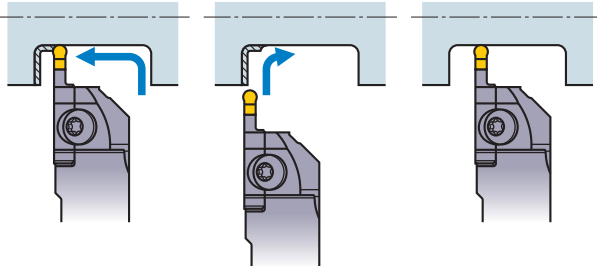
Copying



The diagram shows a cutting tool with a yellow BM breaker insert machining a curved surface. A vertical dimension line labeled 'APMX' indicates the depth of cut from the original surface to the new surface.

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

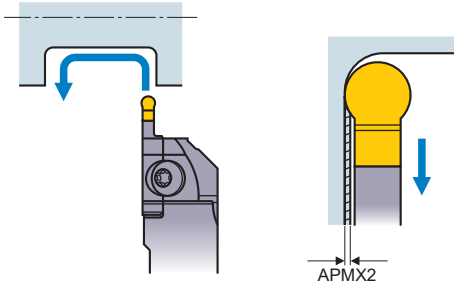
Roughing



The diagram shows three stages of roughing a corner. Blue arrows indicate the direction of the cutting tool and the workpiece rotation.

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

Finishing



The diagram shows two stages of finishing. The first shows a tool with a yellow BM breaker insert performing a back turn. The second shows a ball end mill finishing a corner. A vertical dimension line labeled 'APMX2' indicates the depth of cut.

- Carry out finishing in one process. For the depth of cut (APMX2) when back turning, refer to the table on the right.

Insert	APMX2 (inch)
GY2M0200D100N-BM	.002
GY2M0250E125N-BM	.004
GY2M0300F150N-BM	.006
GY2M0318F159N-BM	.006
GY2M0400G200N-BM	.008
GY2M0475H238N-BM	.009
GY2M0500H250N-BM	.009
GY2M0600J150N-BM	.012
GY2M0635J318N-BM	.012
GY2M0800K400N-BM	.016

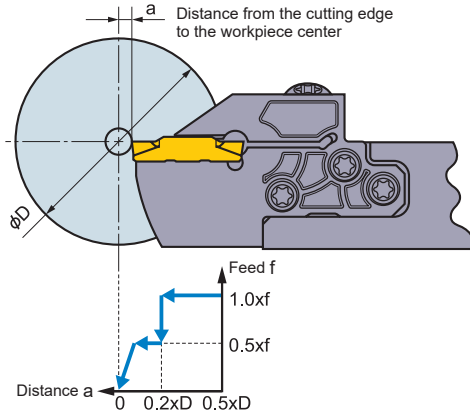
F
GROOVING / CUTTING OFF

MACHINING RECOMMENDATIONS

Notes for cutting off

feed

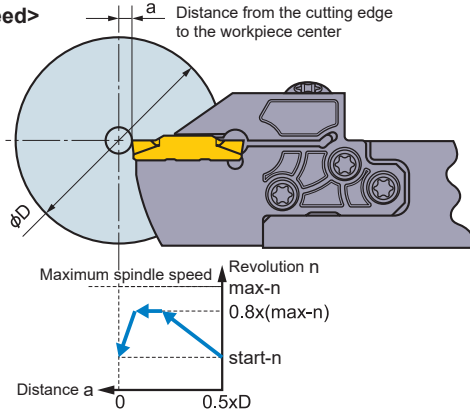
<Feed>



- When the cutting edge approaches the center, reduce the feed by 50%.
- If necessary, stop the feed prior to reaching the center of the workpiece. The part will fall off because of its own weight.

Revolution

<Spindle speed>

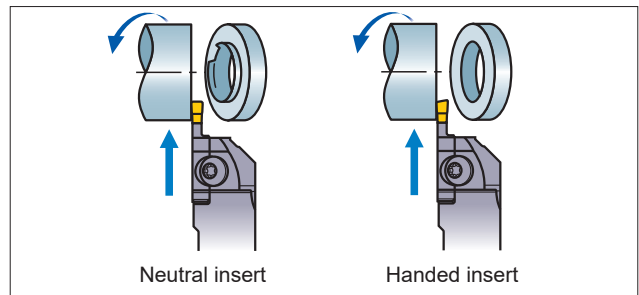
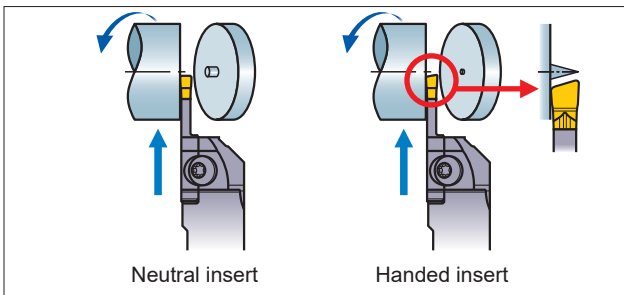


- When using constant cutting speed during a cutting off cycle, it is recommended to limit the spindle speed to 80% of maximum to ensure stability.
- To prevent the workpiece from being expelled, lower the spindle speed before finishing the grooving operation.

F

GROOVING / CUTTING OFF

insert



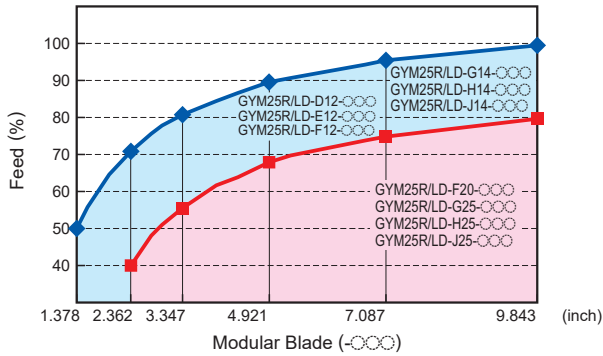
- When there is a center stub on solid bar work or burrs are formed on pipe material, it is possible to decrease them by using a handed insert. With a handed insert, machining tends to be less stable when compared to using a neutral insert. Pay special attention to avoid fracturing of the cutting edge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

Memo

A series of horizontal dotted lines for writing.

GROOVING / CUTTING OFF

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



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

RECOMMENDED CUTTING SPEED (SFM) [For Face Grooving]

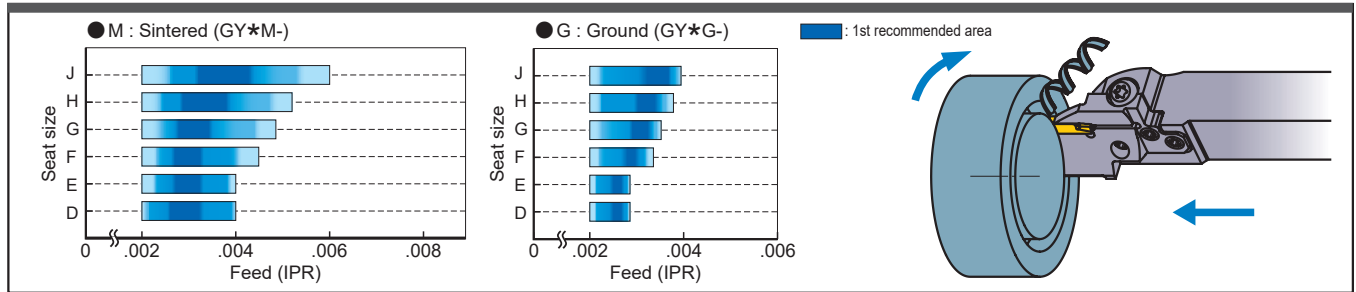
GROOVING / CUTTING OFF

Work Material	Hardness	Grade	Cutting Speed (SFM)						
			165	330	490	655	820	985	
P Mild Steel	≤ 160HB	VP20RT		260		590			
		VP10RT		295		620			
		NX2525		230		560			
	Carbon Steel Alloy Steel	160–280HB	VP20RT		195		460		
			VP10RT		230		490		
			MY5015		295		690		
		≥ 280HB	NX2525		180		440		
			VP20RT		165		360		
			VP10RT		195		395		
		MY5015		260		525			
		NX2525		150		345			
M Stainless Steel	≤ 270HB	VP20RT		165		360			
		VP10RT		195		395			
K Gray Cast Iron	Tensile Strength ≤ 300MPa	VP20RT		195		460			
		VP10RT		230		490			
		MY5015		295		690			
	Ductile Cast Iron	Tensile Strength ≤ 800MPa	VP20RT		165		360		
			VP10RT		195		395		
			MY5015		260		525		
S Heat Resistant Alloy Titanium Alloy	—	MP9015		130		330			
		MP9025		100		295			
		VP20RT		100		195			
		RT9010		130		230			
H Hardened steel	≥ 50HRC	BC8110		195		330			

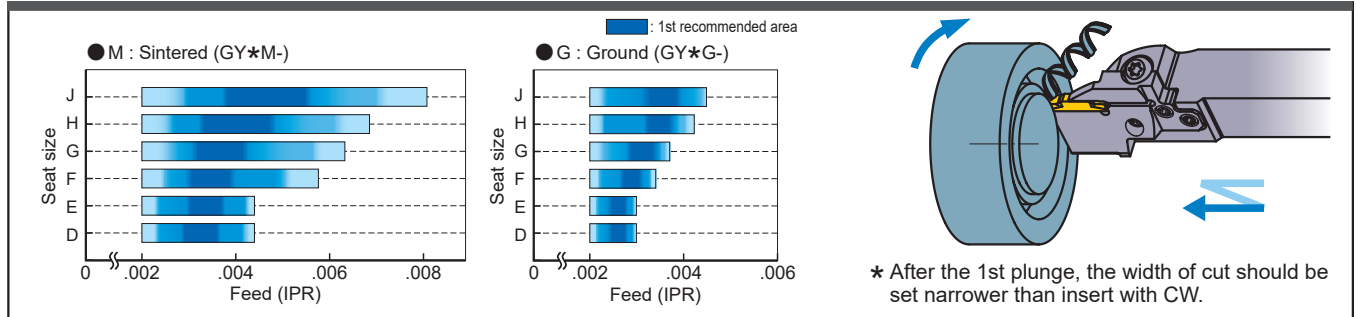
Note 1) For MP9015, MP9025, VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For Face Grooving]

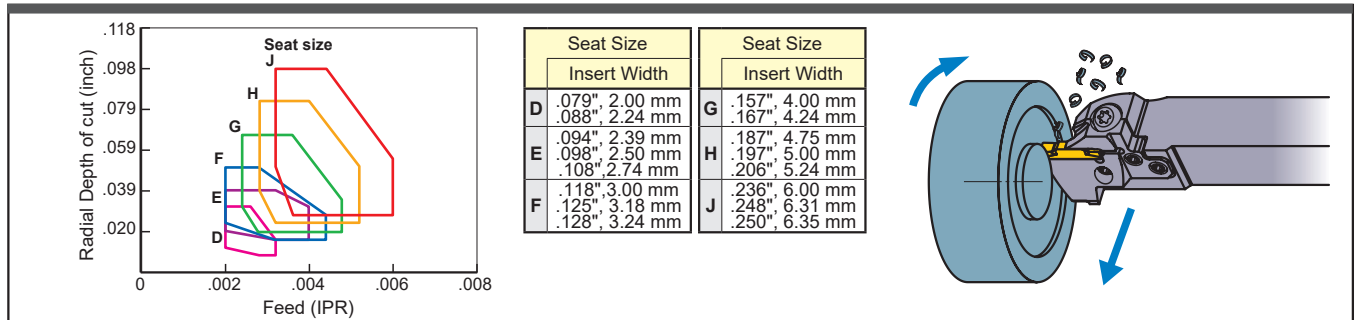
GROOVING



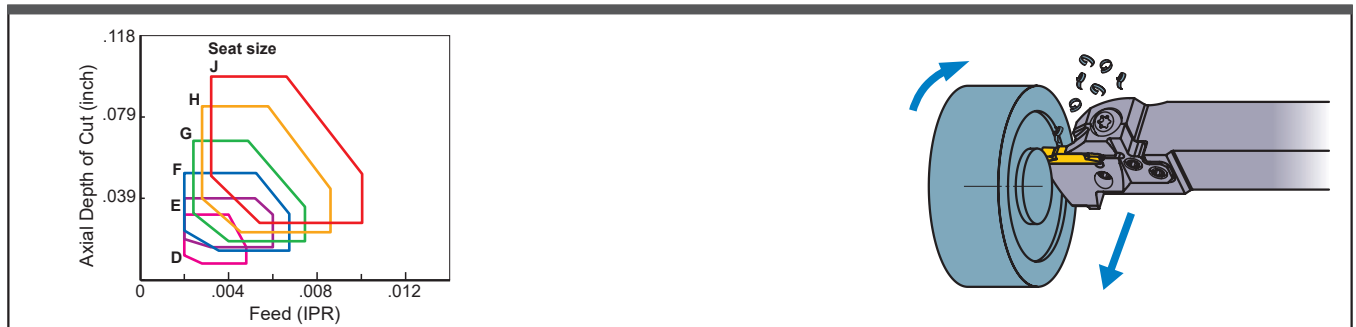
PLUNGING



TRAVERSE MACHINING (MF BREAKER)



TRAVERSE MACHINING (MM/MS BREAKER)



TRAVERSE MACHINING (BM BREAKER)



Note 1) GL chip breaker is not recommended for face grooving.

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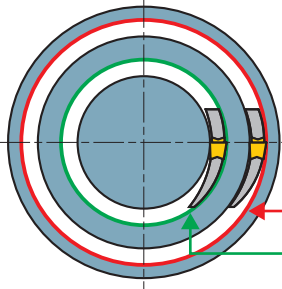
GROOVING / CUTTING OFF

GROOVING / CUTTING OFF

TOOL SELECTION

Notes when selecting the tool body

Modular blade (1)

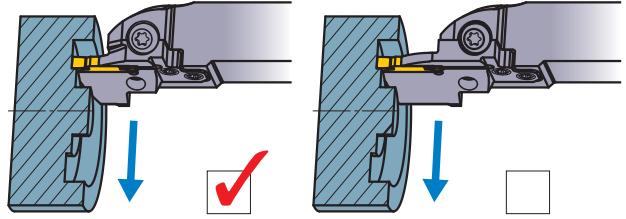


● Select a modular blade for face grooving, so that the cutting diameter at the first pass is within the range of DAXN and DAXX that are described in the table of dimensions.

DAXX (Max.)

DAXN (Min.)

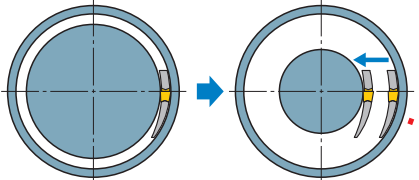
Modular blade (2)



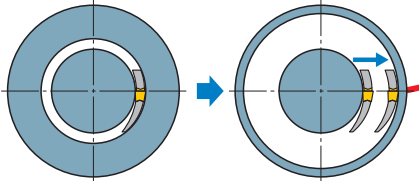
● Select the shortest possible blade suitable for the application.

Modular blade (3)

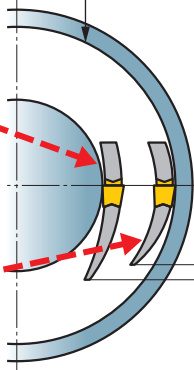
Good



NG



The maximum cutting diameter



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

● Machine from the outer diameter towards the center.



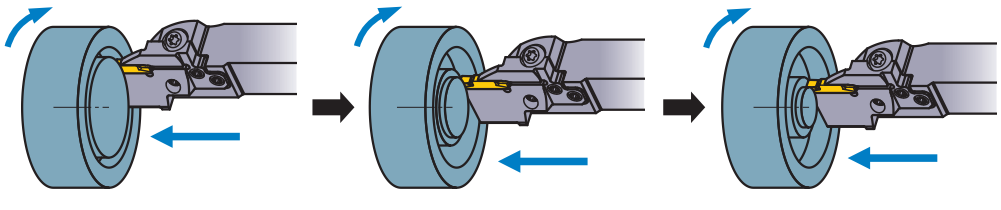
● Increased machining stability and rigidity is possible if a modular blade with the largest possible back metal is used.

F

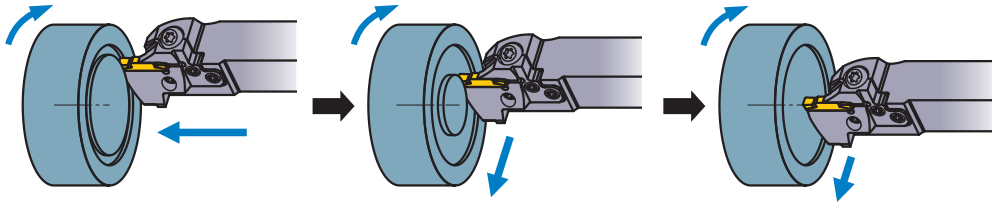
GROOVING / CUTTING OFF

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

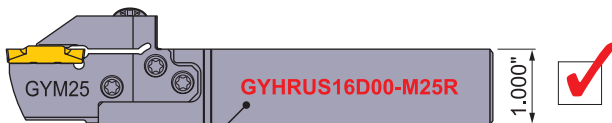
● When plunging in several passes.



● When combining plunging and infeed machining.



Modular holder



Modular holder

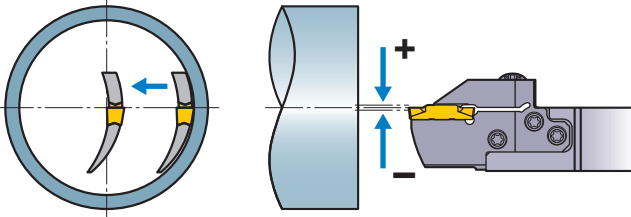


Modular holder

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

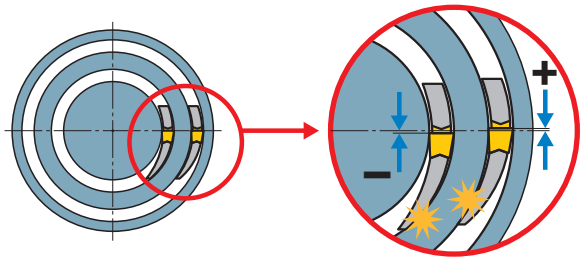
Notes when setting the tool

Setting the cutting edge height



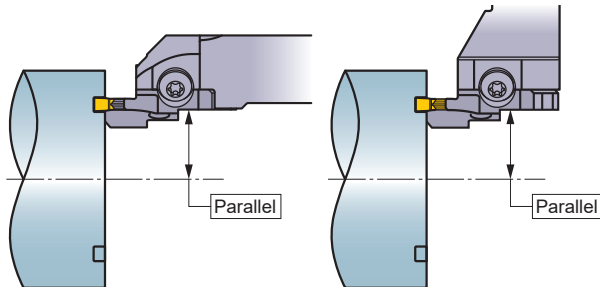
- Set the cutting edge height to ± 0.004 " parallel to the central axis.
- Cutting edge center height check should be done by traverse machining towards the center with a very small depth of cut and ensure that an even surface and no material remains at the center point afterwards.

When interfering the wall of groove and the Modular blade



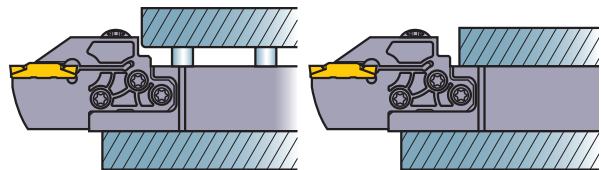
- If interference occurs even when the correct blade is used, the cutting edge height could be incorrect.
 - When interference occurs on the inner side of the blade, the cutting edge height is set too high.
 - When interference occurs on the outer side of the blade, the cutting edge height is set too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

Setting the tool



- Set the insert parallel to the central axis.

Tool overhang



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

F

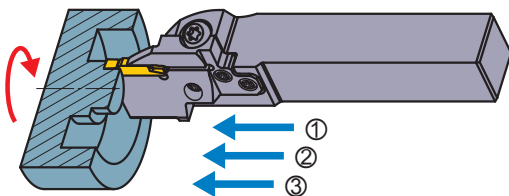
GROOVING / CUTTING OFF

MACHINING RECOMMENDATIONS

Notes when face grooving

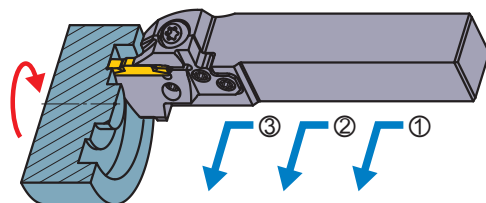
- Always machine from the outer diameter towards the center.

Machining narrow grooves



- Plunging in several passes is recommended.

Machining wide grooves



- Cross feed machining is recommended.

MACHINING RECOMMENDATIONS

Notes when face grooving

Notes on the first pass (1)

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

Notes on the first pass (2)

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

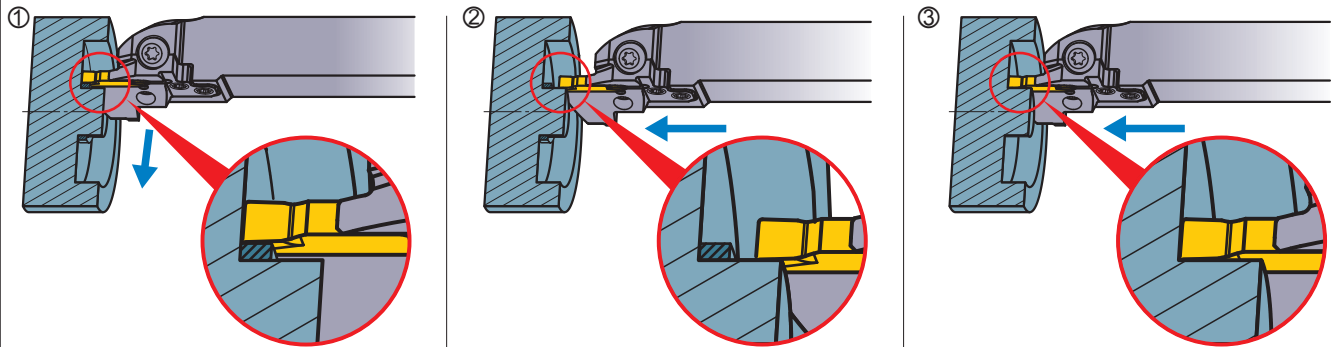
Notes when wide face grooving by plunging in several passes.

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

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

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

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



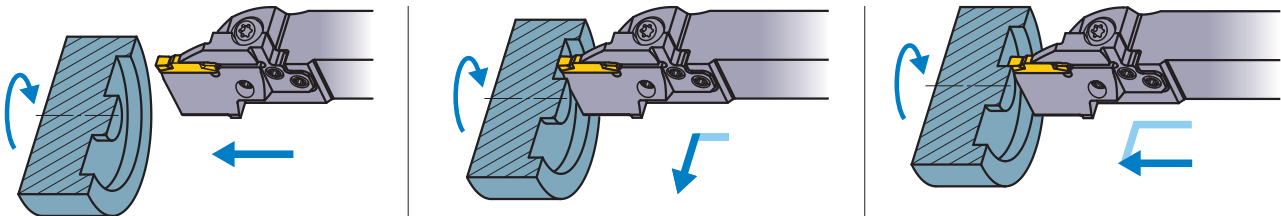
- When infeed machining at the bottom of deep groove, chips may interfere on the cutting edge near the center wall. In such cases, stop infeed machining just before the center wall (at a point less than the insert width) then remove the remaining material by plunging.

Notes when copying (BM Breaker)



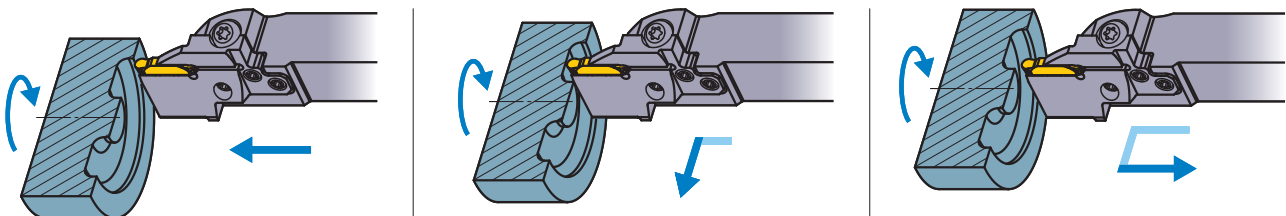
- With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (APMX2) to 30% of the insert width.

Finishing (1)

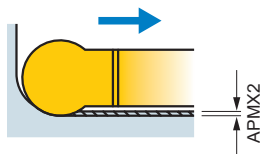


- When finish cutting, machine continuously from the outer wall to the bottom of the groove, then finally plunge cut the center wall.

Finishing (2) (BM Breaker)



- Carry out finishing in one process. For the depth of cut (APMX2) when back turning, refer to the table on the right.

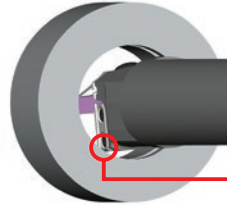


Insert	APMX2 (inch)
GY2M0200D100N-BM	.004
GY2M0250E125N-BM	
GY2M0300F150N-BM	
GY2M0318F159N-BM	.006
GY2M0400G200N-BM	
GY2M0475H238N-BM	.008
GY2M0500H250N-BM	
GY2M0600J150N-BM	.010
GY2M0635J318N-BM	

GROOVING / CUTTING OFF

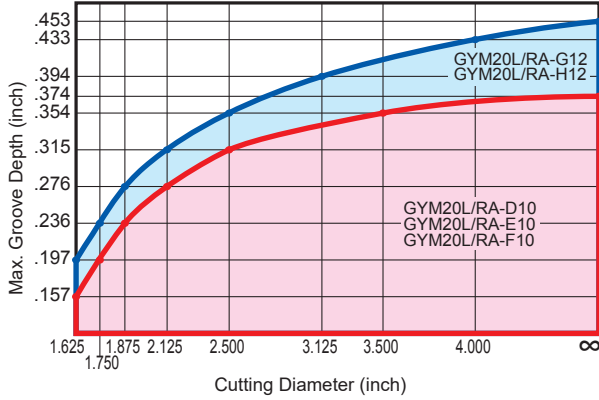
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For Internal Grooving]

- When using the mono block type
The maximum groove depth is not limited by the cutting diameter.
- When using the modular blade type
The maximum groove depth is limited by the cutting diameter.

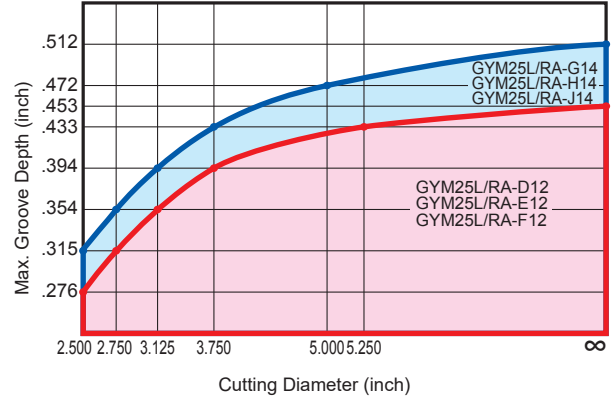


Due to interference of this part, the maximum groove depth is limited by the cutting diameter.

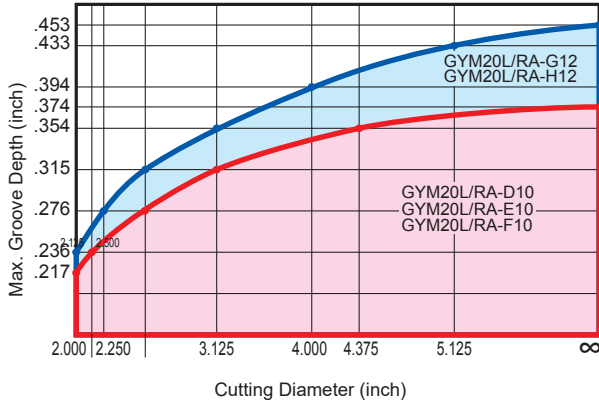
Shank Diameter=1.250 inch (GYM20 Blade)



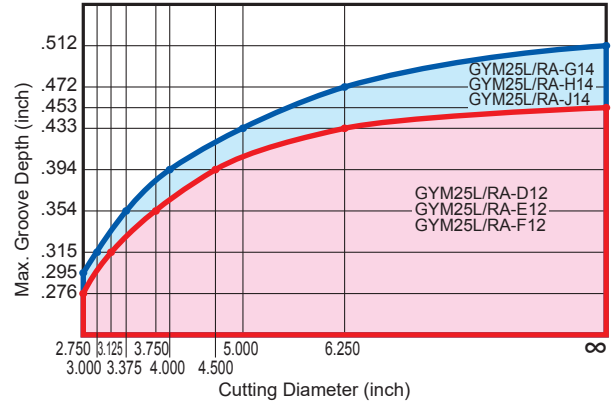
Shank Diameter=1.500 inch (GYM25 Blade)



Shank Diameter=1.500 inch (GYM20 Blade)



Shank Diameter=2.000 inch (GYM25 Blade)



F GROOVING / CUTTING OFF

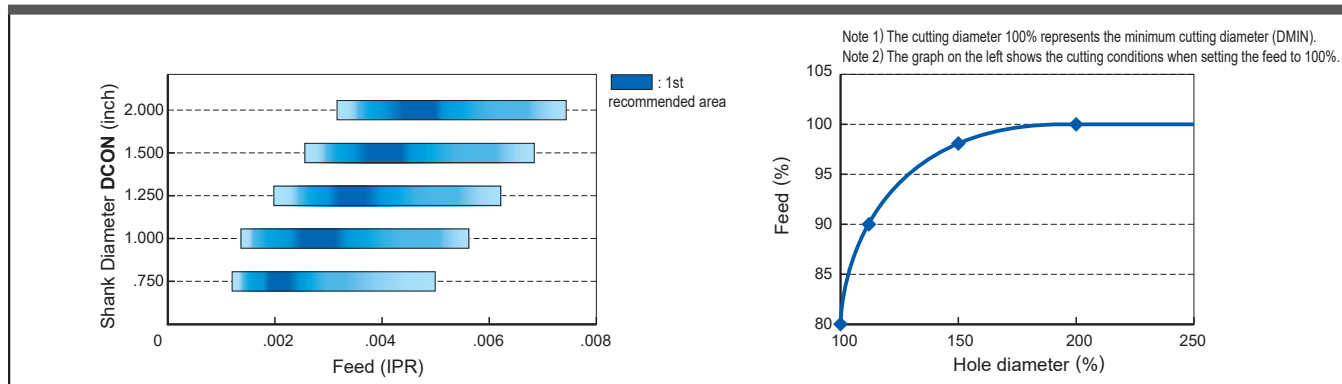
RECOMMENDED CUTTING SPEED (SFM) [For Internal Grooving]

Work Material	Hardness	Grade	Cutting Speed (SFM)						
			165	330	490	655	820	985	1310
P Mild Steel	≤ 160HB	VP20RT	260 — 590						
		VP10RT	295 — 620						
		NX2525	230 — 560						
	Carbon Steel Alloy Steel	160–280HB	VP20RT	195 — 460					
			VP10RT	230 — 490					
			MY5015	295 — 690					
		≥ 280HB	NX2525	180 — 440					
			VP20RT	165 — 360					
			VP10RT	195 — 395					
M Stainless Steel	≤ 270HB	VP20RT	165 — 360						
		VP10RT	195 — 395						
K Gray Cast Iron	Tensile Strength ≤ 300MPa	VP20RT	195 — 460						
		VP10RT	230 — 490						
		MY5015	295 — 690						
	Ductile Cast Iron	Tensile Strength ≤ 800MPa	VP20RT	165 — 360					
			VP10RT	195 — 395					
			MY5015	260 — 525					
S Heat Resistant Alloy Titanium Alloy	—	MP9015	130 — 330						
		MP9025	100 — 295						
		VP20RT	100 — 195						
		VP10RT / RT9010	130 — 230						
H Hardened steel	≥ 50HRC	BC8110	195 — 330						
N Aluminum Alloy	Content Si < 5%	RT9010	490 — 1310						
	Content 5% ≤ Si ≤ 10%	RT9010	490 — 1310						
	Content Si > 10%	RT9010	260 — 525						

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

F
GROOVING / CUTTING OFF

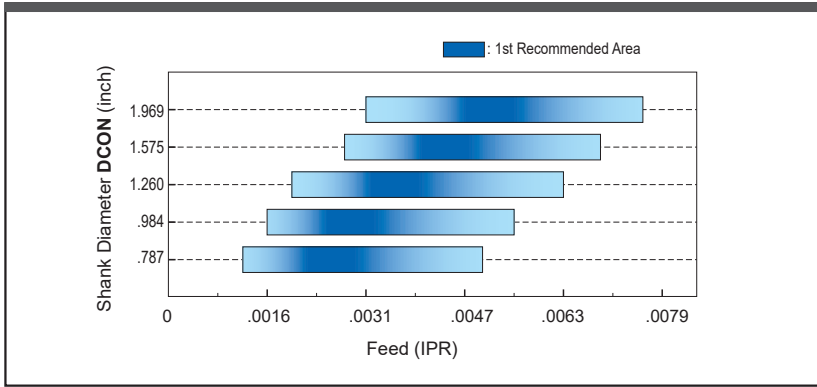
GROOVING



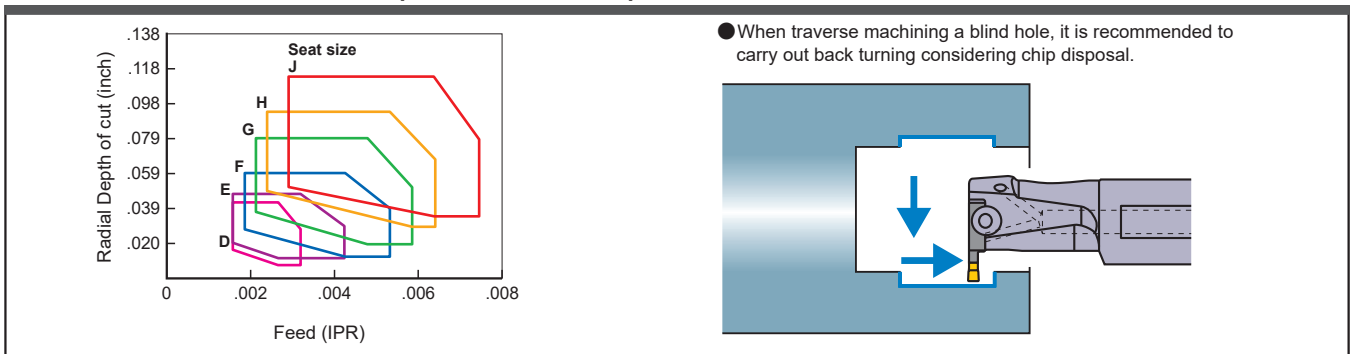
GROOVING / CUTTING OFF

RECOMMENDED CUTTING CONDITIONS [For Internal Grooving]

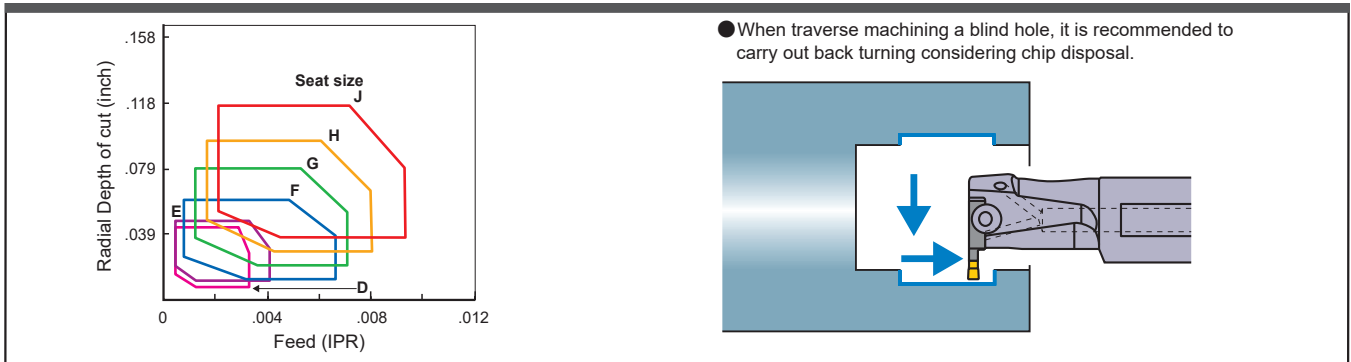
GROOVING (GL BREAKER)



TRAVERSE MACHINING (MF BREAKER)

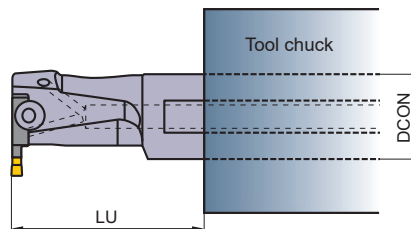


TRAVERSE MACHINING (MM/MS BREAKER)



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

Seat Size	Insert Width	
	D	.079", 2.00 mm
E	.094", 2.39 mm	.098", 2.50 mm
	.108", 2.74 mm	
	.118", 3.00 mm	
F	.125", 3.18 mm	.128", 3.24 mm
	.157", 4.00 mm	
	.167", 4.24 mm	
G	.187", 4.75 mm	.197", 5.00 mm
	.206", 5.24 mm	
	.236", 6.00 mm	
H	.248", 6.31 mm	.250", 6.35 mm



TOOL SELECTION

Notes when selecting the tool body

Holder

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

Modular blade (1)

● For a $\phi 1.5"$ & $\phi 40$ mm shank holder, if there is no restriction for use, select a holder suitable for GYM25 blade.

Modular blade (2)

GYM20R/LA-D10	GYM25R/LA-D12
GYM20R/LA-E10	GYM25R/LA-E12
GYM20R/LA-F10	GYM25R/LA-F12
GYM20R/LA-G12	GYM25R/LA-G14
GYM20R/LA-H12	GYM25R/LA-H14
	GYM25R/LA-J14

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

Notes when setting the tool

Overhang

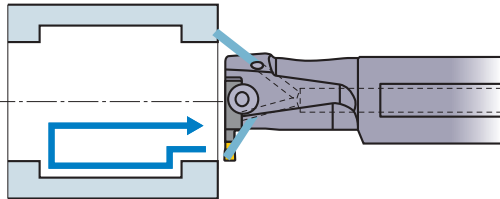
● The maximum groove depth is limited to the dimension LDRED. When machining with longer overhangs, refer to the dimension WF2 of the tool used.

MACHINING RECOMMENDATIONS

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

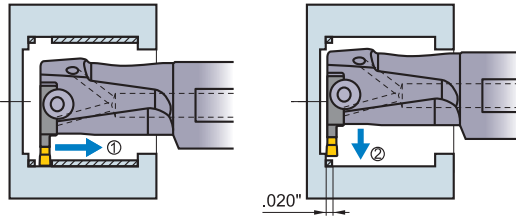
For internal grooving, the machining methods for external grooving (F202 – F203) can be used, but please note the following precautions.

Coolant



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

Machining blind holes



● As continuous chips tend to elongate at the back of the bore, the above operation is recommended. The recommended width of cut for ② is .020 inch.

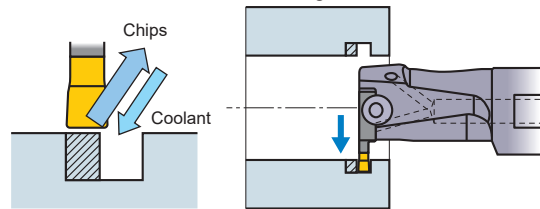
F

GROOVING / CUTTING OFF

Machining Wide Grooves

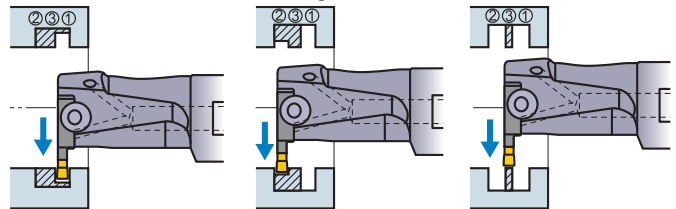
Grooving

● When the insert width is $x \geq$ groove width



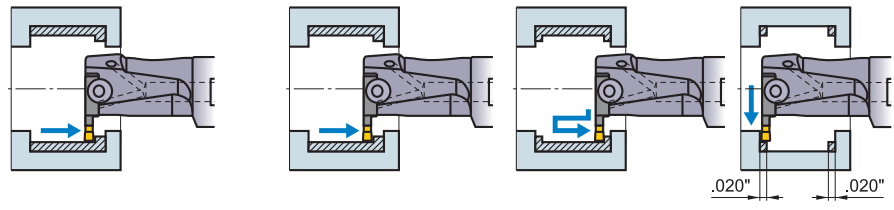
● When the depth of cut is shallower than the insert width, continuous chips are usually produced. When plunging in several passes, it is recommended to carry out machining in the steps above. This ensures that coolant reaches the cutting edge and chips are easily discharged.

● When the insert width is $x <$ groove width



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

Turning

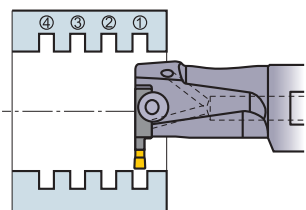


● When chip breaking and disposal are especially important, cross-feed machining is recommended.

● Wide face grooving when the corner R of the workpiece is equal to the corner R of the insert, machine as shown above. (When corner R of the workpiece is larger than corner R of the insert, refer to the description of external wide grooving.)

● If the groove depth exceeds a given level, chips may elongate at the wall. In such a case, increase the feed and carry out machining as shown above.

Machining instruction



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

Memo

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

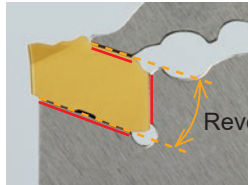
GW Series

Easy to Utilize Configuration that Improves Tool Handling

Clamp

Simple insert clamping method offering high rigidity.

To prevent the insert from being pulled out during machining a reverse taper angle has been designed from the front of the insert. Additionally the design also includes 3 large locating faces between the insert and the blade offering increased cutting edge reliability. The blade itself is made from a special alloy steel to suit this application.



Reverse Taper Angle

In respect to insert indexing, a unique wrench is supplied to ensure ease when changing the insert.

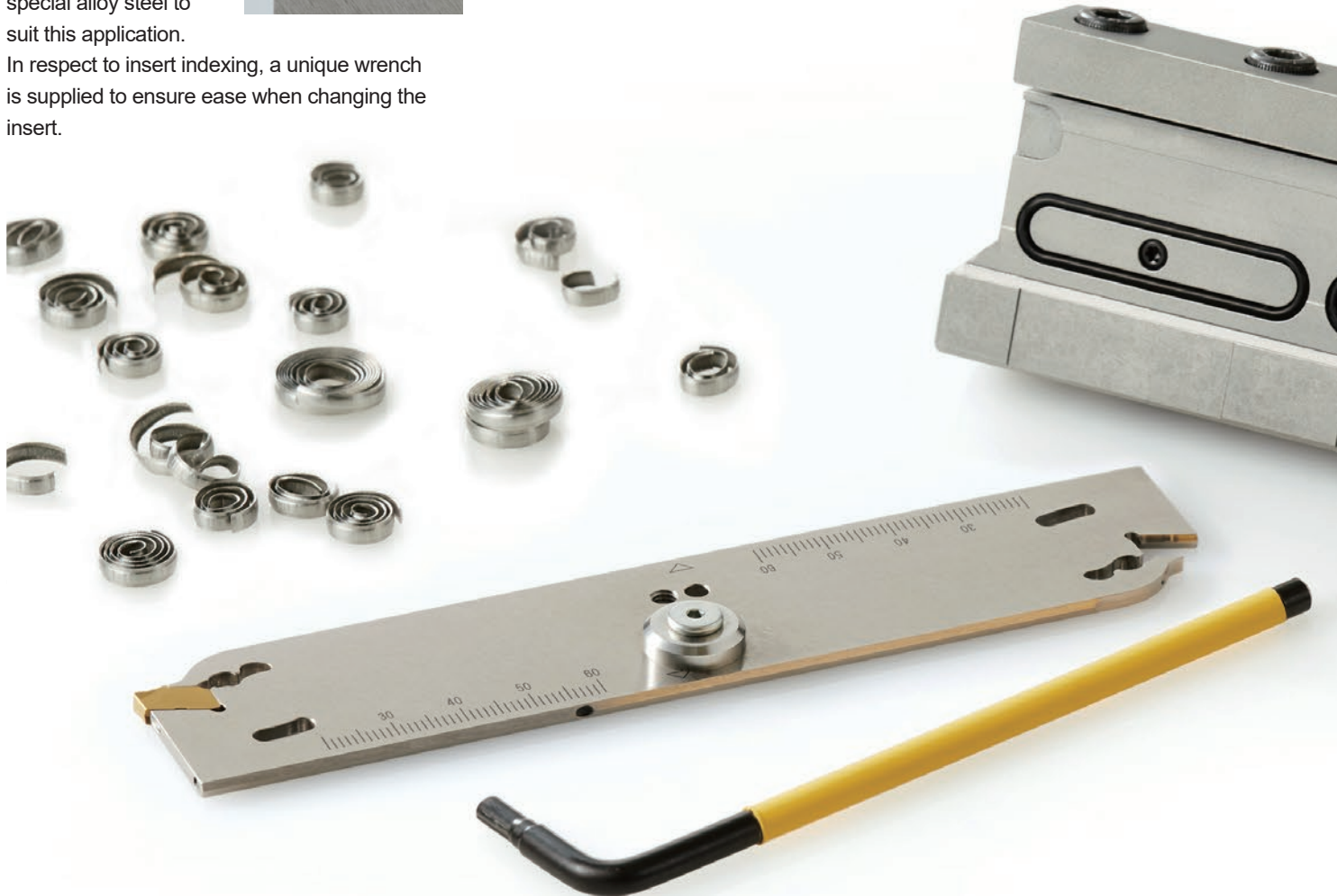
Voice of Developer

Just how easy is it to set an insert?

With the use of a unique wrench, it is possible to locate and remove the insert with one simple action making it easier for use in the workplace.

F

GROOVING / CUTTING OFF



Through Coolant Blade

Increased wear resistance due to the use of 2 through coolant ejection holes.

2 through coolant holes supply the coolant to both the rake and flank face, leading to effective cutting edge cooling and increased wear resistance.



Additionally this blade can also be used for both low pressure and high pressure coolant (1000 PSI).

Voice of Developer

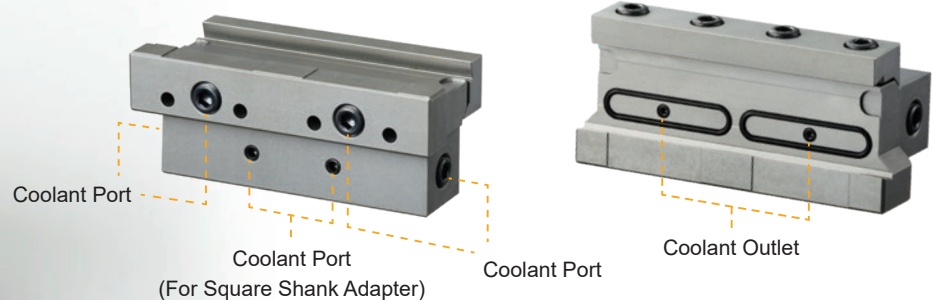
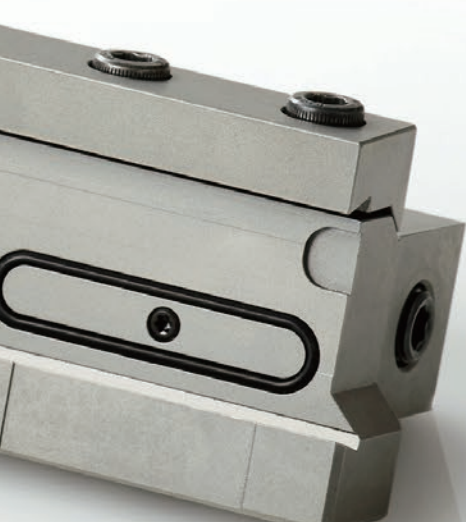
How is it possible to reduce heat generation?

The 2 coolant holes used in the blade are capable of using high coolant pressures of up to (1000 PSI). This is achieved by using as large as possible through coolant hole diameter. The ejection holes are located close to the cutting edge to improve the cutting edge cooling effect and increasing wear resistance.

Coolant Ports

Flexible set up possible with the use of 6 coolant ports.

There are 6 coolant ports designed into the tool block. This makes it easier for the end user to set up the tool block and blade to a configuration that suits their needs. If necessary it is also possible to use coolant hose. The ejection type coolant also improves cutting edge cooling and chip evacuation.



Voice of Developer

Possible set up to suit the requirements of the workplace environment.

One of the objectives of this product is to respond to the customers complaints that "the product did not fit and could not be used". Starting with the coolant outlet that prevents leaks even when oil quantity or overhangs change. Everything from the material and the shape of the O-ring, to the length of the hose has been tailored to the effective use in the workplace.

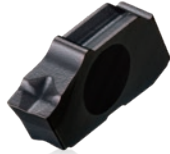
Chip Breaker

Breaker System Offering Excellent Chip Disposal Properties

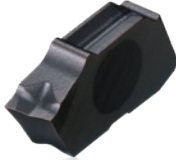
Low Feeds



Neutral



Right Hand (5°)



Right Hand (8°)

GS Breaker

Medium Feeds



Neutral



Right Hand / Left Hand (5°)

GM Breaker

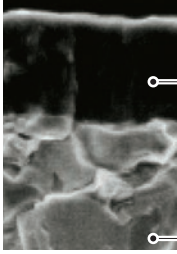
Insert Grades

F

GROOVING / CUTTING OFF

Machining Condition	Work Material			
	P Steel	M Stainless Steel	K Cast Iron	S Heat Resistant Alloy / Titanium Alloy
Stable	MY5015		MY5015	VP10RT
↑ Machining Condition ↓	VP10RT	VP10RT	VP10RT	
	VP20RT	VP20RT	VP20RT	VP20RT
	VP30RT	VP30RT		
Unstable				

VP20RT (1st Recommendation)

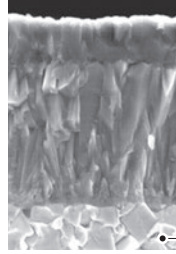


- PVD coated grade suitable for a wide range of applications. The combination of a special tough cemented carbide substrate with MIRACLE coating provides an excellent balance of wear and fracture resistance.

MIRACLE Coating

Carbide Substrate (90.5HRA)

MY5015

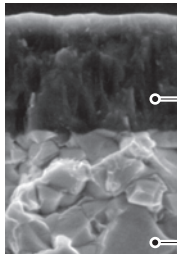


- MY5015 is a CVD coated grade with excellent wear resistance even at high temperatures. It provides longer tool life when machining cast and ductile cast iron. Also suitable for high speed continuous cutting of steels.

CVD Coated Carbide

Carbide Substrate

VP10RT

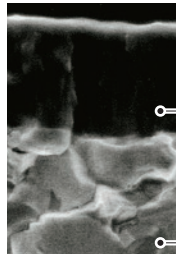


- PVD coated grade with a cemented carbide substrate harder than VP20RT. For use on difficult-to-cut materials and for extending tool life.

MIRACLE Coating

Carbide Substrate (92.0HRA)

VP30RT



- A combination of a tough, special cemented carbide substrate and MIRACLE coating. Ideal for heavy interrupted cutting of stainless and general steels.

MIRACLE Coating (Al,Ti)N

Carbide Substrate (88.8HRA)

F

GROOVING / CUTTING OFF

IDENTIFICATION OF GW SERIES

■ Insert / Blade / Tool Block

● Insert

① **GW** ② **1** ③ **M** ④ **0300** ⑤ **F** ⑥ **030** ⑦ **R** ⑧ **05** - ⑨ **G** ⑩ **M**

① Series Description

③ Peripheral

M	Sintered
---	----------

② Number of Teeth

1	1 Edge Type
---	-------------

④ Groove Width

0200	.079 inch 2.00 mm
0239	.094 inch 2.39 mm
0300	.118 inch 3.00 mm
0400	.157 inch 4.00 mm
0500	.197 inch 5.00 mm

⑤ Seat Size *1

D	.079 inch 2.00 mm
E	.094 inch 2.39 mm
F	.118 inch 3.00 mm
G	.157 inch 4.00 mm
H	.197 inch 5.00 mm

⑦ Hand

N	Neutral
R	Right
L	Left

⑨ Application 1

G	Grooving/Cutting Off
---	----------------------

⑧ Handed Angle

05	5°
08	8°

⑩ Application 2

S	Low Feeds
M	Medium Feeds

⑥ Corner Radius

010	.004 inch
:	:
040	.016 inch

F

GROOVING / CUTTING OFF

● Blade

① **GW** ② **B32** ③ **N** ④ **A** ⑤ **2** - ⑥ **F** ⑦ **60** - ⑧ **C**

① Series Description

③ Hand

N	Neutral
---	---------

④ Blade Geometry

A	Standard Type
---	---------------

② Blade Size *2

B26
B32

⑤ No. of Corners

2	2 Corner
---	----------

⑥ Seat Size *3

D	.079 inch 2.00 mm
F	.118 inch 3.00 mm
G	.157 inch 4.00 mm
H	.197 inch 5.00 mm

⑧ Coolant Hole

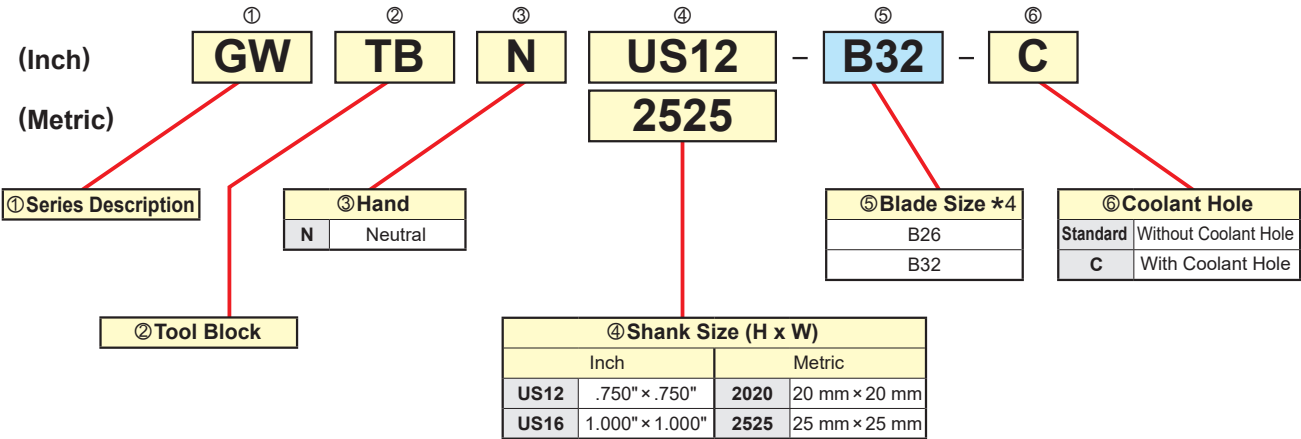
Standard	Without Coolant Hole
C	With Coolant Hole

⑦ Max. Groove Depth

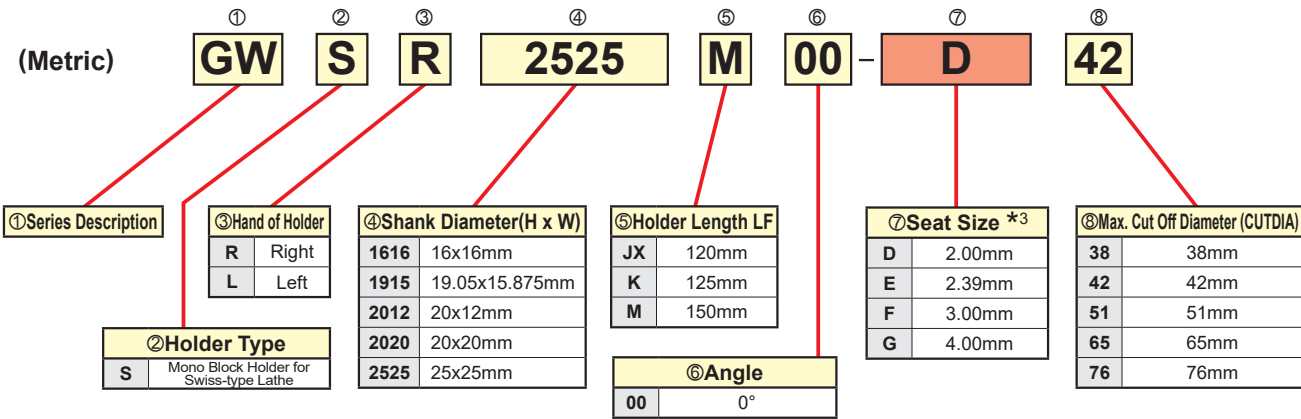
36	1.417 inch
60	2.362 inch

*1 Select seat size with the same symbol as that of blade.
 *2 Select blade size with the same symbol as that of tool block.
 *3 Select seat size with the same symbol of the insert.
 *4 Select blade size with the same symbol as that of blade.

● Tool Block



● MONO BLOCK HOLDER



- *1 Select seat size with the same symbol as that of blade.
- *2 Select blade size with the same symbol as that of tool block.
- *3 Select seat size with the same symbol of the insert.
- *4 Select blade size with the same symbol as that of blade.

GW SERIES (External for Swiss-type lathes)

1-2 00° type holder (Metric) **NEW**

Insert GW1M00000000-GS Insert GW1M000000R00-GS
 Insert GW1M00000000-GM Insert GW1M000000R/L00-GM

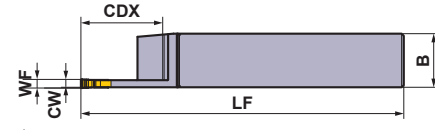
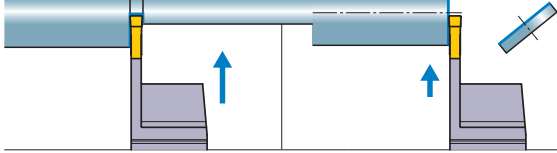
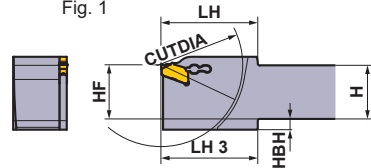


Fig. 1



Right hand tool holder shown.

F

GROOVING / CUTTING OFF

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number		Fig.		
						Holder	Stock			
D	2.00	19	38	Mono Block	R	GWSR1616JX00-D38	★	1		
				Mono Block	L	GWSL1616JX00-D38	★	1		
		21	42	Mono Block	R	GWSR1915K00-D38	★	1		
				Mono Block	L	GWSL1915K00-D38	★	1		
				Mono Block	R	GWSR2020K00-D42	★	1		
				Mono Block	L	GWSL2020K00-D42	★	1		
				Mono Block	R	GWSR2012K00-D42	★	1		
				Mono Block	L	GWSL2012K00-D42	★	1		
E	2.39	19	38	Mono Block	R	GWSR1915K00-E38	★	1		
				Mono Block	L	GWSL1915K00-E38	★	1		
		21	42	Mono Block	R	GWSR2020K00-E42	★	1		
				Mono Block	L	GWSL2020K00-E42	★	1		
				Mono Block	L	GWSL2020K00-E42-M	★	3		
				Mono Block	R	GWSR2012K00-E42	★	1		
				Mono Block	L	GWSL2012K00-E42	★	1		
				Mono Block	R	GWSR2525M00-E42	★	2		
F	3.00	19	38	Mono Block	R	GWSR1915K00-F38	●	1		
				Mono Block	L	GWSL1915K00-F38	●	1		
		21	42	Mono Block	R	GWSR2012K00-F42	●	1		
				Mono Block	L	GWSL2012K00-F42	●	1		
				Mono Block	R	GWSR2020K00-F42	●	1		
				Mono Block	L	GWSL2020K00-F42	●	1		
				Mono Block	L	GWSL2020K00-F42-M	●	3		
				Mono Block	R	GWSR2020K00-F51	●	1		
		25.5	51	Mono Block	L	GWSL2020K00-F51	●	1		
				Mono Block	L	GWSL2020K00-F51-M	●	3		
				Mono Block	R	GWSR2525M00-F51	●	1		
				Mono Block	L	GWSL2525M00-F51	●	1		
				32.5	65	Mono Block	R	GWSR2020M00-F65	●	1
						Mono Block	L	GWSL2020M00-F65	●	1
38	76	Mono Block	R	GWSR2525M00-F76	●	1				
		Mono Block	L	GWSL2525M00-F76	●	1				
G	4.00	38	76	Mono Block	R	GWSR2525M00-G76	★	1		
				Mono Block	L	GWSL2525M00-G76	★	1		

CW = Cutting Width CDX = Max. Groove Depth CUTDIA = Max. Cut Off Diameter

● : USA Stock ★ : Stocked in Japan

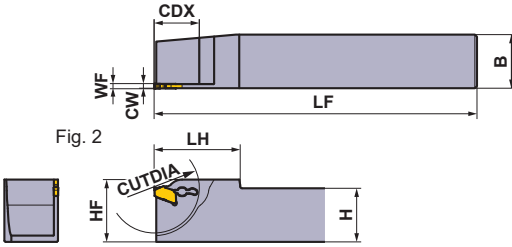


Fig. 2

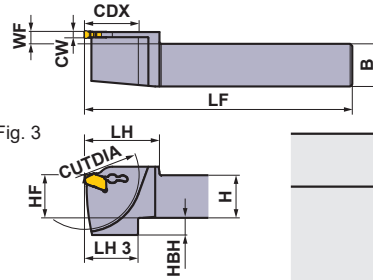


Fig. 3

Right hand tool holder shown.

Left hand tool holder shown.

SPARE PARTS

Holder	
Wrench	
GWSR/L1616JX00-D38	
GWSR/L○○○○○○○○○○00-○○○	GWY39L
GWSR/L2020K00-○○○-M	

Select an Insert

Seat Size	Insert Number
D	GW1M0200D○○○N-Breaker
	GW1M0200D○○○R/L○○-Breaker
E	GW1M0239E○○○N-Breaker
	GW1M0239E○○○R/L○○-Breaker
F	GW1M0300F○○○N-Breaker
	GW1M0300F○○○R/L○○-Breaker
G	GW1M0400G○○○N-Breaker
	GW1M0400G○○○R/L○○-Breaker

For grooving/cutting off breaker > F229

Seat Size	Breaker CW	GS (Low)	GM (Medium)	05-GS (Low)	08-GS (Low)	05-GM (Cutting off)
		Neutral	Neutral	Hand	Hand	Hand
D	.079", 2.00 mm	●	●	●	●	●
E	.094", 2.39 mm	●	●	●	●	●
F	.118", 3.00 mm	●	●	●	●	●
G	.157", 4.00 mm	●	●			●

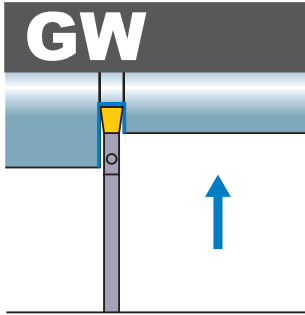
● : Standard insert with dimensions

	Dimensions (mm)							Cutting Mode		
	H	B	LF	LH	LH 3	HF	WF	HBH	Clockwise	Anticlockwise
R	16	16	120	30	30	16	0.3	6		
	16	16	120	30	30	16	0.3	6		
	19.05	15.875	125	35	35	19.05	0.3	3		
	19.05	15.875	125	35	35	19.05	0.3	3		
	20	20	125	35	25	20	0.3	4		
	20	20	125	35	25	20	0.3	4		
	20	12	125	35	25	20	0.3	4		
	20	12	125	35	25	20	0.3	4		
	25	25	150	40	—	25	0.3	—		
	25	25	150	40	—	25	0.3	—		
	19.05	15.875	125	35	35	19.05	0.2	3		
	19.05	15.875	125	35	35	19.05	0.2	3		
20	20	125	35	25	20	0.2	4			
20	20	125	35	25	20	0.2	4			
20	20	125	35	25	20	5.7	8			
20	12	125	35	25	20	0.2	4			
20	12	125	35	25	20	0.2	4			
25	25	150	40	—	25	0.2	—			
25	25	150	40	—	25	0.2	—			
19.05	15.875	125	35	35	19.05	0.3	3	L		
19.05	15.875	125	35	35	19.05	0.3	3			
20	12	125	35	25	20	0.3	4			
20	12	125	35	25	20	0.3	4			
20	20	125	35	25	20	0.3	4			
20	20	125	35	25	20	0.3	4			
20	20	125	35	25	20	5.8	8			
20	20	125	35	25	20	0.3	8			
20	20	125	35	25	20	0.3	8			
20	20	125	35	25	20	5.8	8			
25	25	150	40	40	25	0.3	3			
25	25	150	40	40	25	0.3	3			
20	20	150	40	33	20	0.3	10			
20	20	150	40	33	20	0.3	10			
25	25	150	45	45	25	0.3	5			
25	25	150	45	45	25	0.3	5			
25	25	150	45	45	25	0.4	5			
25	25	150	45	45	25	0.4	5			

GROOVING / CUTTING OFF

GW BLADE

- Simple insert clamping method offering high rigidity.
- The blade is possible to use with both external or through coolant.
- Groove Depth CW .079— .197 inch



For External Cutting Off / Grooving

Fig.1

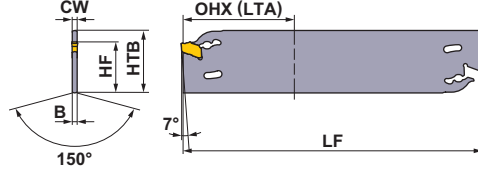
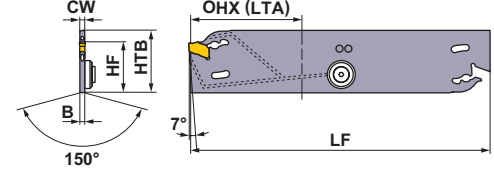


Fig.2



Without Coolant Hole

(inch)

Seat Size	CW	*1 CUTDIA	Order Number	Stock	*2 OHN	*3 OHX (LTA)	B	LF	HTB	HF	Fig.	Insert Type		Wrench	Tool Block Type
												Insert Type	Wrench		
D	.079	2.835	GWB26NA2-D36	●	.630	1.417	.061	4.331	1.024	.843	1	GW1M0200D	GWY39L	GWTBN-B26	
		4.724	GWB32NA2-D60	●	.630	2.362	.061	5.906	1.260	.984	1	GW1M0200D	GWY39L	GWTBN-B32	
F	.118	2.835	GWB26NA2-F36	●	.630	1.417	.096	4.331	1.024	.843	1	GW1M0300F	GWY39L	GWTBN-B26	
		4.724	GWB32NA2-F60	●	.630	2.362	.096	5.906	1.260	.984	1	GW1M0300F	GWY39L	GWTBN-B32	
G	.157	2.835	GWB26NA2-G36	●	.748	1.417	.132	4.331	1.024	.843	1	GW1M0400G	GWY39L	GWTBN-B26	
		4.724	GWB32NA2-G60	●	.748	2.362	.132	5.906	1.260	.984	1	GW1M0400G	GWY39L	GWTBN-B32	
H	.197	2.835	GWB26NA2-H36	●	.748	1.417	.167	4.331	1.024	.843	1	GW1M0500H	GWY39L	GWTBN-B26	
		4.724	GWB32NA2-H60	●	.748	2.362	.167	5.906	1.260	.984	1	GW1M0500H	GWY39L	GWTBN-B32	

With Coolant Hole

(inch)

Seat Size	CW	*1 CUTDIA	Order Number	Stock	*2 OHN	*3 OHX (LTA)	B	LF	HTB	HF	Fig.	Insert Type		Wrench	Tool Block Type
												Insert Type	Wrench		
D	.079	2.835	GWB26NA2-D36-C	●	.630	1.417	.061	4.331	1.024	.843	2	GW1M0200D	GWY39L	GWTBN-B26-C	
		4.724	GWB32NA2-D60-C	●	.630	2.362	.061	5.906	1.260	.984	2	GW1M0200D	GWY39L	GWTBN-B32-C	
F	.118	2.835	GWB26NA2-F36-C	●	.630	1.417	.096	4.331	1.024	.843	2	GW1M0300F	GWY39L	GWTBN-B26-C	
		4.724	GWB32NA2-F60-C	●	.630	2.362	.096	5.906	1.260	.984	2	GW1M0300F	GWY39L	GWTBN-B32-C	
G	.157	2.835	GWB26NA2-G36-C	●	.748	1.417	.132	4.331	1.024	.843	2	GW1M0400G	GWY39L	GWTBN-B26-C	
		4.724	GWB32NA2-G60-C	●	.748	2.362	.132	5.906	1.260	.984	2	GW1M0400G	GWY39L	GWTBN-B32-C	
H	.197	2.835	GWB26NA2-H36-C	●	.748	1.417	.167	4.331	1.024	.843	2	GW1M0500H	GWY39L	GWTBN-B26-C	
		4.724	GWB32NA2-H60-C	●	.748	2.362	.167	5.906	1.260	.984	2	GW1M0500H	GWY39L	GWTBN-B32-C	

*1 CUTDIA: Maximum Cut Off Diameter *2 OHN: Minimum Overhang Length *3 OHX(LTA): Maximum Overhang Length

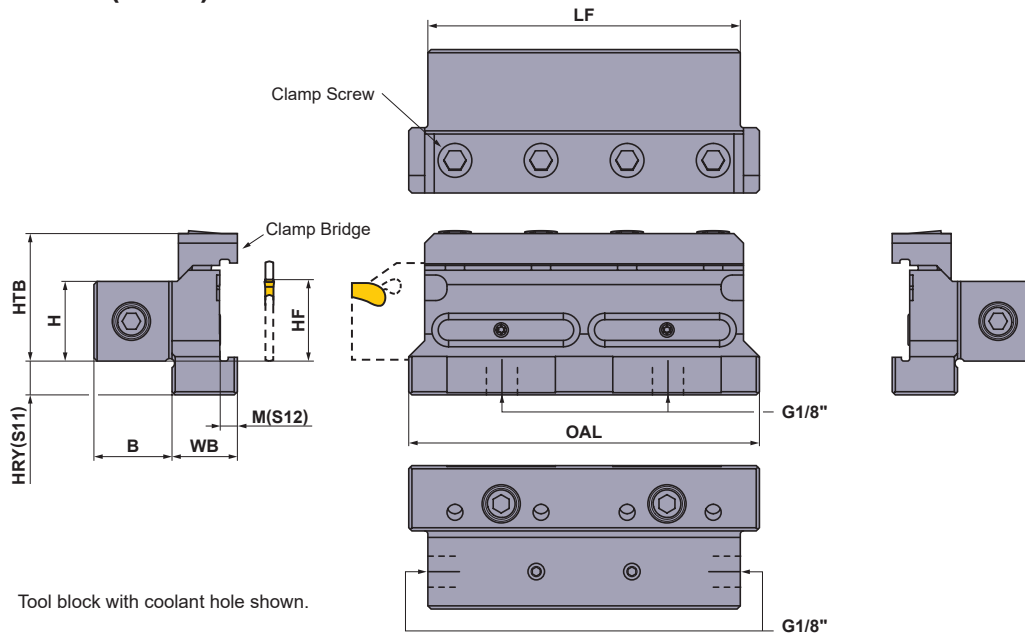
Note 1) Recommended Maximum Coolant Pressure 1000PSI

Spare Parts for Blades with Coolant Hole

(inch)

Order Number	CW	① Washer	② Clamp Screw	③ Plug Wrench
GWB26NA2-D36-C	.079	①GWW04038	GW04005F	HKY20R
GWB32NA2-D60-C	.079	①GWW04038	GW04005F	HKY20R
GWB26NA2-F36-C	.118	①GWW04038	GW04005F	HKY20R
GWB32NA2-F60-C	.118	①GWW04038	GW04005F	HKY20R
GWB26NA2-G36-C	.157	②GWW04026	GW04005F	HKY20R
GWB32NA2-G60-C	.157	②GWW04026	GW04005F	HKY20R
GWB26NA2-H36-C	.197	②GWW04026	GW04005F	HKY20R
GWB32NA2-H60-C	.197	②GWW04026	GW04005F	HKY20R

■ TOOL BLOCK (INCH)



Tool block with coolant hole shown.

Without Coolant Hole

Order Number	Stock	H	HF	HTB	HRY (S11)	B	WB	M (S12)	LF	OAL	(inch)		
											① Clamp Bridge	* Clamp Screw	⌘ Wrench
GWTBNUS12-B26	●	.750	.750	1.28	.470	.730	.790	.200	2.950	3.350	①GWCW1	HSC06020	HKY50R
GWTBNUS12-B32	●	.750	.750	1.34	.650	.730	.810	.220	3.940	4.330	②GWCW2	HSC06020	HKY50R
GWTBNUS16-B26	●	1.000	1.000	1.53	.220	.980	.790	.200	2.950	3.350	①GWCW1	HSC06020	HKY50R
GWTBNUS16-B32	●	1.000	1.000	1.59	.400	.980	.810	.220	3.940	4.330	②GWCW2	HSC06020	HKY50R

With Coolant Hole

Order Number	Stock	H	HF	HTB	HRY (S11)	B	WB	M (S12)	LF	OAL	(inch)		
											① Clamp Bridge	* Clamp Screw	⌘ Wrench
GWTBNUS12-B26-C	●	.750	.750	1.28	.470	.730	.790	.200	2.950	3.350	①GWCW1	HSC06020	HKY50R
GWTBNUS12-B32-C	●	.750	.750	1.34	.650	.730	.810	.220	3.940	4.330	②GWCW2	HSC06020	HKY50R
GWTBNUS16-B26-C	●	1.000	1.000	1.53	.220	.980	.790	.200	2.950	3.350	①GWCW1	HSC06020	HKY50R
GWTBNUS16-B32-C	●	1.000	1.000	1.59	.400	.980	.810	.220	3.940	4.330	②GWCW2	HSC06020	HKY50R

* Clamp Torque (lbf-in) : HSC06020=62

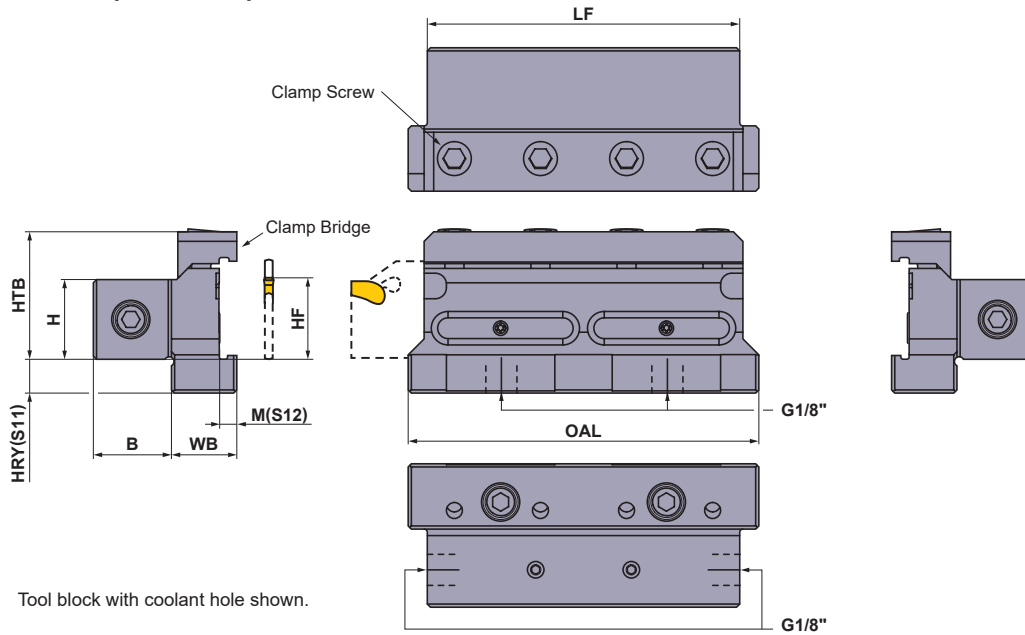
Note 1) Recommended Maximum Coolant Pressure 1000 PSI

Spare Parts for Tool Block with Coolant Hole

Order Number	①	②	③	④	⑤	⑥
	O-ring	Plug	Plug	Wrench	Plug	Wrench
GWTBNUS12-B26-C	①ORGW332N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBNUS12-B32-C	②ORGW457N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBNUS16-B26-C	①ORGW332N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBNUS16-B32-C	②ORGW457N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R

GROOVING / CUTTING OFF

TOOL BLOCK (METRIC)



F

GROOVING / CUTTING OFF

Without Coolant Hole

(mm)

Order Number	Stock	H	HF	HTB	HRY (S11)	B	WB	M (S12)	LF	OAL	①	*	
											②	Clamp Screw	Wrench
GWTBN2020-B26	★	20	20	33.5	11	19.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2020-B32	★	20	20	35.0	15.6	19.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R
GWTBN2525-B26	★	25	25	38.5	6	24.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2525-B32	★	25	25	40.0	10.6	24.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R

With Coolant Hole

(mm)

Order Number	Stock	H	HF	HTB	HRY (S11)	B	WB	M (S12)	LF	OAL	①	*	
											②	Clamp Screw	Wrench
GWTBN2020-B26-C	★	20	20	33.5	11	19.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2020-B32-C	★	20	20	35.0	15.6	19.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R
GWTBN2525-B26-C	★	25	25	38.5	6	24.5	20.0	5.0	75	85	①GWCW1	HSC06020	HKY50R
GWTBN2525-B32-C	★	25	25	40.0	10.6	24.5	20.5	5.5	100	110	②GWCW2	HSC06020	HKY50R

* Clamp Torque (N · m) : HSC06020=7.0

Note 1) Recommended Maximum Coolant Pressure 7MPa

Spare Parts for Tool Block with Coolant Hole

Order Number	①					
	②	O-ring	Plug	Plug	Wrench	Plug
GWTBN2020-B26-C	①ORGW332N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBN2020-B32-C	②ORGW457N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBN2525-B26-C	①ORGW332N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R
GWTBN2525-B32-C	②ORGW457N9	HGJ-PT1/8	HSD05004S	HKY25R	CS300590T	TKY08R

● : USA Stock ★ : Stocked in Japan

<10 inserts in one case>

■ INSERTS

(inch)

Application	Order Number	Stock				Seat Size	CW			RER REL	PSIRR PSIRL	Geometry
		Coating					Cutting Width		Tolerance			
		MY5015	VP10RT	VP20RT	VP30RT		inch	(mm)				
Grooving, Cutting Off	GW1M0200D020N-GS		●	●	●	D	.079	(2.00)	±.0012	.008	—	
Grooving, Cutting Off	NEW GW1M0239E020N-GS		●	●	●	E	.094	(2.39)	±.0012	.008	—	
Grooving, Cutting Off	GW1M0300F020N-GS		●	●	●	F	.118	(3.00)	±.0012	.008	—	
Grooving, Cutting Off	GW1M0400G020N-GS		●	●	●	G	.157	(4.00)	±.0016	.008	—	
Grooving, Cutting Off	GW1M0500H030N-GS		●	●	●	H	.197	(5.00)	±.0016	.012	—	
Grooving, Cutting Off	GW1M0200D020N-GM	●	●	●	●	D	.079	(2.00)	±.0012	.008	—	
Grooving, Cutting Off	NEW GW1M0239E020N-GM	●	●	●	●	E	.094	(2.39)	±.0012	.008	—	
Grooving, Cutting Off	GW1M0300F030N-GM	●	●	●	●	F	.118	(3.00)	±.0012	.012	—	
Grooving, Cutting Off	GW1M0400G030N-GM	●	●	●	●	G	.157	(4.00)	±.0016	.012	—	
Grooving, Cutting Off	GW1M0500H040N-GM	●	●	●	●	H	.197	(5.00)	.0016	.016	—	
Cutting off, Low Feed	NEW GW1M0200D020R05-GS		●	●	●	D	.079	(2.00)	±.0012	.008	5	
Cutting off, Low Feed	NEW GW1M0239E020R05-GS		●	●	●	E	.094	(2.39)	±.0012	.008	5	
Cutting off, Low Feed	NEW GW1M0300F020R05-GS		●	●	●	F	.118	(3.00)	±.0012	.008	5	
Cutting off Low Feed, Lead Angle 8°	NEW GW1M0200D003R08-GS		●	●	●	D	.079	(2.00)	±.0012	.0012	8	
Cutting off Low Feed, Lead Angle 8°	NEW GW1M0239E003R08-GS		●	●	●	E	.094	(2.39)	±.0012	.0012	8	
Cutting off Low Feed, Lead Angle 8°	NEW GW1M0300F003R08-GS		●	●	●	F	.118	(3.00)	±.0012	.0012	8	
Cutting Off	GW1M0200D020R05-GM	●	●	●	●	D	.079	(2.00)	±.0012	.008	5	
Cutting Off	GW1M0200D020L05-GM	●	●	●	●	D	.079	(2.00)	±.0012	.008	5	
Cutting Off	NEW GW1M0239E020R05-GM	●	●	●	●	E	.094	(2.39)	±.0012	.008	5	
Cutting Off	NEW GW1M0239E020L05-GM	●	●	●	●	E	.094	(2.39)	±.0012	.008	5	
Cutting Off	GW1M0300F030R05-GM	●	●	●	●	F	.118	(3.00)	±.0012	.012	5	
Cutting Off	GW1M0300F030L05-GM	●	●	●	●	F	.118	(3.00)	±.0012	.012	5	
Cutting Off	GW1M0400G030R05-GM	●	●	●	●	G	.157	(4.00)	±.0016	.012	5	
Cutting Off	GW1M0400G030L05-GM	●	●	●	●	G	.157	(4.00)	±.0016	.012	5	
Cutting Off	GW1M0500H040R05-GM	●	●	●	●	H	.197	(5.00)	±.0016	.016	5	
Cutting Off	GW1M0500H040L05-GM	●	●	●	●	H	.197	(5.00)	±.0016	.016	5	

Right hand insert shown.

● = NEW

F

GROOVING / CUTTING OFF

Blank Inserts

(inch)

Geometry	Order Number	Carbide		Seat Size	CW			RER	REL
		RT9010	RT9020		Grooving Width		Tolerance		
					inch	(mm)			
1 Edge Type 	GW1B0320D020N	★	★	D	.128	(3.24)	±0.10	.008	.008
	GW1B0440F020N	★	★	F	.175	(4.44)	±0.10	.008	.008
	GW1B0540G020N	★	★	G	.214	(5.44)	±0.10	.008	.008
	GW1B0640H020N	★	★	H	.254	(6.44)	±0.10	.008	.008

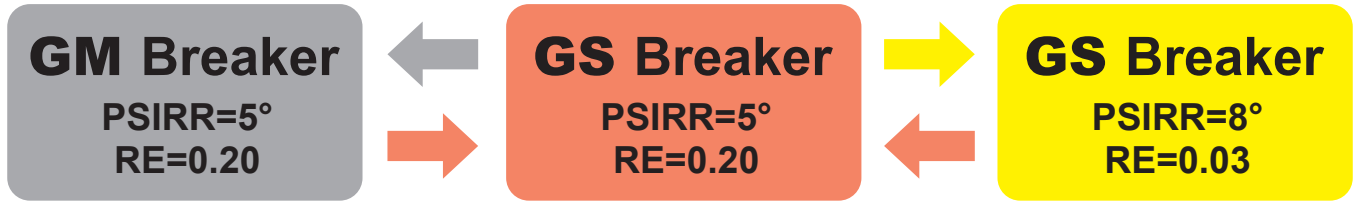
* Insert blank is not suitable for machining without grinding.

Proper Use of GW Series Right Hand Inserts

First Recommended

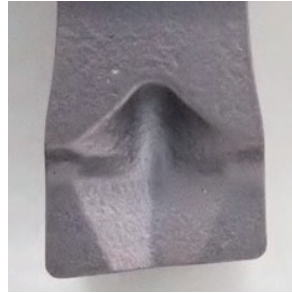
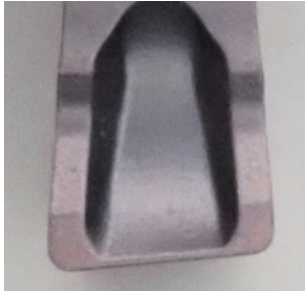
Improved Fracture Resistance

Reduction of Burrs and Core Residue



Reduction of Cutting Resistance

Improved Fracture Resistance








F

GROOVING / CUTTING OFF

Coolant Hose Kit

(inch)

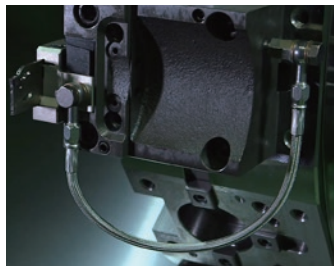
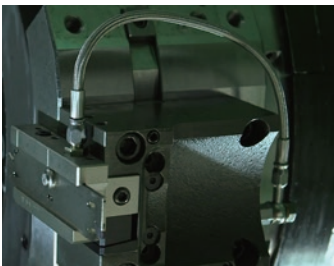
Connector Type	Order Number	Stock	Hose Length	Kit Details								
												
				Code No.	Code No.	QTY.	Code No.	QTY.	Code No.	QTY.	Code No.	QTY.
Straight	CS-1/8-150SS	●	5.91	HOSE-1/8-150	—	—	—	—	AD-G1/8	2	WA-M10	2
Straight	CS-1/8-200SS	●	7.87	HOSE-1/8-200	—	—	—	—	AD-G1/8	2	WA-M10	2
Straight	CS-1/8-250SS	●	9.84	HOSE-1/8-250	—	—	—	—	AD-G1/8	2	WA-M10	2
Straight	CS-1/8-300SS	●	11.81	HOSE-1/8-300	—	—	—	—	AD-G1/8	2	WA-M10	2
Elbow Straight	CS-1/8-150BS	●	5.91	HOSE-1/8-150	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	CS-1/8-200BS	●	7.87	HOSE-1/8-200	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	CS-1/8-250BS	●	9.84	HOSE-1/8-250	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	CS-1/8-300BS	●	11.81	HOSE-1/8-300	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow	CS-1/8-150BB	●	5.91	HOSE-1/8-150	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4
Elbow	CS-1/8-200BB	●	7.87	HOSE-1/8-200	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4
Elbow	CS-1/8-250BB	●	9.84	HOSE-1/8-250	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4
Elbow	CS-1/8-300BB	●	11.81	HOSE-1/8-300	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4

Connection Screw Size = G1/8"

Mounting Example

Elbow Straight Type

Elbow Type



● : USA Stock

RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED

Work Material	Properties	Grade	Cutting Speed v_c (SFM)						
			165	330	490	655	820	985	
P Mild Steel	$\leq 160\text{HB}$	VP20RT		330		785			
		VP10RT		360		820			
	Carbon Steel Alloy Steel	160–280HB	VP20RT		260		655		
			VP10RT		295		690		
			VP30RT	195		590			
		MY5015		360		820			
		$\geq 280\text{HB}$	VP20RT	195		525			
			VP10RT		230		560		
VP30RT	130			460					
MY5015		295		690					
M Stainless Steel	$\leq 270\text{HB}$	VP20RT		195		590			
		VP10RT		230		620			
		VP30RT	130		525				
K Gray Cast Iron	Tensile Strength $\leq 300\text{MPa}$	VP20RT		260		655			
		VP10RT		295		690			
		MY5015		460		985			
	Ductile Cast Iron	Tensile Strength $\leq 800\text{MPa}$	VP20RT		195		525		
			VP10RT		230		560		
			MY5015		295		690		
S Heat Resistant Alloy Titanium Alloy	—	VP20RT	100	195					
		VP10RT	130	230					

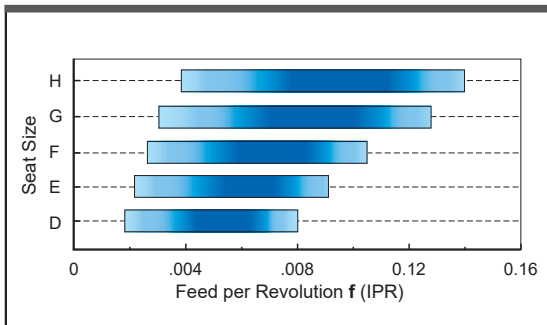
Note 1) VP20RT is the first recommended grade for materials.

Note 2) For VP10RT, VP20RT, VP30RT and MY5015, wet cutting is recommended.

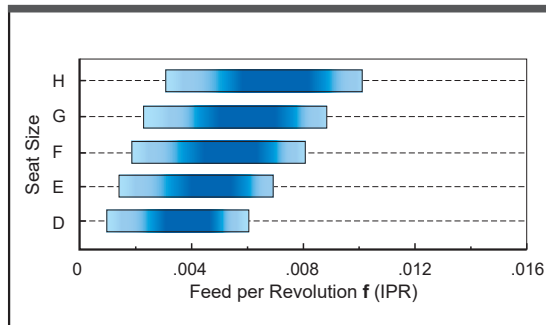
GROOVING / CUTTING OFF

FEED PER REVOLUTION

GM Breaker



GS Breaker



■ : 1st recommended area

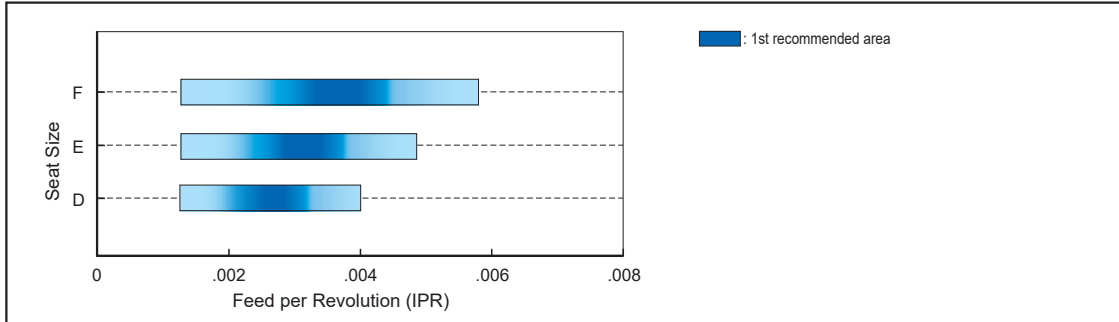
Seat Size	Insert Width
D	.079", 2.0 mm
E	.094", 2.39 mm
F	.118", 3.0 mm
G	.157", 4.0 mm
H	.197", 5.0 mm

Chip Breaker	Feed per Revolution f (IPR)				
	Seat Size D	Seat Size E	Seat Size F	Seat Size G	Seat Size H
GM Breaker	.002–.008	.0024 – .0091	.003–.010	.003–.013	.004–.014
GS Breaker	.001–.006	.0016 – .0067	.002–.008	.002–.009	.003–.010

GROOVING / CUTTING OFF

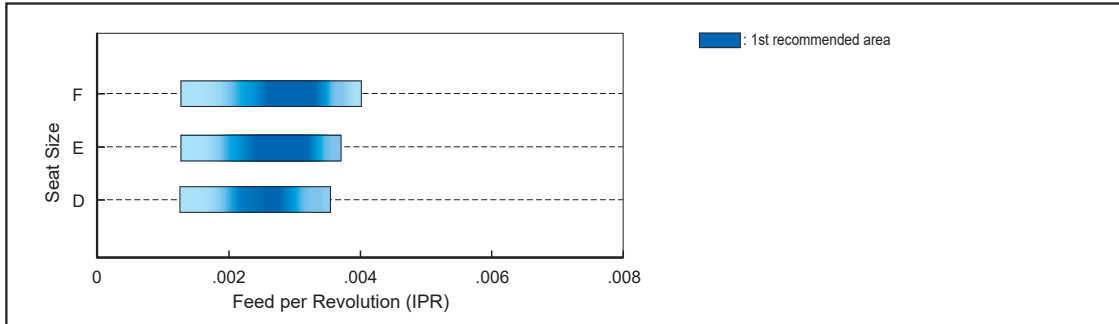
■ CUTTING OFF FEED PER REVOLUTION

R05-GS Breaker



Seat Size	
Insert Width	
D	.079", 2.0 mm
E	.094", 2.39 mm
F	.118", 3.0 mm
G	.157", 4.0 mm
H	.197", 5.0 mm

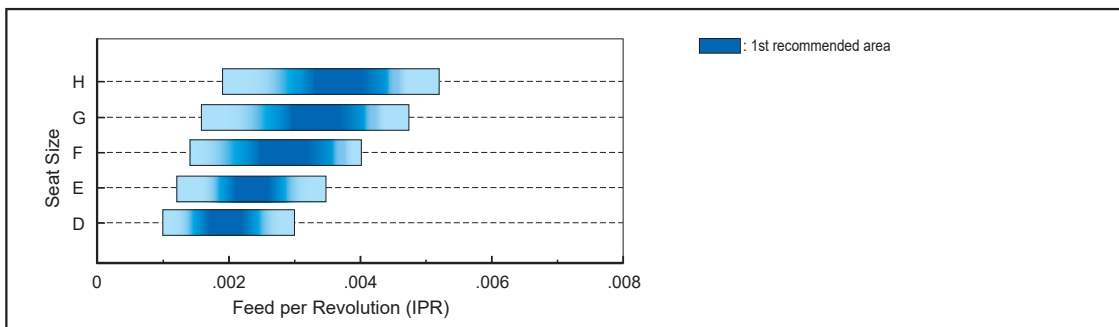
R08-GS Breaker



F

GROOVING / CUTTING OFF

R/L05-GM Breaker

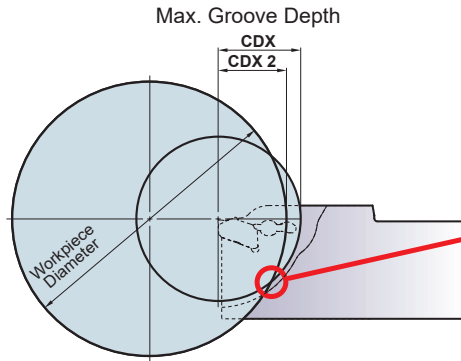


Chip Breaker	PSIPR	Hand	Feed per Revolution (IPR)				
			Seat Size D	Seat Size E	Seat Size F	Seat Size G	Seat Size H
R05-GS	5°	R	.0012 – .0039	.0012 – .0047	.0012 – .0055	–	–
R08-GS	8°	R	.0012 – .0031	.0012 – .0035	.0012 – .0055	–	–
R05-GM	5°	R/L	.0020 – .0059	.0024 – .0067	.0028 – .0079	.0031 – .0091	.0039 – .0102

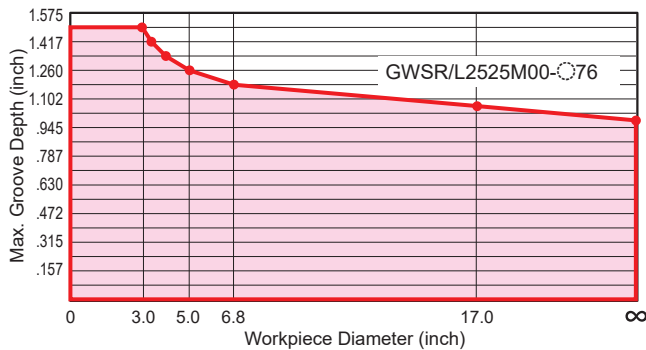
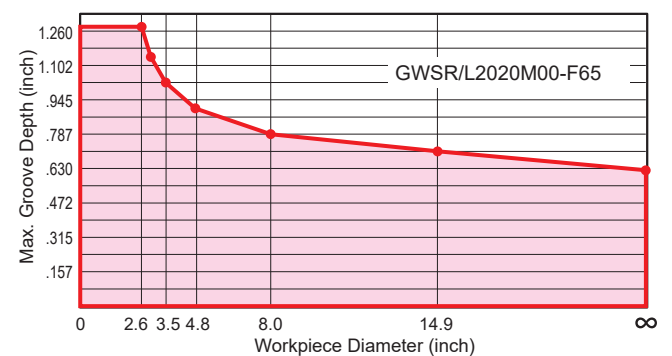
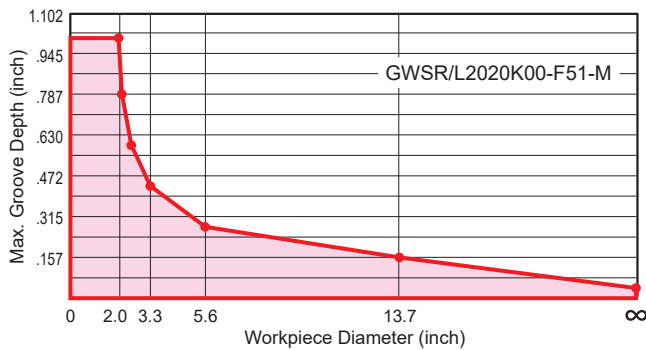
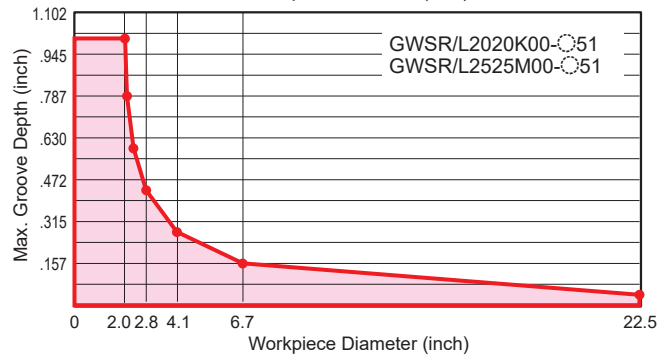
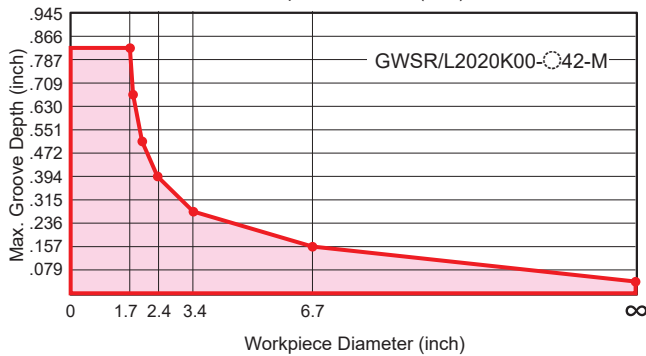
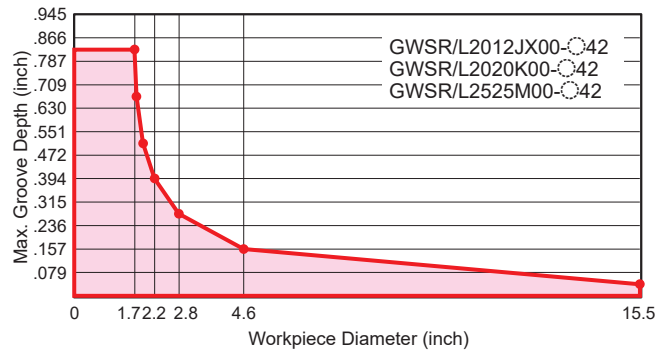
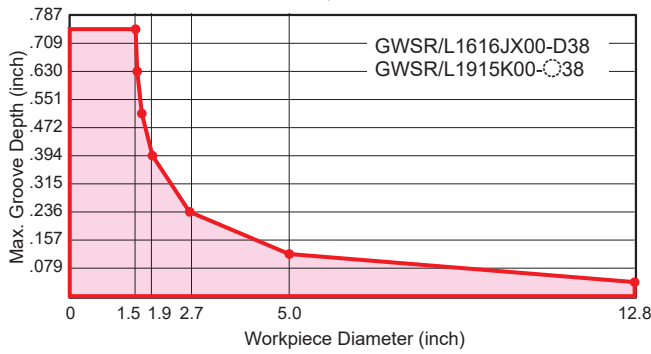
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

•For Swiss-type lathes mono block holder

The maximum groove depth is limited by the workpiece diameter.



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



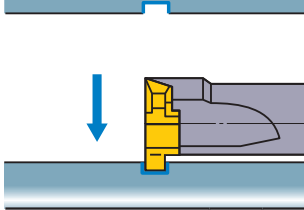
GROOVING / CUTTING OFF

F TYPE BORING BAR

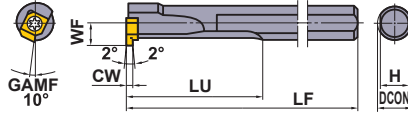
- Min. cutting diameter 10 mm.
- Screw-on type.
- Usable for various applications.
- Max. groove depth: 3 mm.

FSL51

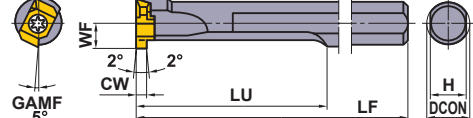
Internal grooving, Threading



1 Corner type (FSL5108R,5110R)



2 Corner type (FSL5112R,5114R,5116R)



Metric Standard

Right hand tool holder only.

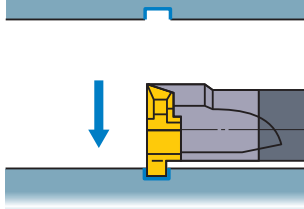
Order Number	Stock	Insert Number			Dimensions (mm)							Max. Groove Depth (mm)	Clamp Screw	Wrench	
		R	Grooving	Threading	DCON	H	LF	LU	WF	CW	DMIN*				
FSL5108R	★		10 \odot L	MLT	1001L	8	7	125	30	4.8	1.2	10	1.0	TS25	TKY08F
FSL5110R	★	MLG	10 \odot L	MLT	1001L	10	9	150	40	5.8	1.5	12	1.0	TS25	TKY08F
FSL5112R	★		14 \odot L	MLT	1401L	12	10.8	180	50	6.8	1.5	14	2.0	TS32	TKY08F
FSL5114R	★	MLG	14 \odot L	MLT	1401L	14	12.4	180	60	7.8	2.0	16	2.0	TS32	TKY08F
FSL5116R	★	MLG	20 \odot L	MLT	2001L	16	14	200	70	9.7	2.0	20	3.0	TS43	TKY15F
											3.0	4.0			

*DMIN : Min. Cutting Diameter

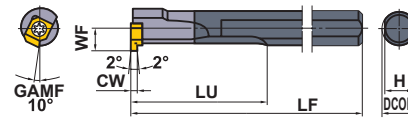
GROOVING / CUTTING OFF

FSL52

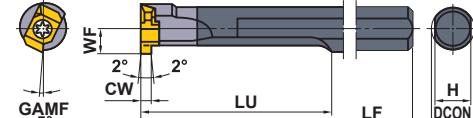
(Carbide shank) Internal grooving, Threading



1 Corner type (FSL5208R,5210R)



2 Corner type (FSL5212R,5214R,5216R)



Metric Standard

Right hand tool holder only.

Order Number	Stock	Insert Number			Dimensions (mm)							Max. Groove Depth (mm)	Clamp Screw	Wrench	
		R	Grooving	Threading	DCON	H	LF	LU	WF	CW	DMIN*				
FSL5208R	★		10 \odot L	MLT	1001L	8	7	125	60	4.8	1.2	10	1.0	TS25	TKY08F
FSL5210R	★	MLG	10 \odot L	MLT	1001L	10	9	150	70	5.8	1.5	12	1.0	TS25	TKY08F
FSL5212R	★		14 \odot L	MLT	1401L	12	10.8	180	80	6.8	1.5	14	2.0	TS32	TKY08F
FSL5214R	★	MLG	14 \odot L	MLT	1401L	14	12.4	180	85	7.8	2.0	16	2.0	TS32	TKY08F
FSL5216R	★	MLG	20 \odot L	MLT	2001L	16	14	200	115	9.7	2.0	20	3.0	TS43	TKY15F
											3.0	4.0			

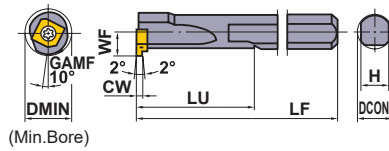
*DMIN : Min. Cutting Diameter

● : USA Stock ★ : Stocked in Japan

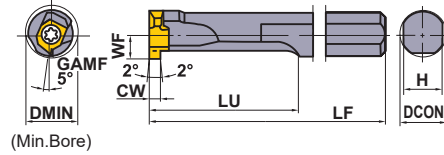
S-SL5N

Internal grooving, Threading, Boring



1 Corner type (S-SL5NR05 / 06)



2 Corner type (S-SL5NR08 / 10 / 12)



Right hand tool holder only.

Order Number	Stock R	Insert Number		Dimensions (inch)							 Clamp Screw	 Wrench
		Grooving	Threading	DCON	H	LF	LU	WF	CW	DMIN		
S-SL5NR05	●	MLG10W○○○L	MLT1001L	.313	.283	5.000	1.250	.188	.062" 1.2 mm	.390	TS25	TKY08F
S-SL5NR06	●	MLG10W○○○L	MLT1001L	.375	.340	6.000	1.500	.219	1.5 mm 2.0 mm	.449	TS25	TKY08F
S-SL5NR08	●	MLG14W○○○L	MLT1401L	.500	.460	7.000	2.000	.281	.062" 1.5 mm 2.0 mm 3.0 mm	.579	TS32	TKY08F
S-SL5NR10	●	MLG20W○○○L	MLT2001L	.625	.560	8.000	3.000	.375	2.0 mm 3.0 mm	.791	TS43	TKY15F
S-SL5NR12	●	MLG20W○○○L	MLT2001L	.750	.700	10.000	4.000	.438	4.0 mm	.902	TS43	TKY15F

F

GROOVING / CUTTING OFF

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (SFM)	Feed (IPR)
P Carbon Steel Alloy Steel	180–280HB	UP20M • UTi20T	295 (195–390)	.002 (.0008–.003)
	280–350HB	UP20M • UTi20T	260 (165–330)	.001 (.0008–.0015)

INSERTS > F236
SPARE PARTS > M001
TECHNICAL DATA > N001

F235

GROOVING / CUTTING OFF

F TYPE

INSERTS

Application	CW (inch)	Order Number	Carbide		Dimensions (inch)					Geometry	
			UT120T	HT110	L	W1	CDX	S	BCH		
Grooving	Inch	.062	MLG10W062L		●	.276	.197	.039	.094	.004	MLG...L (1 Corner type)
	Metric	.047 (1.2 mm)	MLG1012L	●		.276	.197	.039	.094	.004	
		.059 (1.5 mm)	MLG1015L	●		.276	.197	.039	.094	.004	
		.079 (2.0 mm)	MLG1020L	●		.276	.197	.039	.094	.004	
	Metric	.059 (1.5 mm)	MLG1415L	●		.465	.256	.079	.187	.004	MLG...L (2 Corner type)
		.079 (2.0 mm)	MLG1420L	●		.465	.256	.079	.187	.004	
		.118 (3.0 mm)	MLG1430L	●		.465	.256	.079	.187	.004	
		.079 (2.0 mm)	MLG2020L	●		.661	.356	.118	.250	.004	
		.118 (3.0 mm)	MLG2030L	●		.661	.356	.118	.250	.004	
		.157 (4.0 mm)	MLG2040L	●		.661	.356	.118	.250	.004	

GROOVING / CUTTING OFF

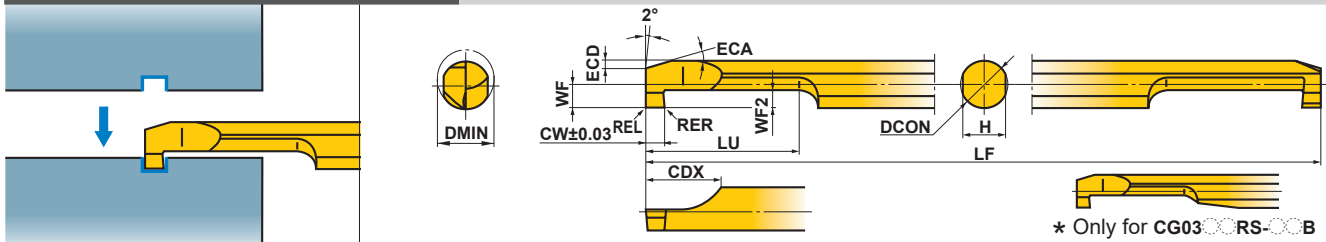
Application	Pitch	Order Number	Coated	Carbide	Dimensions (inch)				Geometry
			UP20M	UT120T	L	W1	S	RE	
Threading	13T.P.I	MLT1001L	●	●	.276	.197	.094	.004	MLT1001L (1 Corner type)
	11T.P.I	MLT1401L	●	●	.465	.256	.187	.004	
	8T.P.I	MLT2001L	●	●	.661	.356	.250	.004	
									MLT1401L /2001L (2 Corner type)

● : USA Stock

MICRO-MINI TWIN

CG

Internal grooving



Order Number	Stock		Breaker	Dimensions (mm)												
	Micro Grain Carbide	Coated		DMIN	CW	WF2	RER/L	DCON	LF	LU	CDX	WF	H	ECA	ECD	
	TF15	VP15TF														
CG0305RS-10	●	●	Without	3	1	1	0.05	3	50	5	6	1.3	2.7	15°	0.3	
CG0305RS-10B	●	●	With	3	1	1	0.05	3	50	5	6	1.3	2.7	15°	0.3	
CG0306RS-20	●	●	Without	3	2	1	0.1	3	50	6	6	1.3	2.7	15°	0.3	
CG0306RS-20B	●	●	With	3	2	1	0.1	3	50	6	6	1.3	2.7	15°	0.3	
CG03RS-10	●	●	Without	3	1	1	0.05	3	50	10	6	1.3	2.7	15°	0.3	
CG03RS-10B	●	●	With	3	1	1	0.05	3	50	10	6	1.3	2.7	15°	0.3	
CG03RS-20	●	●	Without	3	2	1	0.1	3	50	11	6	1.3	2.7	15°	0.3	
CG03RS-20B	●	●	With	3	2	1	0.1	3	50	11	6	1.3	2.7	15°	0.3	
CG0407RS-10	●	●	Without	4	1	1.5	0.05	4	60	7	7	1.8	3.6	15°	0.5	
CG0407RS-10B	●	●	With	4	1	1.5	0.05	4	60	7	7	1.8	3.6	15°	0.5	
CG0408RS-20	●	●	Without	4	2	1.5	0.1	4	60	8	7	1.8	3.6	15°	0.5	
CG0408RS-20B	●	●	With	4	2	1.5	0.1	4	60	8	7	1.8	3.6	15°	0.5	
CG04RS-10	●	●	Without	4	1	1.5	0.05	4	60	15	7	1.8	3.6	15°	0.5	
CG04RS-10B	●	●	With	4	1	1.5	0.05	4	60	15	7	1.8	3.6	15°	0.5	
CG04RS-20	●	●	Without	4	2	1.5	0.1	4	60	16	7	1.8	3.6	15°	0.5	
CG04RS-20B	●	●	With	4	2	1.5	0.1	4	60	16	7	1.8	3.6	15°	0.5	
CG0510RS-10	●	●	Without	5	1	2	0.05	5	70	10	8	2.3	4.5	15°	0.7	
CG0510RS-10B	●	●	With	5	1	2	0.05	5	70	10	8	2.3	4.5	15°	0.7	
CG0511RS-20	●	●	Without	5	2	2	0.1	5	70	11	8	2.3	4.5	15°	0.7	
CG0511RS-20B	●	●	With	5	2	2	0.1	5	70	11	8	2.3	4.5	15°	0.7	
CG05RS-10	●	●	Without	5	1	2	0.05	5	70	20	8	2.3	4.5	15°	0.7	
CG05RS-10B	●	●	With	5	1	2	0.05	5	70	20	8	2.3	4.5	15°	0.7	
CG05RS-20	●	●	Without	5	2	2	0.1	5	70	21	8	2.3	4.5	15°	0.7	
CG05RS-20B	●	●	With	5	2	2	0.1	5	70	21	8	2.3	4.5	15°	0.7	
CG0610RS-10	●	●	Without	6	1	2	0.05	6	75	10	8	2.8	5.4	15°	0.7	
CG0610RS-10B	●	●	With	6	1	2	0.05	6	75	10	8	2.8	5.4	15°	0.7	
CG0611RS-20	●	●	Without	6	2	2	0.1	6	75	11	8	2.8	5.4	15°	0.7	
CG0611RS-20B	●	●	With	6	2	2	0.1	6	75	11	8	2.8	5.4	15°	0.7	
CG06RS-10	●	●	Without	6	1	2	0.05	6	75	20	8	2.8	5.4	15°	0.7	
CG06RS-10B	●	●	With	6	1	2	0.05	6	75	20	8	2.8	5.4	15°	0.7	
CG06RS-20	●	●	Without	6	2	2	0.1	6	75	21	8	2.8	5.4	15°	0.7	
CG06RS-20B	●	●	With	6	2	2	0.1	6	75	21	8	2.8	5.4	15°	0.7	
CG0712RS-10	●	●	Without	7	1	2	0.05	7	85	12	8	3.3	6.4	15°	0.7	
CG0712RS-10B	●	●	With	7	1	2	0.05	7	85	12	8	3.3	6.4	15°	0.7	
CG0713RS-20	●	●	Without	7	2	2	0.1	7	85	13	8	3.3	6.4	15°	0.7	
CG0713RS-20B	●	●	With	7	2	2	0.1	7	85	13	8	3.3	6.4	15°	0.7	
CG07RS-10	●	●	Without	7	1	2	0.05	7	85	25	8	3.3	6.4	15°	0.7	
CG07RS-10B	●	●	With	7	1	2	0.05	7	85	25	8	3.3	6.4	15°	0.7	
CG07RS-20	●	●	Without	7	2	2	0.1	7	85	26	8	3.3	6.4	15°	0.7	
CG07RS-20B	●	●	With	7	2	2	0.1	7	85	26	8	3.3	6.4	15°	0.7	

T

GROOVING / CUTTING OFF

HOLDER

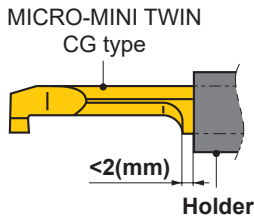
HOLDER CROSS REFERENCE LIST OF INCH SHANK STANDARD

Holder		Stock	MICRO-MINI TWIN	Machine Makers
Type	Order Number *1		CG	
Round Type Holder φ .625 inch	ID : Metric Type	●	030RS-○○(B), 03RS-○○(B)	Citizen Precision Machinery Co., Ltd. NC lathes
		●	040RS-○○(B), 04RS-○○(B)	
		●	051RS-○○(B), 05RS-○○(B)	
		●	061RS-○○(B), 06RS-○○(B)	
		●	071RS-○○(B), 07RS-○○(B)	
Round Type Holder φ .750 inch	ID : Metric Type	●	030RS-○○(B), 03RS-○○(B)	Citizen Precision Machinery Co., Ltd.
		●	040RS-○○(B), 04RS-○○(B)	
		●	051RS-○○(B), 05RS-○○(B)	
		●	061RS-○○(B), 06RS-○○(B)	
		●	071RS-○○(B), 07RS-○○(B)	
Round Type Holder φ 1.000 inch	ID : Metric Type	●	030RS-○○(B), 03RS-○○(B)	Citizen Precision Machinery Co., Ltd. NC lathes
		●	040RS-○○(B), 04RS-○○(B)	
		●	051RS-○○(B), 05RS-○○(B)	
		●	061RS-○○(B), 06RS-○○(B)	
		●	071RS-○○(B), 07RS-○○(B)	

* Mitsubishi Materials obtained the makers' approval before entering their names in the list.

*1 For holder details, refer to Boring Bar Section, page E034—E038.

RECOMMENDED TOOL OVERHANG



Note 1) For LU, refer to page F237.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Speed (SFM)	Feed (IPR)	
			03RS/04RS	05RS/06RS/07RS
P Carbon Steel · Alloy Steel	180—280HB	130—395	.0004—.001	.0004—.002
M Stainless Steel	≤200HB	130—395	.0004—.001	.0004—.002
K Gray Cast Iron	Tensile Strength ≤350MPa	130—395	.0004—.002	.0004—.002
N Non-Ferrous Metal	—	260—525	.0004—.002	.0004—.003

Note 1) Recommend wet machining.

● : USA Stock ★ : Stocked in Japan

HOLDER CROSS REFERENCE LIST OF METRIC SHANK STANDARD

Holder		Stock	MICRO-MINI TWIN	Machine Makers
Type	Order Number*1		CG	
Round Type Holder φ16 mm	RBH1630N	●	030○RS-○○(B), 03RS-○○(B)	MIYANO MACHINERY JAPAN INC. NC lathes
	RBH1640N	●	040○RS-○○(B), 04RS-○○(B)	
	RBH1650N	●	051○RS-○○(B), 05RS-○○(B)	
	RBH1660N	●	061○RS-○○(B), 06RS-○○(B)	
	RBH1670N	●	071○RS-○○(B), 07RS-○○(B)	
Round Type Holder φ20 mm	RBH2030N	●	030○RS-○○(B), 03RS-○○(B)	Citizen Precision Machinery Co., Ltd. Tsugami Corporation MIYANO MACHINERY JAPAN INC. NC lathes
	RBH2040N	●	040○RS-○○(B), 04RS-○○(B)	
	RBH2050N	●	051○RS-○○(B), 05RS-○○(B)	
	RBH2060N	●	061○RS-○○(B), 06RS-○○(B)	
	RBH2070N	●	071○RS-○○(B), 07RS-○○(B)	
Round Type Holder φ22 mm	RBH2230N	●	030○RS-○○(B), 03RS-○○(B)	STAR MICRONICS CO., LTD.
	RBH2240N	●	040○RS-○○(B), 04RS-○○(B)	
	RBH2250N	●	051○RS-○○(B), 05RS-○○(B)	
	RBH2260N	●	061○RS-○○(B), 06RS-○○(B)	
	RBH2270N	●	071○RS-○○(B), 07RS-○○(B)	
Round Type Holder φ25 mm	RBH2530N	●	030○RS-○○(B), 03RS-○○(B)	Tsugami Corporation MIYANO MACHINERY JAPAN INC. NC lathes
	RBH2540N	●	040○RS-○○(B), 04RS-○○(B)	
	RBH2550N	●	051○RS-○○(B), 05RS-○○(B)	
	RBH2560N	●	061○RS-○○(B), 06RS-○○(B)	
	RBH2570N	●	071○RS-○○(B), 07RS-○○(B)	
Square Type Holder □10 mm	SBH1030R	★	030○RS-○○(B), 03RS-○○(B)	NC lathes
	SBH1040R	★	040○RS-○○(B), 04RS-○○(B)	
	SBH1050R	★	051○RS-○○(B), 05RS-○○(B)	
	SBH1060R	★	061○RS-○○(B), 06RS-○○(B)	
	SBH1070R	★	071○RS-○○(B), 07RS-○○(B)	

* Mitsubishi Materials obtained the makers' approval before entering their names in the list.

*1 For holder details, refer to Boring Bar Section, page E034—E038.

F

GROOVING / CUTTING OFF