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GT HOLDER

EXTERNAL GROOVING FOR SMALL PARTS MACHINING

TOOL NEWS **B282A**

External Grooving for Small Parts Machining

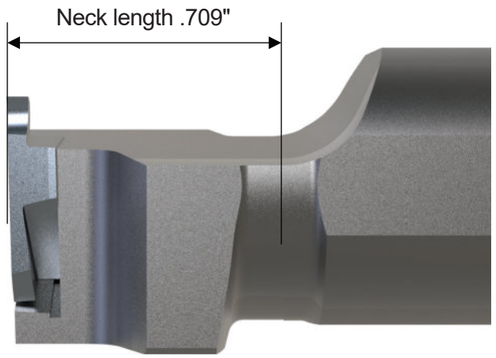
GT Holder

Newly added 90° holder

The neck dimensions have been optimized to improve resistance to chatter and vibration.

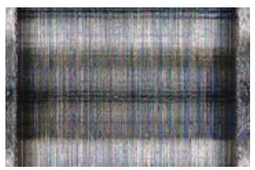
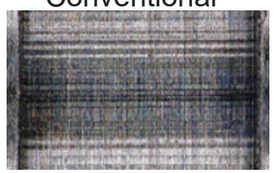
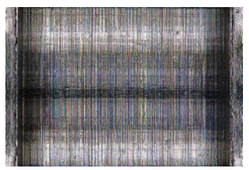
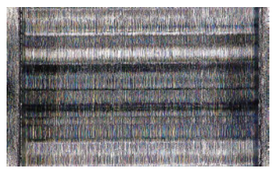
SH-GTAF GTAF

Round shank holder for rear tool post

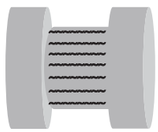


304: Comparison of machined surfaces (round shank holder)

High rigidity and large machining depth provide excellent resistance to chatter and vibration.

	SH-GTAF	Conventional
Feed f =.0012 (IPR)		 Chatter and vibration occur
Feed f =.0028 (IPR)		 Chatter and vibration occur

<Cutting Conditions>
Material : AISI 304 Dia. .630"
Cutting Speed : vc = 260 SFM
Feed per Rev. : f = .0012 IPR, .0028 IPR
Groove Width = .118"
Groove Depth =.059"
Cutting Mode : Wet Cutting

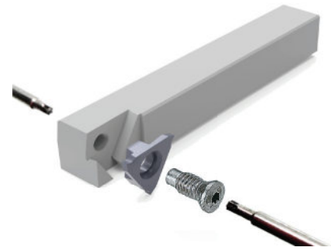

Traces of chatter and vibration

External Grooving for Small Parts Machining

GTAH, GTBH, GTCH

Back Clamping Mechanism

For gang type tool posts on Swiss automatic lathes, tools can be changed quickly and accurately using the same wrench on both sides, improving machine operating efficiency.
Offset type is not included.



Holder	Angle	Name of Tool Holder	Note	Shank Size	Applicable Insert Type
Square Shank	0°	GTAH CW(Groove width) 0.25-3.0 mm	Without off set	8 x 8 x 80 mm	GTAT GTBT GTCT
				8 x 8 x 120 mm	
				10 x 10 x 80 mm	
				10 x 10 x 120 mm	
				12 x 12 x 80 mm	
				12 x 12 x 120 mm	
				16 x 16 x 120 mm	
			With off set	20 x 20 x 120 mm	
				25 x 25 x 150 mm	
		GTBH CW(Groove width) 1.45－3.0 mm	Without off set	.375" x.375" x4.724"	GTAT(inch holder only) GTBT GTCT
				.500" x.500"x4.724"	
				.625" x.625" x4.724"	
				10 x 10 x 80 mm	
				10 x 10 x 120 mm	
				12 x 12 x 120 mm	
				16 x 16 x 120 mm	
			With off set	20 x 20 x 120 mm	
				25 x 25 x 150 mm	
		GTCH CW(Groove width) 2.5－3.0 mm	Without off set	10 x 10 x 80 mm	GTCT
				10 x 10 x 120 mm	
	90°	GTAF CW(Groove width) 0.25-3.0 mm		10 x 10 x 100 mm	GTAT GTBT GTCT
				12 x 12 x 100 mm	
				16 x 16 x 120 mm	
				20 x 20 x 120 mm	
				25 x 25 x 120 mm	
Round Shank	90°	SH-GTAF CW(Groove width) 0.25-3.0 mm	For Back Tool Post	16 x 85 mm	GTAT GTBT GTCT
				19.05 x 115 mm	
				20 x 100 mm	
				22 x 120 mm	
				25 x 120 mm	
				25.4 x 115 mm	

= NEW

MS Series - PVD Coated Grades for High Precision and Small Parts Machining

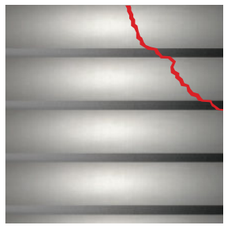
MS7025

Dramatically improved welding and wear resistance in low feed machining with a more precise nano-multilayer coating

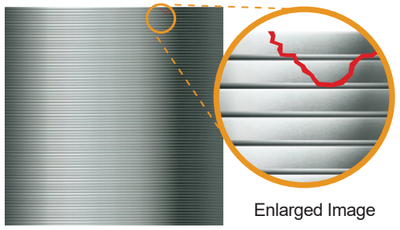
Features

Nano-Multilayer Coating

By combining the high lubrication layer with excellent welding resistance, and the high hardness layer with a greater wear resistance that suppresses the progress of wear at the nano-level, the film damage is significantly reduced and the welding and wear resistance are dramatically improved.



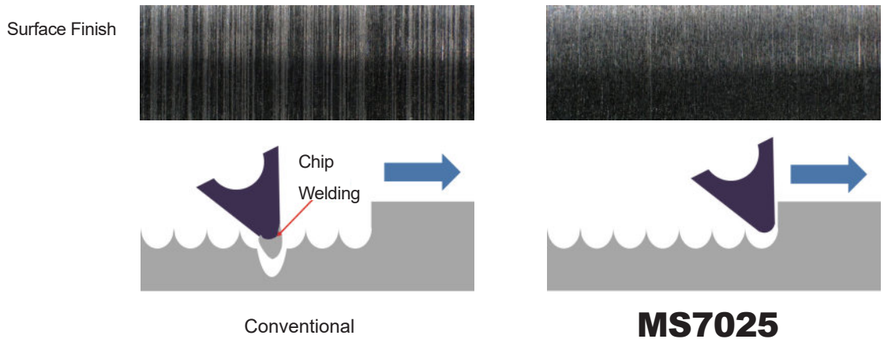
Conventional Multilayer Coating



Nano-Multilayer Coating

Effects of the High Lubrication Layer

The nano-level, high lubrication layer suppresses built-up edge caused by chip welding which tends to occur in low feed machining and in addition, reduces machining marks on the component surface.



Conventional

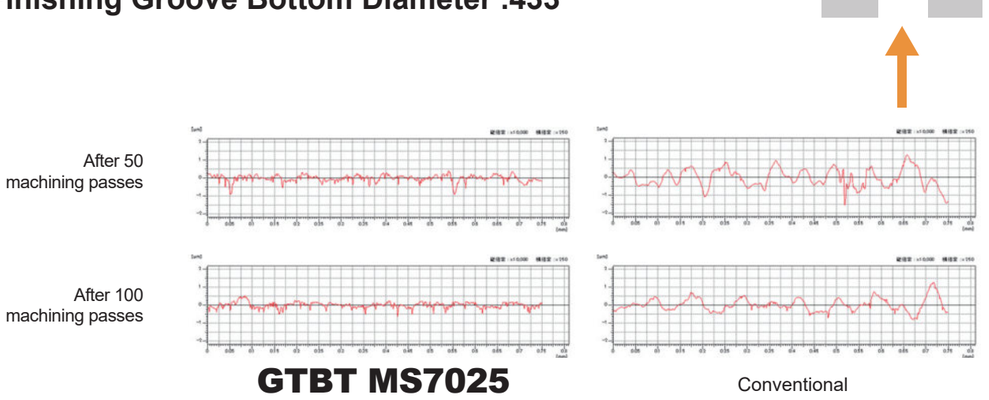
MS7025

Cutting Performance

Comparison of Surface Roughness and Cutting Edge Damage : Pure iron-based soft magnetic materials

The surface roughness is excellent because damage caused by welding is suppressed. It also has excellent wear resistance.

Surface Roughness with Finishing Groove Bottom Diameter .433"



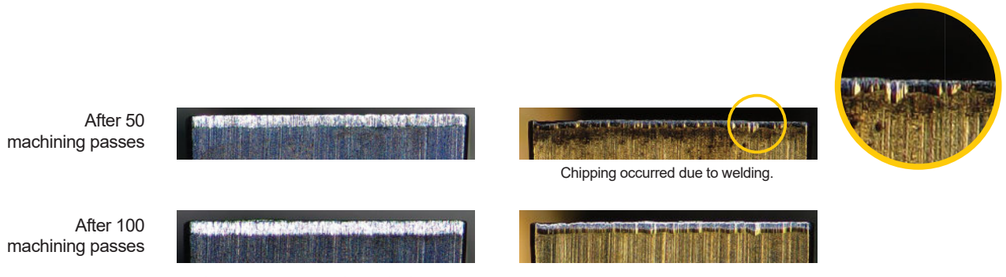
GTBT MS7025

Conventional

MS7025 achieves a good surface finish from the start of machining and maintains excellent consistency even after 100 passes.

Cutting Edge Damage

<Cutting Conditions>
Material : Pure iron-based soft magnetic material Diameter .630"
Cutting Speed : vc = 490 SFM
Feed per Rev. : f = .002 IPR
Radial Depth of Cut : .098"
Cutting Mode : Wet Cutting



Chipping occurred due to welding.

GTBT MS7025

Conventional

Carbide Grade (Non Coated)

MT2015

It has the usual wear resistance of carbide but is also tough and therefore resists sudden fractures. It can be expected to extend the life of non-ferrous metals such as aluminum alloys.

PVD Coated Grades

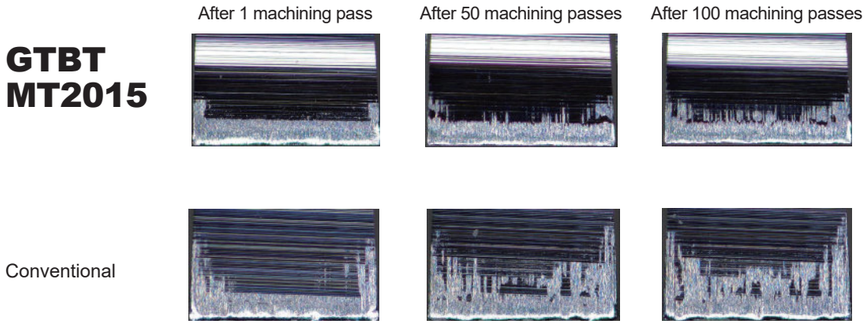
VP15TF/VP15KZ

(Al,Ti)N coated grade with excellent heat resistance and adhesion strength.
It is highly versatile and can be used in a variety of machining processes.

Cutting Performance

Comparison of Cutting Edge Damage : 6061

By suppressing damage to the cutting edge caused by welding, longer tool life can be expected.

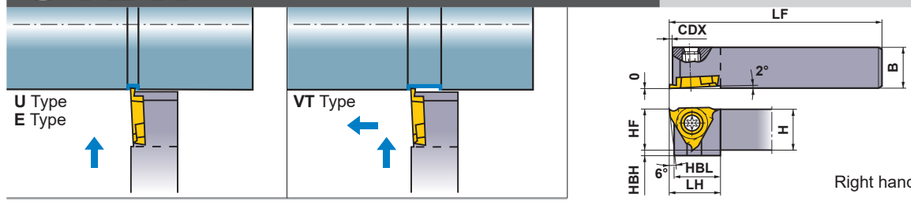


<Cutting Conditions>
Material :ASTM 6061
Diameter .709"
Cutting Speed : vc = 490 SFM
Feed per Rev. : f = .002 IPR
Radial Depth of Cut : .098"
Cutting Mode : Wet Cutting

EXTERNAL GROOVING

INCH STANDARD

GTBH



Right hand tool holder shown.

	Order Number	Stock R	Stock L	Insert Type	Dimensions (in) H	B	HF	LF	CDX *1	LH	HBH	HBL	Cutting Width (in)	*2 Clamp Screw	Wrench
Long Shank	**GTBHR/L-063**	●	●	GTAT GTBT GTCT	.375	.375	.375	4.724	.118	.591	.156	.528	.057–.118	NS404W	NKY158
Long Shank	**GTBHR/L-083**	●	●		.500	.500	.500	4.724	.118	.591	.020	.528	.057–.118	NS404W	NKY158
Long Shank	**GTBHR/L-103**	●	●		.625	.625	.625	4.724	.118	.591	—	.528	.057–.118	NS404W	NKY158

*1 It is not possible to machine depths over **CDX** dimensions(Max. Groove Depth).
For the actual maximum depth that can be machined, check the **CDX** of only the insert.
*2 Clamp Torque (lbf-in) : NS404W=6.2

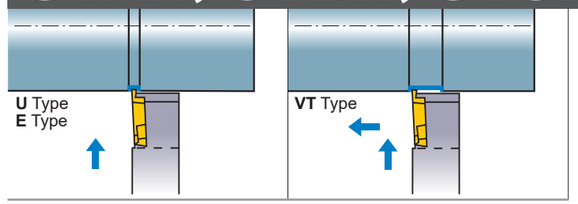
Note 1) Please use right hand insert for right hand holder and left hand insert for left hand holder.

● : USA Stock

EXTERNAL GROOVING

METRIC STANDARD

GTAH, GTBH, GTCH



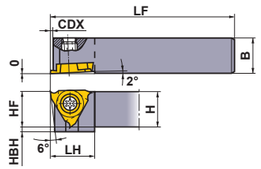


Fig.1

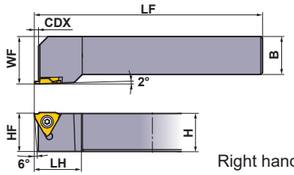


Fig.2

Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Type	Dimensions (mm) H	B	HF	LF	WF	CDX*	LH	HBH	Cutting Width (mm) Min.	Max.	fig.
GTAHR/L0808-20S	●	●		8	8	8	80	—	2	15	5	0.25	3.0	1
GTAHR/L0808-20	●	●		8	8	8	120	—	2	15	5	0.25	3.0	1
GTAHR/L1010-20S	●	●		10	10	10	80	—	2	15	3	0.25	3.0	1
GTAHR/L1010-20	●	●	GTAT	10	10	10	120	—	2	15	3	0.25	3.0	1
GTAHR/L1212-20S	●	●	GTBT*	12	12	12	80	—	2	15	1	0.25	3.0	1
GTAHR/L1212-20	●	●	GTCT*	12	12	12	120	—	2	15	1	0.25	3.0	1
GTAHR/L1616-20	●	●		16	16	16	120	—	2	15	—	0.25	3.0	1
GTAHR/L2020-20	●	●		20	20	20	120	25	2	25	—	0.25	3.0	2
GTAHR/L2525-20	●	●		25	25	25	150	32	2	25	—	0.25	3.0	2
GTBHR/L1010-30S	●	●		10	10	10	80	—	3	15	3	1.45	3.0	1
GTBHR/L1010-30	●	●		10	10	10	120	—	3	15	3	1.45	3.0	1
GTBHR/L1212-30	●	●	GTBT	12	12	12	120	—	3	15	1	1.45	3.0	1
GTBHR/L1616-30	●	●	GTCT	16	16	16	120	—	3	15	—	1.45	3.0	1
GTBHR/L2020-30	●	●		20	20	20	120	25	3	25	—	1.45	3.0	2
GTBHR/L2525-30	●	●		25	25	25	150	32	3	25	—	1.45	3.0	2
GTCHR/L1010-30S	●	●		10	10	10	80	—	3	15	3	2.5	3.0	1
GTCHR/L1010-30	●	●	GTCT	10	10	10	120	—	3	15	3	2.5	3.0	1

* It is not possible to machine depths over **CDX** dimensions(Max. Groove Depth). For the actual maximum depth that can be machined, check the **CDX** of only the insert.

● = NEW

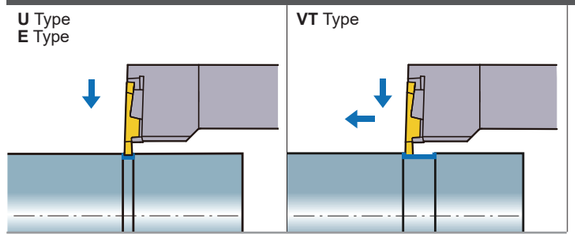
Note 1) Please use right hand insert for right hand holder and left hand insert for left hand holder.

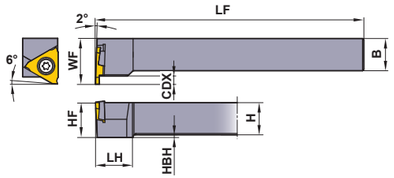
Spare Parts

Holder Type	Clamp Screw	Clamp Torque (lbf-in)	Wrench
GT○H-0808,1010,1212,1616	**NS404W**	6.2	**NKY15S**
GT○H-2020,2525	**FC400890T**	22.1	**TKY10F**

● : USA Stock

GTAF NEW





Right hand tool holder shown.

Order Number	Stock R	Stock L	Insert Type	Dimensions (mm) H	B	HF	LF	WF	CDX*	LH	HBH	Cutting Width (mm) Min.	Max.
GTAFR/L1010-30	●	●		10	10	10	100	15	3	14	3	0.25	3.0
GTAFR/L1212-30	●	●	GTAT	12	12	12	100	17	3	14	1	0.25	3.0
GTAFR/L1616-30	●	●	GTBT*	16	16	16	120	21	3	14	—	0.25	3.0
GTAFR/L2020-30	●	●	GTCT*	20	20	20	120	25	3	14	—	0.25	3.0
GTAFR/L2525-30	●	●		25	25	25	120	30	3	14	—	0.25	3.0

* It is not possible to machine depths over **CDX** dimensions(Max. Groove Depth). For the actual maximum depth that can be machined, check the **CDX** of only the insert.

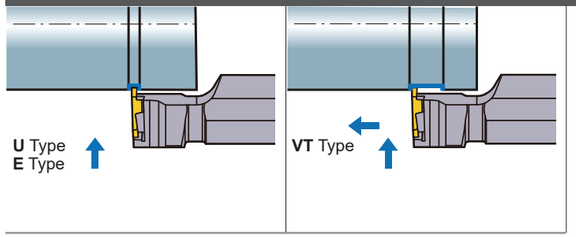
Note 1) Please use left hand insert for right hand holder and right hand insert for left hand holder.

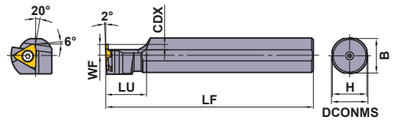
Spare Parts

Clamp Screw	Clamp Torque (lbf-in)	Wrench
FC400890T	22.1	**TKY10F**

EXTERNAL GROOVING

SH-GTAF NEW





Left hand tool holder shown.

Order Number	Stock R	Stock L	Insert Type	Dimensions (mm) H	B	DCONMS	LF	LU	WF	CDX*	Cutting Width (mm) Min.	Max.
SH160-GTAFL-30		●	GTAT GTBT* GTCT*	15	15	16	85	18	6	3	0.25	3.0
SH190-GTAFL-30		●		18	18	19.05	115	18	6	3	0.25	3.0
SH200-GTAFL-30		●		19	19	20	100	18	6	3	0.25	3.0
SH220-GTAFL-30		●		21	21	22	120	18	6	3	0.25	3.0
SH250-GTAFL-30		●		24	24	25	120	18	10	3	0.25	3.0
SH254-GTAFL-30		●		24	24	25.4	115	18	10	3	0.25	3.0

* It is not possible to machine depths over **CDX** dimensions(Max. Groove Depth). For the actual maximum depth that can be machined, check the **CDX** of only the insert.

Note 1) Please use right hand insert for left hand holder.

Spare Parts

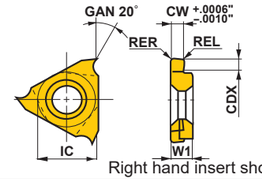
		
Clamp Screw	Clamp Torque (lbf-in)	Wrench
FC400890T	22.1	**TKY10F**

● : **USA Stock**

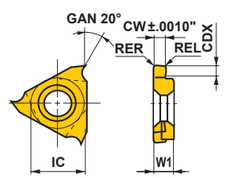
5 inserts in one case

INSERTS

Order Number	Hand	Coated MS7025	Coated VP15TF	Coated VP15KZ	Carbide MT2015		Dimensions (in) CW (in)	CW (mm)	CDX*	RER/L	IC	W1	Geometry
GTAT02506V3RP-E	R	●			●		.010	0.25	.011	.001	.375	.125	Precision Groove E Type (Ring Processing Grooving)
GTAT03006V3RP-E	R	●			●		.012	0.30	.011	.001	.375	.125	
GTAT03306V3RP-E	R	●			●		.013	0.33	.011	.001	.375	.125	
GTAT04312V3RP-E	R	●			●		.017	0.43	.035	.001	.375	.125	
GTAT05312V5RP-E	R	●			●		.021	0.53	.035	.002	.375	.125	
GTAT05312V5LP-E	L	●			●		.021	0.53	.035	.002	.375	.125	
GTAT03306V3R-E	R		●				.013	0.33	.011	.001	.375	.125	**E** Type (Ring Processing Grooving)
GTAT03306V3L-E	L		●				.013	0.33	.011	.001	.375	.125	
GTAT04312V3R-E	R		●				.017	0.43	.035	.001	.375	.125	
GTAT04312V3L-E	L		●				.017	0.43	.035	.001	.375	.125	
GTAT05312V5R-E	R		●				.021	0.53	.035	.002	.375	.125	
GTAT05312V5L-E	L		●				.021	0.53	.035	.002	.375	.125	
GTAT06512V5R-E	R	●			●		.026	0.65	.035	.002	.375	.125	
GTAT06512V5L-E	L	●			●		.026	0.65	.035	.002	.375	.125	
GTAT07520V5R-E	R	●	●		●		.030	0.75	.071	.002	.375	.125	
GTAT07520V5L-E	L	●	●		●		.030	0.75	.071	.002	.375	.125	
GTAT09520V5R-E	R	●	●		●		.037	0.95	.071	.002	.375	.125	
GTAT09520V5L-E	L	●	●		●		.037	0.95	.071	.002	.375	.125	
GTAT10020V5R-E	R	●	●		●		.039	1.00	.071	.002	.375	.125	
GTAT10020V5L-E	L	●	●		●		.039	1.00	.071	.002	.375	.125	
GTAT1002001R-E	R		●				.039	1.00	.071	.004	.375	.125	
GTAT1002001L-E	L		●				.039	1.00	.071	.004	.375	.125	
GTAT11020V5R-E	R	●			●		.043	1.10	.071	.002	.375	.125	
GTAT11020V5L-E	L	●			●		.043	1.10	.071	.002	.375	.125	
GTAT12020V5R-E	R	●	●		●		.047	1.20	.071	.002	.375	.125	
GTAT12020V5L-E	L	●	●		●		.047	1.20	.071	.002	.375	.125	
GTAT1202001R-E	R		●				.047	1.20	.071	.004	.375	.125	
GTAT1202001L-E	L		●				.047	1.20	.071	.004	.375	.125	
GTAT12520V5R-E	R	●			●		.049	1.25	.071	.002	.375	.125	
GTAT12520V5L-E	L	●			●		.049	1.25	.071	.002	.375	.125	
GTAT14020V5R-E	R	●	●		●		.055	1.40	.071	.002	.375	.125	
GTAT14020V5L-E	L	●	●		●		.055	1.40	.071	.002	.375	.125	
GTBT14530V5R-E	R	●			●		.057	1.45	.110	.002	.375	.125	
GTBT14530V5L-E	L	●			●		.057	1.45	.110	.002	.375	.125	
GTBT15030V5R-E	R	●	●		●		.059	1.50	.110	.002	.375	.125	
GTBT15030V5L-E	L	●	●		●		.059	1.50	.110	.002	.375	.125	
GTBT1503001R-E	R		●				.059	1.50	.110	.004	.375	.125	
GTBT1503001L-E	L		●				.059	1.50	.110	.004	.375	.125	
GTBT17030V5R-E	R	●			●		.067	1.70	.110	.002	.375	.125	
GTBT17030V5L-E	L	●			●		.067	1.70	.110	.002	.375	.125	
GTBT17530V5R-E	R	●			●		.069	1.75	.110	.002	.375	.125	
GTBT17530V5L-E	L	●			●		.069	1.75	.110	.002	.375	.125	
GTBT18030V5R-E	R	●	●		●		.071	1.80	.110	.002	.375	.125	
GTBT18030V5L-E	L	●	●		●		.071	1.80	.110	.002	.375	.125	
GTBT20030V5R-E	R	●	●		●		.079	2.00	.110	.002	.375	.125	
GTBT20030V5L-E	L	●	●		●		.079	2.00	.110	.002	.375	.125	
GTBT2003001R-E	R	●	●				.079	2.00	.110	.004	.375	.125	
GTBT2003001L-E	L	●	●				.079	2.00	.110	.004	.375	.125	
GTBT22530V5R-E	R	●	●		●		.089	2.25	.110	.002	.375	.125	
GTBT22530V5L-E	L	●	●		●		.089	2.25	.110	.002	.375	.125	
GTBT2253001R-E	R	●					.089	2.25	.110	.004	.375	.125	
GTBT2253001L-E	L	●					.089	2.25	.110	.004	.375	.125	



Right hand insert shown.

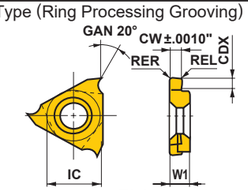


Right hand insert shown.

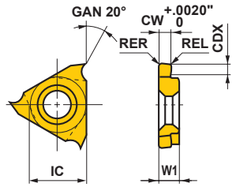
* **CDX** is a value that assumes the machining diameter of ϕ1.654 in or less.
Please note that the maximum machining depth is limited by the holder used.

INSERTS

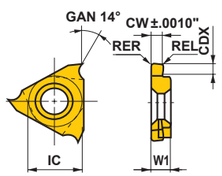
Order Number	Hand	Coated			Carbide		Dimensions (in)						Geometry
							CW		*				
		MS7025	VP15TF	VP15KZ	MT2015		(in)	(mm)	CDX	RER/L	IC	W1	
GTCT25030V5R-E	R	●	●		●		.098	2.50	.110	.002	.375	.125	**E** Type (Ring Processing Grooving)
GTCT25030V5L-E	L	●	●		●		.098	2.50	.110	.002	.375	.125	
GTCT2503001R-E	R	●			●		.098	2.50	.110	.004	.375	.125	
GTCT2503001L-E	L	●			●		.098	2.50	.110	.004	.375	.125	
GTCT27530V5R-E	R	●	●		●		.108	2.75	.110	.002	.375	.125	
GTCT27530V5L-E	L	●	●		●		.108	2.75	.110	.002	.375	.125	
GTCT30030V5R-E	R	●	●		●		.118	3.00	.110	.002	.375	.125	
GTCT30030V5L-E	L	●	●		●		.118	3.00	.110	.002	.375	.125	
GTCT3003001R-E	R	●					.118	3.00	.110	.004	.375	.125	
GTCT3003001L-E	L	●					.118	3.00	.110	.004	.375	.125	
GTAT03006V3R-U	R	●	●		●		.012	0.30	.011	.001	.375	.125	**U** Type (General Purpose Grooving)
GTAT03006V3L-U	L	●	●		●		.012	0.30	.011	.001	.375	.125	
GTAT05012V5R-U	R	●	●		●		.020	0.50	.035	.002	.375	.125	
GTAT05012V5L-U	L	●	●		●		.020	0.50	.035	.002	.375	.125	
GTAT07520V5R-U	R	●	●		●		.030	0.75	.071	.002	.375	.125	
GTAT07520V5L-U	L	●	●		●		.030	0.75	.071	.002	.375	.125	
GTAT09520V5R-U	R	●	●		●		.037	0.95	.071	.002	.375	.125	
GTAT09520V5L-U	L	●	●		●		.037	0.95	.071	.002	.375	.125	
GTAT10020V5R-U	R	●	●		●		.039	1.00	.071	.002	.375	.125	
GTAT10020V5L-U	L	●	●		●		.039	1.00	.071	.002	.375	.125	
GTAT10320V5R-U	R		●				.041	1.03	.071	.002	.375	.125	
GTAT12520V5R-U	R	●	●		●		.049	1.25	.071	.002	.375	.125	
GTAT12520V5L-U	L	●	●		●		.049	1.25	.071	.002	.375	.125	
GTBT14530V5R-U	R	●	●		●		.057	1.45	.110	.002	.375	.125	
GTBT14530V5L-U	L	●	●		●		.057	1.45	.110	.002	.375	.125	
GTBT15030V5R-U	R	●	●		●		.059	1.50	.110	.002	.375	.125	
GTBT15030V5L-U	L	●	●		●		.059	1.50	.110	.002	.375	.125	
GTBT17530V5R-U	R	●	●		●		.069	1.75	.110	.002	.375	.125	
GTBT17530V5L-U	L	●	●		●		.069	1.75	.110	.002	.375	.125	
GTBT20030V5R-U	R	●	●		●		.079	2.00	.110	.002	.375	.125	
GTBT20030V5L-U	L	●	●		●		.079	2.00	.110	.002	.375	.125	
GTCT25030V5R-U	R	●	●		●		.098	2.50	.110	.002	.375	.125	
GTCT25030V5L-U	L	●	●		●		.098	2.50	.110	.002	.375	.125	
GTAT0330600R-VT	R			●			.013	0.33	.010	.000	.375	.125	**VT** Type (Grooving, Side Turning)
GTAT0431200R-VT	R			●			.017	0.43	.035	.000	.375	.125	
GTAT0532000R-VT	R			●			.021	0.53	.063	.000	.375	.125	
GTAT0652000R-VT	R			●			.026	0.65	.063	.000	.375	.125	
GTAT0752000R-VT	R			●			.030	0.75	.063	.000	.375	.125	
GTAT0802000R-VT	R			●			.031	0.80	.063	.000	.375	.125	
GTAT0852000R-VT	R			●			.033	0.85	.063	.000	.375	.125	
GTAT0952000R-VT	R			●			.037	0.95	.063	.000	.375	.125	
GTAT1002000R-VT	R			●			.039	1.00	.063	.000	.375	.125	
GTAT1102000R-VT	R			●			.043	1.10	.063	.000	.375	.125	
GTAT1202000R-VT	R			●			.047	1.20	.063	.000	.375	.125	
GTAT1302000R-VT	R			●			.051	1.30	.063	.000	.375	.125	
GTAT1402000R-VT	R			●			.055	1.40	.063	.000	.375	.125	
GTBT1503000R-VT	R			●			.059	1.50	.106	.000	.375	.125	
GTBT2003000R-VT	R			●			.079	2.00	.106	.000	.375	.125	



Right hand insert shown.



Right hand insert shown.



∗ **CDX** is a value that assumes the machining diameter of ϕ1.654 in or less.
Please note that the maximum machining depth is limited by the holder used.

● : **USA Stock**
5 inserts in one case

RECOMMENDED CUTTING CONDITIONS

	Material	Properties	Grade	Cutting Speed vc (SFM)	Feed f (IPR)
P	Pure Iron, Free Cutting Steel	–	**MS7025, VP15TF**	360 (100—590)	.0020 (.0004—.0035)
	Carbon Steel, Alloy Steel	Hardness 180HB—280HB	**MS7025, VP15TF**	330 (165—490)	.0020 (.0008—.0035)
M	Stainless Steel	Hardness ≤200HB	**MS7025**	260 (165—395)	.0012 (.0008—.0020)
N	Non-Ferrous Metal	–	**MT2015**	490 (230—755)	.0028 (.0012—.0043)

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FOR YOUR SAFETY

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

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Tools specifications subject to change without notice.

B282A-US-2026.4