

Grooving System

GY Series

For small lathes.
Mono-block holder
now included

Grooving Revolution

Innovative clamping system
ensures reliable grooving.

Side A

FEATURES..... P1

GY
INSERTS P9EXTERNAL
GROOVING..... P13
TOOLSFACE
GROOVING..... P37
TOOLSINTERNAL
GROOVING..... P79
TOOLSCUTTING
CONDITIONS
INSTRUCTION ... P87
MANUALAPPLICATION... P105
EXAMPLES

Side B

QUICK
INDEX Q1

AHB

TOOLING & MACHINERY

COMPLETE METALWORKING SOLUTIONS

(800) 991-4225
ISO Certifiedwww.ahbinc.com
customerservice@ahbinc.com

Widened application area for the GY series!



Holder for small lathes

Insert width 1.5–3.24mm

10mm×10mm
12mm×12mm
16mm×16mm
20mm×12mm

> P13

R/L
32
ITEM



Mono-block type holder with zero offset between the holder and cutting edge

Insert width 2.0–6.35mm

20mm×20mm
25mm×25mm

> P15, P19, P21, P23, P25

R/L
40
ITEM



For recessing

Insert width 2.0–6.35mm

20mm×20mm
25mm×25mm

> P35

R/L
22
ITEM



For finishing, O-ring and Circlip groove

Ground insert for multi-functional machining
Insert width

2mm/2.24mm/2.39mm/
2.5mm/2.74mm/3mm/
3.18mm/3.24mm/4mm/
4.24mm/4.75mm/5mm/
5.24mm/6mm/6.31mm/
6.35mm

✕ 4 grades

> P10

112
ITEM

Inserts available for groove widths from 1.5mm up to 8mm.

1.5mm Inserts



3 grades 6 items

> P9

8mm Inserts



3 grades 17 items

> P9, P10, P11

GY SERIES

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

External • Face holders

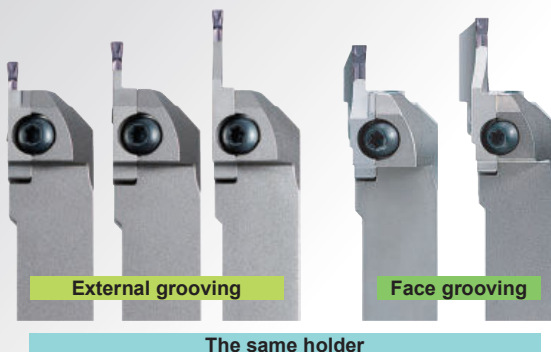
- Corresponding blades to a variety of modular holders with different shank sizes.



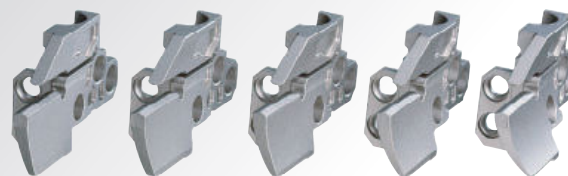
Mono block type

Modular type

- Modular type holders can be used over a wide range of applications by using different modular blades.



- 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 $\phi 25\text{mm}$.

Mono block type
Min. cutting diameter
 $\phi 25, \phi 32$

Modular type
Min. cutting diameter
 $\phi 40, \phi 50, \phi 60, \phi 70$



- Short shank types are standard stocked.

Mono block type

Modular type



Short

Standard

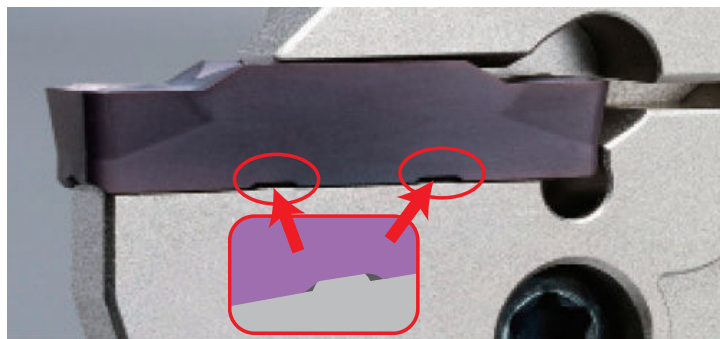
Short

Standard

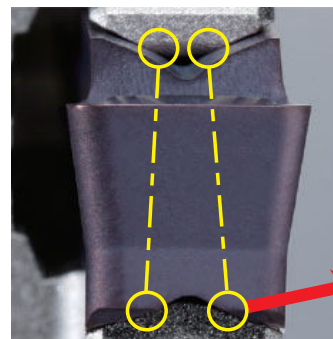
Original insert design leading the way to new grooving applications !

● Highly reliable insert clamping

Safety keys prevent insert movement.



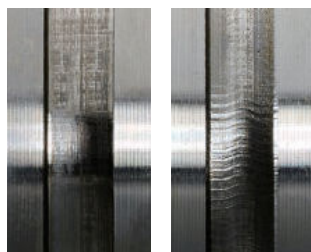
The convex geometry ensures high precision clamping.



FEATURES

Face grooving test results

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



GY

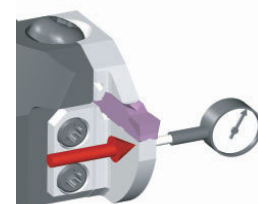
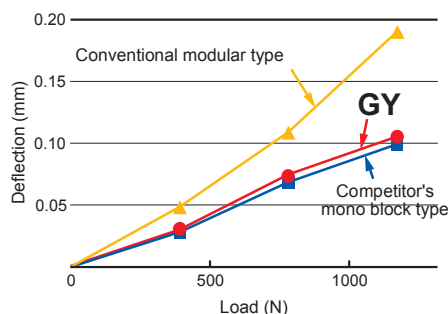
Conventional modular type

<Cutting Conditions>

Workpiece : SCM440
Insert width : 5mm
Cutting speed : 150m/min
Feed : 0.2mm/rev
Groove depth : 23mm

Rigidity comparison

The GY series provides rigidity comparable to a mono block type grooving tool.

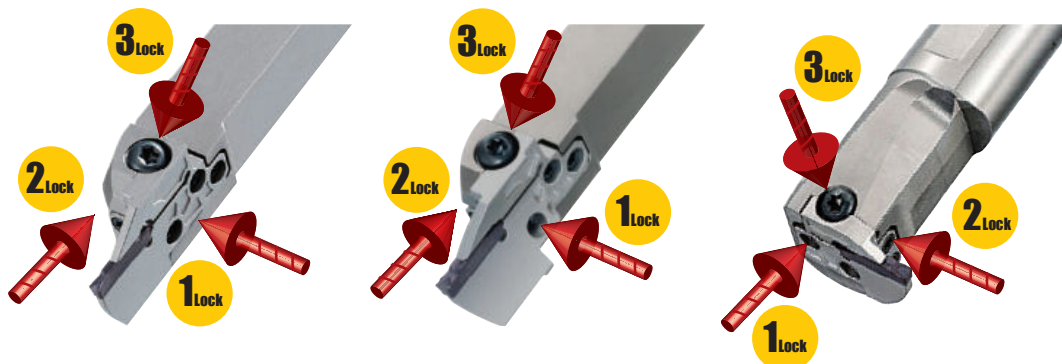


(Tool body for 5mm insert)

New TRI-LOCK System for increased stability and performance!

● TRI-LOCK System

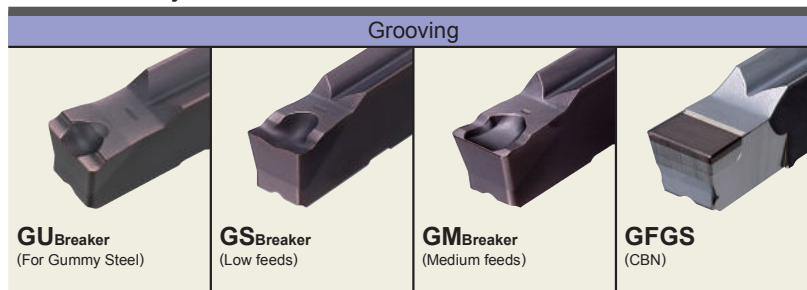
The TRI-LOCK system ensures the blade is securely fixed in 3 directions (side, front and top), giving high rigidity for stable grooving performance.



INSERT

● A WIDE SELECTION OF INSERTS

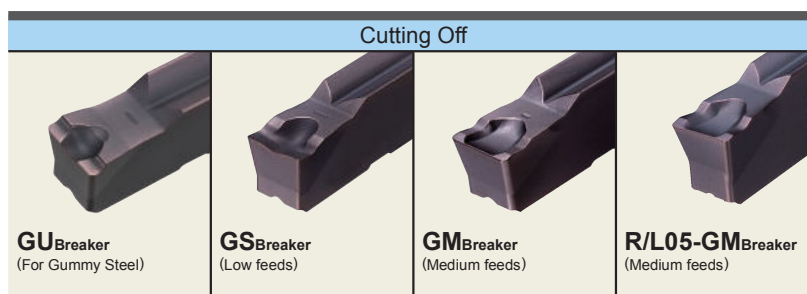
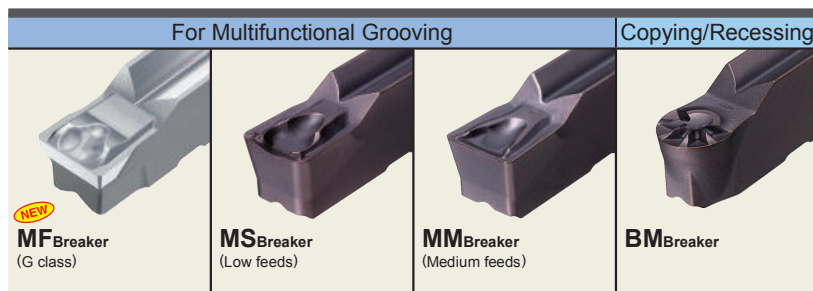
● Breaker system



● Selection of groove widths



● Different corner radii available

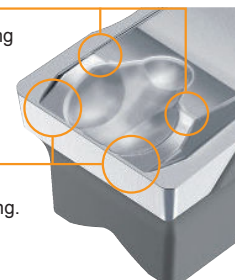


NEW

● MF Breaker

Efficient chip breaking when cross-feed machining.

Chips are controlled when finish machining.



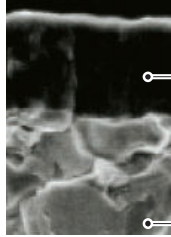
● INSERT GRADE

Work Material Machining Condition	P Steel	M Stainless Steel	K Cast Iron	S Heat resistant Alloy / Titanium Alloy	H Hardened steel
Stable ↑ Machining Condition ↓ Unstable	NX2525 MY5015 VP10RT VP20RT	 VP10RT VP20RT	 MY5015 VP10RT VP20RT	VP10RT RT9010 VP20RT	MB8025

Note1) VP20RT is the first recommended grade for materials other than hardened steel.

Note2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

VP20RT (1st Recommendation)

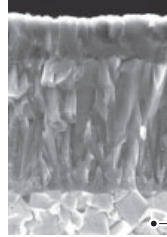


- PVD coated grade suitable for a wide range of applications. The combination of a special tough cemented carbide substrate with MIRACLE coating provides an excellent balance of wear and fracture resistance.

MIRACLE Coating

Carbide substrate (HRA90.5)

MY5015

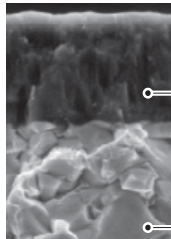


- MY5015 is a CVD coated grade with excellent wear resistance even at high temperatures. It provides longer tool life when machining cast and ductile cast irons. Also suitable for high speed continuous cutting of steels.

CVD Coated Carbide

Carbide substrate

VP10RT (2nd Recommendation)



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

MIRACLE Coating

Carbide substrate (HRA92.0)

RT9010

- First recommended grade for titanium alloys. It is not recommended for use on non-ferrous alloys.

NX2525

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

MB8025

- MB8025 is a sintered CBN grade for hardened steel.

● **BLANK INSERTS**

- Blank inserts for custom grinding



1 Edge Type



2 Edge Type

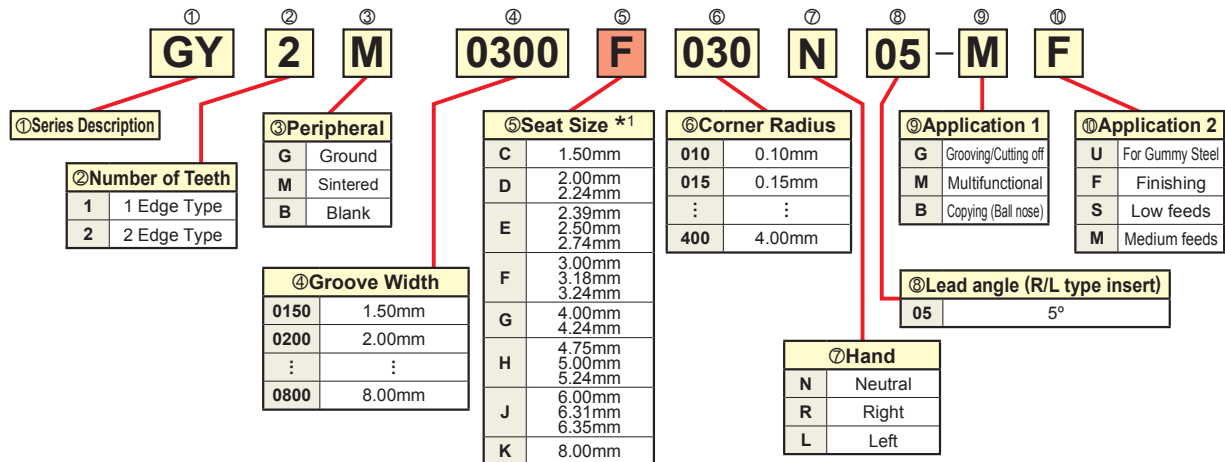
* Blank inserts to be ground by customers.

RT9010/RT9020 for blank insert

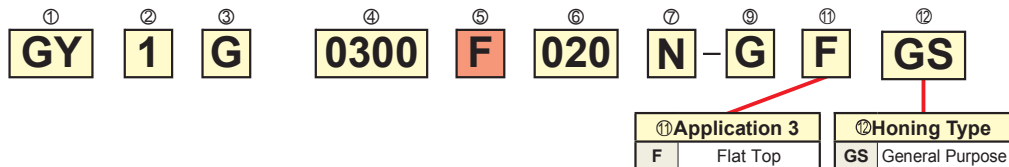
- First recommendation for blanks inserts is RT9020 due to the tougher carbide substrate that is suitable for a wider range of applications. RT9010 has a harder substrate than RT9020 and is ideal for longer tool life on stable cutting applications. Both grades are recommended to have a coating applied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

IDENTIFICATION OF GY SERIES

INSERT



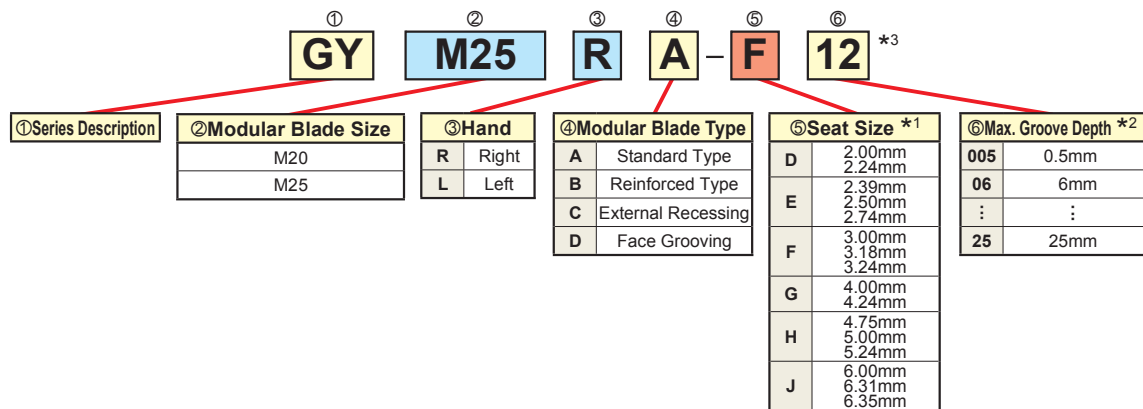
CBN INSERT



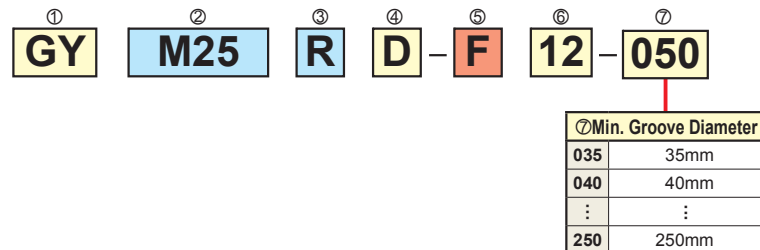
*1 Select a seat size with the same symbol as that of modular blade and mono block holder.

MODULAR BLADE

EXTERNAL/INTERNAL/RECESSING



FACE GROOVING



*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 79—85.

*3 GYM20R/LA-○10, GYM20R/LA-○12, GYM25R/LA-○12 and GYM25R/LA-○14 can be used for both external and internal grooving.

EXTERNAL/FACE GROOVING/RECESSING

● MONO BLOCK HOLDER

① Series Description	② Holder Type	③ Hand of Holder	④ Shank Diameter	⑤ Holder Length	⑥ Angle (degree)	⑦ Seat Size *1	⑧ Max. Groove Depth
GY	S	R	1010	J	00	C	06
P	P	L	1212	JX	50	D	08
R	Q		1616	K	90	E	:
2525	H		2012	M		F	25
			2020	P		G	
			2525			H	
			3225			J	
			3232			K	

● MODULAR TYPE HOLDER

① Series Description	② Holder Type	③ Hand of Holder	④ Shank Diameter	⑤ Holder Length	⑥ Angle (degree)	⑦ Seat Size *1	⑧ Max. Groove Depth
GY	S	R	1010	J	00	C	06
H	P	L	1212	JX	50	D	08
R	Q		1616	K	90	E	:
2525	H		2012	M		F	25
			2020	P		G	
			2525			H	
			3225			J	
			3232			K	

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

INTERNAL

● MONO BLOCK HOLDER

① Series Description	② Holder Type	③ Hand of Holder	④ Shank Diameter	⑤ Holder Length	⑥ Angle (degree)	⑦ Neck Length	⑧ Max. Groove Depth
GY	A	R	20	K	90	A	06
A	P	L	25	L		B	07
R	Q		32	M		C	
20	H		40	P		D	
			50	Q		E	
				R		F	
				S		G	
				T		H	

● MODULAR TYPE HOLDER

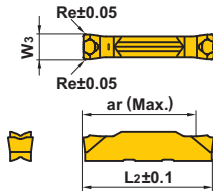
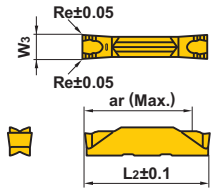
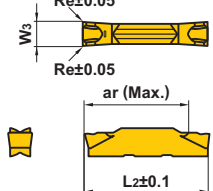
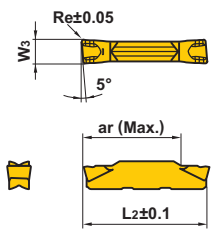
① Series Description	② Holder Type	③ Hand of Holder	④ Shank Diameter	⑤ Holder Length	⑥ Angle (degree)	⑦ Neck Length	⑧ Max. Groove Depth
GY	A	R	20	K	90	A	06
D	P	L	25	L		B	07
R	Q		32	M		C	
40	H		40	P		D	
			50	Q		E	
				R		F	
				S		G	
				T		H	

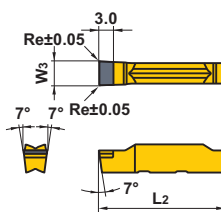
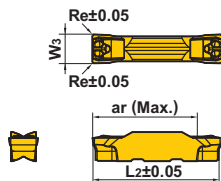
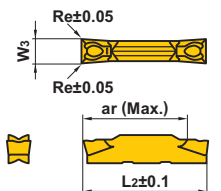
*1 Select a seat size with the same symbol as that of the insert.

ORDER
NUMBER

GY INSERTS

INSERTS

Applications	Geometry	Order Number	Stock							Seat Size	Dimensions (mm)							
			Coated		Cermet	Carbide	CBN	W3			Re	ar (Max.)	L2					
			VP10RT	VP20RT				MY5015	NX2525					RT9010	RT9020	MB8025	Grooving Width	Tolerance
For Grooving / Cutting off	GU Breaker (For gummy steel) 	GY2M0200D020N-GU	●	●	●					D	2.00	±0.03	0.2	19.7	20.70			
		GY2M0239E020N-GU	●	●	●					E	2.39	±0.03	0.2	19.8	20.70			
		GY2M0250E020N-GU	●	●	●					E	2.50	±0.03	0.2	19.5	20.70			
		GY2M0300F030N-GU	●	●	●					F	3.00	±0.03	0.3	19.3	20.70			
		GY2M0318F030N-GU	●	●	●					F	3.18	±0.03	0.3	19.3	20.70			
		GY2M0400G030N-GU	●	●	●					G	4.00	±0.04	0.3	24.2	25.65			
		GY2M0475H040N-GU	●	●	●					H	4.75	±0.04	0.4	24.2	25.65			
		GY2M0500H040N-GU	●	●	●					H	5.00	±0.04	0.4	24.2	25.65			
		GY2M0600J040N-GU	●	●	●					J	6.00	±0.04	0.4	24.2	25.65			
		GY2M0635J040N-GU	●	●	●					J	6.35	±0.04	0.4	24.2	25.65			
	GS Breaker (Low feeds) 	NEW GY2M0150C010N-GS	●	●	●					C	1.50	±0.03	0.1	13.4	14.70			
		GY2M0200D020N-GS	●	●	●					D	2.00	±0.03	0.2	18.7	20.70			
		GY2M0239E020N-GS	●	●	●					E	2.39	±0.03	0.2	18.5	20.70			
		GY2M0250E020N-GS	●	●	●					E	2.50	±0.03	0.2	18.5	20.70			
		GY2M0300F020N-GS	●	●	●					F	3.00	±0.03	0.2	18.5	20.70			
		GY2M0318F020N-GS	●	●	●					F	3.18	±0.03	0.2	18.5	20.70			
		GY2M0400G020N-GS	●	●	●					G	4.00	±0.04	0.2	23.9	25.65			
		GY2M0475H030N-GS	●	●	●					H	4.75	±0.04	0.3	23.9	25.65			
		GY2M0500H030N-GS	●	●	●					H	5.00	±0.04	0.3	24.0	25.65			
		GY2M0600J030N-GS	●	●	●					J	6.00	±0.04	0.3	24.1	25.65			
		GY2M0635J030N-GS	●	●	●					J	6.35	±0.04	0.3	24.1	25.65			
	NEW GY2M0800K030N-GS	●	●	●					K	8.00	±0.04	0.3	29.1	30.50				
	GM Breaker (Medium feeds) 	NEW GY2M0150C020N-GM	●	●	●					C	1.50	±0.03	0.2	13.9	14.70			
		GY2M0200D020N-GM	●	●	●	●				D	2.00	±0.03	0.2	19.4	20.70			
		GY2M0239E020N-GM	●	●	●	●				E	2.39	±0.03	0.2	19.4	20.70			
		GY2M0250E020N-GM	●	●	●	●				E	2.50	±0.03	0.2	19.4	20.70			
		GY2M0300F030N-GM	●	●	●	●				F	3.00	±0.03	0.3	19.4	20.70			
		GY2M0318F030N-GM	●	●	●	●				F	3.18	±0.03	0.3	19.4	20.70			
		GY2M0400G030N-GM	●	●	●	●				G	4.00	±0.04	0.3	24.4	25.65			
		GY2M0475H040N-GM	●	●	●	●				H	4.75	±0.04	0.4	24.3	25.65			
		GY2M0500H040N-GM	●	●	●	●				H	5.00	±0.04	0.4	24.3	25.65			
		GY2M0600J040N-GM	●	●	●	●				J	6.00	±0.04	0.4	24.3	25.65			
		GY2M0635J040N-GM	●	●	●	●				J	6.35	±0.04	0.4	24.3	25.65			
	NEW GY2M0800K050N-GM	●	●	●					K	8.00	±0.04	0.5	29.3	30.50				
R/L05-GM Breaker  Right hand insert shown.	GY2M0200D020R05-GM	●	●						D	2.00	±0.03	0.2	19.5	20.80				
	GY2M0200D020L05-GM	●	●						D	2.00	±0.03	0.2	19.5	20.80				
	GY2M0250E020R05-GM	●	●						E	2.50	±0.03	0.2	19.5	20.825				
	GY2M0250E020L05-GM	●	●						E	2.50	±0.03	0.2	19.5	20.825				
	GY2M0300F030R05-GM	●	●						F	3.00	±0.03	0.3	19.5	20.85				
	GY2M0300F030L05-GM	●	●						F	3.00	±0.03	0.3	19.5	20.85				
	GY2M0400G030R05-GM	●	●						G	4.00	±0.04	0.3	24.5	25.85				
	GY2M0400G030L05-GM	●	●						G	4.00	±0.04	0.3	24.5	25.85				
	GY2M0500H040R05-GM	●	●						H	5.00	±0.04	0.4	24.5	25.95				
	GY2M0500H040L05-GM	●	●						H	5.00	±0.04	0.4	24.5	25.95				

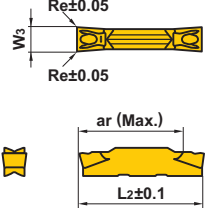
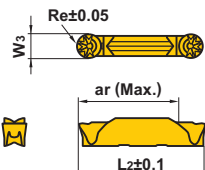
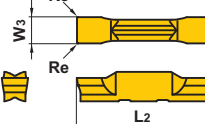
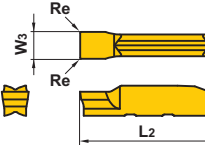
Applications	Geometry	Order Number	Stock							Seat Size	Dimensions (mm)						
			Coated		Cermet	Carbide		CBN	W3		Re	ar (Max.)	L2				
			VP10RT	VP20RT		MY5015	NX2525		RT9010					RT9020	MB8025	Grooving Width	Tolerance
For Grooving	Flat Top (For Hardened material) 	GY1G0200D020N-GFGS							●	D	2.00	±0.03	0.2	—	20.40		
		GY1G0239E020N-GFGS							●	E	2.39	±0.03	0.2	—	20.40		
		GY1G0250E020N-GFGS							●	E	2.50	±0.03	0.2	—	20.40		
		GY1G0300F020N-GFGS							●	F	3.00	±0.03	0.2	—	20.40		
		GY1G0318F020N-GFGS							●	F	3.18	±0.03	0.2	—	20.40		
		GY1G0400G020N-GFGS							●	G	4.00	±0.03	0.2	—	25.30		
		GY1G0475H020N-GFGS							●	H	4.75	±0.03	0.2	—	25.30		
		GY1G0500H020N-GFGS							●	H	5.00	±0.03	0.2	—	25.30		
For Multifunctional Grooving	MF Breaker (Finishing)  	GY2G0200D020N-MF	●	●	●	●				D	2.00	±0.02	0.2	19.5	21.05		
		*1GY2G0224D015N-MF	●	●	●	●				D	2.24	±0.02	0.15	19.8	21.05		
		GY2G0239E020N-MF	●	●	●	●				E	2.39	±0.02	0.2	19.2	21.05		
		GY2G0250E020N-MF	●	●	●	●				E	2.50	±0.02	0.2	19.4	21.05		
		*1GY2G0274E020N-MF	●	●	●	●				E	2.74	±0.02	0.2	19.7	21.05		
		GY2G0300F020N-MF	●	●	●	●				F	3.00	±0.02	0.2	19.5	21.05		
		GY2G0300F040N-MF	●	●	●	●				F	3.00	±0.02	0.4	19.3	21.05		
		GY2G0318F020N-MF	●	●	●	●				F	3.18	±0.02	0.2	19.5	21.05		
		GY2G0318F040N-MF	●	●	●	●				F	3.18	±0.02	0.4	19.3	21.05		
		*1GY2G0324F020N-MF	●	●	●	●				F	3.24	±0.02	0.2	19.5	21.05		
		GY2G0400G020N-MF	●	●	●	●				G	4.00	±0.02	0.2	24.9	25.95		
		GY2G0400G040N-MF	●	●	●	●				G	4.00	±0.02	0.4	24.7	25.95		
		GY2G0400G080N-MF	●	●	●	●				G	4.00	±0.02	0.8	24.3	25.95		
		*1GY2G0424G020N-MF	●	●	●	●				G	4.24	±0.02	0.2	24.9	25.95		
		GY2G0475H020N-MF	●	●	●	●				H	4.75	±0.02	0.2	24.4	25.95		
		GY2G0475H040N-MF	●	●	●	●				H	4.75	±0.02	0.4	24.2	25.95		
		GY2G0475H080N-MF	●	●	●	●				H	4.75	±0.02	0.8	23.8	25.95		
		GY2G0500H020N-MF	●	●	●	●				H	5.00	±0.02	0.2	24.4	25.95		
		GY2G0500H040N-MF	●	●	●	●				H	5.00	±0.02	0.4	24.2	25.95		
		GY2G0500H080N-MF	●	●	●	●				H	5.00	±0.02	0.8	23.8	25.95		
		*1GY2G0524H020N-MF	●	●	●	●				H	5.24	±0.02	0.2	24.4	25.95		
		GY2G0600J020N-MF	●	●	●	●				J	6.00	±0.02	0.2	24.4	25.95		
		GY2G0600J040N-MF	●	●	●	●				J	6.00	±0.02	0.4	24.2	25.95		
		GY2G0600J080N-MF	●	●	●	●				J	6.00	±0.02	0.8	23.8	25.95		
		*1GY2G0631J020N-MF	●	●	●	●				J	6.31	±0.02	0.2	24.4	25.95		
		GY2G0635J020N-MF	●	●	●	●				J	6.35	±0.02	0.2	24.4	25.95		
		GY2G0635J040N-MF	●	●	●	●				J	6.35	±0.02	0.4	24.2	25.95		
		GY2G0635J080N-MF	●	●	●	●				J	6.35	±0.02	0.8	23.8	25.95		
	MS Breaker (Low feeds) 	GY2M0200D020N-MS	●	●	●	●				D	2.00	±0.03	0.2	19.1	20.70		
		GY2M0250E020N-MS	●	●	●	●				E	2.50	±0.03	0.2	19.1	20.70		
GY2M0300F020N-MS		●	●	●	●				F	3.00	±0.03	0.2	19.2	20.70			
GY2M0300F040N-MS		●	●	●	●				F	3.00	±0.03	0.4	18.9	20.70			
GY2M0400G020N-MS		●	●	●	●				G	4.00	±0.04	0.2	24.2	25.65			
GY2M0400G040N-MS		●	●	●	●				G	4.00	±0.04	0.4	23.9	25.65			
GY2M0500H040N-MS		●	●	●	●				H	5.00	±0.04	0.4	23.9	25.65			
GY2M0500H080N-MS		●	●	●	●				H	5.00	±0.04	0.8	23.5	25.65			
GY2M0600J040N-MS		●	●	●	●				J	6.00	±0.04	0.4	23.9	25.65			
GY2M0600J080N-MS		●	●	●	●				J	6.00	±0.04	0.8	23.5	25.65			
NEW GY2M0800K080N-MS		●	●	●					K	8.00	±0.04	0.8	28.5	30.50			

*1 Groove width corresponding to the circlip.

GY
INSERTS

GY INSERTS

INSERTS

Applications	Geometry	Order Number	Stock							Seat Size	Dimensions (mm)						
			Coated				Cermet	Carbide	CBN		W3		Re	ar (Max.)	L2		
			VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020	MB8025		Grooving Width	Tolerance					
For Multifunctional Grooving	MM Breaker (Medium feeds) 	GY2M0200D020N-MM	●	●	●	●					D	2.00	±0.03	0.2	19.1	20.70	
		GY2M0250E020N-MM	●	●	●	●					E	2.50	±0.03	0.2	19.1	20.70	
		GY2M0300F020N-MM	●	●	●	●					F	3.00	±0.03	0.2	19.1	20.70	
		GY2M0300F040N-MM	●	●	●	●					F	3.00	±0.03	0.4	18.9	20.70	
		GY2M0300F080N-MM	●	●	●	●					F	3.00	±0.03	0.8	18.5	20.70	
		GY2M0400G020N-MM	●	●	●	●					G	4.00	±0.04	0.2	24.1	25.65	
		GY2M0400G040N-MM	●	●	●	●					G	4.00	±0.04	0.4	23.9	25.65	
		GY2M0400G080N-MM	●	●	●	●					G	4.00	±0.04	0.8	23.5	25.65	
		GY2M0500H040N-MM	●	●	●	●					H	5.00	±0.04	0.4	23.9	25.65	
		GY2M0500H080N-MM	●	●	●	●					H	5.00	±0.04	0.8	23.5	25.65	
		GY2M0600J040N-MM	●	●	●	●					J	6.00	±0.04	0.4	23.9	25.65	
		GY2M0600J080N-MM	●	●	●	●					J	6.00	±0.04	0.8	23.5	25.65	
		GY2M0800K080N-MM	●	●	●						K	8.00	±0.04	0.8	28.5	30.50	
		NEW GY2M0800K120N-MM	●	●	●						K	8.00	±0.04	1.2	28.1	30.50	
For Copying / Recessing	BM Breaker 	GY2M0200D100N-BM	●	●	●	●					D	2.00	±0.03	1.00	19.5	20.90	
		GY2M0250E125N-BM	●	●	●	●					E	2.50	±0.03	1.25	19.3	20.90	
		GY2M0300F150N-BM	●	●	●	●					F	3.00	±0.03	1.50	19.0	20.90	
		GY2M0318F159N-BM	●	●	●	●					F	3.18	±0.03	1.59	18.9	20.90	
		GY2M0400G200N-BM	●	●	●	●					G	4.00	±0.04	2.00	23.4	25.80	
		GY2M0475H238N-BM	●	●	●	●					H	4.75	±0.04	2.38	22.9	25.80	
		GY2M0500H250N-BM	●	●	●	●					H	5.00	±0.04	2.50	22.8	25.80	
		GY2M0600J300N-BM	●	●	●	●					J	6.00	±0.04	3.00	22.5	25.90	
		GY2M0635J318N-BM	●	●	●	●					J	6.35	±0.04	3.18	22.3	25.90	
		NEW GY2M0800K400N-BM	●	●	●						K	8.00	±0.04	4.00	26.5	30.80	
		★ 2	2 Edge Type 	GY2B0220D020N				●	●	●		D	2.20	±0.10	0.2	—	21.05
				GY2B0270E020N				●	●	●		E	2.70	±0.10	0.2	—	21.05
GY2B0340F020N						●	●	●		F	3.40	±0.10	0.2	—	21.05		
GY2B0420G020N						●	●	●		G	4.20	±0.10	0.2	—	26.00		
GY2B0520H020N						●	●	●		H	5.20	±0.10	0.2	—	26.00		
GY2B0655J020N						●	●	●		J	6.55	±0.10	0.2	—	26.00		
1 Edge Type 	GY1B0220D020N					●	●	●		D	2.20	±0.10	0.2	—	21.07		
	GY1B0270E020N					●	●	●		E	2.70	±0.10	0.2	—	21.10		
	GY1B0340F020N					●	●	●		F	3.40	±0.10	0.2	—	21.00		
	GY1B0420G020N					●	●	●		G	4.20	±0.10	0.2	—	25.86		
Blank		GY1B0520H020N				●	●	●		H	5.20	±0.10	0.2	—	25.90		
		GY1B0655J020N				●	●	●		J	6.55	±0.10	0.2	—	25.90		

*2 Blank inserts to be ground by customers.

CIRCLIP STANDARDS

Category	Application		Name of Standard	Width (Tolerance)										
				For Shaft					For Hole					
C type circlip 	For Shaft	For Hole	ANSI B27.7/27.8 (US) BS 3673 (UK) DIN 471/472 (De) NF E 22 163 (Fr) UNI 7435/7438 (It) JIS B 2804 (JP)	0.5	+0.14 0	0.305	+0.051 0	1.15	+0.14 0	9	+0.14 0	0.457	+0.051 0	
				0.7		0.457	0	1.35		1.1		0.737	0	
				0.8		0.737	+0.076 0	1.75		1.3		0.991	+0.076 0	
				0.9		0.991		0		1.95		1.6	1.168	0
				1.1		1.168	+0.102 0	2.2		1.85		1.422	+0.102 0	
				1.3		1.422		0		2.7		2.15	1.727	0
				1.6		1.727	0	3.2		2.65		2.184	0	
				1.85		2.184	+0.127 0	4.2		3.15		2.616	+0.127 0	
				2.15		2.616		0		4.15		3.048	0	
C type retaining ring 	For Shaft	For Hole		3.15	+0.18 0	3.531	+0.152 0		+0.18 0	6.2	+0.22 0			
				4.15			0							
				5.15			0							
				6.2			0							
E type circlip 	For Shaft			N1*** American	0.32	+0.05 0	0.305	+0.051 0	0.3	+0.05 0				
					0.5	0	0.457	0	0.4	0				
					0.7	+0.10 0	0.584	0	0.5	0				
					1.0	0	0.737	+0.076 0	0.7	+0.10 0				
			1.2		+0.14 0	0.991	0	0.9	0					
			1.4		0	1.168	0	1.15	0					
						1.422	+0.102 0	1.75	+0.14 0					
						1.727	0	2.2	0					

O-RING STANDARDS

Category	Name of Standard	Width (Tolerance)					
		General		For oil pressure		For air pressure	
Static Use	DIN 3770/3771 (De)	2.54	+0.13 0	1.9	+0.1 0	2.3	+0.2 0
		3.18		2.3	0	3.1	
		4.32		2.9	+0.15 0	3.7	
		6.1		3.6	+0.2 0	6.4	
Dynamic Use	JIS B 2401 (JP) ISO 3601	3.2	+0.14 0	4.5	0	9.0	+0.25 0
		2.5		5.5	+0.3 0	2.4	
		3.2		7.0	0	3.6	
		4.7		8.6	+0.4 0	4.8	
	SMS 1586/1588 (Se) BS 1806/4518 (UK)	7.5	+0.25 0	10.7	+0.5 0	7.1	+0.25 0
		11.1				9.5	
	SAE AS-568 (US)	2.39				2.3	
		3.58				3.1	
		4.78	+0.25 0			2.2	+0.25 0
		7.14				3.4	
		9.58				4.6	
						6.9	

 G-class insert with MF breaker is available for single-step machining.

 Conventional GY series insert is available for single-step machining.

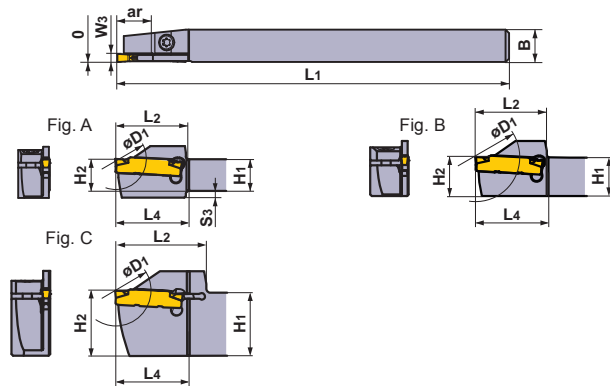
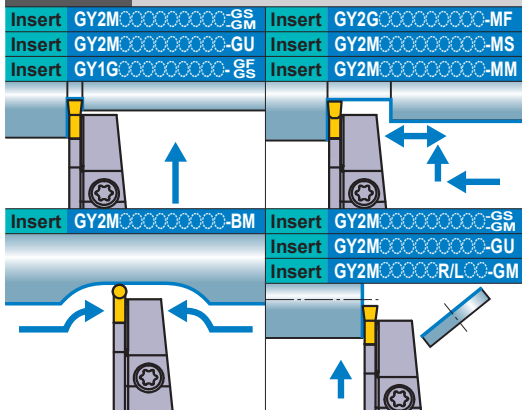
 Machined in multiple steps or by cross feed machining.

GY SERIES (EXTERNAL GROOVING for Swiss style lathes)

1

00° type holder

NEW



Right hand tool holder shown.

Seat Size	W3 (mm)	ar (mm) *4	D1 (mm)	Type	Hand (R/L)	Order Number		Fig.
						Holder	Stock	
C	1.50	11	22	Mono Block	R	GYSR1010JX00-C11	●	A
					L	GYSL1010JX00-C11	●	A
		13	26	Mono Block	R	GYSR1212JX00-C13	●	B
					L	GYSL1212JX00-C13	●	B
		17 *1	34 *2	Mono Block	R	GYSR1616JX00-C17	●	B
					L	GYSL1616JX00-C17	●	B
		18 *1	36 *2	Mono Block	R	GYSR2012JX00-C18	●	C
					L	GYSL2012JX00-C18	●	C
D	2.00 2.24	11	22	Mono Block	R	GYSR1010JX00-D11	●	A
					L	GYSL1010JX00-D11	●	A
		13	26	Mono Block	R	GYSR1212JX00-D13	●	B
					L	GYSL1212JX00-D13	●	B
		17	34	Mono Block	R	GYSR1616JX00-D17	●	B
					L	GYSL1616JX00-D17	●	B
		18	36	Mono Block	R	GYSR2012JX00-D18	●	C
					L	GYSL2012JX00-D18	●	C
E	2.39 2.50 2.74	11	22	Mono Block	R	GYSR1010JX00-E11	●	A
					L	GYSL1010JX00-E11	●	A
		13	26	Mono Block	R	GYSR1212JX00-E13	●	B
					L	GYSL1212JX00-E13	●	B
		17	34	Mono Block	R	GYSR1616JX00-E17	●	B
					L	GYSL1616JX00-E17	●	B
		18	36	Mono Block	R	GYSR2012JX00-E18	●	C
					L	GYSL2012JX00-E18	●	C
F	3.00 3.18 3.24	11	22	Mono Block	R	GYSR1010JX00-F11	●	A
					L	GYSL1010JX00-F11	●	A
		13	26	Mono Block	R	GYSR1212JX00-F13	●	B
					L	GYSL1212JX00-F13	●	B
		17	34	Mono Block	R	GYSR1616JX00-F17	●	B
					L	GYSL1616JX00-F17	●	B
		18	36	Mono Block	R	GYSR2012JX00-F18	●	C
					L	GYSL2012JX00-F18	●	C

W3 = Insert Width ar = Max. Groove Depth D1 = Max. Cut Off Diameter

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

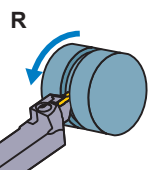
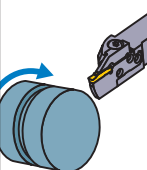
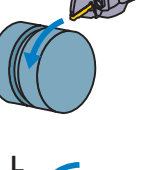
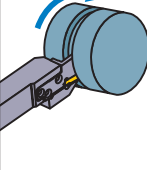
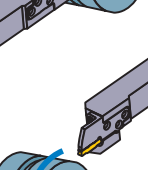
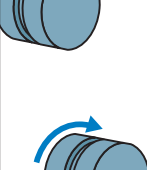
*2 The maximum cut off diameter D1 varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2 and L4 values may vary.

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

SPARE PARTS

Holder Number		
	Clamp Screw	Wrench
GYSR/L1010JX00-11	CS350990T (Clamp Torque : 2.5N·m)	TKY10R
GYSR/L1212JX00-13		
GYSR/L2012JX00-18		
GYSR/L1616JX00-17	TS4SBL (Clamp Torque : 3.5N·m)	TKY15R

	Dimensions (mm) *3							Cutting Mode	
	H1	B	L1	L2	L4	H2	S3	Clockwise	Anticlockwise
	10	10	120	22	16	10	2		
	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	—		
	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	—		

Select an Insert

Seat Size	Insert Number
C	GY000150C0000-Breaker
D	GY000200/0224D0000-Breaker
E	GY000239/0250/0274E0000-Breaker
F	GY000300/0318/0324F0000-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker W3	GU	GS	GM	05-GM
		Neutral	Neutral	Neutral	Hand
C	1.50mm		●	●	
D	2.00mm	●	●	●	●
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●
F	3.00mm	●	●	●	●
	3.18mm	●	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker W3	MF	MS	MM
				Ball nose
D	2.00mm	●	●	●
	2.24mm	●		
E	2.39mm	●		
	2.50mm	●	●	●
	2.74mm	●		
F	3.00mm			●
	Re 0.2	●	●	●
	Re 0.4	●	●	●
	Re 0.8			●
	3.18mm			●
	Re 0.2	●		
	Re 0.4	●		
	3.24mm	●		

● : Gauge insert shown dimensions

EXTERNAL
GROOVING

IDENTIFICATION > P7, P8

CUTTING CONDITIONS > P87

INSTRUCTION MANUAL > P89

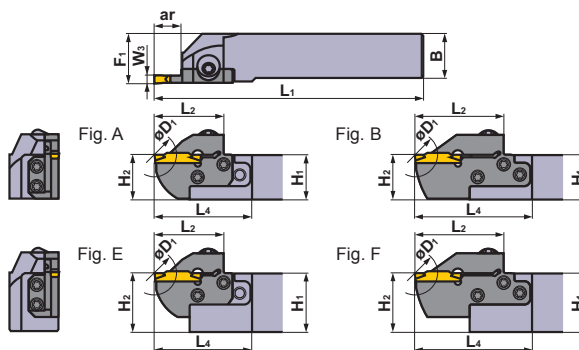
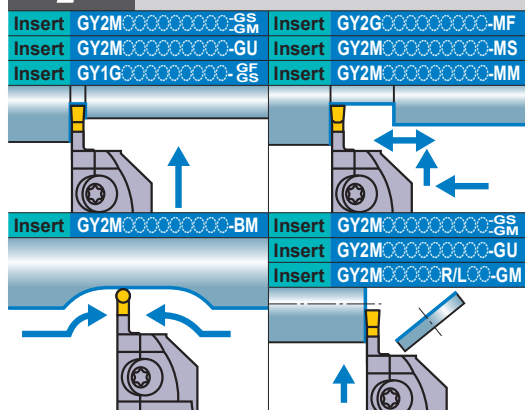
GY SERIES (EXTERNAL GROOVING)

1

00° type holder

(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	W3 (mm)	ar (mm)	D1 (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder		Stock	Modular Blade		
D	2.00 2.24	6	12	Modular	R	GYHR1616J00-M20R	●	GYM20RA-D06	●	C	
					L	GYHL1616J00-M20L	●	GYM20LA-D06	●	C	
				Mono Block	R	GYQR2020K00-D06	●	—	—	G	
					L	GYQL2020K00-D06	●	—	—	G	
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-D06	●	A	
					L	GYHL2020K00-M20L	●	GYM20LA-D06	●	A	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-D06	●	C	
					L	GYHL2020K00-M25L	●	GYM25LA-D06	●	C	
			Mono Block	R	GYQR2525M00-D06	●	—	—	G		
				L	GYQL2525M00-D06	●	—	—	G		
			Modular	R	GYHR2525M00-M25R	●	GYM25RA-D06	●	A		
				L	GYHL2525M00-M25L	●	GYM25LA-D06	●	A		
			Modular	R	GYHR3225P00-M25R	●	GYM25RA-D06	●	E		
				L	GYHL3225P00-M25L	●	GYM25LA-D06	●	E		
			Modular	R	GYHR3232P00-M25R	●	GYM25RA-D06	●	E		
				L	GYHL3232P00-M25L	●	GYM25LA-D06	●	E		
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-D10	●	C	
					L	GYHL1616J00-M20L	●	GYM20LA-D10	●	C	
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-D10	●	A	
					L	GYHL2020K00-M20L	●	GYM20LA-D10	●	A	
			24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-D12	●	C	
					L	GYHL2020K00-M25L	●	GYM25LA-D12	●	C	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-D12	●	A	
					L	GYHL2525M00-M25L	●	GYM25LA-D12	●	A	
		Modular	R	GYHR3225P00-M25R	●	GYM25RA-D12	●	E			
			L	GYHL3225P00-M25L	●	GYM25LA-D12	●	E			
		Modular	R	GYHR3232P00-M25R	●	GYM25RA-D12	●	E			
			L	GYHL3232P00-M25L	●	GYM25LA-D12	●	E			
		18 *4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-D18	●	D	
					L	GYHL1616J00-M20L	●	GYM20LB-D18	●	D	
				Mono Block	R	GYQR2020K00-D18	●	—	—	G	
					L	GYQL2020K00-D18	●	—	—	G	
				Modular	R	GYHR2020K00-M20R	●	GYM20RB-D18	●	B	
					L	GYHL2020K00-M20L	●	GYM20LB-D18	●	B	
		20 *1	40 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RA-D20	●	D	
					L	GYHL2020K00-M25L	●	GYM25LA-D20	●	D	
Mono Block	R			GYQR2525M00-D20	●	—	—	G			
	L			GYQL2525M00-D20	●	—	—	G			
Modular	R			GYHR2525M00-M25R	●	GYM25RA-D20	●	B			
	L			GYHL2525M00-M25L	●	GYM25LA-D20	●	B			
Modular	R			GYHR3225P00-M25R	●	GYM25RA-D20	●	F			
	L			GYHL3225P00-M25L	●	GYM25LA-D20	●	F			
Modular	R	GYHR3232P00-M25R	●	GYM25RA-D20	●	F					
	L	GYHL3232P00-M25L	●	GYM25LA-D20	●	F					

W3 = Insert Width **ar** = Max. Groove Depth **D1** = Max. Cut Off Diameter

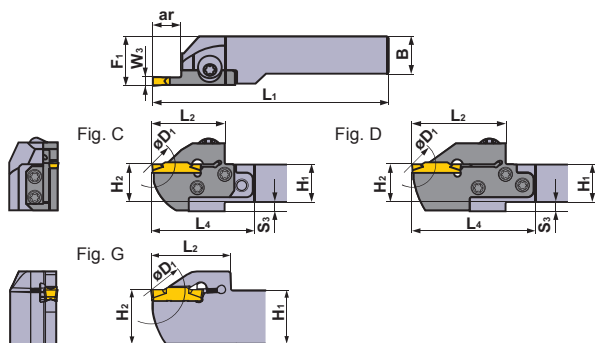
*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

*2 The maximum cut off diameter **D₁** varies according to the insert used. The cut off diameter is double the maximum groove depth (**ar**) of inserts on pages 9 to 11.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2, L4 and F1 values may vary.

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

● : Inventory maintained in Japan.



Right hand tool holder shown.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		5 pcs.	R D
	Clamp Screw	Blade Screw	Wrench ★
GYQR/L○○○○○○○○○○○○○○○○○○○○	HSC05030 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L○○○○○○○○○○-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY15D
GYHR/L○○○○○○○○○○-M25R/L		TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D

Dimensions (mm) ★3								Cutting Mode	
H1	B	L1	L2	L4	H2	F1	S3	Clockwise	Anticlockwise
16	16	104	28	44	16	20	4		
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	20.1	—		
20	20	125	39	—	20	20.1	—		
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	25.1	—		
25	25	150	41	—	25	25.1	—		
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	GY○○0200/0224D○○○○-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	05-GM
		Neutral	Neutral	Neutral	Hand
W3		●	●	●	●
D	2.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
				Ball nose
W3		●	●	●
D	2.00mm	●	●	●
	2.24mm	●	●	●

● : Gauge insert shown dimensions

EXTERNAL GROOVING

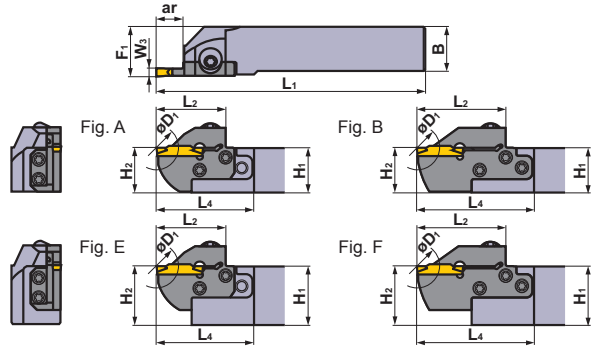
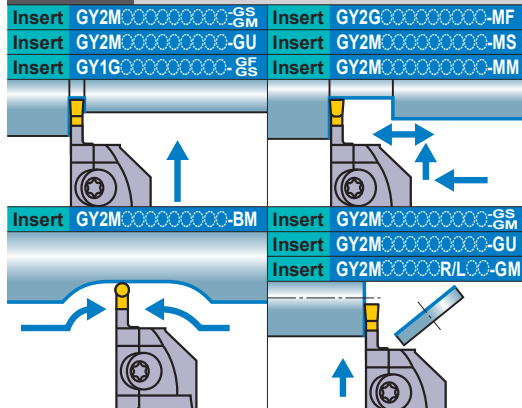
GY SERIES (EXTERNAL GROOVING)

1

00° type holder

(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	W3 (mm)	ar (mm)	D1 (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	●	C
				Modular	L	GYHL1616J00-M20L	●	GYM20LA-E06	●	C
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-E06	●	A
				Modular	L	GYHL2020K00-M20L	●	GYM20LA-E06	●	A
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-E06	●	C
				Modular	L	GYHL2020K00-M25L	●	GYM25LA-E06	●	C
		10	20	Modular	R	GYHR2525M00-M25R	●	GYM25RA-E06	●	A
				Modular	L	GYHL2525M00-M25L	●	GYM25LA-E06	●	A
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-E06	●	E
				Modular	L	GYHL3225P00-M25L	●	GYM25LA-E06	●	E
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-E06	●	E
				Modular	L	GYHL3232P00-M25L	●	GYM25LA-E06	●	E
		12	24	Modular	R	GYHR1616J00-M20R	●	GYM20RA-E10	●	C
				Modular	L	GYHL1616J00-M20L	●	GYM20LA-E10	●	C
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-E10	●	A
				Modular	L	GYHL2020K00-M20L	●	GYM20LA-E10	●	A
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-E12	●	C
				Modular	L	GYHL2020K00-M25L	●	GYM25LA-E12	●	C
		18 *4	36	Modular	R	GYHR2525M00-M25R	●	GYM25RA-E12	●	A
				Modular	L	GYHL2525M00-M25L	●	GYM25LA-E12	●	A
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-E12	●	E
				Modular	L	GYHL3225P00-M25L	●	GYM25LA-E12	●	E
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-E12	●	E
				Modular	L	GYHL3232P00-M25L	●	GYM25LA-E12	●	E
		20 *1	40 *2	Modular	R	GYHR1616J00-M20R	●	GYM20RB-E18	●	D
				Modular	L	GYHL1616J00-M20L	●	GYM20LB-E18	●	D
				Modular	R	GYHR2020K00-M20R	●	GYM20RB-E18	●	B
				Modular	L	GYHL2020K00-M20L	●	GYM20LB-E18	●	B
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-E20	●	D
				Modular	L	GYHL2020K00-M25L	●	GYM25LA-E20	●	D
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-E20	●	B
				Modular	L	GYHL2525M00-M25L	●	GYM25LA-E20	●	B
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-E20	●	F
				Modular	L	GYHL3225P00-M25L	●	GYM25LA-E20	●	F
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-E20	●	F
				Modular	L	GYHL3232P00-M25L	●	GYM25LA-E20	●	F

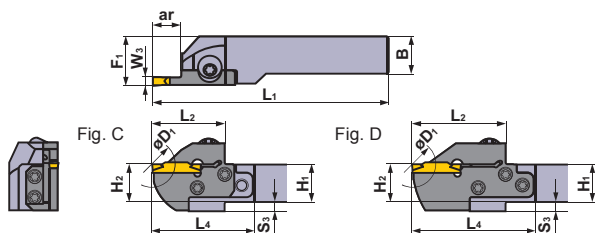
W3 = Insert Width ar = Max. Groove Depth D1 = Max. Cut Off Diameter

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

*2 The maximum cut off diameter D1 varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2, L4 and F1 values may vary.

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

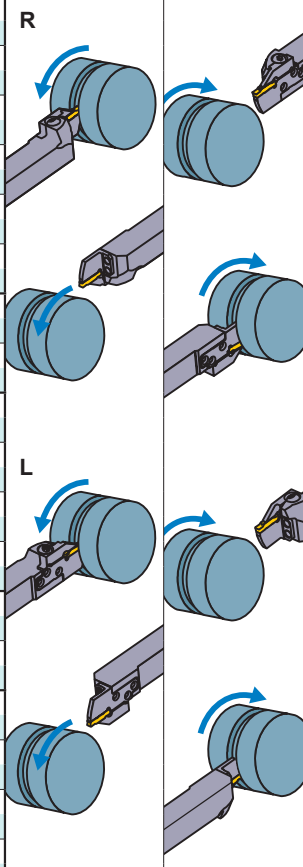


★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYQR/L○○○○○○○○○○○○○○○○○○○○	HSC05030 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L○○○○○○○○○○○○○○○○○○○○-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY15D
GYHR/L○○○○○○○○○○○○○○○○○○○○-M25R/L		TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D

Right hand tool holder shown.

	Dimensions (mm) ★3								Cutting Mode	
	H1	B	L1	L2	L4	H2	F1	S3	Clockwise	Anticlockwise
	16	16	104	28	44	16	20	4		
	16	16	104	28	44	16	20	4		
	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	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	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	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
E	GY○○0239/0250/0274E○○○○-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	05-GM
	W3	Neutral	Neutral	Neutral	Hand
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
	W3			BM
E	2.39mm	●		
	2.50mm	●	●	●
	2.74mm	●		

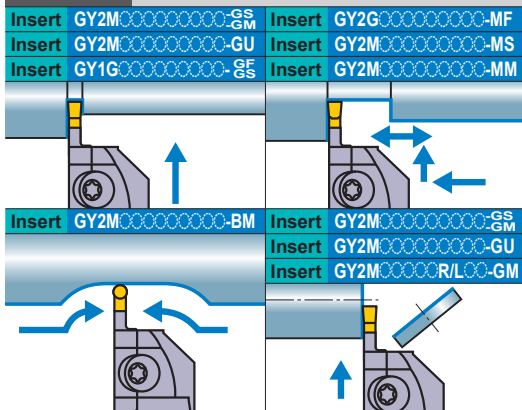
● : Gauge insert shown dimensions

EXTERNAL GROOVING

GY SERIES (EXTERNAL GROOVING)

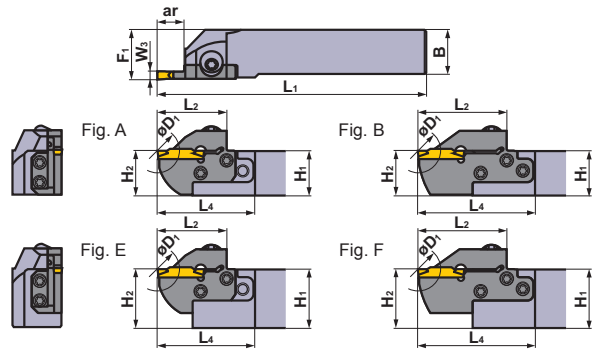
1

00° type holder



(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	W3 (mm)	ar (mm)	D1 (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	●	C
				Modular	L	GYHL1616J00-M20L	●	GYM20LA-F06	●	C
				Mono Block	R	GYQR2020K00-F06	●	—	—	G
					L	GYQL2020K00-F06	●	—	—	G
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-F06	●	A
				Modular	L	GYHL2020K00-M20L	●	GYM20LA-F06	●	A
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-F06	●	C
				Modular	L	GYHL2020K00-M25L	●	GYM25LA-F06	●	C
				Mono Block	R	GYQR2525M00-F06	●	—	—	G
					L	GYQL2525M00-F06	●	—	—	G
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-F06	●	A
				Modular	L	GYHL2525M00-M25L	●	GYM25LA-F06	●	A
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-F06	●	E
				Modular	L	GYHL3225P00-M25L	●	GYM25LA-F06	●	E
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-F06	●	E
				Modular	L	GYHL3232P00-M25L	●	GYM25LA-F06	●	E
		10	20	Modular	R	GYHR1616J00-M20R	●	GYM20RA-F10	●	C
				Modular	L	GYHL1616J00-M20L	●	GYM20LA-F10	●	C
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-F10	●	A
				Modular	L	GYHL2020K00-M20L	●	GYM20LA-F10	●	A
		12	24	Modular	R	GYHR2020K00-M25R	●	GYM25RA-F12	●	C
				Modular	L	GYHL2020K00-M25L	●	GYM25LA-F12	●	C
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-F12	●	A
				Modular	L	GYHL2525M00-M25L	●	GYM25LA-F12	●	A
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-F12	●	E
				Modular	L	GYHL3225P00-M25L	●	GYM25LA-F12	●	E
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-F12	●	E
				Modular	L	GYHL3232P00-M25L	●	GYM25LA-F12	●	E
		18 *4	36	Modular	R	GYHR1616J00-M20R	●	GYM20RB-F18	●	D
				Modular	L	GYHL1616J00-M20L	●	GYM20LB-F18	●	D
				Mono Block	R	GYQR2020K00-F18	●	—	—	G
					L	GYQL2020K00-F18	●	—	—	G
				Modular	R	GYHR2020K00-M20R	●	GYM20RB-F18	●	B
				Modular	L	GYHL2020K00-M20L	●	GYM20LB-F18	●	B
		20 *1	40 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RA-F20	●	D
				Modular	L	GYHL2020K00-M25L	●	GYM25LA-F20	●	D
				Mono Block	R	GYQR2525M00-F20	●	—	—	G
					L	GYQL2525M00-F20	●	—	—	G
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-F20	●	B
				Modular	L	GYHL2525M00-M25L	●	GYM25LA-F20	●	B
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-F20	●	F
				Modular	L	GYHL3225P00-M25L	●	GYM25LA-F20	●	F
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-F20	●	F
				Modular	L	GYHL3232P00-M25L	●	GYM25LA-F20	●	F

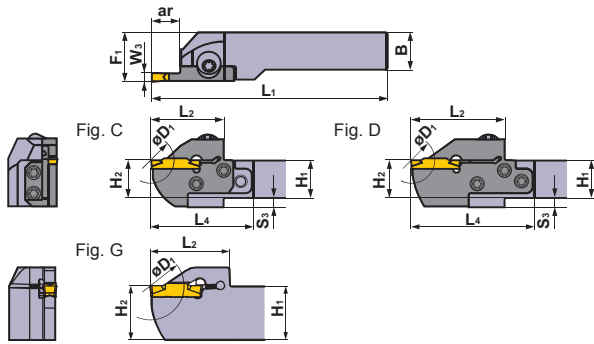
W3 = Insert Width ar = Max. Groove Depth D1 = Max. Cut Off Diameter

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

*2 The maximum cut off diameter D1 varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2, L4 and F1 values may vary.

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.



Right hand tool holder shown.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		5 pcs.	R D
	Clamp Screw	Blade Screw	Wrench ★
GYQR/L○○○○○○○○○○○○○○○○○○○○	HSC05030 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L○○○○○○○○○○-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY15D
GYHR/L○○○○○○○○○○-M25R/L		TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D

Dimensions (mm) ★3									Cutting Mode	
H1	B	L1	L2	L4	H2	F1	S3		Clockwise	Anticlockwise
16	16	104	28	44	16	20	4		R	
16	16	104	28	44	16	20	4			
20	20	125	36	—	20	20.3	—			
20	20	125	36	—	20	20.3	—			
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	25.3	—			
25	25	150	36	—	25	25.3	—			
25	25	142	31	49	25	28	—		L	
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		R	
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	—		L	
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	—		R	
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○○0239/0250/0274E○○○○-Breaker

For Grooving/Cutting off > P9, P10						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
	W3	Neutral	Neutral	Neutral	Hand	Neutral
F	3.00mm	●	●	●	●	●
	3.18mm	●	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
	W3				Ball nose
F	3.00mm	●	●	●	●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8			●	
	3.18mm				●
	Re 0.2	●			
	Re 0.4	●			
	3.24mm	●			

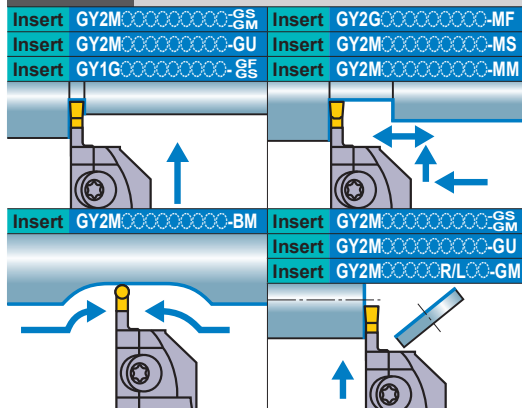
● : Gauge insert shown dimensions

EXTERNAL GROOVING

GY SERIES (EXTERNAL GROOVING)

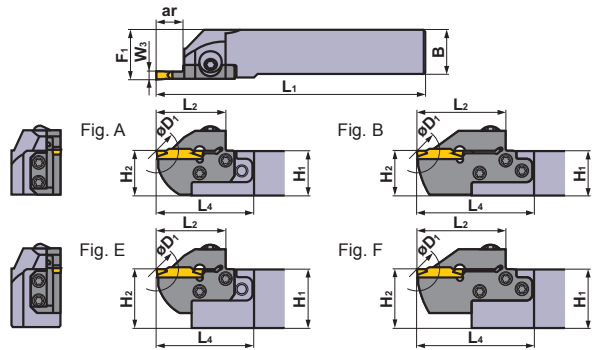
1

00° type holder



(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	W3 (mm)	ar (mm)	D1 (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	8	16	NEW Mono Block	R	GYQR2020K00-G08	●	—	—	G
					L	GYQL2020K00-G08	●	—	—	G
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-G08	●	C
					L	GYHL2020K00-M25L	●	GYM25LA-G08	●	C
				NEW Mono Block	R	GYQR2525M00-G08	●	—	—	G
					L	GYQL2525M00-G08	●	—	—	G
			24	Modular	R	GYHR2525M00-M25R	●	GYM25RA-G08	●	A
					L	GYHL2525M00-M25L	●	GYM25LA-G08	●	A
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-G08	●	E
					L	GYHL3225P00-M25L	●	GYM25LA-G08	●	E
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-G08	●	E
					L	GYHL3232P00-M25L	●	GYM25LA-G08	●	E
		12	24	Modular	R	GYHR1616J00-M20R	●	GYM20RA-G12	●	C
					L	GYHL1616J00-M20L	●	GYM20LA-G12	●	C
			28	Modular	R	GYHR2020K00-M20R	●	GYM20RA-G12	●	A
					L	GYHL2020K00-M20L	●	GYM20LA-G12	●	A
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-G14	●	C
					L	GYHL2020K00-M25L	●	GYM25LA-G14	●	C
		14	28	Modular	R	GYHR2525M00-M25R	●	GYM25RA-G14	●	A
					L	GYHL2525M00-M25L	●	GYM25LA-G14	●	A
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-G14	●	E
					L	GYHL3225P00-M25L	●	GYM25LA-G14	●	E
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-G14	●	E
					L	GYHL3232P00-M25L	●	GYM25LA-G14	●	E
		25 *1	50 *2	NEW Mono Block	R	GYQR2020K00-G25	●	—	—	H
					L	GYQL2020K00-G25	●	—	—	H
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-G25	●	D
					L	GYHL2020K00-M25L	●	GYM25LA-G25	●	D
				NEW Mono Block	R	GYQR2525M00-G25	●	—	—	G
					L	GYQL2525M00-G25	●	—	—	G
		25 *1	50 *2	Modular	R	GYHR2525M00-M25R	●	GYM25RA-G25	●	B
					L	GYHL2525M00-M25L	●	GYM25LA-G25	●	B
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-G25	●	F
					L	GYHL3225P00-M25L	●	GYM25LA-G25	●	F
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-G25	●	F
					L	GYHL3232P00-M25L	●	GYM25LA-G25	●	F

W3 = Insert Width ar = Max. Groove Depth D1 = Max. Cut Off Diameter

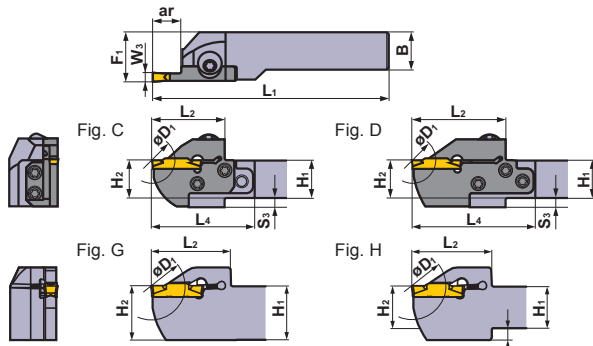
*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

*2 The maximum cut off diameter D1 varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2, L4 and F1 values may vary.



★ Wrench : R : Clamp Screw, D : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number		5 pcs.	R D
	Clamp Screw	Blade Screw	Wrench ★
GYQR/L	HSC05030 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY15D
GYHR/L		TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D

Dimensions (mm) ★3									Cutting Mode	
H1	B	L1	L2	L4	H2	F1	S3		Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—			
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	GY000239/0250/0274E0000-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	05-GM
	W3	Neutral	Neutral	Neutral	Hand
G	4.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
	W3			Ball nose
G	4.00mm	●	●	●
	Re 0.2	●	●	●
	Re 0.4	●	●	●
	Re 0.8	●	●	●
	4.24mm	●		

● : Gauge insert shown dimensions

EXTERNAL GROOVING

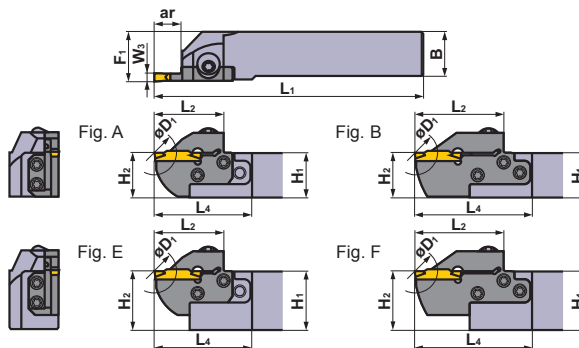
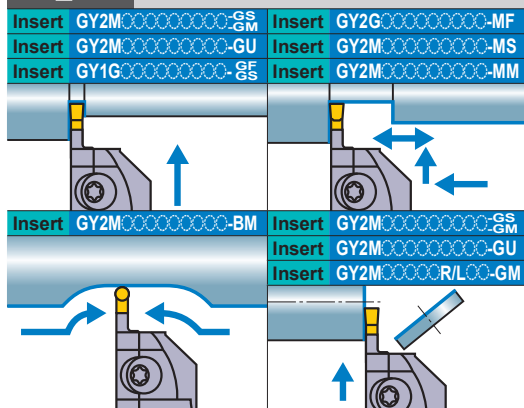
GY SERIES (EXTERNAL GROOVING)

1

00° type holder

(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	W3 (mm)	ar (mm)	D1 (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder		Stock	Modular Blade		
H	4.75 5.00 5.24	8	16	NEW Mono Block	R	GYQR2020K00-H08	●	—	—	G	
					L	GYQL2020K00-H08	●	—	—	G	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-H08	●	C	
					L	GYHL2020K00-M25L	●	GYM25LA-H08	●	C	
				NEW Mono Block	R	GYQR2525M00-H08	●	—	—	G	
					L	GYQL2525M00-H08	●	—	—	G	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-H08	●	A	
					L	GYHL2525M00-M25L	●	GYM25LA-H08	●	A	
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-H08	●	E	
					L	GYHL3225P00-M25L	●	GYM25LA-H08	●	E	
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-H08	●	E	
					L	GYHL3232P00-M25L	●	GYM25LA-H08	●	E	
		12	24	Modular	R	GYHR1616J00-M20R	●	GYM20RA-H12	●	C	
					L	GYHL1616J00-M20L	●	GYM20LA-H12	●	C	
				Modular	R	GYHR2020K00-M20R	●	GYM20RA-H12	●	A	
					L	GYHL2020K00-M20L	●	GYM20LA-H12	●	A	
		14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-H14	●	C	
					L	GYHL2020K00-M25L	●	GYM25LA-H14	●	C	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-H14	●	A	
					L	GYHL2525M00-M25L	●	GYM25LA-H14	●	A	
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-H14	●	E	
					L	GYHL3225P00-M25L	●	GYM25LA-H14	●	E	
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-H14	●	E	
					L	GYHL3232P00-M25L	●	GYM25LA-H14	●	E	
25 *1	50 *2	NEW Mono Block	R	GYQR2020K00-H25	●	—	—	H			
			L	GYQL2020K00-H25	●	—	—	H			
		Modular	R	GYHR2020K00-M25R	●	GYM25RA-H25	●	D			
			L	GYHL2020K00-M25L	●	GYM25LA-H25	●	D			
		NEW Mono Block	R	GYQR2525M00-H25	●	—	—	G			
			L	GYQL2525M00-H25	●	—	—	G			
		Modular	R	GYHR2525M00-M25R	●	GYM25RA-H25	●	B			
			L	GYHL2525M00-M25L	●	GYM25LA-H25	●	B			
		Modular	R	GYHR3225P00-M25R	●	GYM25RA-H25	●	F			
			L	GYHL3225P00-M25L	●	GYM25LA-H25	●	F			
		Modular	R	GYHR3232P00-M25R	●	GYM25RA-H25	●	F			
			L	GYHL3232P00-M25L	●	GYM25LA-H25	●	F			

W3 = Insert Width **ar** = Max. Groove Depth **D1** = Max. Cut Off Diameter

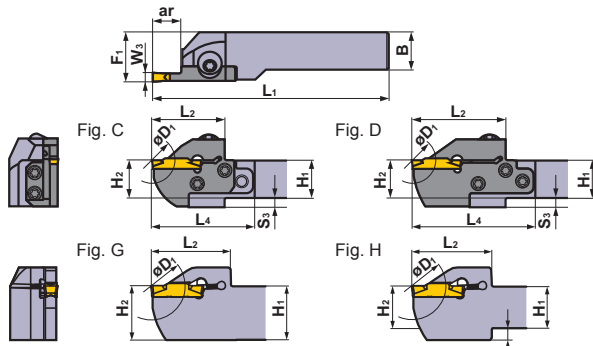
*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

*2 The maximum cut off diameter D_1 varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then **L1**, **L2**, **L4** and **F1** values may vary.



★ Wrench : R : Clamp Screw, D : Blade Screw



Right hand tool holder shown.

SPARE PARTS

Holder Number		5 pcs.	R D
	Clamp Screw	Blade Screw	Wrench ★
GYQR/L○○○○○○○○○○○○○○○○○○○○	HSC05030 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L○○○○○○○○○○○○○○○○○○○○-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY15D
GYHR/L○○○○○○○○○○○○○○○○○○○○-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D

Dimensions (mm) ★3									Cutting Mode	
H1	B	L1	L2	L4	H2	F1	S3		Clockwise	Anticlockwise
20	20	125	41	—	20	20.35	—			
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
H	GY○○○0475/0500/0524H○○○-Breaker

For Grooving/Cutting off > P9, P10						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
	W3	Neutral	Neutral	Neutral	Hand	Neutral
H	4.75mm	●	●	●	●	●
	5.00mm	●	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
	W3				Ball nose
H	4.75mm				●
	Re 0.2	●			
	Re 0.4	●			
	Re 0.8	●			
	5.00mm				●
	Re 0.2	●	●	●	
H	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
	5.24mm	●			

● : Gauge insert shown dimensions

EXTERNAL GROOVING

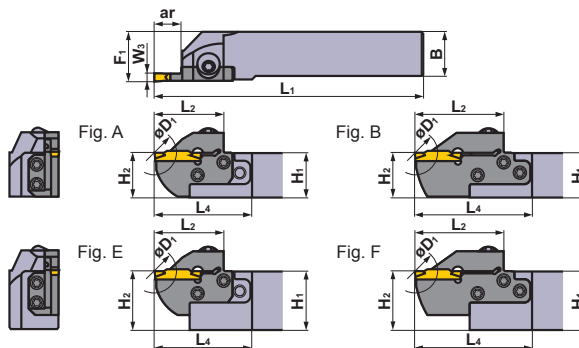
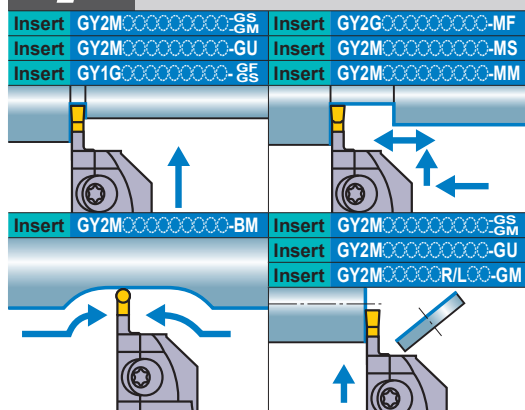
GY SERIES (EXTERNAL GROOVING)

1

00° type holder

(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.

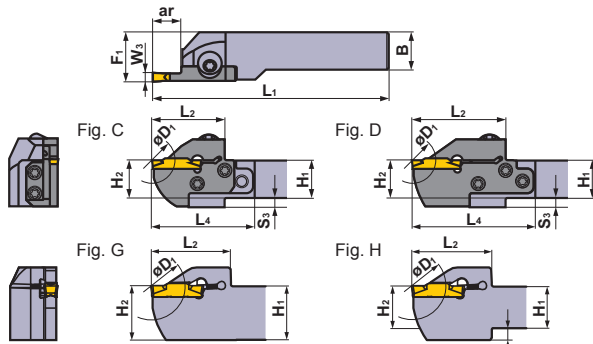
Seat Size	W3 (mm)	ar (mm)	D1 (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder		Stock	Modular Blade		
J	6.00 6.31 6.35	8	16	NEW Mono Block	R	GYQR2020K00-J08	●	—	—	G	
					L	GYQL2020K00-J08	●	—	—	G	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-J08	●	C	
					L	GYHL2020K00-M25L	●	GYM25LA-J08	●	C	
				NEW Mono Block	R	GYQR2525M00-J08	●	—	—	G	
					L	GYQL2525M00-J08	●	—	—	G	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-J08	●	A	
					L	GYHL2525M00-M25L	●	GYM25LA-J08	●	A	
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-J08	●	E	
					L	GYHL3225P00-M25L	●	GYM25LA-J08	●	E	
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-J08	●	E	
					L	GYHL3232P00-M25L	●	GYM25LA-J08	●	E	
		14	28	Modular	R	GYHR2020K00-M25R	●	GYM25RA-J14	●	C	
					L	GYHL2020K00-M25L	●	GYM25LA-J14	●	C	
				Modular	R	GYHR2525M00-M25R	●	GYM25RA-J14	●	A	
					L	GYHL2525M00-M25L	●	GYM25LA-J14	●	A	
				Modular	R	GYHR3225P00-M25R	●	GYM25RA-J14	●	E	
					L	GYHL3225P00-M25L	●	GYM25LA-J14	●	E	
				Modular	R	GYHR3232P00-M25R	●	GYM25RA-J14	●	E	
					L	GYHL3232P00-M25L	●	GYM25LA-J14	●	E	
		25 *1	50 *2	NEW Mono Block	R	GYQR2020K00-J25	●	—	—	H	
					L	GYQL2020K00-J25	●	—	—	H	
				Modular	R	GYHR2020K00-M25R	●	GYM25RA-J25	●	D	
					L	GYHL2020K00-M25L	●	GYM25LA-J25	●	D	
NEW Mono Block	R			GYQR2525M00-J25	●	—	—	G			
	L			GYQL2525M00-J25	●	—	—	G			
Modular	R			GYHR2525M00-M25R	●	GYM25RA-J25	●	B			
	L			GYHL2525M00-M25L	●	GYM25LA-J25	●	B			
Modular	R			GYHR3225P00-M25R	●	GYM25RA-J25	●	F			
	L			GYHL3225P00-M25L	●	GYM25LA-J25	●	F			
Modular	R			GYHR3232P00-M25R	●	GYM25RA-J25	●	F			
	L			GYHL3232P00-M25L	●	GYM25LA-J25	●	F			

W3 = Insert Width **ar** = Max. Groove Depth **D1** = Max. Cut Off Diameter

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

*2 The maximum cut off diameter D_1 varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2, L4 and F1 values may vary.



Right hand tool holder shown.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number	5 pcs.	5 pcs.	R D
	Clamp Screw	Blade Screw	Wrench ★
GYQR/L○○○○○○○○○○	HSC05030 (Clamp Torque : 7.0N·m)	—	HKY40R
GYHR/L○○○○○○○○○○-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D

	Dimensions (mm) ★3								Cutting Mode	
	H1	B	L1	L2	L4	H2	F1	S3	Clockwise	Anticlockwise
	20	20	125	41	—	20	20.35	—		
	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	—		
	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
J	GY○○0600/0631/0635J○○○○-Breaker

For Grooving/Cutting off > P9					
Seat Size	Breaker	GU	GS	GM	05-GM
		Neutral	Neutral	Neutral	Hand
J	W3	●	●	●	●
	W3	●	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
		●	●	●
J	W3	●	●	●
	W3	●	●	●
	W3	●	●	●
	W3	●	●	●
	W3	●	●	●
	W3	●	●	●
	W3	●	●	●
	W3	●	●	●

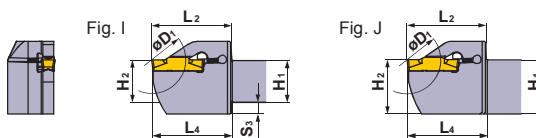
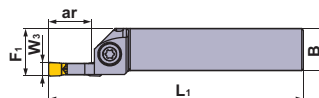
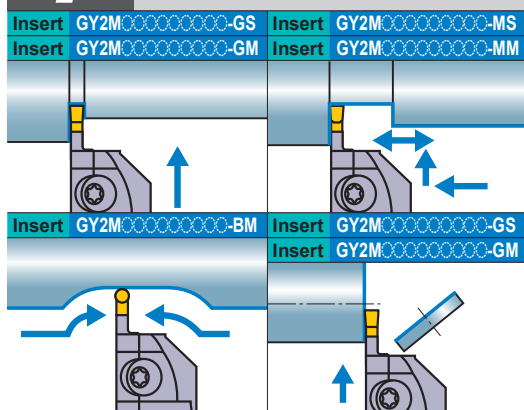
● : Gauge insert shown dimensions

EXTERNAL GROOVING

GY SERIES (EXTERNAL GROOVING)

1

00° type holder



Right hand tool holder shown.

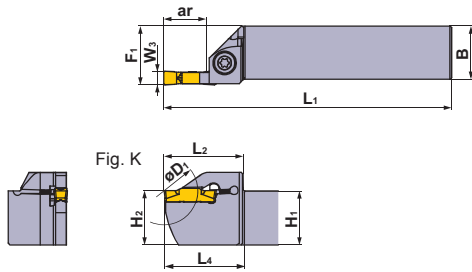
Seat Size	W3 (mm)	ar (mm)	D1 (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
K	8.00	25 *1	50 *2	Mono Block	R	GYPR2525M00-K25	●	—	—	I	
					L	GYPL2525M00-K25	●	—	—	I	
				Mono Block	R	GYPR3225P00-K25	●	—	—	J	
					L	GYPL3225P00-K25	●	—	—	J	
				Mono Block	R	GYPR3232P00-K25	●	—	—	K	
					L	GYPL3232P00-K25	●	—	—	K	

W3 = Insert Width ar = Max. Groove Depth D1 = Max. Cut Off Diameter

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

*2 The maximum cut off diameter D1 varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2, L4 and F1 values may vary.



Right hand tool holder shown.

SPARE PARTS

Holder Number		
	Clamp Screw	Wrench
GYPR/L○○○○○○00-K25	GY06013M (Clamp Torque : 6.0N·m)	TKY30R

	Dimensions (mm) *3								Cutting Mode	
	H1	B	L1	L2	L4	H2	F1	S3	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 > P9					
Seat Size	Breaker	GU	GS	GM	05-GM
	W3	Neutral	Neutral	Neutral	Hand
K	8.00mm		●	●	

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
	W3			
	8.00mm			
	Re 0.8		●	●
	Re 1.2			●

● : Gauge insert shown dimensions

EXTERNAL GROOVING

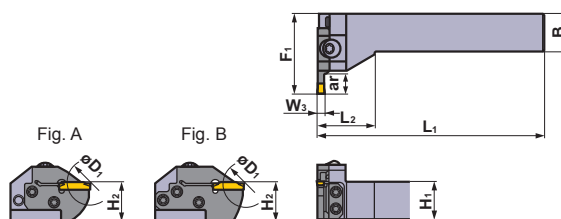
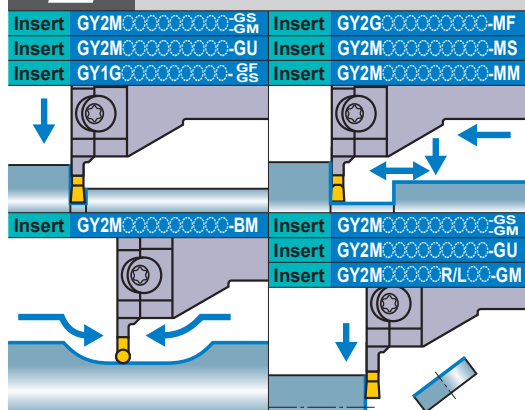
GY SERIES (EXTERNAL GROOVING)

2

90° type holder

(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.

Seat Size	W3 (mm)	ar (mm)	D1 (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder		Stock	Modular Blade		
D	2.00 2.24	6	12	Modular	R	GYHR2020K90-M20L	●	GYM20LA-D06	●	A	
				L	GYHL2020K90-M20R	●	GYM20RA-D06	●	A		
		Modular	R	GYHR2525M90-M25L	●	GYM25LA-D06	●	A			
			L	GYHL2525M90-M25R	●	GYM25RA-D06	●	A			
		10	20	Modular	R	GYHR2020K90-M20L	●	GYM20LA-D10	●	A	
				L	GYHL2020K90-M20R	●	GYM20RA-D10	●	A		
		12	24	Modular	R	GYHR2525M90-M25L	●	GYM25LA-D12	●	A	
				L	GYHL2525M90-M25R	●	GYM25RA-D12	●	A		
18 *4	36	Modular	R	GYHR2020K90-M20L	●	GYM20LB-D18	●	B			
		L	GYHL2020K90-M20R	●	GYM20RB-D18	●	B				
20 *1	40 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-D20	●	B			
		L	GYHL2525M90-M25R	●	GYM25RA-D20	●	B				
E	2.39 2.50 2.74	6	12	Modular	R	GYHR2020K90-M20L	●	GYM20LA-E06	●	A	
				L	GYHL2020K90-M20R	●	GYM20RA-E06	●	A		
		Modular	R	GYHR2525M90-M25L	●	GYM25LA-E06	●	A			
			L	GYHL2525M90-M25R	●	GYM25RA-E06	●	A			
		10	20	Modular	R	GYHR2020K90-M20L	●	GYM20LA-E10	●	A	
				L	GYHL2020K90-M20R	●	GYM20RA-E10	●	A		
		12	24	Modular	R	GYHR2525M90-M25L	●	GYM25LA-E12	●	A	
				L	GYHL2525M90-M25R	●	GYM25RA-E12	●	A		
18 *4	36	Modular	R	GYHR2020K90-M20L	●	GYM20LB-E18	●	B			
		L	GYHL2020K90-M20R	●	GYM20RB-E18	●	B				
20 *1	40 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-E20	●	B			
		L	GYHL2525M90-M25R	●	GYM25RA-E20	●	B				

W3 = Insert Width **ar** = Max. Groove Depth **D1** = Max. Cut Off Diameter

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

*2 The maximum cut off diameter D_1 varies according to the insert used. The cut off diameter is double the maximum groove depth (**ar**) of inserts on pages 9 to 11.

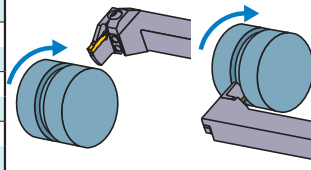
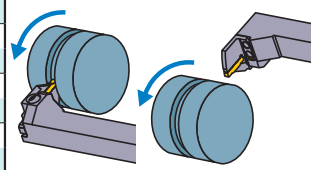
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2 and F1 values may vary.

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR2020K90-M20L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY15D
GYHL2020K90-M20R			
GYHR2525M90-M25L		TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★3						Cutting Mode
	H1	B	L1	L2	H2	F1	
	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	L 
	25	25	150	38	25	59	
	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	

Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker W3	GU	GS	GM	05-GM
		Neutral	Neutral	Neutral	Hand
D	2.00mm	●	●	●	●
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker W3	MF	MS	MM	BM
					Ball nose
D	2.00mm	●	●	●	●
	2.24mm	●	●	●	●
	2.39mm	●	●	●	●
E	2.50mm	●	●	●	●
	2.74mm	●	●	●	●

● : Gauge insert shown dimensions

EXTERNAL GROOVING

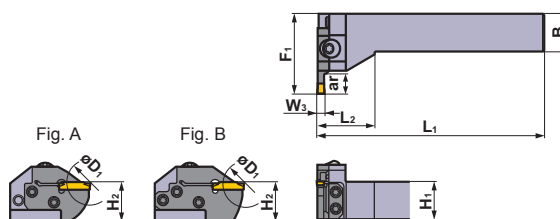
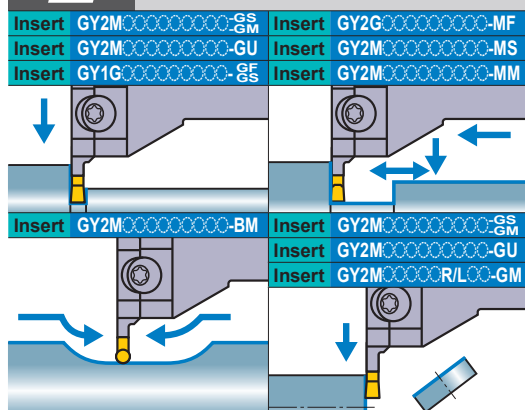
GY SERIES (EXTERNAL GROOVING)

2

90° type holder

(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.

[illegible]

W3 = Insert Width **ar** = Max. Groove Depth **D1** = Max. Cut Off Diameter

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

*2 The maximum cut off diameter D_1 varies according to the insert used. The cut off diameter is double the maximum groove depth (**ar**) of inserts on pages 9 to 11.

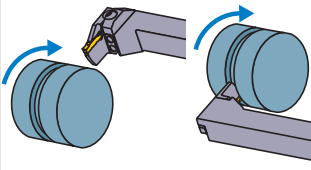
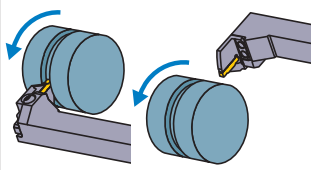
*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2 and F1 values may vary.

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR2020K90-M20L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY15D
GYHL2020K90-M20R			
GYHR2525M90-M25L		TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★3						Cutting Mode
	H1	B	L1	L2	H2	F1	
	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	L 
	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 > P9, P10					
Seat Size	Breaker	GU	GS	GM	05-GM
		Neutral	Neutral	Neutral	Hand
F	3.00mm	●	●	●	●
	3.18mm	●	●	●	●
G	4.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
F	3.00mm			
	Re 0.2	●	●	●
	Re 0.4	●	●	●
	Re 0.8			●
	3.18mm			●
	Re 0.2	●		
	Re 0.4	●		
	3.24mm	●		
	4.00mm			●
	Re 0.2	●	●	●
G	Re 0.4	●	●	●
	Re 0.8	●		●
	4.24mm	●		

● : Gauge insert shown dimensions

EXTERNAL GROOVING

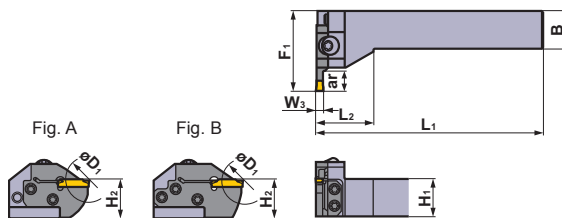
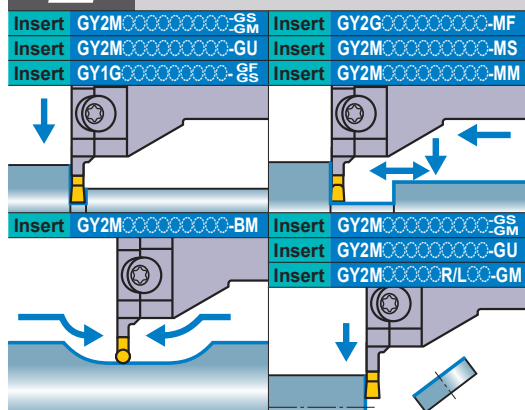
GY SERIES (EXTERNAL GROOVING)

2

90° type holder

(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.

Seat Size	W3 (mm)	ar (mm)	D1 (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	8	16	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LA-H08 GYM25RA-H08	● ●	A A
		12	24	Modular	R L	GYHR2020K90-M20L GYHL2020K90-M20R	● ●	GYM20LA-H12 GYM20RA-H12	● ●	A A
		14	28	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LA-H14 GYM25RA-H14	● ●	A A
		25 *1	50 *2	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LA-H25 GYM25RA-H25	● ●	B B
J	6.00 6.31 6.35	8	16	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LA-J08 GYM25RA-J08	● ●	A A
		14	28	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LA-J14 GYM25RA-J14	● ●	A A
		25 *1	50 *2	Modular	R L	GYHR2525M90-M25L GYHL2525M90-M25R	● ●	GYM25LA-J25 GYM25RA-J25	● ●	B B

W3 = Insert Width **ar** = Max. Groove Depth **D1** = Max. Cut Off Diameter

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

*2 The maximum cut off diameter D_1 varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

*3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L2 and F1 values may vary.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR2020K90-M20L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY15D
GYHL2020K90-M20R			
GYHR2525M90-M25L		TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★3						Cutting Mode
	H1	B	L1	L2	H2	F1	
	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	L
	25	25	150	38	25	64	
	25	25	150	38	25	47	
	25	25	150	38	25	47	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	L
	25	25	150	38	25	64	
	25	25	150	38	25	47	
	25	25	150	38	25	47	
	25	25	150	38	25	53	
	25	25	150	38	25	53	

Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	05-GM
	W3	Neutral	Neutral	Neutral	Hand
H	4.75mm	●	●	●	●
	5.00mm	●	●	●	●
J	6.00mm	●	●	●	●
	6.35mm	●	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
	W3			BM
H	4.75mm			Ball nose
	Re 0.2	●		
	Re 0.4	●		
	Re 0.8	●		
	5.00mm			
	Re 0.2	●		
J	Re 0.4	●	●	●
	Re 0.8	●	●	●
	5.24mm	●		
	6.00mm			
	Re 0.2	●		
	Re 0.4	●	●	●
J	Re 0.8	●	●	●
	6.31mm	●		
	6.35mm			
	Re 0.2	●		
	Re 0.4	●		
	Re 0.8	●		

● : Gauge insert shown dimensions

EXTERNAL GROOVING

IDENTIFICATION > P7, P8

CUTTING CONDITIONS > P87

INSTRUCTION MANUAL > P91

GY SERIES (EXTERNAL RECESSING)

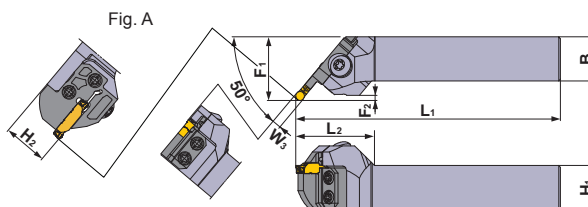
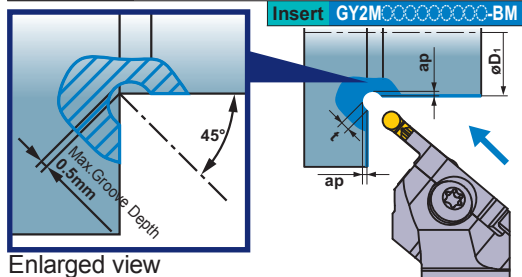
3

50° type holder

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.



Right hand tool holder shown.

Seat Size	W3 (mm)	ar (mm)	D1 (mm)	t (mm)	ap (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 L	GYHR2020K50-M20L GYHL2020K50-M20R	● ●	GYM20LC-D005 GYM20RC-D005		● ●	A A			
						Modular	R L	GYHR2525M50-M25L GYHL2525M50-M25R	● ●	GYM25LC-D005 GYM25RC-D005		● ●	A A			
E	2.50			1.75	0.72	Modular	R L	GYHR2020K50-M20L GYHL2020K50-M20R	● ●	GYM20LC-E005 GYM20RC-E005		● ●	A A			
						Modular	R L	GYHR2525M50-M25L GYHL2525M50-M25R	● ●	GYM25LC-E005 GYM25RC-E005		● ●	A A			
F	3.00 3.18		2	0.793	Modular	R L	GYHR2020K50-M20L GYHL2020K50-M20R	● ●	GYM20LC-F005 GYM20RC-F005		● ●	A A				
					Modular	R L	GYHR2525M50-M25L GYHL2525M50-M25R	● ●	GYM25LC-F005 GYM25RC-F005		● ●	A A				
G	4.00		20	2.5	0.939	Modular	R L	GYHR2020K50-M20L GYHL2020K50-M20R	● ●	GYM20LC-G005 GYM20RC-G005		● ●	A A			
						Modular	R L	GYHR2525M50-M25L GYHL2525M50-M25R	● ●	GYM25LC-G005 GYM25RC-G005		● ●	A A			
H	4.75 5.00					2.88	1.049	Modular	R L	GYHR2020K50-M20L GYHL2020K50-M20R	● ●	GYM20LC-H005 GYM20RC-H005		● ●	A A	
								Modular	R L	GYHR2525M50-M25L GYHL2525M50-M25R	● ●	GYM25LC-H005 GYM25RC-H005		● ●	A A	
J	6.00 6.35	3.5		1.232	Modular	R L	GYHR2525M50-M25L GYHL2525M50-M25R	● ●	GYM25LC-J005 GYM25RC-J005		● ●	A A				

W₃ = Insert Width ar = Max. Groove Depth D₁ = Min. Cut Diameter t = Max. Recessing Depth ap = Dist. from the material surface to the recess

*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 L₁, L₂, F₁ and F₂ values may vary.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 5 pcs.	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K50-M20R/L	GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY25D
GYHR/L2525M50-M25R/L		TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D

	Dimensions (mm) ★2							Cutting Mode
	H1	B	L1	L2	H2	F1	F2	
	20	20	125	40	20	32	1.6	R
	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	R
	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	R
	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	L
	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	L
	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	L
	25	25	150	44	25	36	3.4	

Select an Insert

Insert Number

GY2M○○○○○○○○N-BM

For Multifunctional Grooving > P11		
Seat Size	Breaker	BM
	W3	Ball nose
D	2.00mm	●
E	2.50mm	●
F	3.00mm	●
F	3.18mm	●
G	4.00mm	●
H	4.75mm	●
H	5.00mm	●
J	6.00mm	●
J	6.35mm	●

● : Gauge insert shown dimensions

EXTERNAL GROOVING

IDENTIFICATION > P7, P8

CUTTING CONDITIONS > P90

INSTRUCTION MANUAL > P90

GY SERIES (FACE GROOVING)

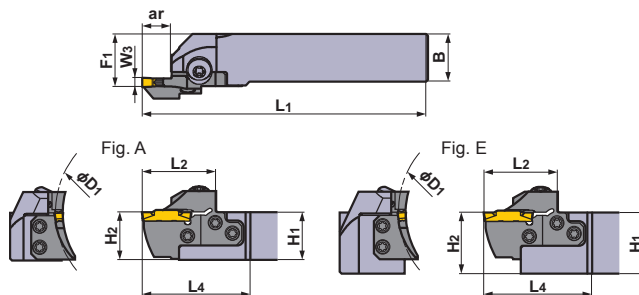
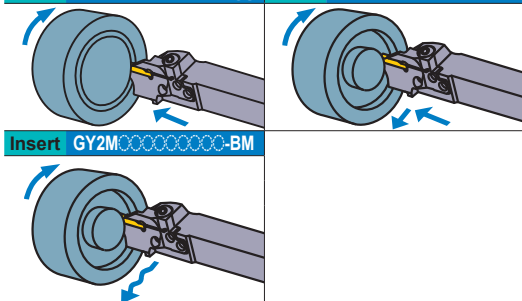
4

00° type holder

(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.

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM



Right hand tool holder shown.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-040	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-040	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-040	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-040	●	A
		50	60	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-040	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-D12-040	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-040	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-D12-040	●	E
		60	75	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-050	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-050	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-050	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-050	●	A
		75	100	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-050	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-D12-050	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-050	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-D12-050	●	E
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-060	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-060	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-060	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-060	●	A
		75	100	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-060	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-D12-060	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-060	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-D12-060	●	E
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-075	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-075	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-075	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-075	●	A
		75	100	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-075	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-D12-075	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-075	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-D12-075	●	E

W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 values may vary.

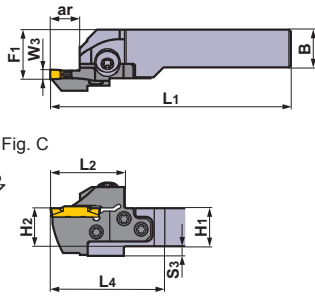


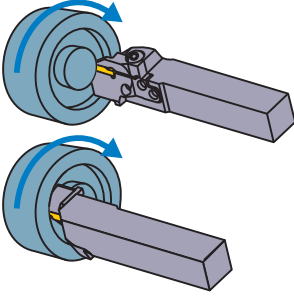
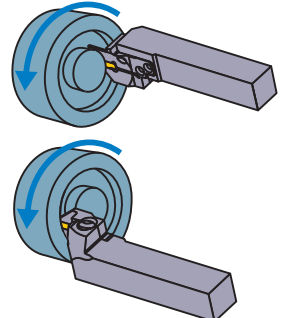
Fig. C

Right hand tool holder shown.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	20	20	125	39	60	20	26	5	R 
	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	—	L 
	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 > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
W3					
D	2.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
W3				Ball nose
D	2.00mm	●	●	●
	2.24mm	●	●	●

● : Gauge insert shown dimensions

FACE
GROOVING

GY SERIES (FACE GROOVING)

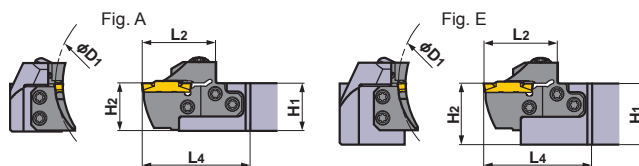
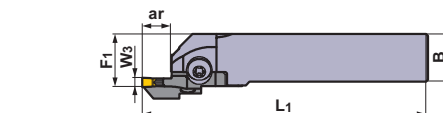
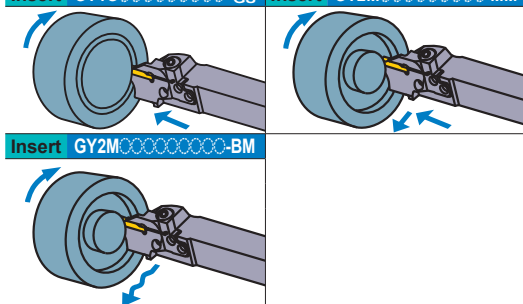
4

00° type holder

(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.

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM

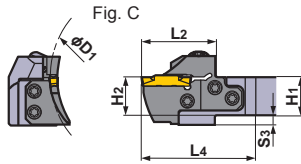
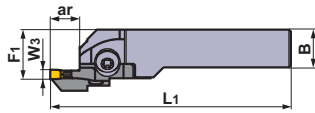


Right hand tool holder shown.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-100	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-100	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-100	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-100	●	A
		135	200	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-100	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-D12-100	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-100	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-D12-100	●	E
		180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-135	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-135	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-135	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-135	●	A
		180	250	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-135	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-D12-135	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-135	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-D12-135	●	E
		180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-D12-180	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-D12-180	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-D12-180	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-D12-180	●	A
		180	250	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-D12-180	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-D12-180	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-D12-180	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-D12-180	●	E

W3 = Insert Width D1 = First Cut Diameter ar = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 values may vary.



Right hand tool holder shown.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	20	20	125	39	60	20	26	5	R
	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	L
	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	GY0000200/0224D0000-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
W3					
D	2.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
W3				Ball nose
D	2.00mm	●	●	●
	2.24mm	●	●	●

● : Gauge insert shown dimensions

FACE
GROOVING

GY SERIES (FACE GROOVING)

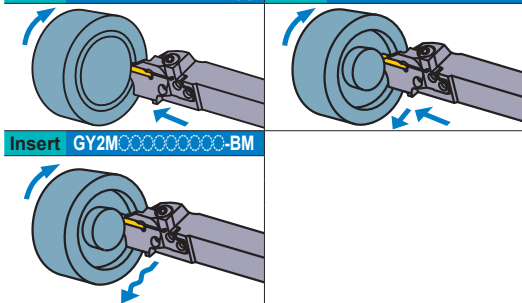
4

00° type holder

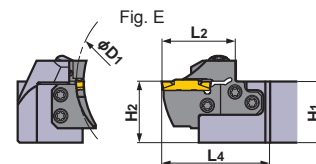
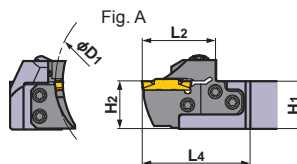
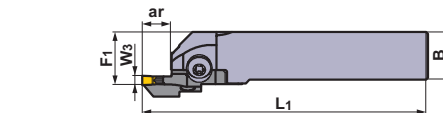
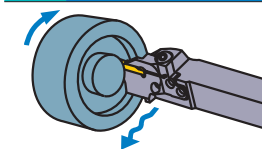
(Note 1) For modular blades and holders, please order separately.

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

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM



Insert GY2M-BM



Right hand tool holder shown.

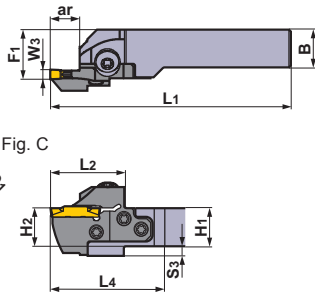
Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-040	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-040	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-040	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-040	●	A
		50	60	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-040	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-040	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-040	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-040	●	E
		60	75	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-050	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-050	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-050	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-050	●	A
		75	100	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-050	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-050	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-050	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-050	●	E
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-060	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-060	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-060	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-060	●	A
		75	100	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-060	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-060	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-060	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-060	●	E
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-075	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-075	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-075	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-075	●	A
		75	100	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-075	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-075	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-075	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-075	●	E

W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 values may vary.



Right hand tool holder shown.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	20	20	125	39	60	20	26	5	R
	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	—	R
	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	—	L
	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	—	L
	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	GY000239/0250/0274E0000-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
E	W3				
	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
E	W3				Ball nose
	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			

● : Gauge insert shown dimensions

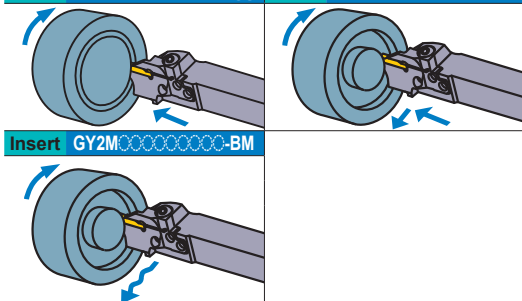
FACE
GROOVING

GY SERIES (FACE GROOVING)

4

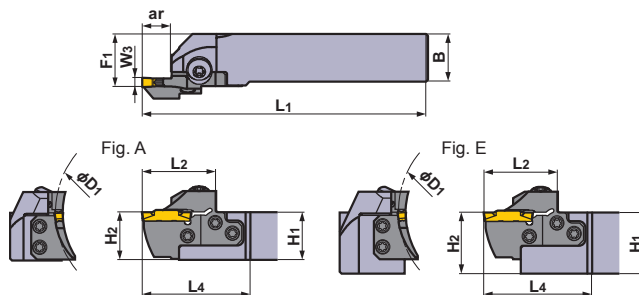
00° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	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.

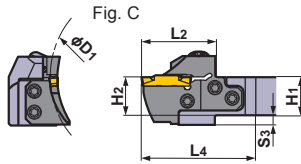
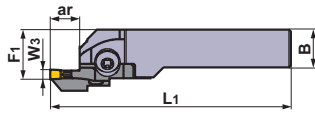
Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-100	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-100	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-100	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-100	●	A
		135	200	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-100	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-100	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-100	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-100	●	E
		180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-135	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-135	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-135	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-135	●	A
		180	250	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-135	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-135	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-135	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-135	●	E
		180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-E12-180	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-E12-180	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-E12-180	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-E12-180	●	A
		180	250	12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-E12-180	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-E12-180	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-E12-180	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-E12-180	●	E

W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 values may vary.



Right hand tool holder shown.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	20	20	125	39	60	20	26	5	R
	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	L
	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	GY000239/0250/0274E0000-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
E	W3				
	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
E	W3				Ball nose
	2.39mm	●			
	2.50mm	●	●	●	●
	2.74mm	●			

● : Gauge insert shown dimensions

FACE
GROOVING

GY SERIES (FACE GROOVING)

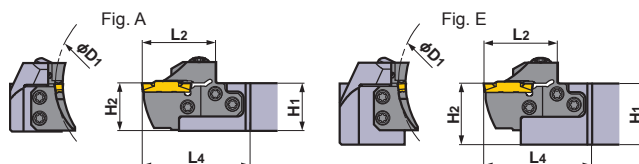
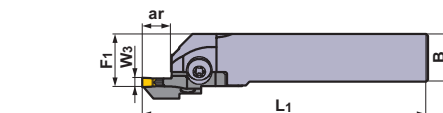
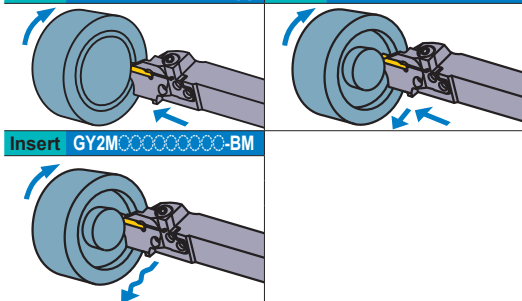
4

00° type holder

(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.

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM



Right hand tool holder shown.

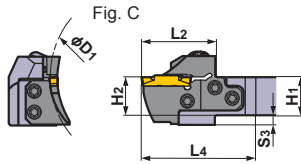
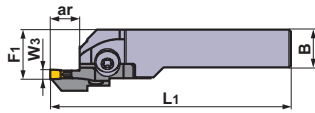
Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	35	40	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-035	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-035	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-035	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-035	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-035	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-035	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-035	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-035	●	E
		40	50	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-040	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-040	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-040	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-040	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-040	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-040	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-040	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-040	●	E
		50	60	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-050	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-050	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-050	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-050	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-050	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-050	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-050	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-050	●	E

W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

★1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 values may vary.

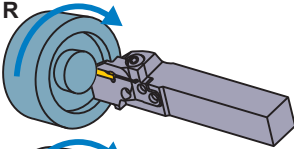
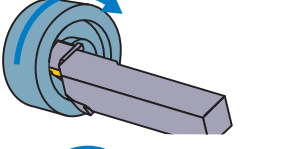
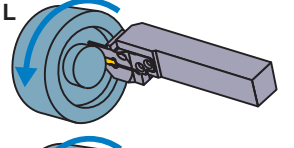
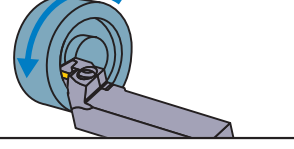


Right hand tool holder shown.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	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 > P9, P10				
Seat Size	Breaker	GU	GS	GM
F	W3			
	3.00mm	●	●	●
	3.18mm	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
F	W3			
	3.00mm			Ball nose
	Re 0.2	●	●	●
	Re 0.4	●	●	●
	Re 0.8			●
	3.18mm			●
	Re 0.2	●		
	Re 0.4	●		
	3.24mm	●		

● : Gauge insert shown dimensions

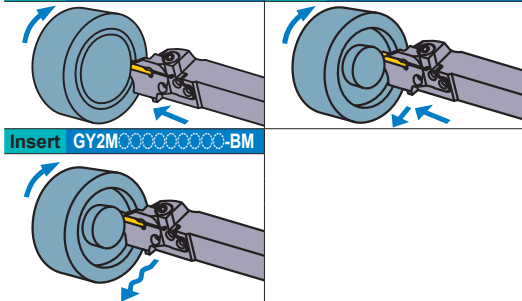
FACE
GROOVING

GY SERIES (FACE GROOVING)

4

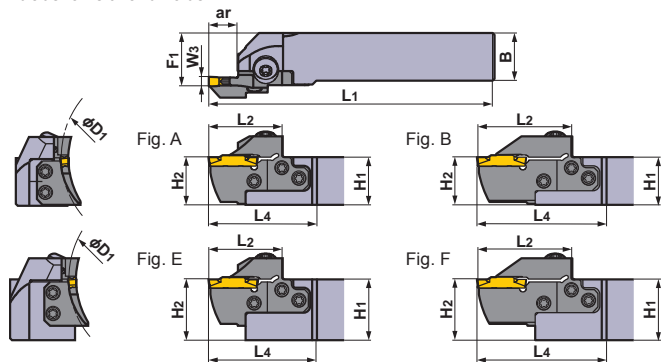
00° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	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.



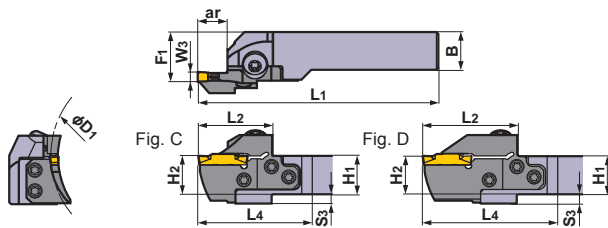
Right hand tool holder shown.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	60	75	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-060	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-060	●	C
				20 *2	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-060	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-060	●	A
				20 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-060	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-060	●	E
				20 *2	Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-060	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-060	●	E
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-060	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-060	●	D
				20 *2	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-060	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-060	●	B
				20 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-060	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F20-060	●	F
				20 *2	Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-060	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F20-060	●	F
		75	100	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-075	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-075	●	C
				20 *2	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-075	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-075	●	A
				20 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-075	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-075	●	E
				20 *2	Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-075	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-075	●	E

W3 = Insert Width D1 = First Cut Diameter ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 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 9 to 11.



★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	20	20	125	39	60	20	26	5	R
	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	—	L
	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	—	F
	32	25	176	45	63	32	28	—	
	32	32	176	45	63	32	35	—	
	32	32	176	45	63	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	—	F
	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 > P9, P10				
Seat Size	Breaker	GU	GS	GM
F	W3			
	3.00mm	●	●	●
	3.18mm	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
F	W3			
	3.00mm			Ball nose
	Re 0.2	●	●	●
	Re 0.4	●	●	●
	Re 0.8			●
	3.18mm			●
	Re 0.2	●		
	Re 0.4	●		
	3.24mm	●		

● : Gauge insert shown dimensions

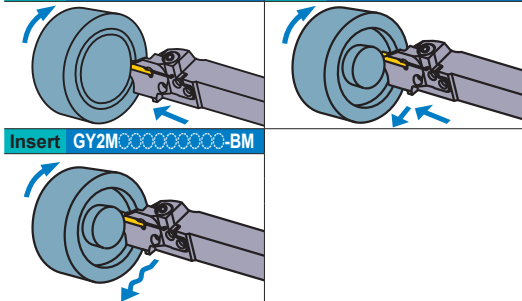
FACE
GROOVING

GY SERIES (FACE GROOVING)

4

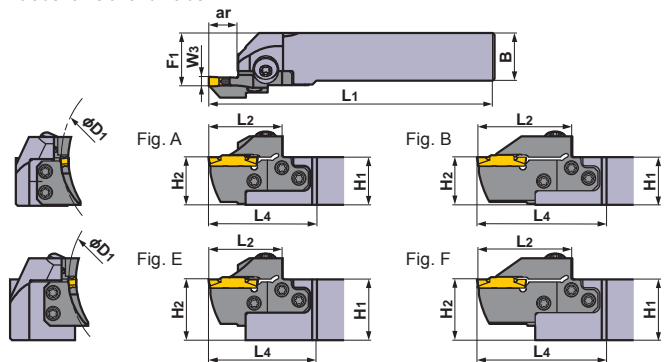
00° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	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.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	100	150	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-100	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-100	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-100	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-100	●	A
				20 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-100	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-100	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-100	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-100	●	E
				20 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-100	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-100	●	D
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-100	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-100	●	B
				12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-100	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F20-100	●	F
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-100	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F20-100	●	F
		135	200	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-135	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-135	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-135	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-135	●	A
				20 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-135	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-135	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-135	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-135	●	E
				20 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-135	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-135	●	D
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-135	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-135	●	B
				12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-135	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F20-135	●	F
				20 *2	Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-135	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F20-135	●	F

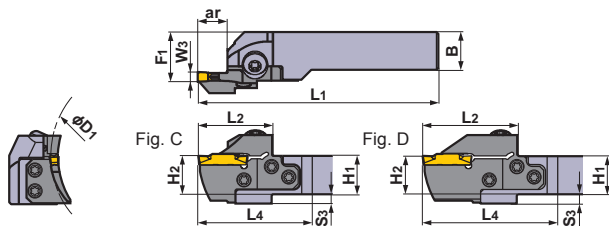
W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 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 9 to 11.



★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	20	20	125	39	60	20	26	5	R
	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	—	L
	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	—	L
	32	25	176	45	63	32	28	—	
	32	32	176	45	63	32	35	—	
	32	32	176	45	63	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	—	L
	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 > P9, P10				
Seat Size	Breaker	GU	GS	GM
F	W3			
	3.00mm	●	●	●
	3.18mm	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
F	W3			
	3.00mm			Ball nose
	Re 0.2	●	●	●
	Re 0.4	●	●	●
	Re 0.8			●
	3.18mm			●
	Re 0.2	●		
	Re 0.4	●		
	3.24mm	●		

● : Gauge insert shown dimensions

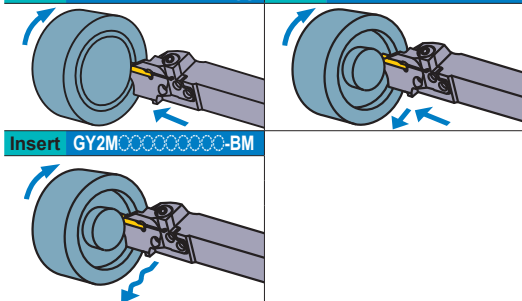
FACE
GROOVING

GY SERIES (FACE GROOVING)

4

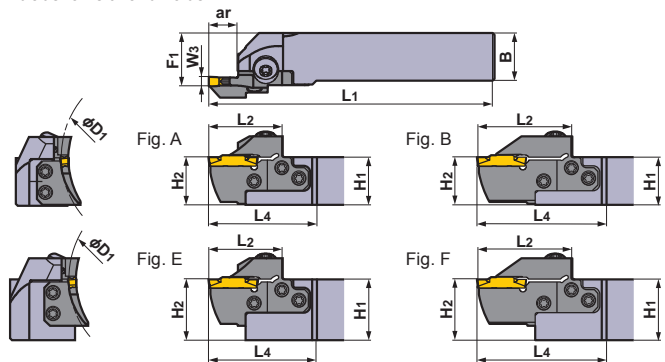
00° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	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.



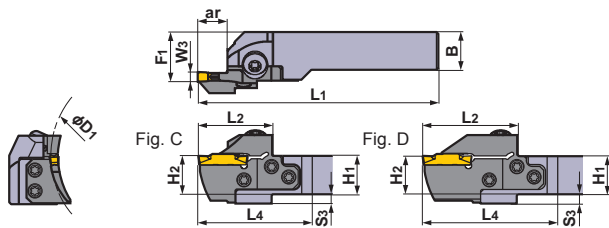
Right hand tool holder shown.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	180	250	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-180	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-180	●	C
				12	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-180	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-180	●	A
				12	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-180	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-180	●	E
				20 *2	Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-180	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-180	●	E
					Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-180	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-180	●	D
				20 *2	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-180	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-180	●	B
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-180	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F20-180	●	F
				12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F12-225	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F12-225	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-F12-225	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F12-225	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-F12-225	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F12-225	●	E
				20 *2	Modular	R	GYHR3232P00-M25R	●	GYM25RD-F12-225	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F12-225	●	E
		225	999	12	Modular	R	GYHR2020K00-M25R	●	GYM25RD-F20-225	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-F20-225	●	D
				12	Modular	R	GYHR2525M00-M25R	●	GYM25RD-F20-225	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-F20-225	●	B
				20 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-F20-225	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-F20-225	●	F
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-F20-225	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-F20-225	●	F

W3 = Insert Width D1 = First Cut Diameter ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 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 9 to 11.



★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number			
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	20	20	125	39	60	20	26	5	R
	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	—	L
	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	—	L
	32	25	176	45	63	32	28	—	
	32	32	176	45	63	32	35	—	
	32	32	176	45	63	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	—	L
	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 > P9, P10				
Seat Size	Breaker	GU	GS	GM
F	W3			
	3.00mm	●	●	●
	3.18mm	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
F	W3			
	3.00mm			Ball nose
	Re 0.2	●	●	●
	Re 0.4	●	●	●
	Re 0.8			●
	3.18mm			●
	Re 0.2	●		
	Re 0.4	●		
	3.24mm	●		

● : Gauge insert shown dimensions

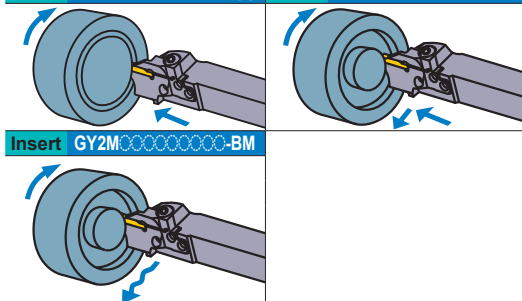
FACE
GROOVING

GY SERIES (FACE GROOVING)

4

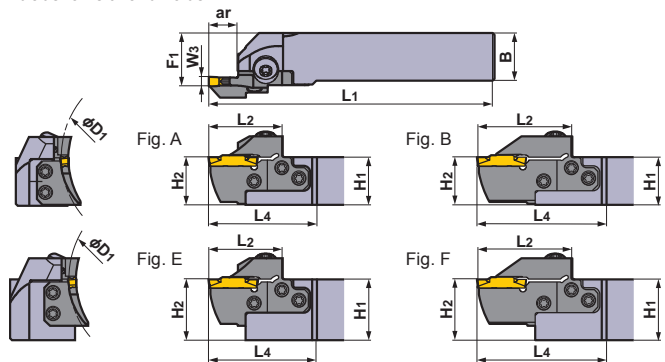
00° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	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.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	40	50	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-040	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-040	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-040	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-040	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-040	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-G14-040	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-040	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-G14-040	●	E
		50	60	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-050	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-050	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-050	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-050	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-050	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-G14-050	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-050	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-G14-050	●	E
		60	85	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-060	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G14-060	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-060	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G14-060	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-060	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-G14-060	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-060	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-G14-060	●	E
				25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-060	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-G25-060	●	D
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-060	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-G25-060	●	B
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-G25-060	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-G25-060	●	F
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G25-060	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-G25-060	●	F

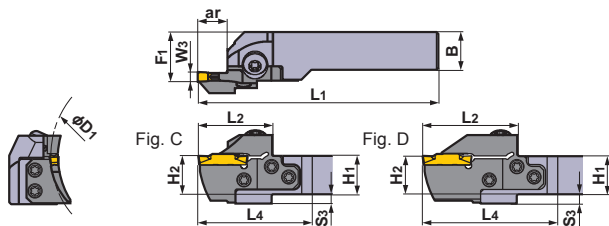
W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 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 9 to 11.

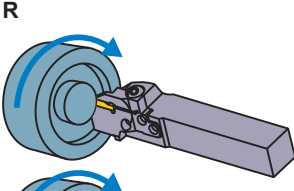
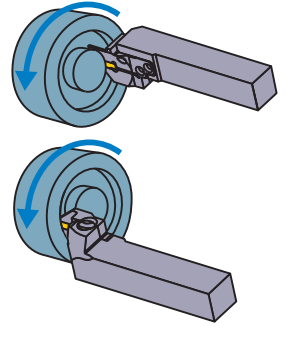


★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	20	20	125	39	60	20	26	5	R
	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	—	L
	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	—	
	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	GY0000400/0424G0000-Breaker

For Grooving/Cutting off > P9, P10				
Seat Size	Breaker	GU	GS	GM
W3				
G	4.00mm	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
W3				
G	4.00mm	●	●	●
	Re 0.2	●	●	●
	Re 0.4	●	●	●
	Re 0.8	●	●	●
	4.24mm	●	●	●

● : Gauge insert shown dimensions

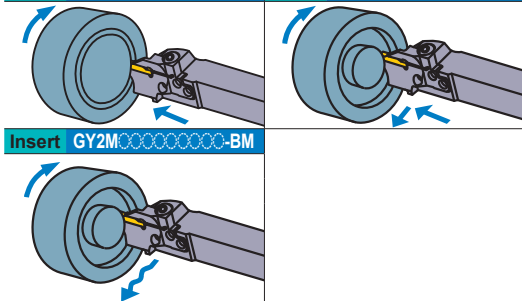
FACE
GROOVING

GY SERIES (FACE GROOVING)

4

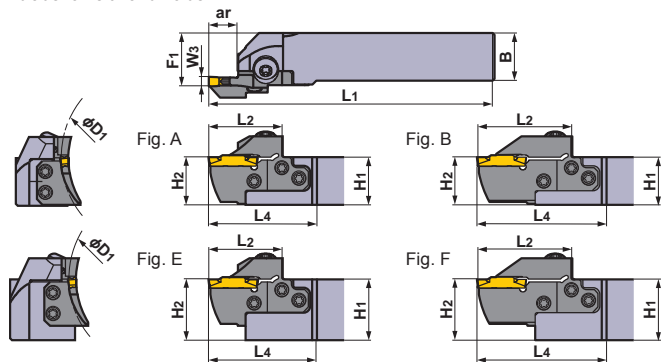
00° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	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.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
FACE GROOVING	G	4.00 4.24	85	125	14	R	GYHR2020K00-M25R	●	GYM25RD-G14-085	●	C
						L	GYHL2020K00-M25L	●	GYM25LD-G14-085	●	C
						R	GYHR2525M00-M25R	●	GYM25RD-G14-085	●	A
						L	GYHL2525M00-M25L	●	GYM25LD-G14-085	●	A
					25 *2	R	GYHR3225P00-M25R	●	GYM25RD-G14-085	●	E
						L	GYHL3225P00-M25L	●	GYM25LD-G14-085	●	E
						R	GYHR3232P00-M25R	●	GYM25RD-G14-085	●	E
						L	GYHL3232P00-M25L	●	GYM25LD-G14-085	●	E
			125	200	14	R	GYHR2020K00-M25R	●	GYM25RD-G25-085	●	D
						L	GYHL2020K00-M25L	●	GYM25LD-G25-085	●	D
						R	GYHR2525M00-M25R	●	GYM25RD-G25-085	●	B
						L	GYHL2525M00-M25L	●	GYM25LD-G25-085	●	B
						R	GYHR3225P00-M25R	●	GYM25RD-G25-085	●	F
						L	GYHL3225P00-M25L	●	GYM25LD-G25-085	●	F
						R	GYHR3232P00-M25R	●	GYM25RD-G25-085	●	F
						L	GYHL3232P00-M25L	●	GYM25LD-G25-085	●	F
				25 *2	14	R	GYHR2020K00-M25R	●	GYM25RD-G14-125	●	C
						L	GYHL2020K00-M25L	●	GYM25LD-G14-125	●	C
						R	GYHR2525M00-M25R	●	GYM25RD-G14-125	●	A
						L	GYHL2525M00-M25L	●	GYM25LD-G14-125	●	A
						R	GYHR3225P00-M25R	●	GYM25RD-G14-125	●	E
						L	GYHL3225P00-M25L	●	GYM25LD-G14-125	●	E
						R	GYHR3232P00-M25R	●	GYM25RD-G14-125	●	E
						L	GYHL3232P00-M25L	●	GYM25LD-G14-125	●	E
					25 *2	R	GYHR2020K00-M25R	●	GYM25RD-G25-125	●	D
						L	GYHL2020K00-M25L	●	GYM25LD-G25-125	●	D
						R	GYHR2525M00-M25R	●	GYM25RD-G25-125	●	B
						L	GYHL2525M00-M25L	●	GYM25LD-G25-125	●	B
						R	GYHR3225P00-M25R	●	GYM25RD-G25-125	●	F
						L	GYHL3225P00-M25L	●	GYM25LD-G25-125	●	F
						R	GYHR3232P00-M25R	●	GYM25RD-G25-125	●	F
						L	GYHL3232P00-M25L	●	GYM25LD-G25-125	●	F

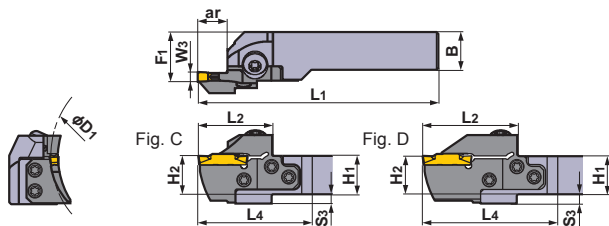
W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 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 9 to 11.

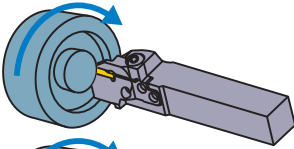
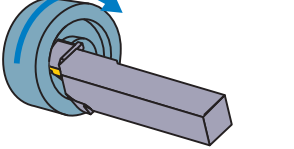
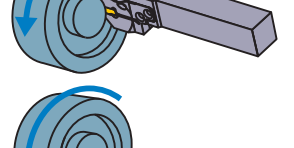
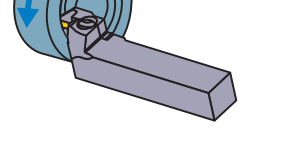


★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	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	GY0000400/0424G0000-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
W3					
G	4.00mm	●	●	●	●

For Multifunctional Grooving					> P10, P11
Seat Size	Breaker	MF	MS	MM	BM
	W3				Ball nose
G	4.00mm				●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8	●		●	
	4.24mm	●			

● : Gauge insert shown dimensions

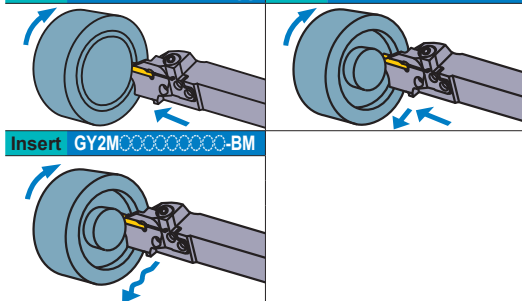
FACE
GROOVING

GY SERIES (FACE GROOVING)

4

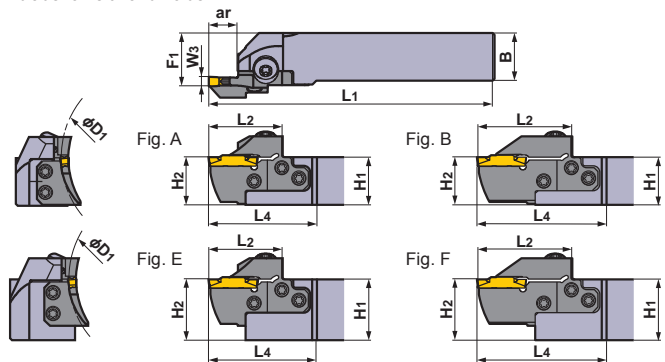
00° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	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.



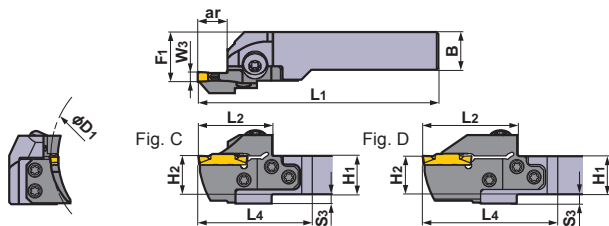
Right hand tool holder shown.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.	
		min	max				Holder	Stock	Modular Blade	Stock		
G	4.00 4.24	180	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-180	●	C	
						L	GYHL2020K00-M25L	●	GYM25LD-G14-180	●	C	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-180	●	A	
						L	GYHL2525M00-M25L	●	GYM25LD-G14-180	●	A	
				Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-180	●	E		
					L	GYHL3225P00-M25L	●	GYM25LD-G14-180	●	E		
				Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-180	●	E		
					L	GYHL3232P00-M25L	●	GYM25LD-G14-180	●	E		
		25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-180	●	D			
				L	GYHL2020K00-M25L	●	GYM25LD-G25-180	●	D			
			Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-180	●	B			
				L	GYHL2525M00-M25L	●	GYM25LD-G25-180	●	B			
		Modular	R	GYHR3225P00-M25R	●	GYM25RD-G25-180	●	F				
			L	GYHL3225P00-M25L	●	GYM25LD-G25-180	●	F				
		Modular	R	GYHR3232P00-M25R	●	GYM25RD-G25-180	●	F				
			L	GYHL3232P00-M25L	●	GYM25LD-G25-180	●	F				
		250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-250	●	C	
						L	GYHL2020K00-M25L	●	GYM25LD-G14-250	●	C	
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-250	●	A	
						L	GYHL2525M00-M25L	●	GYM25LD-G14-250	●	A	
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-G14-250	●	E	
						L	GYHL3225P00-M25L	●	GYM25LD-G14-250	●	E	
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-G14-250	●	E	
						L	GYHL3232P00-M25L	●	GYM25LD-G14-250	●	E	
25 *2	Modular			R	GYHR2020K00-M25R	●	GYM25RD-G25-250	●	D			
				L	GYHL2020K00-M25L	●	GYM25LD-G25-250	●	D			
	Modular			R	GYHR2525M00-M25R	●	GYM25RD-G25-250	●	B			
				L	GYHL2525M00-M25L	●	GYM25LD-G25-250	●	B			
	Modular			R	GYHR3225P00-M25R	●	GYM25RD-G25-250	●	F			
				L	GYHL3225P00-M25L	●	GYM25LD-G25-250	●	F			
	Modular			R	GYHR3232P00-M25R	●	GYM25RD-G25-250	●	F			
				L	GYHL3232P00-M25L	●	GYM25LD-G25-250	●	F			

W3 = Insert Width D1 = First Cut Diameter ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 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 9 to 11.

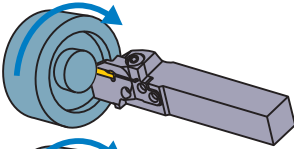
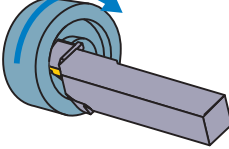
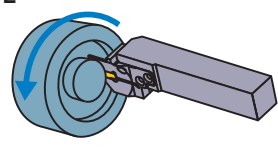
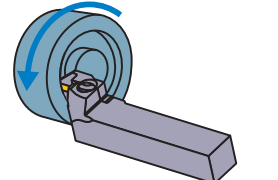
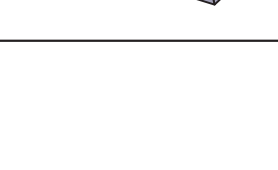


★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	20	20	125	39	60	20	26	5	R 
	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	—	L 
	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	GY000400/0424G0000-Breaker

For Grooving/Cutting off > P9, P10				
Seat Size	Breaker	GU	GS	GM
W3				
G	4.00mm	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
W3				
G	4.00mm	●	●	●
	Re 0.2	●	●	●
	Re 0.4	●	●	●
	Re 0.8	●	●	●
	4.24mm	●	●	●

● : Gauge insert shown dimensions

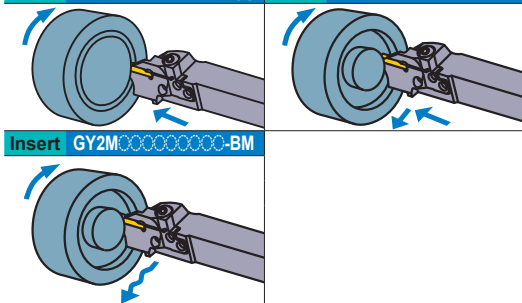
FACE
GROOVING

GY SERIES (FACE GROOVING)

4

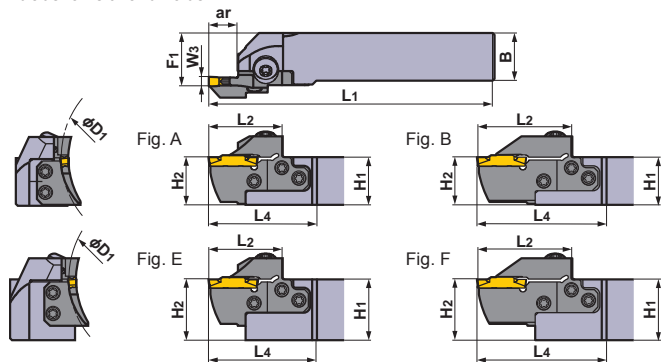
00° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	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.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	50	60	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-050	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-050	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-050	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-050	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-050	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-H14-050	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-050	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-H14-050	●	E
		60	85	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-060	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-060	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-060	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-060	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-060	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-H14-060	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-060	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-H14-060	●	E
		60	85	25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-060	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-060	●	D
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-060	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-060	●	B
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-060	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-H25-060	●	F
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-060	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-H25-060	●	F

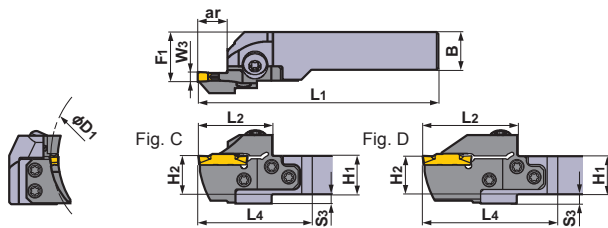
W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 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 9 to 11.

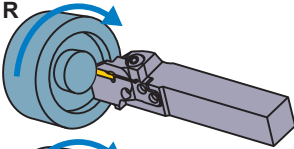
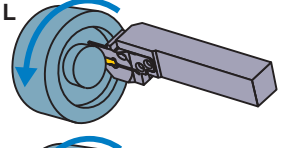


★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	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	GY000475/0500/0524H0000-Breaker

For Grooving/Cutting off > P9, P10				
Seat Size	Breaker	GU	GS	GM
W3				
H	4.75mm	●	●	●
	5.00mm	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
W3				
H	4.75mm			●
	Re 0.2	●		
	Re 0.4	●		
	Re 0.8	●		
	5.00mm			●
	Re 0.2	●		
	Re 0.4	●	●	●
	Re 0.8	●	●	●
	5.24mm	●		

● : Gauge insert shown dimensions

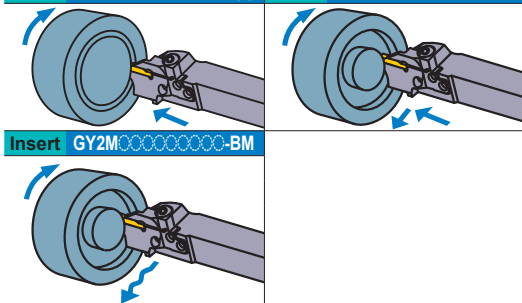
FACE
GROOVING

GY SERIES (FACE GROOVING)

4

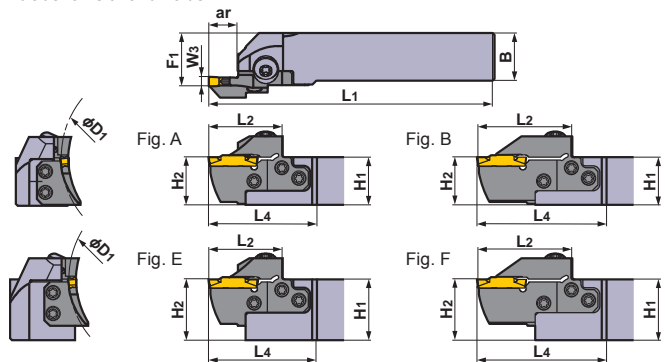
00° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	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.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
FACE GROOVING H	4.75 5.00 5.24	85	125	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-085	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-085	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-085	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-085	●	A
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-085	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-H14-085	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-085	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-H14-085	●	E
		125	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-085	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-085	●	D
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-085	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-085	●	B
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-085	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-H25-085	●	F
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-085	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-H25-085	●	F
				14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-125	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-125	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-125	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-125	●	A
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-125	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-H14-125	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-125	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-H14-125	●	E

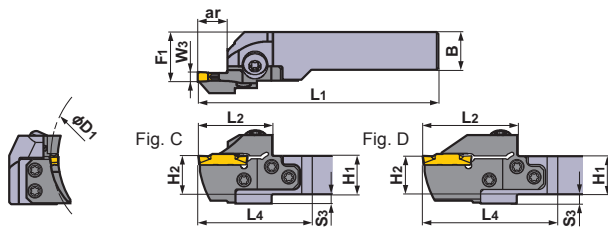
W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 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 9 to 11.

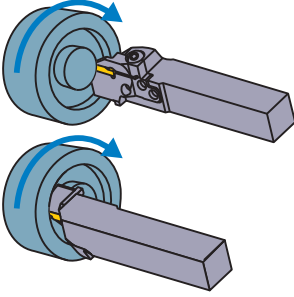
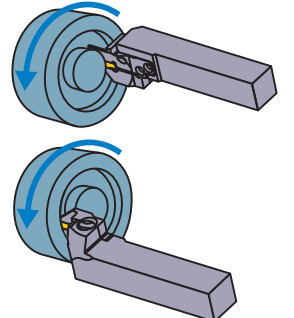


★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	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	—	
	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	—	

Select an Insert

Seat Size	Insert Number
H	GY000475/0500/0524H0000-Breaker

For Grooving/Cutting off > P9, P10				
Seat Size	Breaker	GU	GS	GM
W3				
H	4.75mm	●	●	●
	5.00mm	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
W3				
H	4.75mm			●
	Re 0.2	●		
	Re 0.4	●		
	Re 0.8	●		
	5.00mm			●
	Re 0.2	●		
	Re 0.4	●	●	●
	Re 0.8	●	●	●
	5.24mm	●		

● : Gauge insert shown dimensions

FACE
GROOVING

IDENTIFICATION > P7, P8

CUTTING CONDITIONS > P95

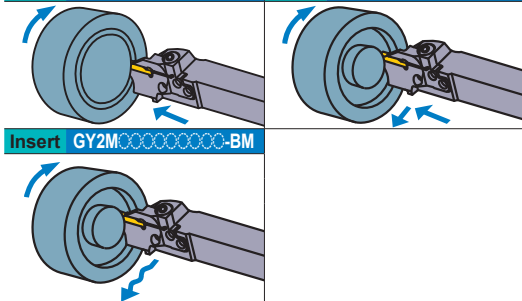
INSTRUCTION MANUAL > P97

GY SERIES (FACE GROOVING)

4

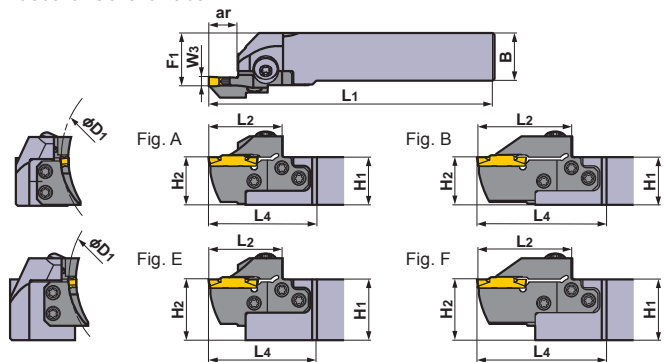
00° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	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.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
FACE GROOVING H	4.75 5.00 5.24	180	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-180	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-180	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-180	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-180	●	A
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-180	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-H14-180	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-180	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-H14-180	●	E
		250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-180	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-180	●	D
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-180	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-180	●	B
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-180	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-H25-180	●	F
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-180	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-H25-180	●	F
				14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H14-250	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H14-250	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H14-250	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H14-250	●	A
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-H14-250	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-H14-250	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H14-250	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-H14-250	●	E
				25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-H25-250	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-H25-250	●	D
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-H25-250	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-H25-250	●	B
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-H25-250	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-H25-250	●	F
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-H25-250	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-H25-250	●	F

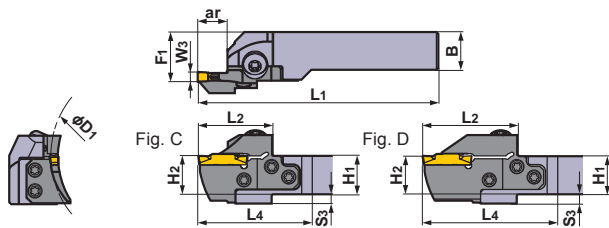
W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 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 9 to 11.



★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
	20	20	125	39	60	20	26	5	R
	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	—	L
	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	—	L
	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	—	L
	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	L
	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	—	L
	32	32	181	50	68	32	35	—	

Select an Insert

Seat Size	Insert Number
H	GY000475/0500/0524H0000-Breaker

For Grooving/Cutting off > P9, P10				
Seat Size	Breaker	GU	GS	GM
W3				
H	4.75mm	●	●	●
	5.00mm	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
W3				
H	4.75mm			●
	Re 0.2	●		
	Re 0.4	●		
	Re 0.8	●		
	5.00mm			●
	Re 0.2	●		
	Re 0.4	●	●	●
	Re 0.8	●	●	●
	5.24mm	●		

● : Gauge insert shown dimensions

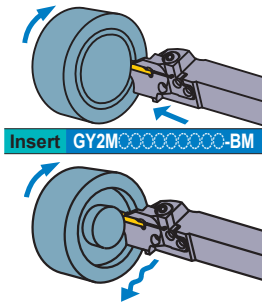
FACE
GROOVING

GY SERIES (FACE GROOVING)

4

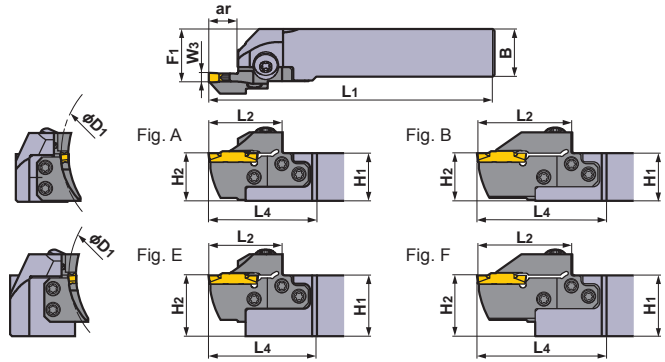
00° type holder

 Insert GY2M0000000000-GS
 Insert GY2M0000000000-GU

 Insert GY2G0000000000-MF
 Insert GY2M0000000000-MS
 Insert GY2M0000000000-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.



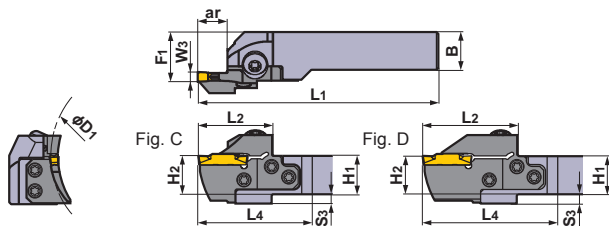
Right hand tool holder shown.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
J	6.00 6.31 6.35	50	70	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-050	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-050	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-050	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-050	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-050	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-J14-050	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-050	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-J14-050	●	E
		70	110	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-070	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-070	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-070	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-070	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-070	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-J14-070	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-070	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-J14-070	●	E
		110	200	25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-070	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-070	●	D
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-070	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-070	●	B
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J25-070	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-J25-070	●	F
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J25-070	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-J25-070	●	F
		110	200	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-110	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-110	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-110	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-110	●	A
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-110	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-J14-110	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-110	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-J14-110	●	E
		110	200	25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-110	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-110	●	D
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-110	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-110	●	B
					Modular	R	GYHR3225P00-M25R	●	GYM25RD-J25-110	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-J25-110	●	F
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J25-110	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-J25-110	●	F

W3 = Insert Width D1 = First Cut Diameter ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 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 9 to 11.



★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number	(5 pieces)	(5 pieces)	R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
R	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	—	
L	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	GY000600/0631/0635J00000-Breaker

For Grooving/Cutting off > P9				
Seat Size	Breaker W3	GU	GS	GM
J	6.00mm	●	●	●
	6.35mm	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker W3	MF	MS	MM
J	6.00mm			Ball nose
	Re 0.2	●		●
	Re 0.4	●	●	●
	Re 0.8	●	●	●
	6.31mm	●		
	6.35mm			●
	Re 0.2	●		
	Re 0.4	●		
	Re 0.8	●		

● : Gauge insert shown dimensions

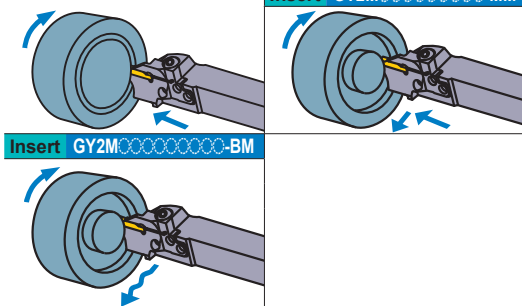
FACE GROOVING

GY SERIES (FACE GROOVING)

4

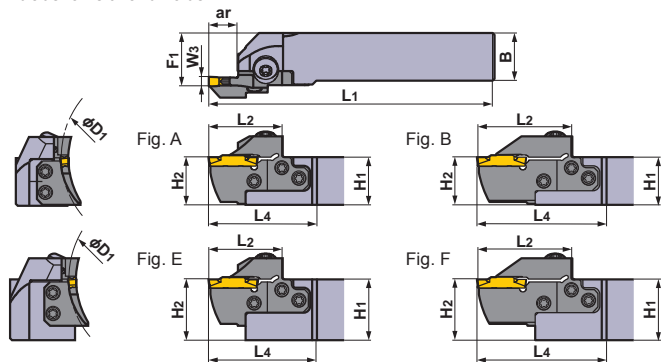
00° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
			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.



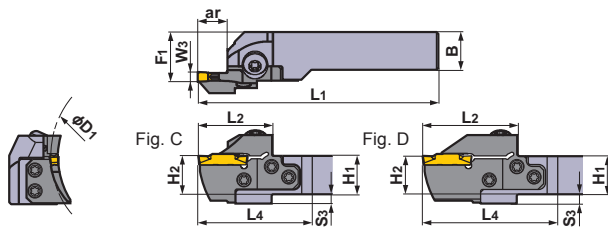
Right hand tool holder shown.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
J	6.00 6.31 6.35	170	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-170	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-170	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-170	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-170	●	A
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-170	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-J14-170	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-170	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-J14-170	●	E
		250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-170	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-170	●	D
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-170	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-170	●	B
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-J25-170	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-J25-170	●	F
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J25-170	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-J25-170	●	F
				14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-250	●	C
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J14-250	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-250	●	A
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J14-250	●	A
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-J14-250	●	E
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-J14-250	●	E
					Modular	R	GYHR3232P00-M25R	●	GYM25RD-J14-250	●	E
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-J14-250	●	E
				25 *2	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J25-250	●	D
					Modular	L	GYHL2020K00-M25L	●	GYM25LD-J25-250	●	D
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J25-250	●	B
					Modular	L	GYHL2525M00-M25L	●	GYM25LD-J25-250	●	B
				25 *2	Modular	R	GYHR3225P00-M25R	●	GYM25RD-J25-250	●	F
					Modular	L	GYHL3225P00-M25L	●	GYM25LD-J25-250	●	F
				25 *2	Modular	R	GYHR3232P00-M25R	●	GYM25RD-J25-250	●	F
					Modular	L	GYHL3232P00-M25L	●	GYM25LD-J25-250	●	F

W3 = Insert Width D1 = First Cut Diameter ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, L4, and F1 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 9 to 11.

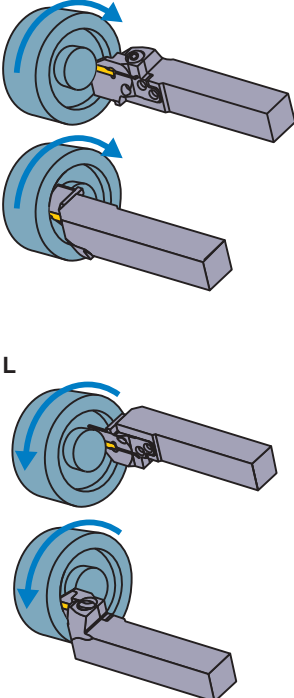


★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	
	Clamp Screw	Blade Screw	Wrench ★
GYHR/L2020K00-M25R/L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHR/L2525M00-M25R/L			
GYHR/L3225P00-M25R/L			
GYHR/L3232P00-M25R/L			

Right hand tool holder shown.

	Dimensions (mm) ★1								Cutting Mode
	H1	B	L1	L2	L4	H2	F1	S3	
R	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	—	
L	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	—	

Select an Insert

Seat Size	Insert Number
J	GY000600/0631/0635J00000-Breaker

For Grooving/Cutting off > P9				
Seat Size	Breaker	GU	GS	GM
J	W3			
	6.00mm	●	●	●
	6.35mm	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
J	W3			
	6.00mm			Ball nose
	Re 0.2	●		
	Re 0.4	●	●	
	Re 0.8	●	●	
	6.31mm	●		
	6.35mm			●
	Re 0.2	●		
	Re 0.4	●		
	Re 0.8	●		

● : Gauge insert shown dimensions

FACE
GROOVING

GY SERIES (FACE GROOVING)

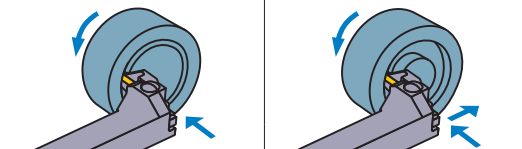
5

90° type holder

(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	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM



Insert GY2M-BM

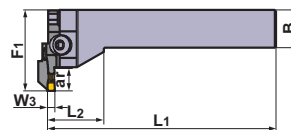
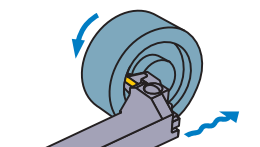


Fig. A



Right hand tool holder shown.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	40	50	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-040	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-D12-040	●	A
		50	60	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-050	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-D12-050	●	A
		60	75	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-060	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-D12-060	●	A
		75	100	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-075	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-D12-075	●	A
E	2.39 2.50 2.74	100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-100	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-D12-100	●	A
		135	200	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-135	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-D12-135	●	A
		180	250	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-D12-180	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-D12-180	●	A
		40	50	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-040	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-E12-040	●	A
		50	60	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-050	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-E12-050	●	A
		60	75	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-060	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-E12-060	●	A
		75	100	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-075	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-E12-075	●	A
		100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-100	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-E12-100	●	A
		135	200	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-135	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-E12-135	●	A
		180	250	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-E12-180	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-E12-180	●	A

W3 = Insert Width

D1 = First Cut Diameter

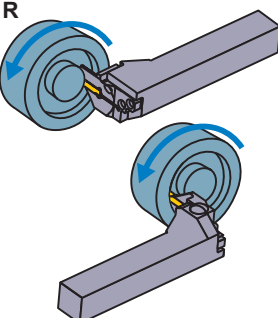
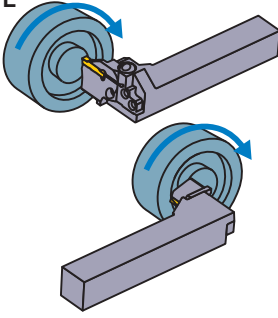
ar = Max. Groove Depth

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, and F1 values may vary.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR2525M90-M25L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★1						Cutting Mode
	H1	B	L1	L2	H2	F1	
	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	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	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	53	
	25	25	150	38	25	53	

Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker W ₃	GU	GS	GM	GFGS
		●	●	●	●
D	2.00mm	●	●	●	●
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker W ₃	MF	MS	MM	BM
		●	●	●	●
D	2.00mm	●	●	●	●
	2.24mm	●	●	●	●
E	2.39mm	●	●	●	●
	2.50mm	●	●	●	●
	2.74mm	●	●	●	●

● : Gauge insert shown dimensions

FACE
GROOVING

GY SERIES (FACE GROOVING)

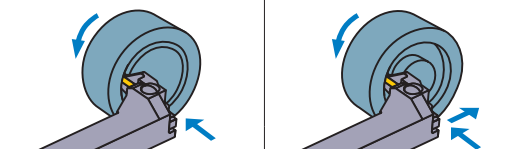
5

90° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	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.



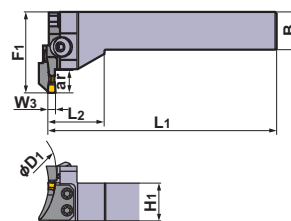
Insert GY2M-BM



Fig. A



Fig. B



Right hand tool holder shown.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	35	40	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-035	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-035	●	A
		40	50	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-040	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-040	●	A
		50	60	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-050	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-050	●	A
		60	75	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-060	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-060	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-060	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-060	●	B
		75	100	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-075	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-075	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-075	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-075	●	B
		100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-100	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-100	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-100	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-100	●	B
		135	200	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-135	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-135	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-135	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-135	●	B
		180	250	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-180	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-180	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-180	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-180	●	B
		225	999	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-225	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-225	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-225	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-225	●	B

W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

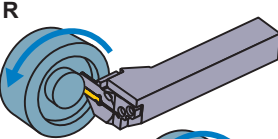
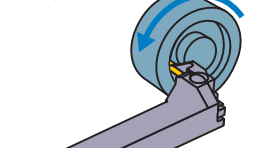
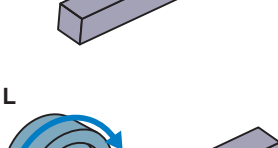
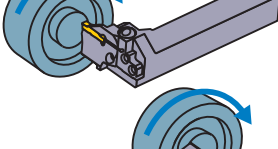
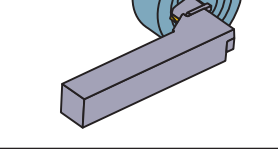
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, and F1 values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR2525M90-M25L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★1						Cutting Mode
	H1	B	L1	L2	H2	F1	
	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	53	
	25	25	150	38	25	53	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	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	59	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	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	59	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	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	59	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	59	

Select an Insert

Seat Size	Insert Number
F	GY000300/0318/0324F0000-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
F	W3				
	3.00mm	●	●	●	●
	3.18mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
F	W3				Ball nose
	3.00mm	●	●	●	●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8			●	
	3.18mm				●
	Re 0.2	●			
	Re 0.4	●			
	3.24mm	●			

● : Gauge insert shown dimensions

FACE
GROOVING

GY SERIES (FACE GROOVING)

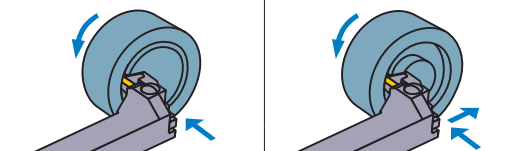
5

90° type holder

(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	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM



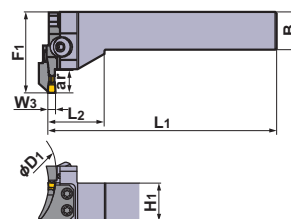
Insert GY2M-BM



Fig. A



Fig. B



Right hand tool holder shown.

Seat Size	W ₃ (mm)	D ₁ (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
G	4.00 4.24	40	50	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-040	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-040	●	A
		50	60	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-050	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-050	●	A
		60	85	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-060	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-060	●	A
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-060	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-G25-060	●	B
		85	125	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-085	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-085	●	A
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-085	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-G25-085	●	B
		125	200	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-125	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-125	●	A
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-125	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-G25-125	●	B
		180	280	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-180	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-180	●	A
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-180	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-G25-180	●	B
		250	999	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G14-250	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-G14-250	●	A
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-G25-250	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-G25-250	●	B

W₃ = Insert Width

D₁ = First Cut Diameter

ar = Max. Groove Depth

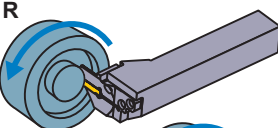
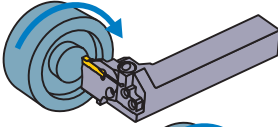
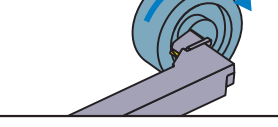
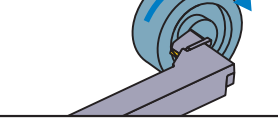
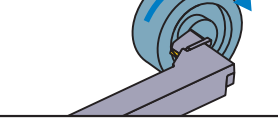
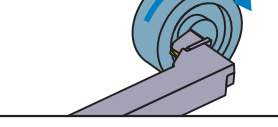
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L₁, L₂, and F₁ values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR2525M90-M25L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★1						Cutting Mode
	H1	B	L1	L2	H2	F1	
	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	64	
	25	25	150	38	25	64	
	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	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	64	
	25	25	150	38	25	64	
	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	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	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	64	

Select an Insert

Seat Size	Insert Number
G	GY0000400/0424G0000-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
W3					
G	4.00mm	●	●	●	●

For Multifunctional Grooving				> P10, P11	
Seat Size	Breaker	MF	MS	MM	BM
	W3				Ball nose
G	4.00mm				●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8	●		●	
	4.24mm	●			

● : Gauge insert shown dimensions

FACE
GROOVING

GY SERIES (FACE GROOVING)

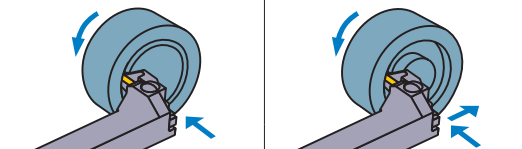
5

90° type holder

(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	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM



Insert GY2M-BM

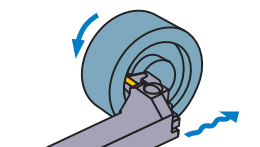
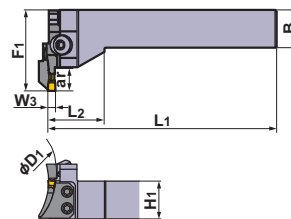


Fig. A



Fig. B



Right hand tool holder shown.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	50	60	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-050	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-H14-050	●	A
		60	85	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-060	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-H14-060	●	A
		85	125	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-060	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-H25-060	●	B
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-085	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-H14-085	●	A
		125	200	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-085	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-H25-085	●	B
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-125	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-H14-125	●	A
		180	280	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-125	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-H25-125	●	B
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-180	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-H14-180	●	A
		250	999	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-180	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-H25-180	●	B
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H14-250	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-H14-250	●	A
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-H25-250	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-H25-250	●	B

W3 = Insert Width

D1 = First Cut Diameter

ar = Max. Groove Depth

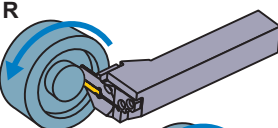
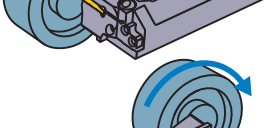
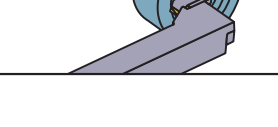
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, and F1 values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR2525M90-M25L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★1						Cutting Mode
	H1	B	L1	L2	H2	F1	
	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	

Select an Insert

Seat Size	Insert Number
H	GY000475/0500/0524H0000-Breaker

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
W3					
H	4.75mm	●	●	●	●
	5.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
W3					Ball nose
H	4.75mm				●
	Re 0.2	●			
	Re 0.4	●			
	Re 0.8	●			
	5.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
	5.24mm	●			

● : Gauge insert shown dimensions

FACE
GROOVING

GY SERIES (FACE GROOVING)

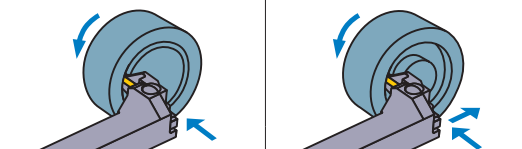
5

90° type holder

(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	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM



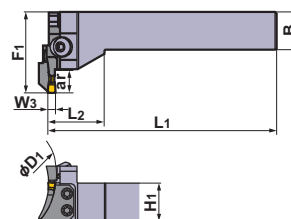
Insert GY2M-BM



Fig. A



Fig. B



Right hand tool holder shown.

Seat Size	W3 (mm)	D1 (mm)		ar (mm)	Type	Hand (R/L)	Order Number				Fig.
		min	max				Holder	Stock	Modular Blade	Stock	
J	6.00 6.31 6.35	50	70	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-050	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-J14-050	●	A
		70	110	14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-070	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-J14-070	●	A
		110	200	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-070	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-J25-070	●	B
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-110	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-J14-110	●	A
		170	280	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-110	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-J25-110	●	B
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-170	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-J14-170	●	A
		250	999	25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-170	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-J25-170	●	B
				14	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J14-250	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-J14-250	●	A
				25 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-J25-250	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-J25-250	●	B

W3 = Insert Width D1 = First Cut Diameter ar = Max. Groove Depth

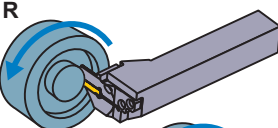
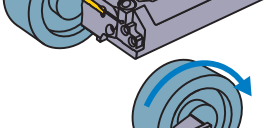
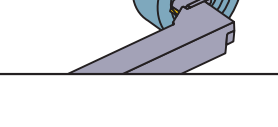
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then L1, L2, and F1 values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number		 (5 pieces)	 R D
	Clamp Screw	Blade Screw	Wrench ★
GYHR2525M90-M25L	GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYHL2525M90-M25R			

	Dimensions (mm) ★1						Cutting Mode
	H1	B	L1	L2	H2	F1	
	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	

Select an Insert

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

For Grooving/Cutting off					> P9
Seat Size	Breaker	GU	GS	GM	GFGS
	W3				
J	6.00mm	●	●	●	
	6.35mm	●	●	●	

For Multifunctional Grooving					> P10, P11
Seat Size	Breaker	MF	MS	MM	BM
	W ₃				Ball nose
J	6.00mm				●
	Re 0.2	●			
	Re 0.4	●	●	●	
	Re 0.8	●	●	●	
	6.31mm	●			
	6.35mm				●
	Re 0.2	●			
	Re 0.4	●			
	Re 0.8	●			

● : Gauge insert shown dimensions

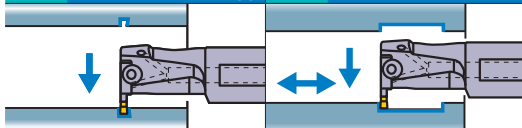
FACE
GROOVING

GY SERIES (INTERNAL GROOVING)

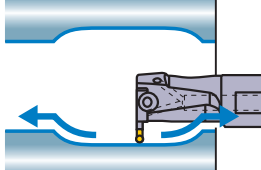
6

90° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM



Insert GY2M-BM



(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)



Fig. A

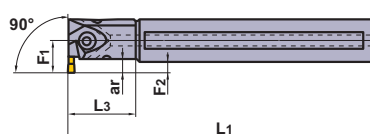
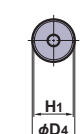


Fig. B



Right hand tool holder shown.

Seat Size	W3 (mm)	ar (mm) *3	D1 (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	●	—	—	B
				Mono Block	L	GYAL20K90A-D06	●	—	—	B
			32	Mono Block	R	GYAR20Q90A-D06	●	—	—	A
				Mono Block	L	GYAL20Q90A-D06	●	—	—	A
		4—9.5 *1	40	Mono Block	R	GYAR25K90B-D06	●	—	—	B
				Mono Block	L	GYAL25K90B-D06	●	—	—	B
				Mono Block	R	GYAR25R90B-D06	●	—	—	A
				Mono Block	L	GYAL25R90B-D06	●	—	—	A
		5.5—9.5 *1	50	Modular	R	GYDR32L90C-M20L	●	GYM20LA-D10	●	D
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-D10	●	D
				Modular	R	GYDR32S90C-M20L	●	GYM20LA-D10	●	C
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-D10	●	C
		7—11.5 *1	60	Modular	R	GYDR40M90D-M20L	●	GYM20LA-D10	●	D
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-D10	●	D
				Modular	R	GYDR40T90D-M20L	●	GYM20LA-D10	●	C
				Modular	L	GYDL40T90D-M20R	●	GYM20RA-D10	●	C
			70	Modular	R	GYDR40M90D-M25L	●	GYM25LA-D12	●	D
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-D12	●	D
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-D12	●	C
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-D12	●	C

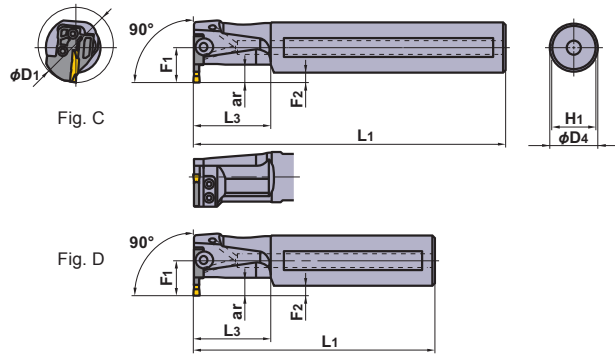
W3 = Insert Width ar = Max. Groove Depth D1 = Min. Cutting Diameter

*1 The maximum groove depth varies according to the cutting diameter D1. For details, please refer to page 101.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L3, F1 and F2 values may vary.

*3 The maximum groove depth (ar) is a value within the dimension L3.

●Modular blade type (Air / coolant through)



Right hand tool holder shown.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	R Wrench D
GYAR/L20○90A-○06	①GY05016S (Clamp Torque : 5.0N·m)	—	TKY20R
GYAR/L25○90B-○06	②GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY15D
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYDR/L40○90D-M20L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYDR/L40○90D-M25L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D
GYDR/L50○90F-M25L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D

	Dimensions (mm) ★2						Cutting Mode
	D4	L1	L3	F1	F2	H1	
	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	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	30	R
	32	140	50	22	6	30	
	32	250	50	22	6	30	
	32	250	50	22	6	30	
	40	150	60	28	8	37	L
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	40	150	60	28	8	37	L
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	50	170	80	34	9	47	L
	50	170	80	34	9	47	
	50	300	80	34	9	47	
	50	300	80	34	9	47	

Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
W3					
D	2.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11				
Seat Size	Breaker	MF	MS	MM
W3				
D	2.00mm	●	●	●
	2.24mm	●	●	●

● : Gauge insert shown dimensions

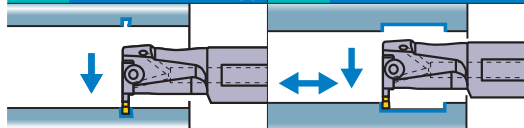
INTERNAL GROOVING

GY SERIES (INTERNAL GROOVING)

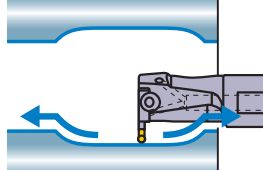
6

90° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM



Insert GY2M-BM



(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)



Fig. A

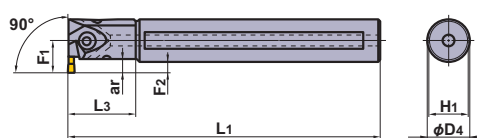


Fig. B

Right hand tool holder shown.

Seat Size	W3 (mm)	ar (mm) *3	D1 (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	●	—	—	B
				Mono Block	L	GYAL20K90A-E06	●	—	—	B
			32	Mono Block	R	GYAR20Q90A-E06	●	—	—	A
				Mono Block	L	GYAL20Q90A-E06	●	—	—	A
				Mono Block	R	GYAR25K90B-E06	●	—	—	B
				Mono Block	L	GYAL25K90B-E06	●	—	—	B
			40	Mono Block	R	GYAR25R90B-E06	●	—	—	A
				Mono Block	L	GYAL25R90B-E06	●	—	—	A
		4—9.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-E10	●	D
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-E10	●	D
			50	Modular	R	GYDR32S90C-M20L	●	GYM20LA-E10	●	C
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-E10	●	C
		5.5—9.5 *1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-E10	●	D
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-E10	●	D
				Modular	R	GYDR40T90D-M20L	●	GYM20LA-E10	●	C
				Modular	L	GYDL40T90D-M20R	●	GYM20RA-E10	●	C
			60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-E12	●	D
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-E12	●	D
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-E12	●	C
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-E12	●	C
		7—11.5 *1	70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-E12	●	D
				Modular	L	GYDL50P90F-M25R	●	GYM25RA-E12	●	D
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-E12	●	C
				Modular	L	GYDL50T90F-M25R	●	GYM25RA-E12	●	C

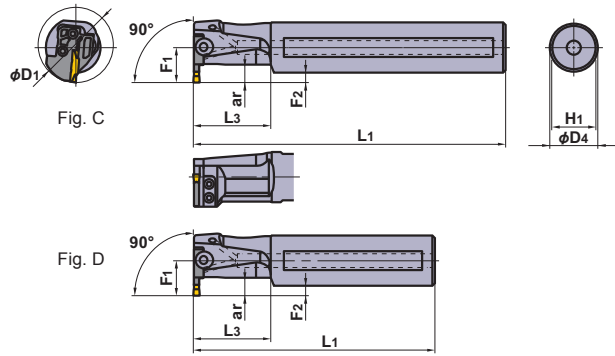
W3 = Insert Width ar = Max. Groove Depth D1 = Min. Cutting Diameter

*1 The maximum groove depth varies according to the cutting diameter D1. For details, please refer to page 101.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L3, F1 and F2 values may vary.

*3 The maximum groove depth (ar) is a value within the dimension L3.

●Modular blade type (Air / coolant through)



Right hand tool holder shown.

	Dimensions (mm) *2						Cutting Mode
	D4	L1	L3	F1	F2	H1	
	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	6.5	23	L
	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	30	L
	32	140	50	22	6	30	
	32	250	50	22	6	30	
	32	250	50	22	6	30	
	40	150	60	28	8	37	L
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	40	150	60	28	8	37	L
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	50	170	80	34	9	47	L
	50	170	80	34	9	47	
	50	300	80	34	9	47	
	50	300	80	34	9	47	

* Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number	①	②	4 pcs.	R	D
	Clamp Screw	Blade Screw	Wrench *		
GYAR/L20○90A-○06	①GY05016S (Clamp Torque : 5.0N·m)	—	TKY20R		
GYAR/L25○90B-○06	②GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY15D		
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D		
GYDR/L40○90D-M20L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D		
GYDR/L40○90D-M25L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D		
GYDR/L50○90F-M25L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D		

Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
E	W3	●	●	●	●
	2.39mm	●	●	●	●
	2.50mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
E	W3	●	●	●	●
	2.39mm	●	●	●	●
	2.50mm	●	●	●	●
	2.74mm	●	●	●	●

● : Gauge insert shown dimensions

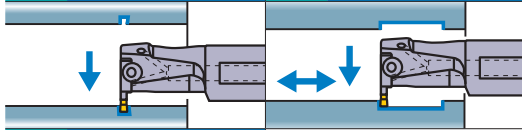
INTERNAL GROOVING

GY SERIES (INTERNAL GROOVING)

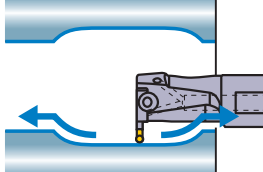
6

90° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM



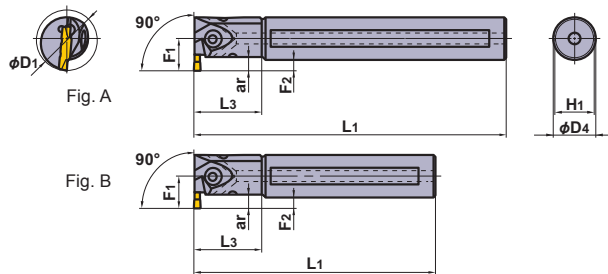
Insert GY2M-BM



(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.

Seat Size	W3 (mm)	ar (mm) *3	D1 (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	●	—	—	B
				Mono Block	L	GYAL20K90A-F06	●	—	—	B
			32	Mono Block	R	GYAR20Q90A-F06	●	—	—	A
				Mono Block	L	GYAL20Q90A-F06	●	—	—	A
		4—9.5 *1	40	Mono Block	R	GYAR25K90B-F06	●	—	—	B
				Mono Block	L	GYAL25K90B-F06	●	—	—	B
			50	Mono Block	R	GYAR25R90B-F06	●	—	—	A
				Mono Block	L	GYAL25R90B-F06	●	—	—	A
		5.5—9.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-F10	●	D
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-F10	●	D
			50	Modular	R	GYDR32S90C-M20L	●	GYM20LA-F10	●	C
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-F10	●	C
		7—11.5 *1	60	Modular	R	GYDR40M90D-M20L	●	GYM20LA-F10	●	D
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-F10	●	D
			70	Modular	R	GYDR40T90D-M20L	●	GYM20LA-F10	●	C
				Modular	L	GYDL40T90D-M20R	●	GYM20RA-F10	●	C
G	4.00 4.24	7	32	Mono Block	R	GYAR25K90B-G07	●	—	—	B
				Mono Block	L	GYAL25K90B-G07	●	—	—	B
			40	Mono Block	R	GYAR25R90B-G07	●	—	—	A
				Mono Block	L	GYAL25R90B-G07	●	—	—	A
		4.5—11.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-G12	●	D
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-G12	●	D
			50	Modular	R	GYDR32S90C-M20L	●	GYM20LA-G12	●	C
				Modular	L	GYDL32S90C-M20R	●	GYM20RA-G12	●	C
		6—11.5 *1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-G12	●	D
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-G12	●	D
			60	Modular	R	GYDR40T90D-M20L	●	GYM20LA-G12	●	C
				Modular	L	GYDL40T90D-M20R	●	GYM20RA-G12	●	C
		7.5—13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-G14	●	D
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-G14	●	D
			70	Modular	R	GYDR40T90D-M25L	●	GYM25LA-G14	●	C
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-G14	●	C

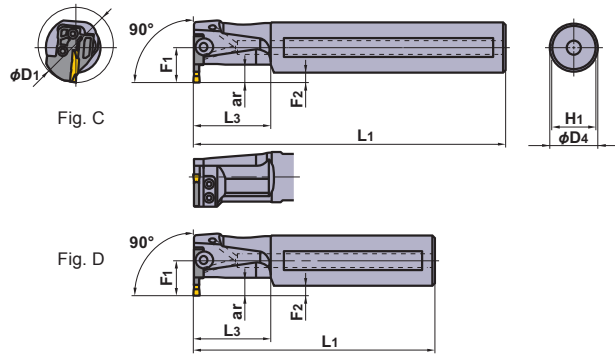
W3 = Insert Width ar = Max. Groove Depth D1 = Min. Cutting Diameter

*1 The maximum groove depth varies according to the cutting diameter D1. For details, please refer to page 101.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L3, F1 and F2 values may vary.

*3 The maximum groove depth (ar) is a value within the dimension L3.

●Modular blade type (Air / coolant through)



Right hand tool holder shown.

★ Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number	①	②	4 pcs.	R	D
	Clamp Screw	Blade Screw		Wrench	*
GYAR/L20○90A-F06	①GY05016S (Clamp Torque : 5.0N·m)	—		TKY20R	
GYAR/L25○90B-○○○					
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)		TKY30R TKY15D	
GYDR/L40○90D-M20L/R					
GYDR/L40○90D-M25L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)		TKY30R TKY25D	
GYDR/L50○90F-M25L/R					

	Dimensions (mm) ★2						Cutting Mode
	D4	L1	L3	F1	F2	H1	
	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	6.5	23	
	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	30	
	32	140	50	22	6	30	
	32	250	50	22	6	30	L
	32	250	50	22	6	30	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	50	170	80	34	9	47	L
	50	170	80	34	9	47	
	50	300	80	34	9	47	
	50	300	80	34	9	47	
	25	125	40	19	6.5	23	
	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	30	
	32	140	50	22	6	30	
	32	250	50	22	6	30	L
	32	250	50	22	6	30	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	50	170	80	34	9	47	L
	50	170	80	34	9	47	
	50	300	80	34	9	47	
	50	300	80	34	9	47	

Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
W3					
F	3.00mm	●	●	●	●
	3.18mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
W3					Ball nose
F	3.00mm	●	●	●	●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8			●	
	3.18mm				●
	Re 0.2	●			
	Re 0.4	●			
	3.24mm	●			

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
W3					
G	4.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
W3					Ball nose
G	4.00mm	●	●	●	●
	Re 0.2	●	●	●	
	Re 0.4	●	●	●	
	Re 0.8	●		●	
	4.24mm	●			

● : Gauge insert shown dimensions

IDENTIFICATION > P7, P8

CUTTING CONDITIONS > P101

INSTRUCTION MANUAL > P103

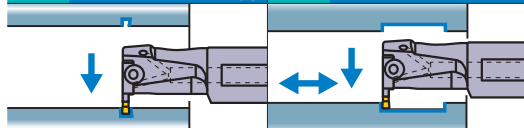
INTERNAL GROOVING

GY SERIES (INTERNAL GROOVING)

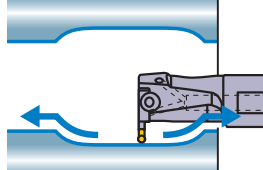
6

90° type holder

Insert	GY2M	GS	Insert	GY2G	MF
Insert	GY2M	GU	Insert	GY2M	MS
Insert	GY1G	GS	Insert	GY2M	MM



Insert GY2M-BM



(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)



Fig. A

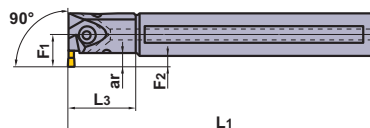
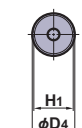


Fig. B



Right hand tool holder shown.

Seat Size	W3 (mm)	ar (mm) *3	D1 (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	●	—	—	B
					L	GYAL25K90B-H07	●	—	—	B
				Mono Block	R	GYAR25R90B-H07	●	—	—	A
					L	GYAL25R90B-H07	●	—	—	A
		4.5—11.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-H12	●	D
					L	GYDL32L90C-M20R	●	GYM20RA-H12	●	D
				Modular	R	GYDR32S90C-M20L	●	GYM20LA-H12	●	C
					L	GYDL32S90C-M20R	●	GYM20RA-H12	●	C
		6—11.5 *1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-H12	●	D
					L	GYDL40M90D-M20R	●	GYM20RA-H12	●	D
				Modular	R	GYDR40T90D-M20L	●	GYM20LA-H12	●	C
					L	GYDL40T90D-M20R	●	GYM20RA-H12	●	C
		7.5—13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-H14	●	D
					L	GYDL40M90D-M25R	●	GYM25RA-H14	●	D
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-H14	●	C
					L	GYDL40T90D-M25R	●	GYM25RA-H14	●	C
			70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-H14	●	D
					L	GYDL50P90F-M25R	●	GYM25RA-H14	●	D
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-H14	●	C
					L	GYDL50T90F-M25R	●	GYM25RA-H14	●	C
J	6.00 6.31 6.35	7.5—13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-J14	●	D
					L	GYDL40M90D-M25R	●	GYM25RA-J14	●	D
				Modular	R	GYDR40T90D-M25L	●	GYM25LA-J14	●	C
					L	GYDL40T90D-M25R	●	GYM25RA-J14	●	C
			70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-J14	●	D
					L	GYDL50P90F-M25R	●	GYM25RA-J14	●	D
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-J14	●	C
					L	GYDL50T90F-M25R	●	GYM25RA-J14	●	C

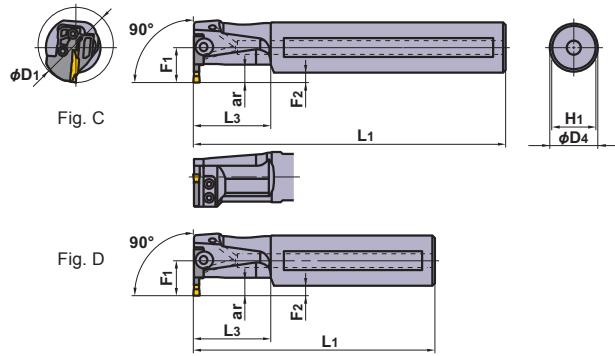
W3 = Insert Width ar = Max. Groove Depth D1 = Min. Cutting Diameter

*1 The maximum groove depth varies according to the cutting diameter D1. For details, please refer to page 101.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then L1, L3, F1 and F2 values may vary.

*3 The maximum groove depth (ar) is a value within the dimension L3.

●Modular blade type (Air / coolant through)



Right hand tool holder shown.

	Dimensions (mm) *2						Cutting Mode
	D4	L1	L3	F1	F2	H1	
R	25	125	40	19	6.5	23	
	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	30	
	32	140	50	22	6	30	
	32	250	50	22	6	30	
	32	250	50	22	6	30	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
L	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	
	50	170	80	34	9	47	
	50	170	80	34	9	47	
	50	300	80	34	9	47	
	50	300	80	34	9	47	
	40	150	60	28	8	37	
	40	150	60	28	8	37	
	40	300	60	28	8	37	
	40	300	60	28	8	37	

* Wrench : R : Clamp Screw, D : Blade Screw

SPARE PARTS

Holder Number	①	②	③	④
	Clamp Screw	Blade Screw	Wrench *	
GYAR/L25○90B-○07	①GY05016S (Clamp Torque : 5.0N·m)	—	TKY20R	
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS407 (Clamp Torque : 3.5N·m)	TKY30R TKY15D	
GYDR/L40○90D-M20L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D	
GYDR/L40○90D-M25L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D	
GYDR/L50○90F-M25L/R	②GY06013M (Clamp Torque : 6.0N·m)	TS55 (Clamp Torque : 5.0N·m)	TKY30R TKY25D	

Select an Insert

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
W3					
H	4.75mm	●	●	●	●
	5.00mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
W3					Ball nose
H	4.75mm	●	●	●	●
	Re 0.2	●	●	●	●
	Re 0.4	●	●	●	●
	Re 0.8	●	●	●	●
	5.00mm	●	●	●	●
	Re 0.2	●	●	●	●
	Re 0.4	●	●	●	●
	Re 0.8	●	●	●	●
	5.24mm	●	●	●	●

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

For Grooving/Cutting off > P9, P10					
Seat Size	Breaker	GU	GS	GM	GFGS
W3					
J	6.00mm	●	●	●	●
	6.35mm	●	●	●	●

For Multifunctional Grooving > P10, P11					
Seat Size	Breaker	MF	MS	MM	BM
W3					Ball nose
J	6.00mm	●	●	●	●
	Re 0.2	●	●	●	●
	Re 0.4	●	●	●	●
	Re 0.8	●	●	●	●
	6.31mm	●	●	●	●
	6.35mm	●	●	●	●
	Re 0.2	●	●	●	●
	Re 0.4	●	●	●	●
	Re 0.8	●	●	●	●

● : Gauge insert shown dimensions

IDENTIFICATION > P7, P8
CUTTING CONDITIONS > P101
INSTRUCTION MANUAL > P103

INTERNAL GROOVING

Grooving system

RECOMMENDED CUTTING SPEED (m/min) [For External Grooving]

	Work Material	Hardness	Grade	Cutting Speed (m/min)					
				50	100	150	200	250	300
P	Mild Steel	≤160HB	VP20RT		100	220			
			VP10RT		110	230			
			NX2525		90	210			
	Carbon Steel Alloy Steel	160–280HB	VP20RT		80	180			
			VP10RT		90	190			
			MY5015		110	250			
		280HB≤	NX2525		70	170			
			VP20RT	60	140				
			VP10RT	70	150				
M	Stainless Steel	≤270HB	VP20RT	60	140				
			VP10RT	70	150				
			MY5015						
	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT		80	180			
			VP10RT		90	190			
			MY5015			140	300		
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	60	140				
			VP10RT	70	150				
			MY5015		90	210			
S	Heat Resistant Alloy Titanium Alloy	—	VP20RT	30	60				
			VP10RT	40	70				
			RT9010	40	70				
H	Hardened steel	50HRC≤	MB8025		80	120			

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.

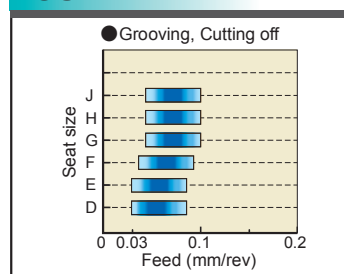
(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For External Grooving]

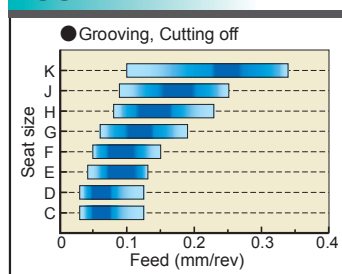
*Below are the recommended cutting conditions when using the modular type holder GYHR/L2525M00/90-M25R/L with the modular blade GYM25R/LA-○○○.

Recommended feed rate and depth of cut

GU BREAKER

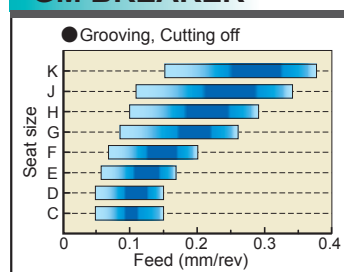


GS BREAKER

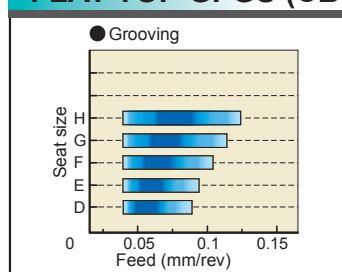


1st recommended area

GM BREAKER

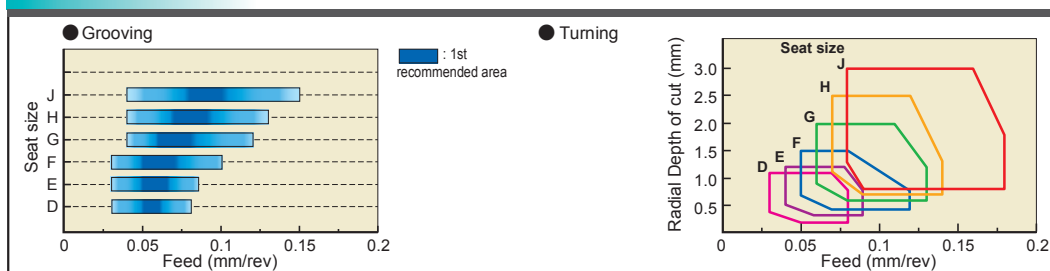


FLAT TOP GFGS (CBN)



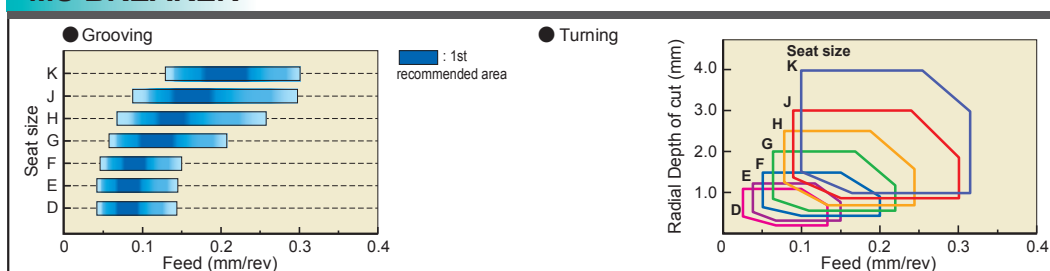
Seat Size	
Insert Width (mm)	
C	1.50
D	2.00
E	2.24
F	2.39
G	2.50
H	2.74
I	3.00
J	3.18
K	3.24
L	4.00
M	4.24
N	4.75
O	5.00
P	5.24
Q	6.00
R	6.31
S	6.35
T	8.00

MF BREAKER

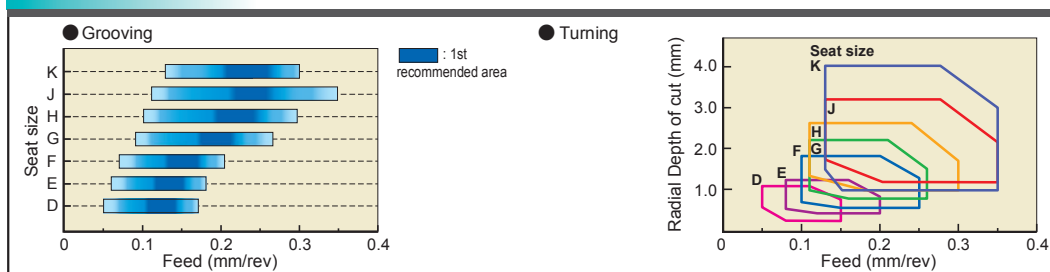


Seat Size	
Insert Width (mm)	
D	2.00 2.24
E	2.39 2.50 2.74
F	3.00 3.18 3.24
G	4.00 4.24
H	4.75 5.00 5.24
J	6.00 6.31 6.35
K	8.00

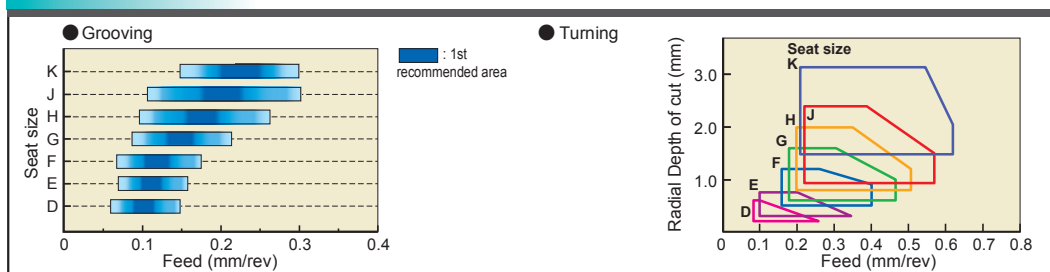
MS BREAKER



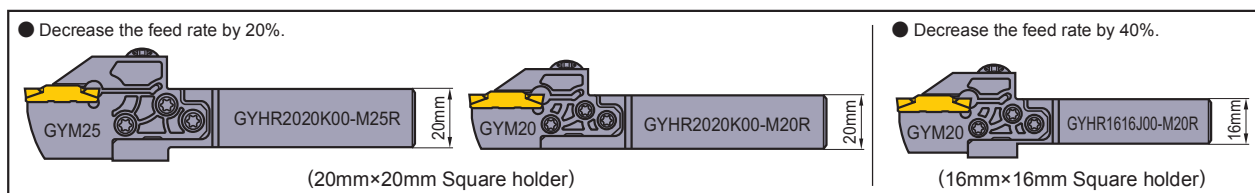
MM BREAKER



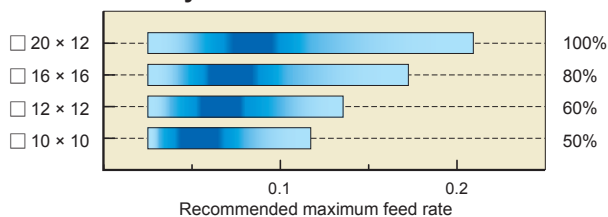
BM BREAKER



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



For Swiss style lathes mono block holder



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

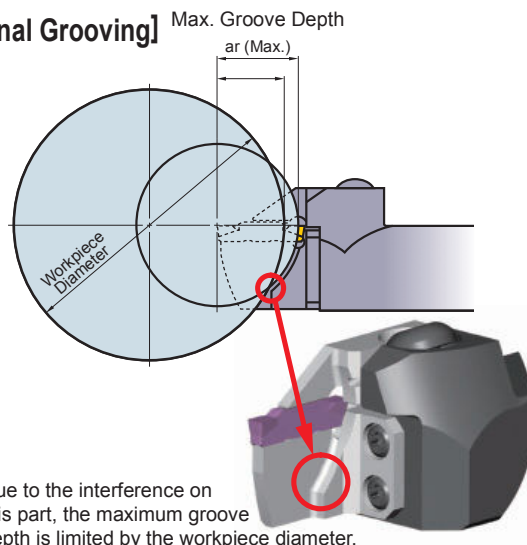
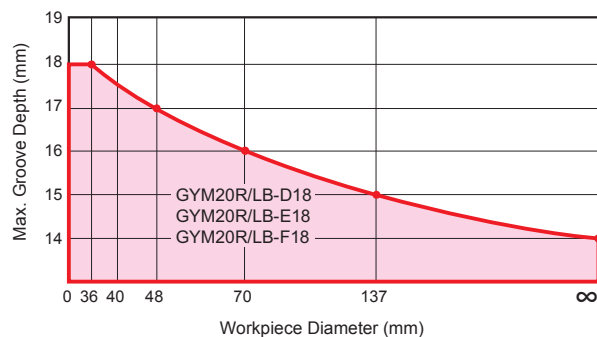
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

•When using the modular blade GYM○○○R/LA-○○○

The maximum groove depth is not limited by the workpiece diameter.

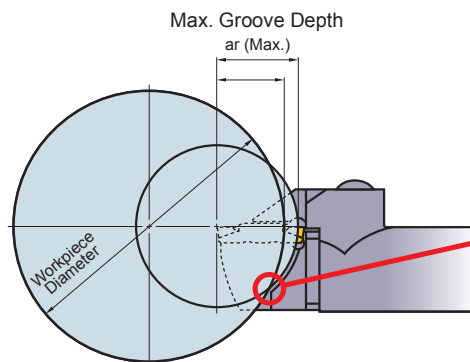
•When using the modular blade GYM○○○R/LB-○○○

The maximum groove depth is limited by the workpiece diameter.

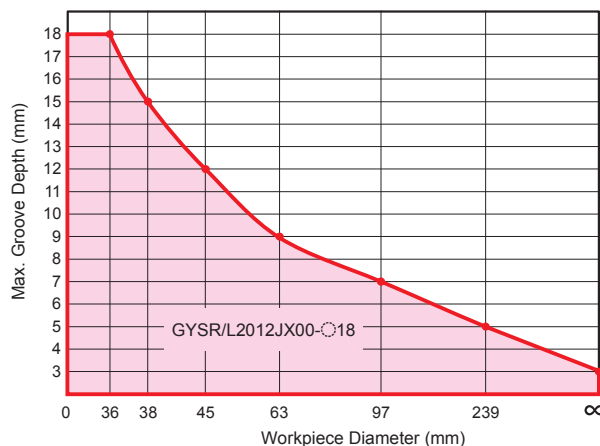
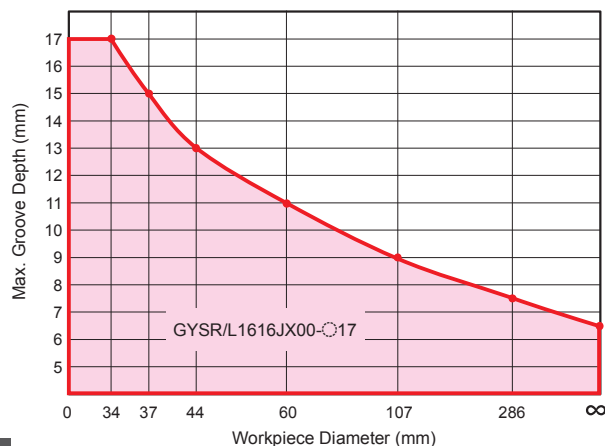
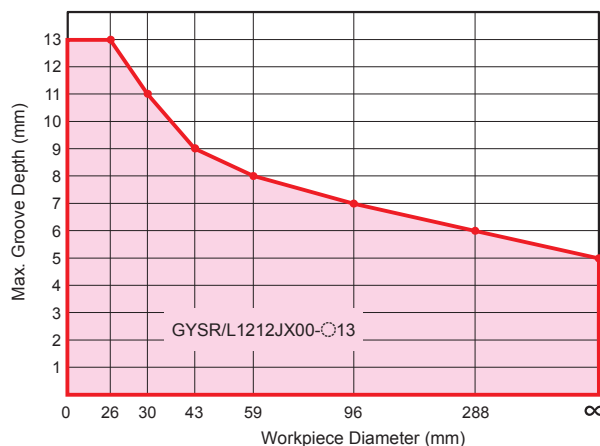
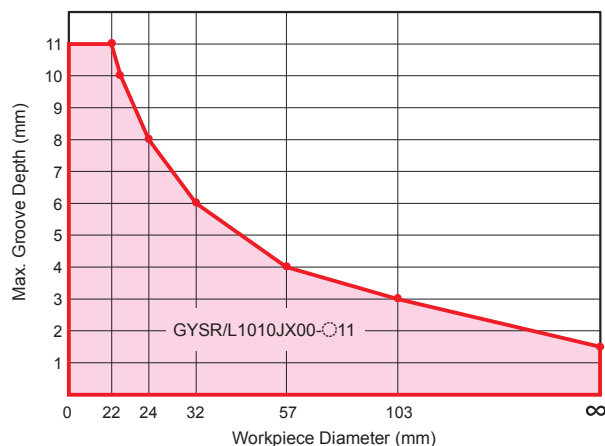


•For Swiss style lathes mono block holder

The maximum groove depth is limited by the workpiece diameter.



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



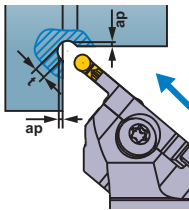
RECOMMENDED CUTTING SPEED (m/min) [For External Recessing]

	Work Material	Hardness	Grade	Cutting Speed (m/min)				
				50	100	150	200	250
P	Mild Steel	≤180HB	VP20RT		80	180		
			VP10RT		90	190		
	Carbon Steel Alloy Steel	180–280HB	VP20RT	60	140			
			VP10RT	70	150			
			MY5015		90	210		
	Carbon Steel Alloy Steel	280–350HB	NX2525	55	135			
			VP20RT	50	110			
			VP10RT	60	120			
			MY5015		80	160		
			NX2525	45	105			
M	Stainless Steel	≤350HB	VP20RT	50	110			
			VP10RT	60	120			
K	Gray Cast Iron	Tensile Strength ≤350MPa	VP20RT	60	140			
			VP10RT	70	150			
			MY5015		90	210		
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	50	110			
			VP10RT	60	120			
			MY5015		80	160		
S	Titanium Alloy	—	VP20RT	30	60			
			VP10RT	40	70			
	Heat Resistant Alloy	—	VP20RT	30	60			
			VP10RT	40	70			

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.

(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

DISTANCE FROM THE WORKPIECE TO THE RECESS DEPTH

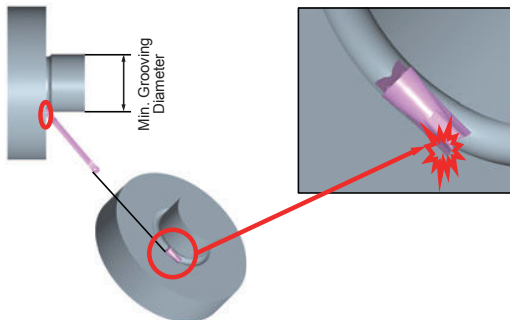


Grooving Width W (mm)	Recessing Depth t (mm)	Distance workpiece to the recess depth ap (mm)
2.00	1.50	0.646
2.50	1.75	0.720
3.00	2.00	0.793
3.18	2.09	0.819
4.00	2.50	0.939
4.75	2.88	1.049
5.00	3.00	1.086
6.00	3.50	1.232
6.35	3.68	1.283

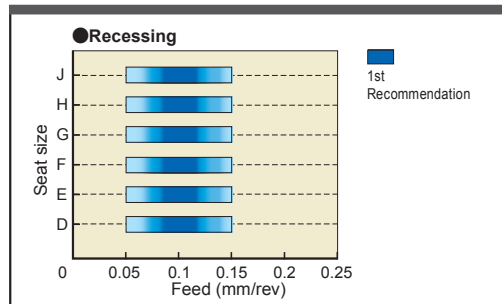
BM BREAKER

Minimum grooving diameter

Ensure the tool is suitable for the diameter being machined. Refer to the Min. Grooving Diameter D1 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

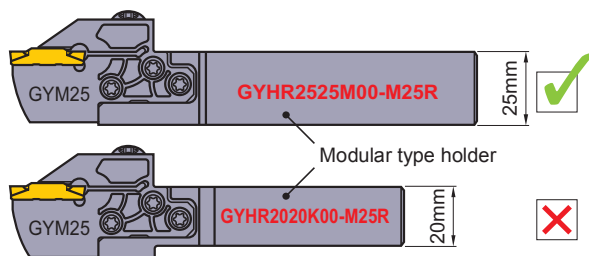


Grooving system

TOOL SELECTION

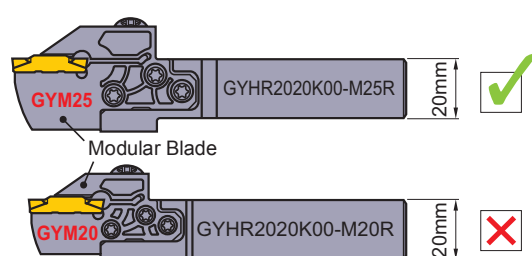
Notes when selecting the tool body

Modular type holder



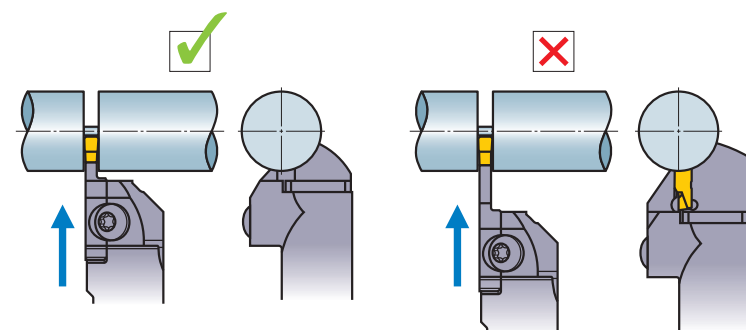
- To ensure sufficient clamping rigidity, select a modular type holder with the largest possible shank size.

Modular blade (1)



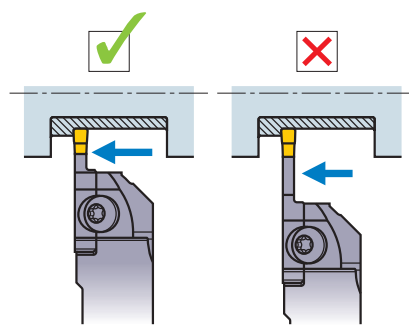
- If there is no restriction for use, select the largest modular blade for the same shank size.

Modular blade (2)



- Select the shortest possible blade suitable for the application.

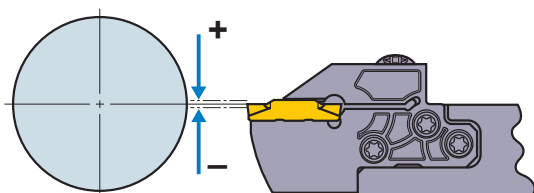
Modular blade (3)



- Select the shortest possible blade suitable for the application.

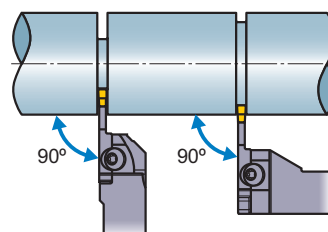
Notes when setting the tool

Setting of cutting edge height



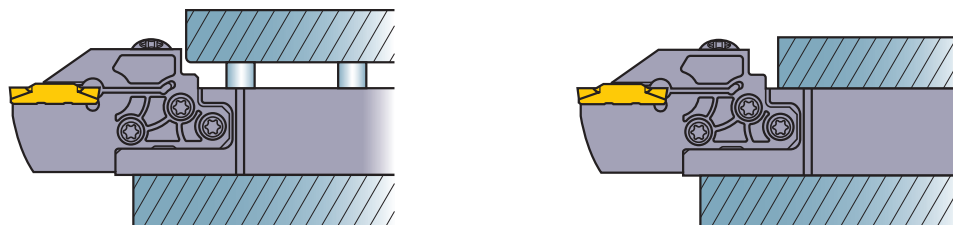
- <Grooving/Cross-feed machining>
Set the cutting edge height to $\pm 0.1\text{mm}$ parallel to the central axis.
- <Cutting off>
Set the cutting edge height to $0-+0.2\text{mm}$ parallel to the central axis.

Tool body setting angle



- Set the insert perpendicular to the central axis.

Overhang

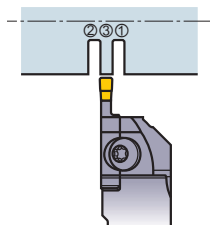


- When setting the tool, ensure that the overhang is as short as possible and avoid the step difference part as above figure shows.

MACHINING RECOMMENDATIONS

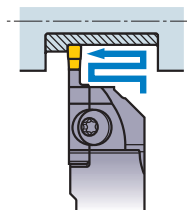
● Notes on multi-functional machining (MF, MS, MM and BM breakers)

Machining narrow grooves



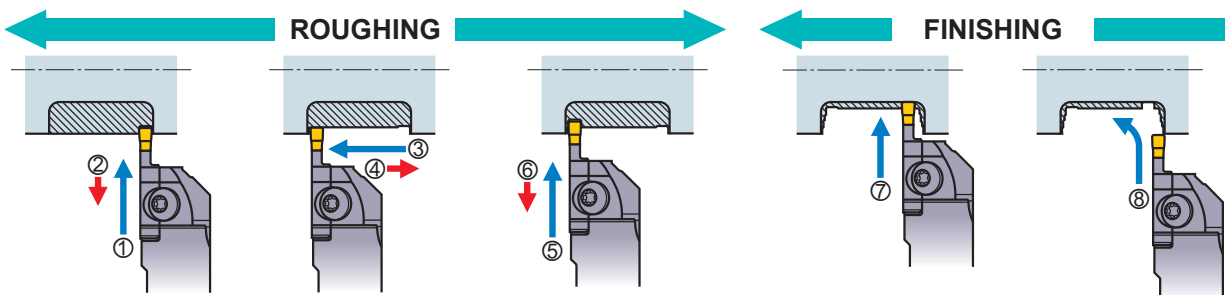
- It is recommended to carry out plunging in several passes. Following the steps above makes it difficult for chips to elongate. This also improves the accuracy of workpiece wall surface.

Machining wide grooves



- It is recommended that cross-feed machining is used.

Machining wide grooves



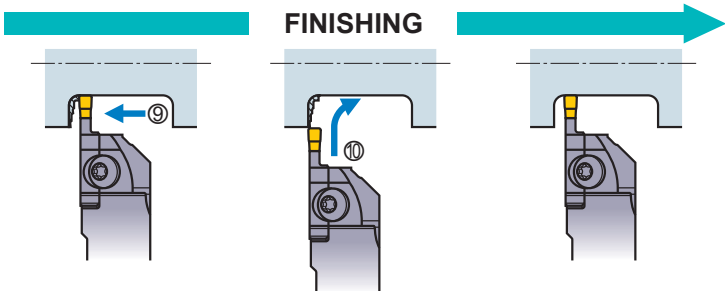
- ① Carry out grooving.
② Retract the tool approx 0.1mm.

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

- ⑤ Carry out grooving.
⑥ Retract the tool approx 0.1mm.
* Repeat the steps ①–⑥.

- 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.

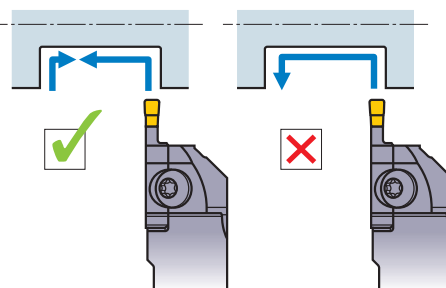


- ⑨ Stop at the bottom of the corner radius.

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

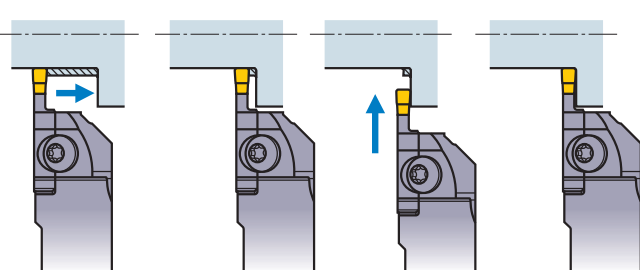
- ⑪ Finish machining.

Precautions when finishing walls



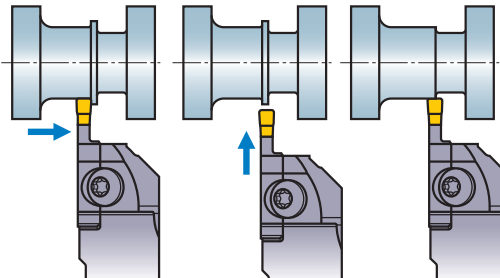
- To produce high accuracy walls using MS or MM breaker insert, do not carry out back turning. Plunging is recommended.

Wall machining



- When machining a wall, chip jamming can occur. In this case, stop cross feed machining just before the wall (at a point less than the insert width) then remove the remaining material by plunging.

Machining of a ring section

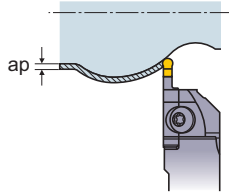


- When a ring remains in a cross feed end process, finish cross feed machining 1–1.5mm short of the end point, then remove the ring by plunging.

MACHINING RECOMMENDATIONS

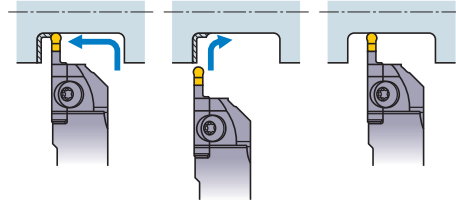
Notes on multi-functional machining (BM breaker)

Copying



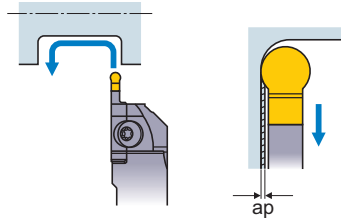
- With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (a_p) to 40% less than the insert width.

Roughing



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

Finishing



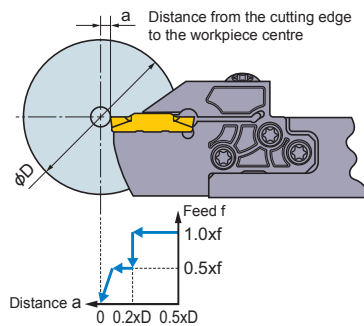
- Carry out finishing in one process. For the depth of cut (a_p) when back turning, refer to the table on the right.

Insert	a_p (mm)
GY2M0200D100N-BM	0.05
GY2M0250E125N-BM	0.10
GY2M0300F150N-BM	0.15
GY2M0318F159N-BM	0.15
GY2M0400G200N-BM	0.20
GY2M0475H238N-BM	0.24
GY2M0500H250N-BM	0.24
GY2M0600J150N-BM	0.30
GY2M0635J318N-BM	0.30
GY2M0800K400N-BM	0.40

Notes for cutting off

Feed

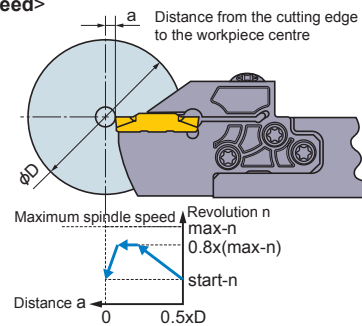
<Feed>



- When the cutting edge approaches the centre, reduce the feed by 50%.
- If necessary, stop the feed prior to reaching the centre of the workpiece to prevent it falling under its own weight.

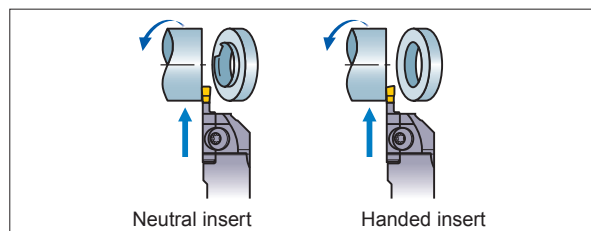
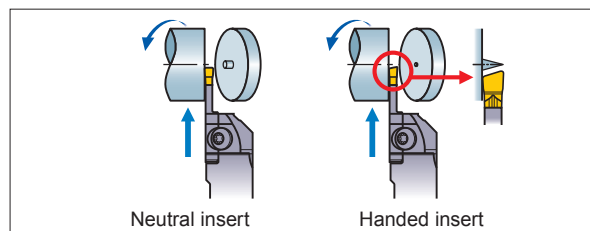
Revolution

<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.

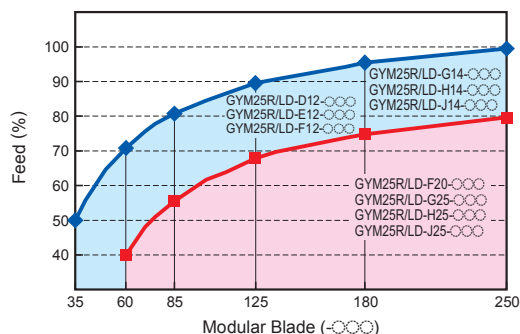
Insert



- When there is a centre stub on solid bar work or burrs are formed on pipe material, it is possible to decrease them by using a handed insert. With a handed insert, machining tends to be less stable when compared to using a neutral insert. Pay special attention to avoid fracturing of the cutting edge and decrease the feed when necessary.

Grooving system

RELATIONSHIP BETWEEN THE MODULAR BLADE AND FEED PER ROTATION [For Face Grooving]



(Note) Adjust the feed per rotation in the cutting conditions to the percentage shown in the table above.

RECOMMENDED CUTTING SPEED (m/min) [For Face Grooving]

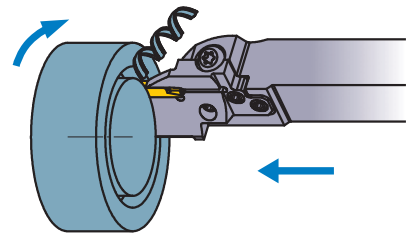
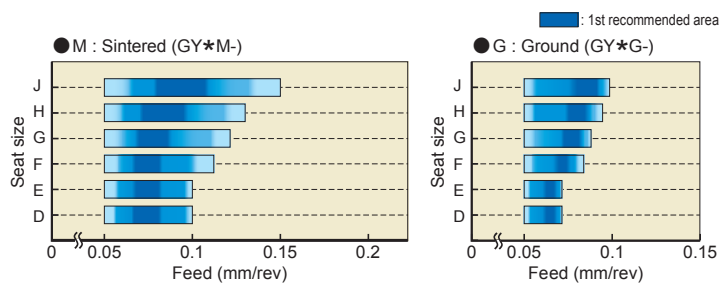
	Work Material	Hardness	Grade	Cutting Speed (m/min)					
				50	100	150	200	250	300
P	Mild Steel	≤160HB	VP20RT		80	180			
			VP10RT		90	190			
			NX2525		70	170			
	Carbon Steel Alloy Steel	160–280HB	VP20RT	60	140				
			VP10RT	70	150				
			MY5015		90	210			
			NX2525	55	135				
		280HB≤	VP20RT	50	110				
			VP10RT	60	120				
			MY5015		80	160			
			NX2525	45	105				
M	Stainless Steel	≤270HB	VP20RT	50	110				
			VP10RT	60	120				
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT	60	140				
			VP10RT	70	150				
			MY5015		90	210			
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	50	110				
			VP10RT	60	120				
			MY5015		80	160			
S	Heat Resistant Alloy Titanium Alloy	—	VP20RT	30	60				
			VP10RT	40	70				
			RT9010	40	70				
H	Hardened steel	50HRC≤	MB8025	60	100				

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.

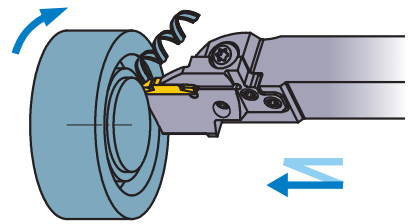
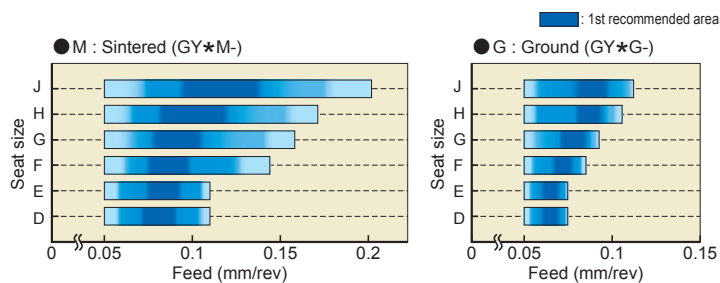
(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For Face Grooving]

GROOVING

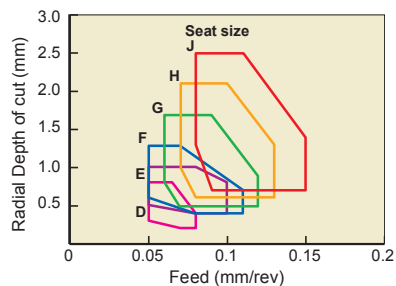


PLUNGING

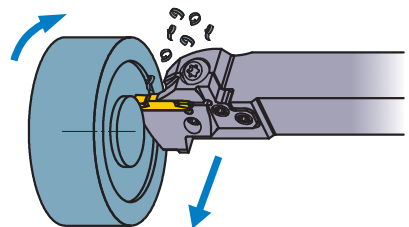


★ After the 1st plunge, the width of cut should be set narrower than insert with W3.

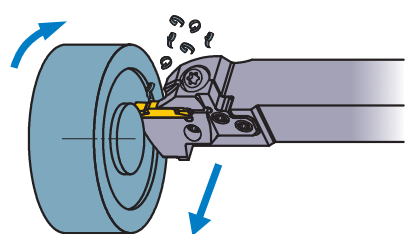
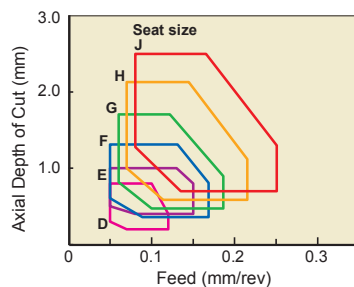
TRAVERSE MACHING (MF BREAKER)



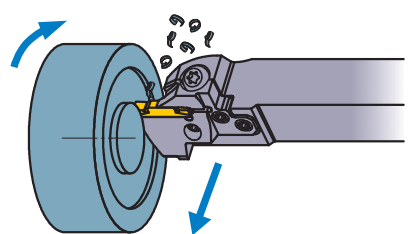
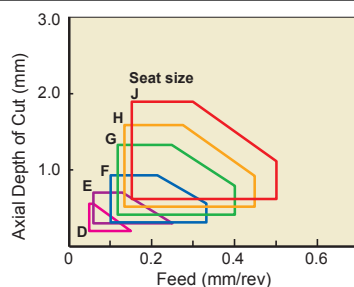
Seat Size		Seat Size	
Insert Width (mm)		Insert Width (mm)	
D	2.00 2.24	G	4.00 4.24
E	2.39 2.50	H	4.75 5.00
F	2.74 3.00	J	5.24 6.00
	3.18 3.24		6.31 6.35



TRAVERSE MACHING (MM/MS BREAKER)



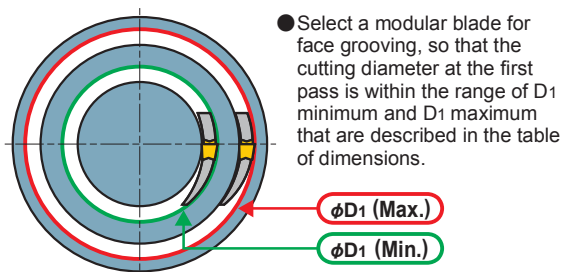
TRAVERSE MACHING (BM BREAKER)



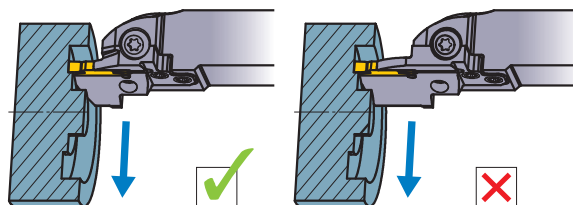
TOOL SELECTION

Notes when selecting the tool body

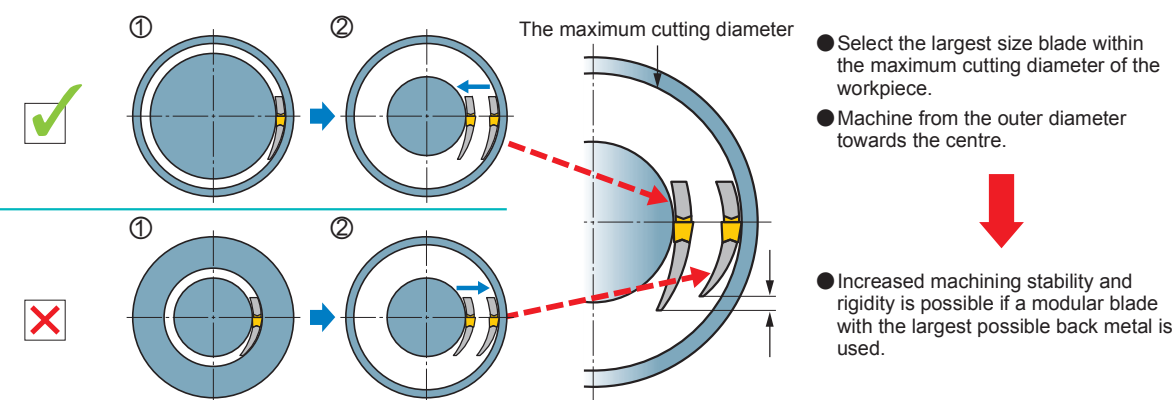
Modular blade (1)



Modular blade (2)

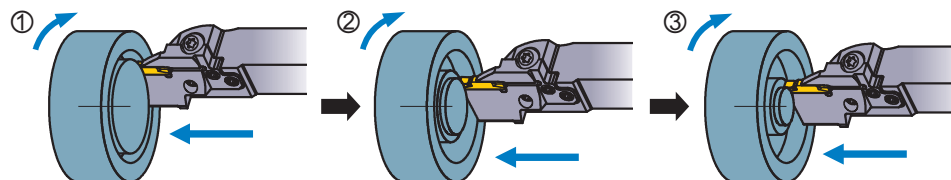


Modular blade (3)

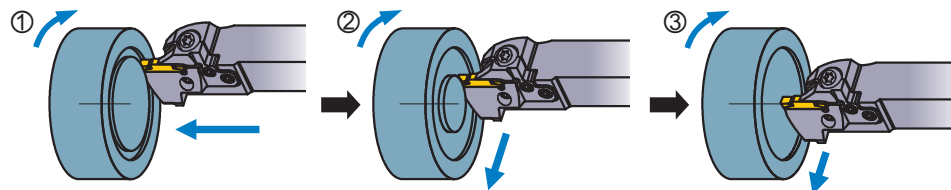


● At first machine the maximum cutting diameter, there is no restriction in the cutting diameter on the remaining process.

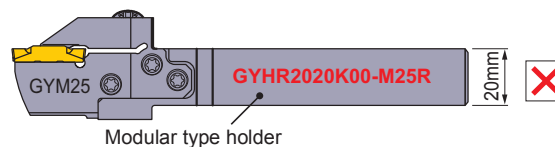
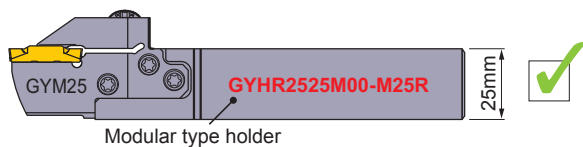
● When plunging in several passes.



● When combining plunging and infeed machining.



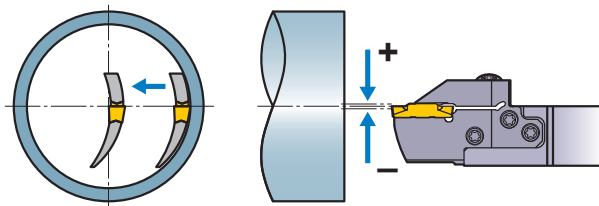
Modular type holder



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

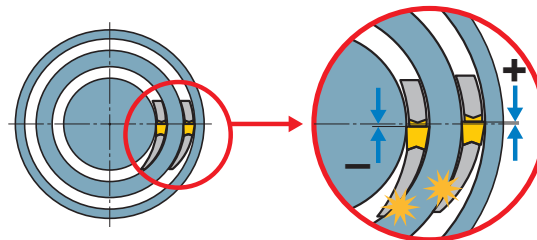
● Notes when setting the tool

Setting the cutting edge height



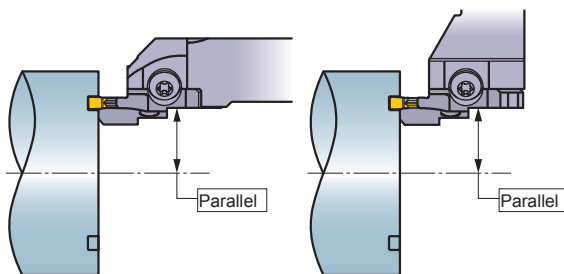
- Set the cutting edge height to $\pm 0.1\text{mm}$ parallel to the central axis.
- Cutting edge centre height check should be done by traverse machining towards the centre with a very small depth of cut and ensure that an even surface and no material remains at the centre point afterwards.

When intertering the wall of groove and the Modular blade



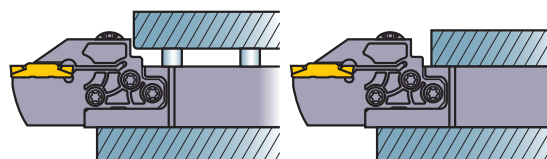
- If interference occurs even when the correct blade is used, the cutting edge height could be incorrect.
 - When interference occurs on the inner side of the blade, the cutting edge height is set too high.
 - When interference occurs on the outer side of the blade, the cutting edge height is set too low.

Setting the tool



- Set the insert parallel to the central axis.

Tool overhang



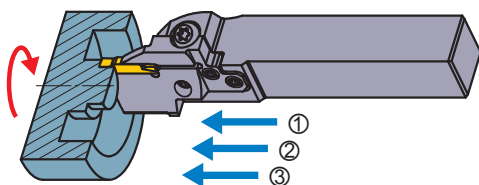
- When setting the tool, ensure that the overhang is as short as possible and avoid the step difference part as above figure shows.

MACHINING RECOMMENDATIONS

● Notes when face grooving

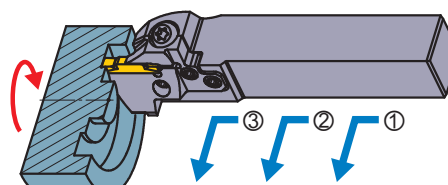
- Always machine from the outer diameter towards the centre.

Machining narrow grooves



- Plunging in several passes is recommended.

Machining wide grooves

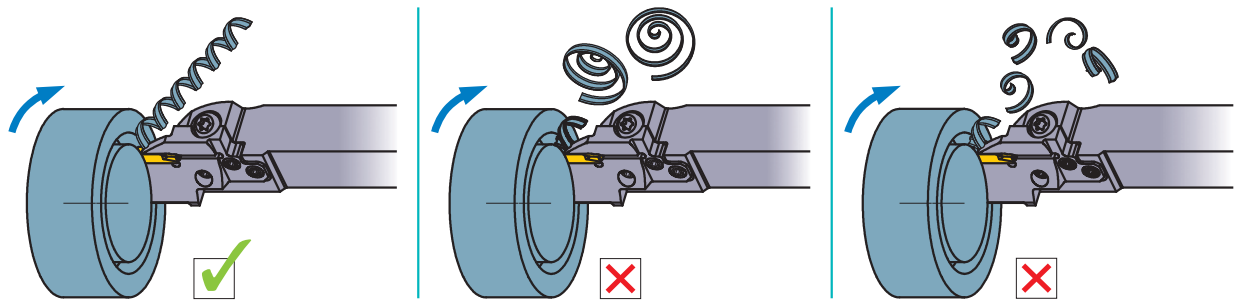


- Cross feed machining is recommended.

MACHINING RECOMMENDATIONS

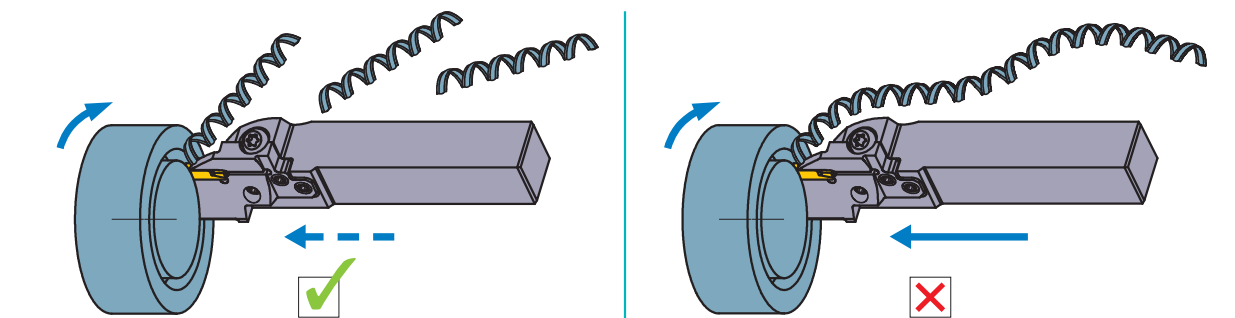
● Notes when face grooving (2)

Notes on the first pass (1)



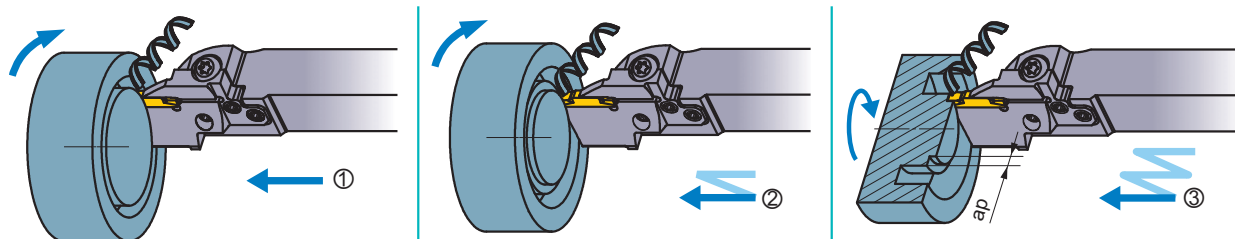
- During the first face grooving pass it is difficult to disperse broken chips and can lead to problems such as a chipped insert. Maintain longer chips that disperse easily by decreasing the feed per rotation.

Notes on the first pass (2)



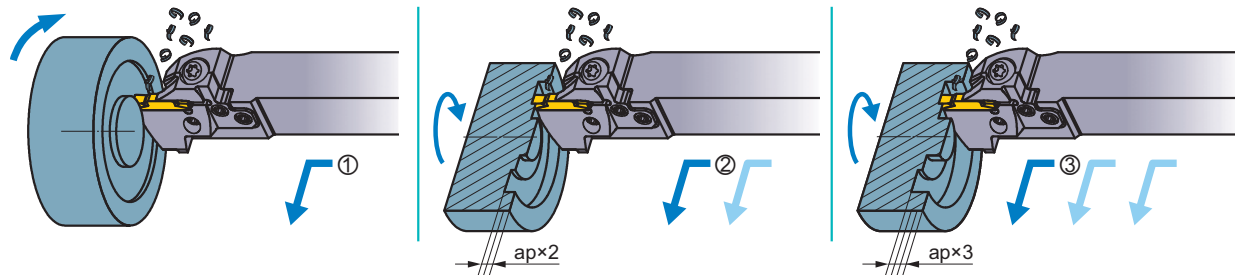
- When chips become too long, use peck feed to break them into a suitable length.

Notes when wide face grooving by plunging in several passes



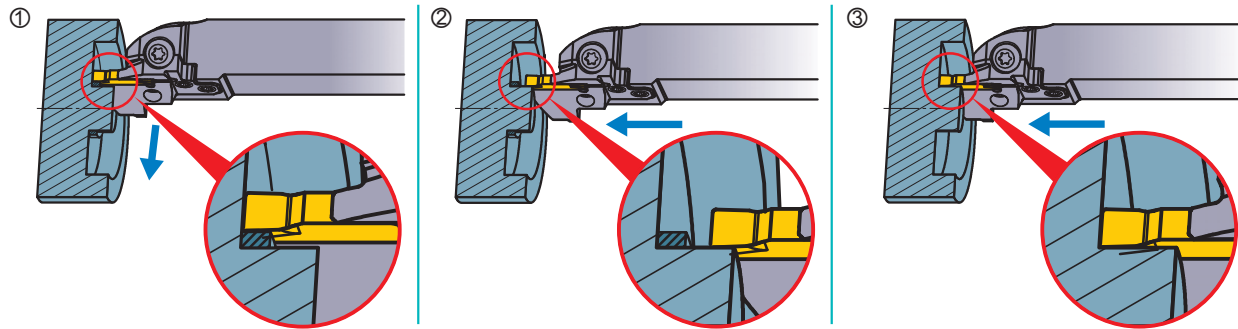
- When machining a face groove in several passes, machine from the outer diameter towards the centre so that space for discharging chips is created to prevent insert damage caused by chip jamming.
- Plunging width of cut is recommended to be set at 60 - 80% of the insert width. This enhances the effect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

Notes when wide face grooving by combination of plunging and traverse machining (1)



- When face groove machining by using plunge feed and traverse machining, always machine from the outer diameter towards the centre to disperse chips outward to avoid chip jamming problems.
- Set the depth of cut within 40% of the insert width.

Notes when wide face grooving by combination of plunging and traverse machining (2)



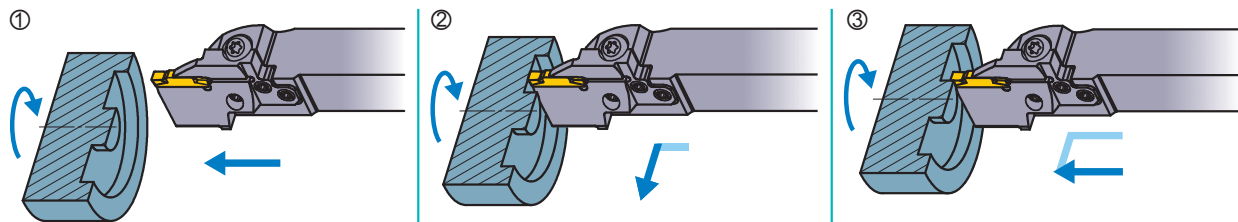
- When infeed machining at the bottom of a deep groove, chips may interfere on the cutting edge near the centre wall. In such cases, stop infeed machining just before the centre wall (at a point less than the insert width) then remove the remaining material by plunging.

Notes when copying (BM Breaker)



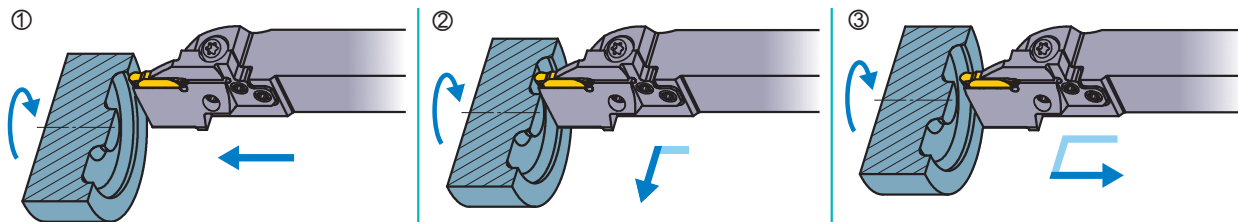
- With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (a_p) to 30% less than the insert width.

Finishing (1)

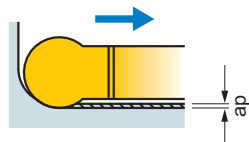


- When finish cutting, machine continuously from the outer wall to the bottom of the groove, then finally plunge cut the centre wall.

Finishing (2) (BM Breaker)



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



Insert	a_p (mm)
GY2M0200D100N-BM	0.10
GY2M0250E125N-BM	
GY2M0300F150N-BM	
GY2M0318F159N-BM	
GY2M0400G200N-BM	0.15
GY2M0475H238N-BM	
GY2M0500H250N-BM	0.20
GY2M0600J300N-BM	
GY2M0635J318N-BM	0.25

Grooving system

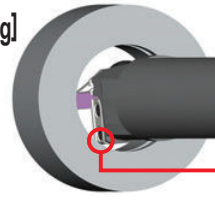
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For Internal Grooving]

•When using the mono block type

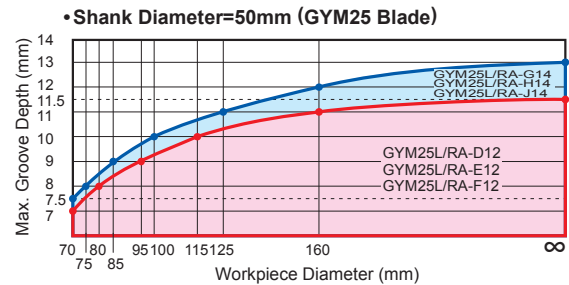
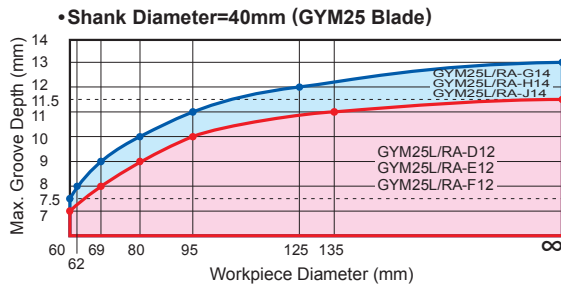
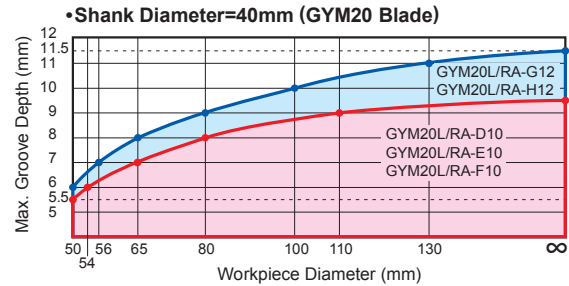
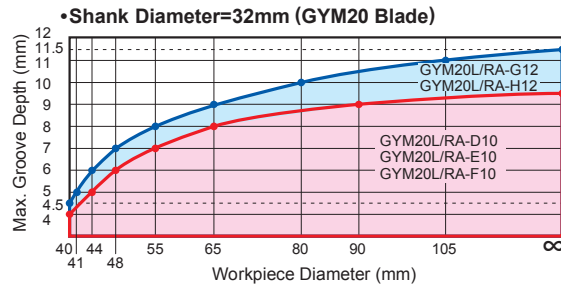
The maximum groove depth is not limited by the cutting diameter.

•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.



RECOMMENDED CUTTING SPEED (m/min) [For Internal Grooving]

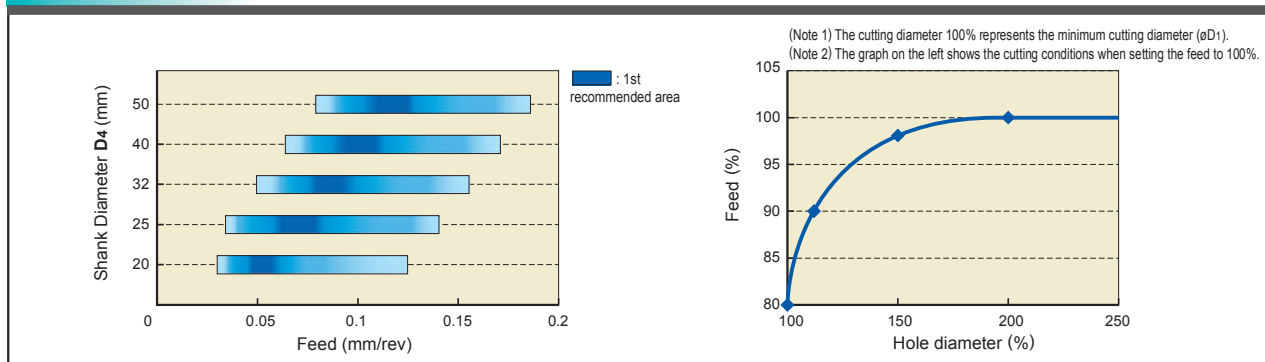
	Work Material	Hardness	Grade	Cutting Speed (m/min)						
				50	100	150	200	250	300	
P	Mild Steel	≤160HB	VP20RT		80	180				
			VP10RT		90	190				
			NX2525		70	170				
	Carbon Steel Alloy Steel	160—280HB	VP20RT	60	140					
			VP10RT	70	150					
			MY5015		90	210				
			NX2525	55	135					
		280HB≤	VP20RT	50	110					
VP10RT			60	120						
MY5015				80	160					
	NX2525	45	105							
M	Stainless Steel	≤270HB	VP20RT	50	110					
		VP10RT	60	120						
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT	60	140					
			VP10RT	70	150					
			MY5015		90	210				
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	50	110					
			VP10RT	60	120					
			MY5015		80	160				
S	Heat Resistant Alloy Titanium Alloy	—	VP20RT	30	60					
			VP10RT	40	70					
			RT9010	40	70					
H	Hardened steel	50HRC≤	MB8025	60	100					

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.

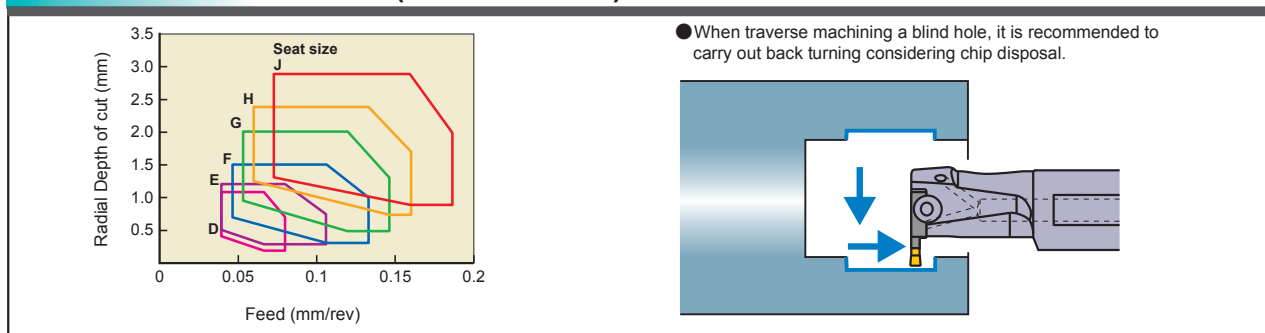
(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For Internal Grooving]

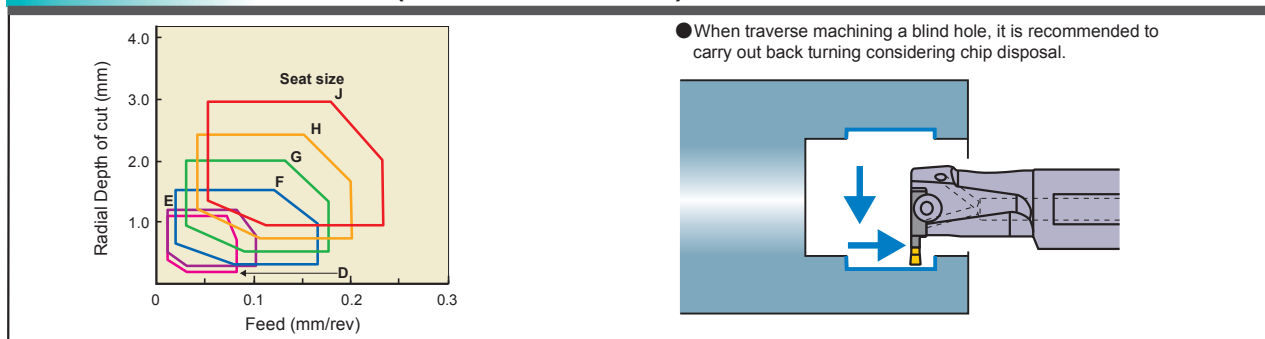
GROOVING



TRAVERSE MACHINING (MF BREAKER)

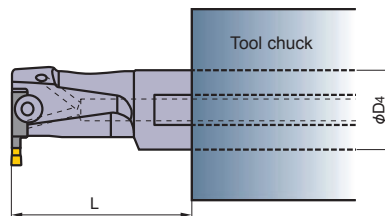


TRAVERSE MACHINING (MM/MS BREAKER)



(Note) The above cutting conditions are for when using the tool overhang (L) 1.6-2.0 times larger than the shank diameter (ϕD_4). ($L/D=1.6-2.0$)
 When using L/D larger than 2.0, reduce the cutting conditions.

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

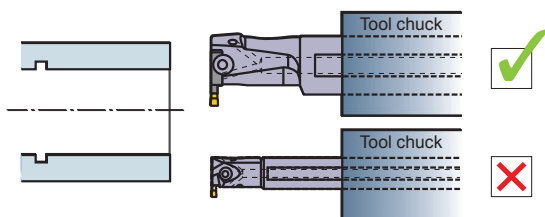


Grooving system

TOOL SELECTION

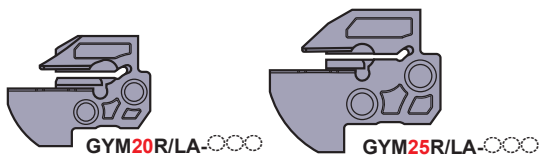
Notes when selecting the tool body

Holder



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

Modular blade (1)

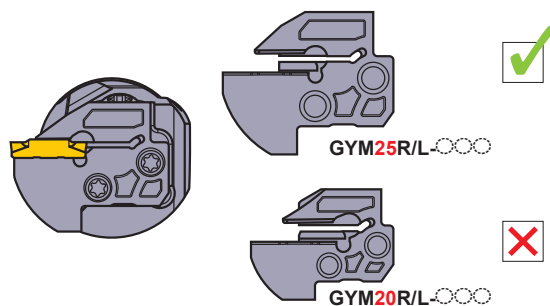


GYM20R/LA-D10
GYM20R/LA-E10
GYM20R/LA-F10
GYM20R/LA-G12
GYM20R/LA-H12

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

- For a $\phi 40$ shank holder, if there is no restriction for use, select a holder suitable for GYM25 blade.

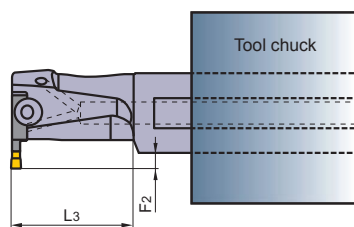
Modular blade (2)



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

Notes when setting the tool

Overhang



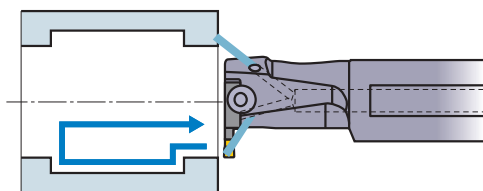
- The maximum groove depth is limited to the dimension L3. When machining with longer overhangs, refer to the dimension F2 of the tool used.

MACHINING RECOMMENDATIONS

● Notes on multi-function machining (MF, MS, MM and BM breakers)

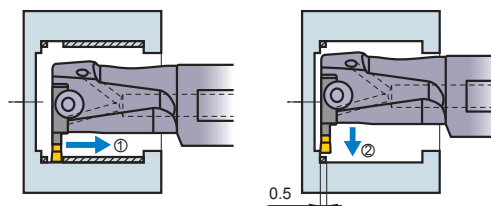
For internal grooving, the machining methods for external grooving (P92–P93) can be used, but please note the following precautions.

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

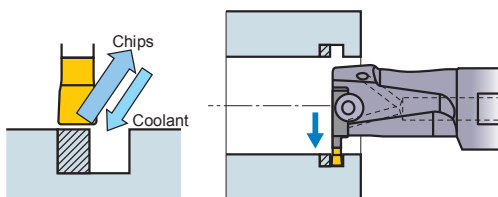


- As continuous chips tend to elongate at the back of the bore, the above operation is recommended. The recommended width of cut for ② is 0.5mm.

Machining Wide Grooves

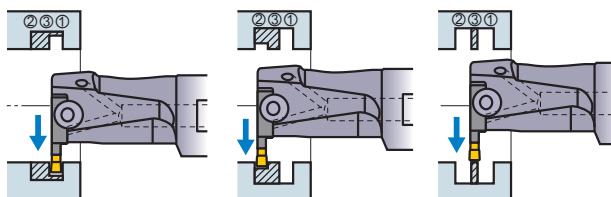
Grooving

- When the cutting edge width is $x \geq$ groove width



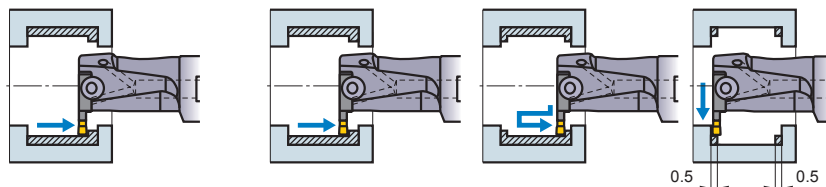
- When the depth of cut is shallower than the cutting edge width, continuous chips are usually produced. When plunging in several passes, it is recommended to carry out machining in the steps above. This ensures that coolant reaches the cutting edge and chips are easily discharged.

- When the cutting edge width is $x <$ groove width



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

Turning

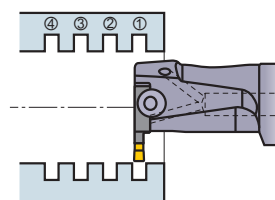


- When chip breaking and disposal are especially important, cross-feed machining is recommended.

- Wide face grooving when the corner R of the work piece is equal to the corner R of the insert, machine as shown above. (When corner R of the work piece is larger than corner R of the insert, refer to the description of external wide grooving.)

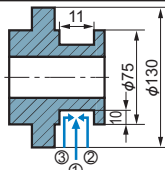
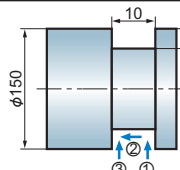
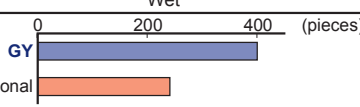
- If the groove depth exceeds a given level, chips may elongate at the wall. In such a case, increase the feed and carry out machining as shown above.

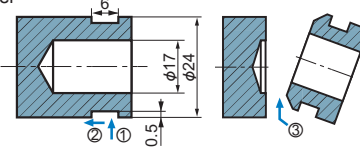
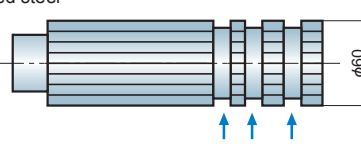
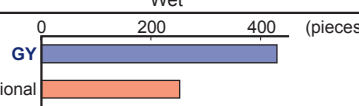
Machining instruction

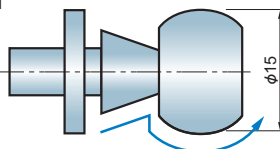
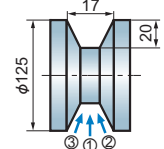
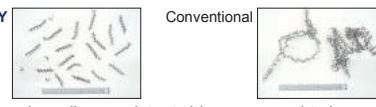


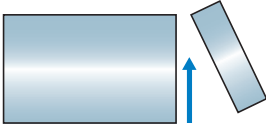
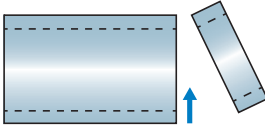
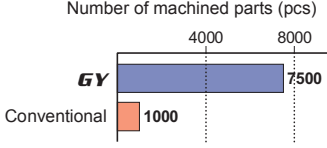
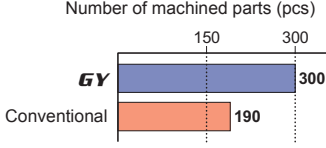
- It is recommended to carry out grooving from the front end of the workpiece. This reduces workpiece deflection.

Application Examples for External Grooving

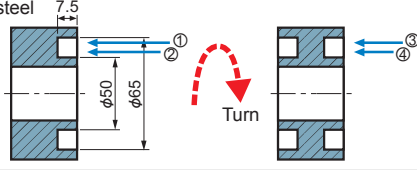
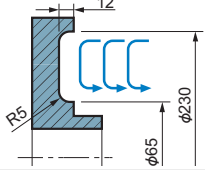
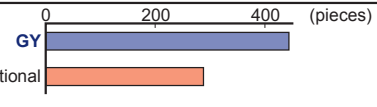
Holder	GYHL2525M00-M25L	GYHL3232P00-M25L
Modular Blade	GYM25LA-H14	GYM25LA-F12
Insert	GY2M0500H080N-MS	GY2M0300F020N-MS
Insert Grade	VP10RT	NX2525
Workpiece	Alloy steel 	Carbon steel 
Component	Automotive transmission gear	Hydraulic piston
Cutting Conditions		
Cutting Speed (m/min)	180	210
Feed (mm/rev)	0.15	①②③: 0.05
Radial Depth of Cut (mm)	10	①③: 5 ②: Machining allowance 0.15
Axial Depth of Cut (mm)	①(Grooving): 5 ②③(Plunging): 3	①③: Machining allowance 0.25 ②: 10
Coolant	Wet	Wet
Results	 GY gave 1.6 times longer tool life. Additionally, the sharper edge geometry resulted in lower cutting forces and prevented the workpiece being drawn out of the chuck.	 GY tools achieved a smooth shiny surface finish compared to the dull conventional tool finish.

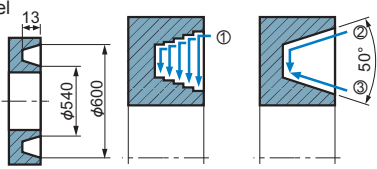
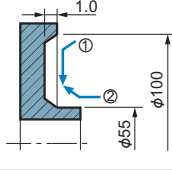
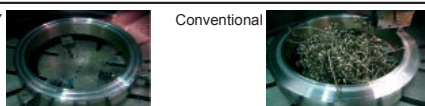
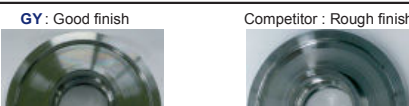
Holder	GYHR2020K00-M20R	GYHR2525M00-M25R
Modular Blade	GYM20RB-F18	GYM25RA-F06
Insert	GY2M0300F020N-MS	GY1G0300F020N-GFGS
Insert Grade	VP20RT	MB8025
Workpiece	Alloy steel 	Hardened steel 
Component	Machine parts	Truck transmission main shaft
Cutting Conditions		
Cutting Speed (m/min)	130	129
Feed (mm/rev)	①③: 0.1 ②: 0.15	0.1
Radial Depth of Cut (mm)	①②: 0.5 ③: 3.5	1.3 (Machining allowance 0.15)
Axial Depth of Cut (mm)	①③: 3	3 (Machining allowance 0.15)
Coolant	Wet	Wet
Results	GY reduces cycle times and tool changes due to the ability to both groove and turn. Improved chip disposal compared to conventional products. 	 GY achieved 1.5 times longer tool life than a conventional product.

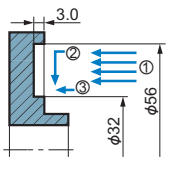
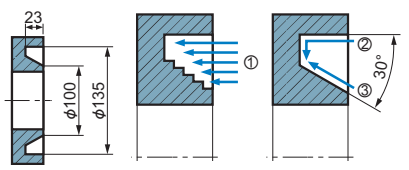
Holder	GYHR2020K00-M25R	GYHR2525M00-M25R
Modular Blade	GYM25RA-G08	GYM25RA-J25
Insert	GY2M0400G200N-BM	GY2M0600H040N-MS
Insert Grade	VP10RT	MY5015
Workpiece	Carbon steel 	Cast iron 
Component	Ball stud for ball joint	Pulley
Cutting Conditions		
Cutting Speed (m/min)	150	300
Feed (mm/rev)	0.2	①②③: 0.15
Radial Depth of Cut (mm)	Machining allowance 0.25–0.45	①②③: 20
Axial Depth of Cut (mm)	Machining allowance 0.25–0.45	①: 6 ②③: 5.5
Coolant	Wet	Wet
Results	 GY produced smaller consistent chips compared to longer uncontrolled chips when using conventional tools.	When machining cast iron, the highly rigid design allows stable cutting without vibration and negated the conventional problem of the insert becoming chipped.

Holder	NEW GYSL1212JX00-D13	NEW GYSR1212JX-C13
Insert	GY2M0200D020N-GM (VP20RT)	GY2M0150C010N-GS (VP20RT)
Workpiece	SUS316 Cutting off 	Inconel ® 625 Cutting off 
Component	Medical component	Washer (Pipe Material)
Cutting Speed (m/min)	61	30.5
Feed (mm/rev)	0.031 → 0.038	0.025
Results	Number of machined parts (pcs)  During a surface finishing test, GY achieved 7 times longer tool life and a high degree of efficiency due to high feed rate.	Number of machined parts (pcs)  Extended tool life was achieved because GY displayed only normal wear, but conventional products suffered from fracturing.

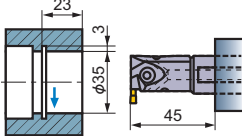
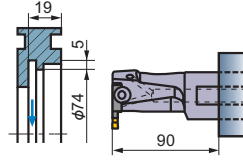
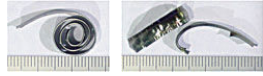
Application Examples for Face Grooving

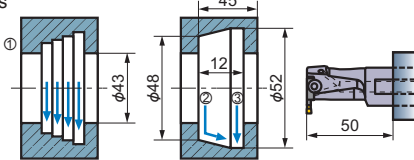
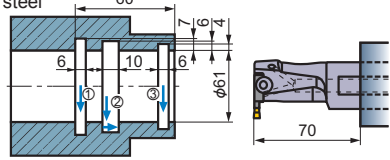
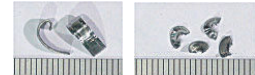
Holder	GYHR2525M00-M25R	GYHR2525M00-M25R
Modular Blade	GYM25RD-G14-060	GYM25RD-H14-180
Insert	GY2M0400G040N-MM	GY2M0500H250N-BM
Insert Grade	VP10RT	MY5015
Workpiece	Carbon steel 	Carbon steel 
Component	Construction equipment parts	Automotive flywheel
Cutting Conditions		
Cutting Speed (m/min)	150	150
Feed (mm/rev)	①③:0.10 ②④:0.12	0.2
Radial Depth of Cut (mm)	①③:4.0 ②④:3.5	Machining allowance:1.0
Axial Depth of Cut (mm)	7.5	Machining allowance:1.0
Coolant	Wet	Wet
Results	 GY achieved 1.5 times greater tool life compared to conventional products and with less machining noise.	The rigid design allowed an increase in cutting conditions compared to conventional tools. The grade MY5015 also reduced tool costs with double tool the life over conventional grades.

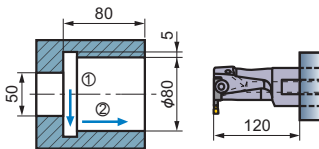
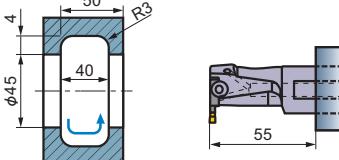
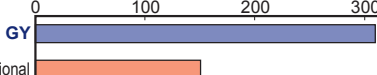
Holder	GYHL3232P00-M25L	GYHL2525M00-M25L
Modular Blade	GYM25LD-J14-250	GYM25LD-H14-085
Insert	GY2M0600J040N-MM	GY2M0500H080N-MM
Insert Grade	VP20RT	MY5015
Workpiece	Carbon steel 	Alloy steel 
Component	Windturbine parts	Automotive parts
Cutting Conditions		
Cutting Speed (m/min)	①: 100 ②③: 150	150
Feed (mm/rev)	①: 0.1 ②③: 0.08	①:0.3 ②:0.15
Radial Depth of Cut (mm)	①: - ②③: Machining allowance 0.5	①: - ②: Machining allowance 0.3-0.5
Axial Depth of Cut (mm)	①:2.5 ②③: -	①:1.0 ②: -
Coolant	Wet	Wet
Results	 The ability to traverse instead of just plunging produced better chip control.	 MY5015 grade produced an improved surface finish over a longer period than conventional tools that only gave a dull finish.

Holder	GYHR2020K00-M25R	GYHL2525M00-M25L
Modular Blade	GYM25RD-F12-050	GYM25LD-H25-125
Insert	GY2M0300F020N-MS	GY2M0500H040N-MS
Insert Grade	NX2525	VP20RT
Workpiece	Alloy steel 	Stainless steel 
Component	Automotive clutch parts	Plant pipe nut
Cutting Conditions		
Cutting Speed (m/min)	120	65
Feed (mm/rev)	①:0.15 ②③:0.12	①:0.05 (Step feed) ②③:0.8
Radial Depth of Cut (mm)	①:3.0 ②③: Machining allowance 0.2	①:3-5 ②③: Machining allowance 0.3
Axial Depth of Cut (mm)	①:2.8 ②③: Machining allowance 0.2	①:23 ②③: -
Coolant	Wet	Wet
Results	Cermet grades were used traditionally to give good surface finishes. Conventional operations ① and ② needed to be stopped frequently due to bad chip control because conventional grades were produced without chip breakers.	Conventional groove machining produced inconsistent diameters in operation 1 due to tool deflection. With higher rigidity, GY gave consistent, high precision results for finishing operations ② and ③.

Application Examples for Internal Grooving

Holder	GYAL25R90B-E06	GYDR50P90F-M25L
Modular Blade	-	GYM25LA-G14
Insert	GY2M0239E020N-GM	GY2M0400G020N-GS
Insert Grade	VP20RT	VP20RT
Workpiece	Carbon steel 	Alloy steel 
Component	Machine parts	Transmission gear
Cutting Conditions		
Cutting Speed (m/min)	120	100
Feed (mm/rev)	0.12	0.15
Radial Depth of Cut (mm)	3	5
Axial Depth of Cut (mm)	2.39	4
Coolant	Wet	Wet
Results	In comparison with conventional products, GY showed excellent chip breaking. Additionally, low cutting resistance enabled stable machining even at high feeds.	With GY, chips were not burnt due to lower cutting resistance, resulting in longer tool life. Additionally, GY showed excellent chip disposal. ● Chip geometry 

Holder	GYDL32L90C-M20R	GYDR40T90D-M25L
Modular Blade	GYM20RA-F10	GYM25LA-J14
Insert	GY2M0300F020N-MS	GY2M0600J040N-MS
Insert Grade	VP20RT	VP20RT
Workpiece	Stainless steel 	Carbon steel 
Component	Machine parts	Cylinder
Cutting Conditions		
Cutting Speed (m/min)	80	150
Feed (mm/rev)	①③:0.10 ②:0.12	0.05
Radial Depth of Cut (mm)	①:2.0-4.3 ②③: Machining allowance 0.2	①:7 ②:6 ③:4
Axial Depth of Cut (mm)	①:2.4-3.0 ②③: Machining allowance 0.2	①:6 ②:10 ③:6
Coolant	Wet	Wet
Results	A highly efficient disposal rate allowed stability even when machining stainless steel. The ability to traverse cut meant the same tools could be used for different size components which led to tool cost reductions.	GY could carry out machining higher feeds, resulting in a reduction in cycle time. Additionally, GY showed good chip disposal for both grooving and cross-feed machining. 

Holder	GYDL50T90F-M25R	GYDR32L90C-M20L
Modular Blade	GYM25RA-F12	GYM20LA-H12
Insert	GY2M0300F040N-MM	GY2M0500H250N-BM
Insert Grade	MY5015	NX2525
Workpiece	Cast iron 	Alloy steel 
Component	Machine parts	Bearing
Cutting Conditions		
Cutting Speed (m/min)	200	120
Feed (mm/rev)	①:0.12 ②:0.15	0.1
Radial Depth of Cut (mm)	①:5 ②:0.5	Machining allowance :0.2
Axial Depth of Cut (mm)	①:3 ②:-	Machining allowance :0.2
Coolant	Wet	Wet
Results	 GY achieved double tool life, improved surface finish and vibration free machining.	Traditional machining methods left a blend mark between passes. By using a BM type breaker the blend marks were eliminated and the surface finish was improved.

Modular Blades Selection Chart (For Internal Grooving)

Modular Type Holder		Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)			Order Number	Hand (R/L)	
GYDR50P90F-M25L	R	90°	D	GYM25LA-D12	L	79,80
			E	GYM25LA-E12	L	81,82
			F	GYM25LA-F12	L	83,84
			G	GYM25LA-G14	L	
			H	GYM25LA-H14	L	
			J	GYM25LA-J14	L	
GYDL50P90F-M25R	L	90°	D	GYM25RA-D12	R	79,80
			E	GYM25RA-E12	R	81,82
			F	GYM25RA-F12	R	83,84
			G	GYM25RA-G14	R	
			H	GYM25RA-H14	R	
			J	GYM25RA-J14	R	
GYDR50T90F-M25L	R	90°	D	GYM25LA-D12	L	79,80
			E	GYM25LA-E12	L	81,82
			F	GYM25LA-F12	L	83,84
			G	GYM25LA-G14	L	
			H	GYM25LA-H14	L	
			J	GYM25LA-J14	L	
GYDL50T90F-M25R	L	90°	D	GYM25RA-D12	R	79,80
			E	GYM25RA-E12	R	81,82
			F	GYM25RA-F12	R	83,84
			G	GYM25RA-G14	R	
			H	GYM25RA-H14	R	
			J	GYM25RA-J14	R	

Modular Type Holder		Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)			Order Number	Hand (R/L)	
GYDR32L90C-M20L	R	90°	D	GYM20LA-D10	L	79,80
			E	GYM20LA-E10	L	81,82
			F	GYM20LA-F10	L	83,84
			G	GYM20LA-G12	L	
			H	GYM20LA-H12	L	85,86
			D	GYM20RA-D10	R	79,80
			E	GYM20RA-E10	R	81,82
			F	GYM20RA-F10	R	83,84
G	GYM20RA-G12	R				
			H	GYM20RA-H12	R	85,86
			D	GYM20LA-D10	L	79,80
			E	GYM20LA-E10	L	81,82
			F	GYM20LA-F10	L	83,84
G	GYM20LA-G12	L				
			H	GYM20LA-H12	L	85,86
			D	GYM20RA-D10	R	79,80
			E	GYM20RA-E10	R	81,82
			F	GYM20RA-F10	R	83,84
G	GYM20RA-G12	R				
			H	GYM20RA-H12	R	85,86
			D	GYM20LA-D10	L	79,80
			E	GYM20LA-E10	L	81,82
			F	GYM20LA-F10	L	83,84
G	GYM20LA-G12	L				
			H	GYM20LA-H12	L	85,86
			D	GYM20RA-D10	R	79,80
			E	GYM20RA-E10	R	81,82
			F	GYM20RA-F10	R	83,84
G	GYM20RA-G12	R				
			H	GYM20RA-H12	R	85,86
			D	GYM25LA-D12	L	79,80
			E	GYM25LA-E12	L	81,82
			F	GYM25LA-F12	L	83,84
G	GYM25LA-G14	L				
			H	GYM25LA-H14	L	85,86
			J	GYM25LA-J14	L	
			D	GYM25RA-D12	R	79,80
			E	GYM25RA-E12	R	81,82
			F	GYM25RA-F12	R	83,84
			G	GYM25RA-G14	R	
			H	GYM25RA-H14	R	85,86
			J	GYM25RA-J14	R	
			D	GYM20LA-D10	L	79,80
			E	GYM20LA-E10	L	81,82
			F	GYM20LA-F10	L	83,84
			G	GYM20LA-G12	L	
			H	GYM20LA-H12	L	85,86
			D	GYM20RA-D10	R	79,80
			E	GYM20RA-E10	R	81,82
			F	GYM20RA-F10	R	83,84
G	GYM20RA-G12	R				
			H	GYM20RA-H12	R	85,86
			D	GYM25LA-D12	L	79,80
			E	GYM25LA-E12	L	81,82
			F	GYM25LA-F12	L	83,84
G	GYM25LA-G14	L				
			H	GYM25LA-H14	L	85,86
			J	GYM25LA-J14	L	
			D	GYM25RA-D12	R	79,80
			E	GYM25RA-E12	R	81,82
			F	GYM25RA-F12	R	83,84
			G	GYM25RA-G14	R	
			H	GYM25RA-H14	R	85,86
			J	GYM25RA-J14	R	

QUICK INDEX

Modular Blades Selection Chart (For External and Face Grooving)

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHL3232P00-M25L	L	Face	00°	H	GYM25LD-H14-050	L	59,60
					GYM25LD-H14-060	L	
					GYM25LD-H14-085	L	61,62
					GYM25LD-H14-125	L	
					GYM25LD-H14-180	L	63,64
					GYM25LD-H14-250	L	
					GYM25LD-H25-060	L	59,60
					GYM25LD-H25-085	L	61,62
					GYM25LD-H25-125	L	
					GYM25LD-H25-180	L	63,64
					GYM25LD-H25-250	L	
				J	GYM25LD-J14-050	L	65,66
					GYM25LD-J14-070	L	
					GYM25LD-J14-110	L	67,68
					GYM25LD-J14-170	L	
					GYM25LD-J14-250	L	65,66
					GYM25LD-J25-070	L	
					GYM25LD-J25-110	L	67,68
					GYM25LD-J25-170	L	
					GYM25LD-J25-250	L	

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHL3232P00-M25L	L	Ext.	00°	D	GYM25LA-D06	L	15,16
					GYM25LA-D12	L	
					GYM25LA-D20	L	17,18
					GYM25LA-E06	L	
				E	GYM25LA-E12	L	19,20
					GYM25LA-E20	L	
				F	GYM25LA-F06	L	21,22
					GYM25LA-F12	L	
					GYM25LA-F20	L	23,24
				G	GYM25LA-G08	L	
					GYM25LA-G14	L	25,26
				H	GYM25LA-G25	L	
					GYM25LA-H08	L	37,38
				J	GYM25LA-H14	L	
					GYM25LA-H25	L	39,40
				D	GYM25LD-D12-040	L	
					GYM25LD-D12-050	L	41,42
					GYM25LD-D12-060	L	
					GYM25LD-D12-075	L	43,44
				E	GYM25LD-D12-100	L	
					GYM25LD-D12-135	L	45,46
					GYM25LD-D12-180	L	
					GYM25LD-E12-040	L	47,48
				F	GYM25LD-E12-050	L	
					GYM25LD-E12-060	L	49,50
					GYM25LD-E12-075	L	
					GYM25LD-E12-100	L	51,52
				G	GYM25LD-E12-135	L	
					GYM25LD-E12-180	L	53,54
					GYM25LD-F12-035	L	
				D	GYM25LD-F12-040	L	55,56
					GYM25LD-F12-050	L	
					GYM25LD-F12-060	L	57,58
					GYM25LD-F12-075	L	
				E	GYM25LD-F12-100	L	59,60
					GYM25LD-F12-135	L	
					GYM25LD-F12-180	L	61,62
					GYM25LD-F12-225	L	
				F	GYM25LD-F20-060	L	63,64
					GYM25LD-F20-075	L	
					GYM25LD-F20-100	L	65,66
					GYM25LD-F20-135	L	
				G	GYM25LD-F20-180	L	67,68
					GYM25LD-F20-225	L	
					GYM25LD-G14-040	L	69,70
					GYM25LD-G14-050	L	
				D	GYM25LD-G14-060	L	71,72
					GYM25LD-G14-085	L	
					GYM25LD-G14-125	L	73,74
					GYM25LD-G14-180	L	
				E	GYM25LD-G14-250	L	75,76
					GYM25LD-G25-060	L	
					GYM25LD-G25-085	L	77,78
					GYM25LD-G25-125	L	
				F	GYM25LD-G25-180	L	79,80
					GYM25LD-G25-250	L	

QUICK INDEX

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHR3232P00-M25R	R	Face	00°	E	GYM25RD-E12-040	R	41,42
					GYM25RD-E12-050	R	
					GYM25RD-E12-060	R	
					GYM25RD-E12-075	R	43,44
					GYM25RD-E12-100	R	
					GYM25RD-E12-135	R	
					GYM25RD-E12-180	R	
				F	GYM25RD-F12-035	R	45,46
					GYM25RD-F12-040	R	
					GYM25RD-F12-050	R	
					GYM25RD-F12-060	R	47,48
					GYM25RD-F12-075	R	
					GYM25RD-F12-100	R	49,50
					GYM25RD-F12-135	R	
					GYM25RD-F12-180	R	51,52
					GYM25RD-F20-060	R	
					GYM25RD-F20-075	R	47,48
					GYM25RD-F20-100	R	
					GYM25RD-F20-135	R	49,50
					GYM25RD-F20-180	R	
					GYM25RD-F20-225	R	51,52
				G	GYM25RD-G14-040	R	
					GYM25RD-G14-050	R	53,54
					GYM25RD-G14-060	R	
					GYM25RD-G14-085	R	55,56
					GYM25RD-G14-125	R	
					GYM25RD-G14-180	R	57,58
					GYM25RD-G14-250	R	
					GYM25RD-G25-060	R	53,54
					GYM25RD-G25-085	R	
					GYM25RD-G25-125	R	55,56
					GYM25RD-G25-180	R	
					GYM25RD-G25-250	R	57,58
				H	GYM25RD-H14-050	R	
					GYM25RD-H14-060	R	59,60
					GYM25RD-H14-085	R	
					GYM25RD-H14-125	R	61,62
					GYM25RD-H14-180	R	
					GYM25RD-H14-250	R	63,64
					GYM25RD-H25-060	R	
					GYM25RD-H25-085	R	59,60
					GYM25RD-H25-125	R	
					GYM25RD-H25-180	R	61,62
					GYM25RD-H25-250	R	
				J	GYM25RD-J14-050	R	65,66
					GYM25RD-J14-070	R	
					GYM25RD-J14-110	R	67,68
					GYM25RD-J14-170	R	
					GYM25RD-J14-250	R	65,66
					GYM25RD-J25-070	R	
					GYM25RD-J25-110	R	67,68
					GYM25RD-J25-170	R	
					GYM25RD-J25-250	R	67,68

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHL3225P00-M25L	L	Face	00°	G	GYM25LD-G14-040	L	53,54
					GYM25LD-G14-050	L	
					GYM25LD-G14-060	L	
					GYM25LD-G14-085	L	55,56
					GYM25LD-G14-125	L	
					GYM25LD-G14-180	L	57,58
					GYM25LD-G14-250	L	
					GYM25LD-G25-060	L	53,54
					GYM25LD-G25-085	L	
					GYM25LD-G25-125	L	55,56
					GYM25LD-G25-180	L	
					GYM25LD-G25-250	L	57,58
				H	GYM25LD-H14-050	L	
					GYM25LD-H14-060	L	59,60
					GYM25LD-H14-085	L	
					GYM25LD-H14-125	L	61,62
					GYM25LD-H14-180	L	
					GYM25LD-H14-250	L	63,64
					GYM25LD-H25-060	L	
					GYM25LD-H25-085	L	59,60
					GYM25LD-H25-125	L	
					GYM25LD-H25-180	L	61,62
					GYM25LD-H25-250	L	
GYHR3232P00-M25R	R	Ext.	00°	J	GYM25LD-J14-050	L	65,66
					GYM25LD-J14-070	L	
					GYM25LD-J14-110	L	67,68
					GYM25LD-J14-170	L	
					GYM25LD-J14-250	L	65,66
					GYM25LD-J25-070	L	
					GYM25LD-J25-110	L	67,68
					GYM25LD-J25-170	L	
					GYM25LD-J25-250	L	67,68
				D	GYM25RA-D06	R	15,16
					GYM25RA-D12	R	
					GYM25RA-D20	R	17,18
					GYM25RA-E06	R	
					GYM25RA-E12	R	19,20
					GYM25RA-E20	R	
					GYM25RA-F06	R	21,22
					GYM25RA-F12	R	
					GYM25RA-F20	R	23,24
					GYM25RA-G08	R	
					GYM25RA-G14	R	25,26
					GYM25RA-G25	R	
				D	GYM25RA-H08	R	37,38
					GYM25RA-H14	R	
					GYM25RA-H25	R	39,40
					GYM25RA-J08	R	
					GYM25RA-J14	R	37,38
					GYM25RA-J25	R	
					GYM25RD-D12-040	R	37,38
					GYM25RD-D12-050	R	
					GYM25RD-D12-060	R	39,40
					GYM25RD-D12-075	R	
					GYM25RD-D12-100	R	39,40
					GYM25RD-D12-135	R	
					GYM25RD-D12-180	R	39,40

QUICK INDEX

Modular Blades Selection Chart (For External and Face Grooving)

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHR3225P00-M25R	R	Face	00°	J	GYM25RD-J14-050	R	65,66
					GYM25RD-J14-070	R	
					GYM25RD-J14-110	R	
					GYM25RD-J14-170	R	
					GYM25RD-J14-250	R	67,68
					GYM25RD-J25-070	R	
					GYM25RD-J25-110	R	65,66
					GYM25RD-J25-170	R	
					GYM25RD-J25-250	R	67,68
GYHL3225P00-M25L	L	Ext.	00°	D	GYM25LA-D06	L	15,16
					GYM25LA-D12	L	
					GYM25LA-D20	L	
				E	GYM25LA-E06	L	17,18
					GYM25LA-E12	L	
				F	GYM25LA-E20	L	
					GYM25LA-F06	L	
				G	GYM25LA-F12	L	19,20
					GYM25LA-F20	L	
				H	GYM25LA-G08	L	21,22
					GYM25LA-G14	L	
					GYM25LA-G25	L	
				J	GYM25LA-H08	L	23,24
					GYM25LA-H14	L	
					GYM25LA-H25	L	
				D	GYM25LA-J08	L	25,26
					GYM25LA-J14	L	
					GYM25LA-J25	L	
				D	GYM25LD-D12-040	L	37,38
					GYM25LD-D12-050	L	
					GYM25LD-D12-060	L	
					GYM25LD-D12-075	L	
				E	GYM25LD-D12-100	L	39,40
					GYM25LD-D12-135	L	
					GYM25LD-D12-180	L	
				E	GYM25LD-E12-040	L	41,42
					GYM25LD-E12-050	L	
					GYM25LD-E12-060	L	
					GYM25LD-E12-075	L	
				F	GYM25LD-E12-100	L	43,44
					GYM25LD-E12-135	L	
					GYM25LD-E12-180	L	
				F	GYM25LD-F12-035	L	45,46
					GYM25LD-F12-040	L	
					GYM25LD-F12-050	L	
					GYM25LD-F12-060	L	
				G	GYM25LD-F12-075	L	47,48
					GYM25LD-F12-100	L	
					GYM25LD-F12-135	L	
					GYM25LD-F12-180	L	
				H	GYM25LD-F12-225	L	49,50
					GYM25LD-F20-060	L	
					GYM25LD-F20-075	L	
					GYM25LD-F20-100	L	
				F	GYM25LD-F20-135	L	51,52
					GYM25LD-F20-180	L	
					GYM25LD-F20-225	L	

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHR3225P00-M25R	R	Ext.	00°	J	GYM25RA-J08	R	25,26
					GYM25RA-J14	R	
					GYM25RA-J25	R	
				D	GYM25RD-D12-040	R	37,38
					GYM25RD-D12-050	R	
					GYM25RD-D12-060	R	
					GYM25RD-D12-075	R	
				E	GYM25RD-D12-100	R	39,40
					GYM25RD-D12-135	R	
					GYM25RD-D12-180	R	
				E	GYM25RD-E12-040	R	41,42
					GYM25RD-E12-050	R	
					GYM25RD-E12-060	R	
					GYM25RD-E12-075	R	
				F	GYM25RD-E12-100	R	43,44
					GYM25RD-E12-135	R	
					GYM25RD-E12-180	R	
				F	GYM25RD-F12-035	R	45,46
					GYM25RD-F12-040	R	
					GYM25RD-F12-050	R	
					GYM25RD-F12-060	R	
				G	GYM25RD-F12-075	R	47,48
					GYM25RD-F12-100	R	
					GYM25RD-F12-135	R	
					GYM25RD-F12-180	R	
				H	GYM25RD-F12-225	R	49,50
					GYM25RD-F20-060	R	
					GYM25RD-F20-075	R	
					GYM25RD-F20-100	R	
				G	GYM25RD-G14-040	R	51,52
					GYM25RD-G14-050	R	
					GYM25RD-G14-060	R	
					GYM25RD-G14-085	R	
				H	GYM25RD-G14-125	R	53,54
					GYM25RD-G14-180	R	
					GYM25RD-G14-250	R	
					GYM25RD-G25-060	R	
				F	GYM25RD-G25-085	R	55,56
					GYM25RD-G25-125	R	
					GYM25RD-G25-180	R	
					GYM25RD-G25-250	R	
				H	GYM25RD-H14-050	R	57,58
					GYM25RD-H14-060	R	
					GYM25RD-H14-085	R	
					GYM25RD-H14-125	R	
				G	GYM25RD-H14-180	R	59,60
					GYM25RD-H14-250	R	
					GYM25RD-H25-060	R	
					GYM25RD-H25-085	R	
				H	GYM25RD-H25-125	R	61,62
					GYM25RD-H25-180	R	
					GYM25RD-H25-250	R	

QUICK INDEX

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHL2525M90-M25R	L	Face	90°	F	GYM25RD-F12-035	R	71,72
					GYM25RD-F12-040	R	
					GYM25RD-F12-050	R	
					GYM25RD-F12-060	R	
					GYM25RD-F12-075	R	
					GYM25RD-F12-100	R	
					GYM25RD-F12-135	R	
					GYM25RD-F12-180	R	
					GYM25RD-F12-225	R	
					GYM25RD-F20-060	R	
					GYM25RD-F20-075	R	
					GYM25RD-F20-100	R	
					GYM25RD-F20-135	R	
					GYM25RD-F20-180	R	
					GYM25RD-F20-225	R	
				G	GYM25RD-G14-040	R	73,74
					GYM25RD-G14-050	R	
					GYM25RD-G14-060	R	
					GYM25RD-G14-085	R	
					GYM25RD-G14-125	R	
					GYM25RD-G14-180	R	
					GYM25RD-G14-250	R	
					GYM25RD-G25-060	R	
				H	GYM25RD-G25-085	R	75,76
					GYM25RD-G25-125	R	
					GYM25RD-G25-180	R	
					GYM25RD-G25-250	R	
					GYM25RD-H14-050	R	
					GYM25RD-H14-060	R	
					GYM25RD-H14-085	R	
					GYM25RD-H14-125	R	
				J	GYM25RD-H14-180	R	77,78
					GYM25RD-H14-250	R	
					GYM25RD-H25-060	R	
					GYM25RD-H25-085	R	
					GYM25RD-H25-125	R	
					GYM25RD-H25-180	R	
					GYM25RD-H25-250	R	
					GYM25RD-J14-050	R	
GYHR3225P00-M25R	R	Ext.	00°	D	GYM25RA-D06	R	15,16
					GYM25RA-D12	R	
					GYM25RA-D20	R	
				E	GYM25RA-E06	R	17,18
					GYM25RA-E12	R	
					GYM25RA-E20	R	
				F	GYM25RA-F06	R	19,20
					GYM25RA-F12	R	
					GYM25RA-F20	R	
				G	GYM25RA-G08	R	21,22
					GYM25RA-G14	R	
					GYM25RA-G25	R	
				H	GYM25RA-H08	R	23,24
					GYM25RA-H14	R	
					GYM25RA-H25	R	

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHR2525M90-M25L	R	Face	90°	H	GYM25LD-H14-050	L	75,76
					GYM25LD-H14-060	L	
					GYM25LD-H14-085	L	
					GYM25LD-H14-125	L	
					GYM25LD-H14-180	L	
					GYM25LD-H14-250	L	
					GYM25LD-H25-060	L	
					GYM25LD-H25-085	L	
				J	GYM25LD-H25-125	L	77,78
					GYM25LD-H25-180	L	
					GYM25LD-H25-250	L	
					GYM25LD-J14-050	L	
					GYM25LD-J14-070	L	
					GYM25LD-J14-110	L	
					GYM25LD-J14-170	L	
					GYM25LD-J14-250	L	
GYHL2525M90-M25R	L	Ext.	90°	D	GYM25RA-D06	R	29,30
					GYM25RA-D12	R	
					GYM25RA-D20	R	
				E	GYM25RA-E06	R	29,30
					GYM25RA-E12	R	
					GYM25RA-E20	R	
				F	GYM25RA-F06	R	31,32
					GYM25RA-F12	R	
					GYM25RA-F20	R	
				G	GYM25RA-G08	R	31,32
					GYM25RA-G14	R	
					GYM25RA-G25	R	
				H	GYM25RA-H08	R	33,34
					GYM25RA-H14	R	
					GYM25RA-H25	R	
				J	GYM25RA-J08	R	33,34
					GYM25RA-J14	R	
					GYM25RA-J25	R	
		Face	90°	D	GYM25RD-D12-040	R	69,70
					GYM25RD-D12-050	R	
					GYM25RD-D12-060	R	
					GYM25RD-D12-075	R	
					GYM25RD-D12-100	R	
					GYM25RD-D12-135	R	
					GYM25RD-D12-180	R	
				E	GYM25RD-E12-040	R	69,70
					GYM25RD-E12-050	R	
					GYM25RD-E12-060	R	
					GYM25RD-E12-075	R	
					GYM25RD-E12-100	R	
					GYM25RD-E12-135	R	
					GYM25RD-E12-180	R	

QUICK INDEX

QUICK INDEX

Modular Blades Selection Chart (For External and Face Grooving)

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHR2525M90-M25L	R	Ext.	90°	D	GYM25LA-D06	L	29,30
					GYM25LA-D12	L	
					GYM25LA-D20	L	
				E	GYM25LA-E06	L	29,30
					GYM25LA-E12	L	
					GYM25LA-E20	L	
				F	GYM25LA-F06	L	31,32
					GYM25LA-F12	L	
					GYM25LA-F20	L	
				G	GYM25LA-G08	L	31,32
					GYM25LA-G14	L	
					GYM25LA-G25	L	
				H	GYM25LA-H08	L	33,34
					GYM25LA-H14	L	
					GYM25LA-H25	L	
				J	GYM25LA-J08	L	33,34
					GYM25LA-J14	L	
					GYM25LA-J25	L	
GYHR2525M90-M25L	R	Face	90°	D	GYM25LD-D12-040	L	69,70
					GYM25LD-D12-050	L	
					GYM25LD-D12-060	L	
					GYM25LD-D12-075	L	
					GYM25LD-D12-100	L	
					GYM25LD-D12-135	L	
					GYM25LD-D12-180	L	
				E	GYM25LD-E12-040	L	69,70
					GYM25LD-E12-050	L	
					GYM25LD-E12-060	L	
					GYM25LD-E12-075	L	
					GYM25LD-E12-100	L	
					GYM25LD-E12-135	L	
					GYM25LD-E12-180	L	
				F	GYM25LD-F12-035	L	71,72
					GYM25LD-F12-040	L	
					GYM25LD-F12-050	L	
					GYM25LD-F12-060	L	
					GYM25LD-F12-075	L	
					GYM25LD-F12-100	L	
					GYM25LD-F12-135	L	
					GYM25LD-F12-180	L	
					GYM25LD-F12-225	L	
					GYM25LD-F20-060	L	
					GYM25LD-F20-075	L	
					GYM25LD-F20-100	L	
					GYM25LD-F20-135	L	
					GYM25LD-F20-180	L	
					GYM25LD-F20-225	L	
				G	GYM25LD-G14-040	L	73,74
					GYM25LD-G14-050	L	
					GYM25LD-G14-060	L	
					GYM25LD-G14-085	L	
					GYM25LD-G14-125	L	
					GYM25LD-G14-180	L	
					GYM25LD-G14-250	L	
					GYM25LD-G25-060	L	
					GYM25LD-G25-085	L	
					GYM25LD-G25-125	L	
					GYM25LD-G25-180	L	
					GYM25LD-G25-250	L	

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHL2525M00-M25L	L	Face	00°	F	GYM25LD-F12-035	L	45,46
					GYM25LD-F12-040	L	
					GYM25LD-F12-050	L	
					GYM25LD-F12-060	L	47,48
					GYM25LD-F12-075	L	
					GYM25LD-F12-100	L	
					GYM25LD-F12-135	L	49,50
					GYM25LD-F12-180	L	
					GYM25LD-F12-225	L	
					GYM25LD-F20-060	L	47,48
					GYM25LD-F20-075	L	
					GYM25LD-F20-100	L	
				G	GYM25LD-F20-135	L	49,50
					GYM25LD-F20-180	L	
					GYM25LD-F20-225	L	
					GYM25LD-G14-040	L	53,54
					GYM25LD-G14-050	L	
					GYM25LD-G14-060	L	
					GYM25LD-G14-085	L	55,56
					GYM25LD-G14-125	L	
					GYM25LD-G14-180	L	57,58
					GYM25LD-G14-250	L	
					GYM25LD-G25-060	L	53,54
					GYM25LD-G25-085	L	
					GYM25LD-G25-125	L	55,56
					GYM25LD-G25-180	L	
					GYM25LD-G25-250	L	57,58
				H	GYM25LD-H14-050	L	59,60
					GYM25LD-H14-060	L	
					GYM25LD-H14-085	L	61,62
					GYM25LD-H14-125	L	
					GYM25LD-H14-180	L	63,64
					GYM25LD-H14-250	L	
					GYM25LD-H25-060	L	59,60
					GYM25LD-H25-085	L	
					GYM25LD-H25-125	L	61,62
					GYM25LD-H25-180	L	
					GYM25LD-H25-250	L	63,64
GYHR2525M50-M25L	R	Ext.	Recessing	D	GYM25LC-D005	L	35,36
				E	GYM25LC-E005	L	
				F	GYM25LC-F005	L	
				G	GYM25LC-G005	L	
				H	GYM25LC-H005	L	
				J	GYM25LC-J005	L	
GYHL2525M50-M25R	L	Ext.	Recessing	D	GYM25RC-D005	R	35,36
				E	GYM25RC-E005	R	
				F	GYM25RC-F005	R	
				G	GYM25RC-G005	R	
				H	GYM25RC-H005	R	
				J	GYM25RC-J005	R	

QUICK INDEX

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHR2525M00-M25R	R	Face	00°	H	GYM25RD-H14-050	R	59,60
					GYM25RD-H14-060	R	
					GYM25RD-H14-085	R	61,62
					GYM25RD-H14-125	R	
					GYM25RD-H14-180	R	63,64
					GYM25RD-H14-250	R	
					GYM25RD-H25-060	R	59,60
					GYM25RD-H25-085	R	61,62
					GYM25RD-H25-125	R	
					GYM25RD-H25-180	R	63,64
					GYM25RD-H25-250	R	
				J	GYM25RD-J14-050	R	
					GYM25RD-J14-070	R	65,66
					GYM25RD-J14-110	R	
					GYM25RD-J14-170	R	67,68
					GYM25RD-J14-250	R	
					GYM25RD-J25-070	R	65,66
					GYM25RD-J25-110	R	
					GYM25RD-J25-170	R	67,68
					GYM25RD-J25-250	R	
GYHL2525M00-M25L	L	Ext.	00°	D	GYM25LA-D06	L	
					GYM25LA-D12	L	15,16
					GYM25LA-D20	L	
				E	GYM25LA-E06	L	
					GYM25LA-E12	L	17,18
					GYM25LA-E20	L	
				F	GYM25LA-F06	L	
					GYM25LA-F12	L	19,20
					GYM25LA-F20	L	
				G	GYM25LA-G08	L	
					GYM25LA-G14	L	21,22
					GYM25LA-G25	L	
				H	GYM25LA-H08	L	
					GYM25LA-H14	L	23,24
					GYM25LA-H25	L	
				J	GYM25LA-J08	L	
					GYM25LA-J14	L	25,26
					GYM25LA-J25	L	
		Face	00°	D	GYM25LD-D12-040	L	
					GYM25LD-D12-050	L	37,38
					GYM25LD-D12-060	L	
					GYM25LD-D12-075	L	
					GYM25LD-D12-100	L	
					GYM25LD-D12-135	L	39,40
					GYM25LD-D12-180	L	
				E	GYM25LD-E12-040	L	
					GYM25LD-E12-050	L	41,42
					GYM25LD-E12-060	L	
					GYM25LD-E12-075	L	
					GYM25LD-E12-100	L	
					GYM25LD-E12-135	L	43,44
					GYM25LD-E12-180	L	

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHR2525M00-M25R	R	Ext.	00°	D	GYM25RA-D06	R	
					GYM25RA-D12	R	15,16
					GYM25RA-D20	R	
				E	GYM25RA-E06	R	
					GYM25RA-E12	R	17,18
					GYM25RA-E20	R	
				F	GYM25RA-F06	R	
					GYM25RA-F12	R	19,20
					GYM25RA-F20	R	
				G	GYM25RA-G08	R	
					GYM25RA-G14	R	21,22
					GYM25RA-G25	R	
				H	GYM25RA-H08	R	
					GYM25RA-H14	R	23,24
					GYM25RA-H25	R	
				J	GYM25RA-J08	R	
					GYM25RA-J14	R	25,26
					GYM25RA-J25	R	
		Face	00°	D	GYM25RD-D12-040	R	
					GYM25RD-D12-050	R	37,38
					GYM25RD-D12-060	R	
					GYM25RD-D12-075	R	
					GYM25RD-D12-100	R	
					GYM25RD-D12-135	R	39,40
				E	GYM25RD-E12-040	R	
					GYM25RD-E12-050	R	
					GYM25RD-E12-060	R	41,42
					GYM25RD-E12-075	R	
					GYM25RD-E12-100	R	
					GYM25RD-E12-135	R	43,44
				F	GYM25RD-F12-035	R	
					GYM25RD-F12-040	R	45,46
					GYM25RD-F12-050	R	
					GYM25RD-F12-060	R	47,48
					GYM25RD-F12-075	R	
					GYM25RD-F12-100	R	49,50
				G	GYM25RD-G14-040	R	
					GYM25RD-G14-050	R	53,54
					GYM25RD-G14-060	R	
					GYM25RD-G14-085	R	
					GYM25RD-G14-125	R	55,56
					GYM25RD-G14-180	R	57,58
				H	GYM25RD-H14-050	R	
					GYM25RD-H14-060	R	59,60
					GYM25RD-H14-085	R	
					GYM25RD-H14-125	R	61,62
					GYM25RD-H14-180	R	
					GYM25RD-H14-250	R	63,64

QUICK INDEX

Modular Blades Selection Chart (For External and Face Grooving)

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHL2020K00-M25L	L	Face	00°	H	GYM25LD-H14-050	L	59,60
					GYM25LD-H14-060	L	
					GYM25LD-H14-085	L	61,62
					GYM25LD-H14-125	L	
					GYM25LD-H14-180	L	63,64
					GYM25LD-H14-250	L	
					GYM25LD-H25-060	L	59,60
					GYM25LD-H25-085	L	
				J	GYM25LD-H25-125	L	61,62
					GYM25LD-H25-180	L	
					GYM25LD-H25-250	L	63,64
					GYM25LD-J14-050	L	
					GYM25LD-J14-070	L	65,66
					GYM25LD-J14-110	L	
					GYM25LD-J14-170	L	67,68
					GYM25LD-J14-250	L	
GYHR2020K50-M20L	R	Ext.	Recessing	D	GYM20LC-D005	L	35,36
				E	GYM20LC-E005	L	
				F	GYM20LC-F005	L	
				G	GYM20LC-G005	L	
				H	GYM20LC-H005	L	
GYHL2020K50-M20R	L	Ext.	Recessing	D	GYM20RC-D005	R	35,36
				E	GYM20RC-E005	R	
				F	GYM20RC-F005	R	
				G	GYM20RC-G005	R	
				H	GYM20RC-H005	R	
GYHR2020K90-M20L	R	Ext.	90°	D	GYM20LA-D06	L	29,30
					GYM20LA-D10	L	
					GYM20LB-D18	L	
				E	GYM20LA-E06	L	31,32
					GYM20LA-E10	L	
					GYM20LB-E18	L	
				F	GYM20LA-F06	L	33,34
					GYM20LA-F10	L	
					GYM20LB-F18	L	
					GYM20LA-G12	L	
GYHL2020K90-M20R	L	Ext.	90°	D	GYM20RA-D06	R	29,30
					GYM20RA-D10	R	
					GYM20RB-D18	R	
				E	GYM20RA-E06	R	31,32
					GYM20RA-E10	R	
					GYM20RB-E18	R	
				F	GYM20RA-F06	R	33,34
					GYM20RA-F10	R	
					GYM20RB-F18	R	
				G	GYM20RA-G12	R	33,34
					GYM20RA-H12	R	
					GYM20RA-H12	R	

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHL2020K00-M25L	L	Ext.	00°	D	GYM25LA-D06	L	15,16
					GYM25LA-D12	L	
					GYM25LA-D20	L	
				E	GYM25LA-E06	L	17,18
					GYM25LA-E12	L	
					GYM25LA-E20	L	
				F	GYM25LA-F06	L	19,20
					GYM25LA-F12	L	
					GYM25LA-F20	L	
				G	GYM25LA-G08	L	21,22
					GYM25LA-G14	L	
					GYM25LA-G25	L	
				H	GYM25LA-H08	L	23,24
					GYM25LA-H14	L	
					GYM25LA-H25	L	
				J	GYM25LA-J08	L	25,26
					GYM25LA-J14	L	
					GYM25LA-J25	L	
		Face	00°	D	GYM25LD-D12-040	L	37,38
					GYM25LD-D12-050	L	
					GYM25LD-D12-060	L	
					GYM25LD-D12-075	L	
					GYM25LD-D12-100	L	39,40
				E	GYM25LD-D12-135	L	
					GYM25LD-D12-180	L	
					GYM25LD-E12-040	L	41,42
					GYM25LD-E12-050	L	
					GYM25LD-E12-060	L	
					GYM25LD-E12-075	L	
					GYM25LD-E12-100	L	43,44
				F	GYM25LD-E12-135	L	
					GYM25LD-E12-180	L	
					GYM25LD-F12-035	L	45,46
					GYM25LD-F12-040	L	
					GYM25LD-F12-050	L	
					GYM25LD-F12-060	L	47,48
					GYM25LD-F12-075	L	
					GYM25LD-F12-100	L	
					GYM25LD-F12-135	L	49,50
					GYM25LD-F12-180	L	
					GYM25LD-F12-225	L	
				G	GYM25LD-F20-060	L	51,52
					GYM25LD-F20-075	L	
					GYM25LD-F20-100	L	
					GYM25LD-F20-135	L	
					GYM25LD-F20-180	L	
					GYM25LD-F20-225	L	53,54
					GYM25LD-G14-040	L	
					GYM25LD-G14-050	L	
					GYM25LD-G14-060	L	
					GYM25LD-G14-085	L	
					GYM25LD-G14-125	L	55,56
					GYM25LD-G14-180	L	
					GYM25LD-G14-250	L	
					GYM25LD-G25-060	L	57,58
					GYM25LD-G25-085	L	
					GYM25LD-G25-125	L	
					GYM25LD-G25-180	L	
					GYM25LD-G25-250	L	

QUICK INDEX

Modular Blades Selection Chart (For External and Face Grooving)

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHR2020K00-M25R	R	Face	00°	D	GYM25RD-D12-040	R	37,38
					GYM25RD-D12-050	R	
					GYM25RD-D12-060	R	
					GYM25RD-D12-075	R	39,40
					GYM25RD-D12-100	R	
					GYM25RD-D12-135	R	
				E	GYM25RD-D12-180	R	41,42
					GYM25RD-E12-040	R	
					GYM25RD-E12-050	R	
					GYM25RD-E12-060	R	43,44
					GYM25RD-E12-075	R	
					GYM25RD-E12-100	R	
				F	GYM25RD-E12-135	R	45,46
					GYM25RD-E12-180	R	
					GYM25RD-F12-035	R	47,48
					GYM25RD-F12-040	R	
					GYM25RD-F12-050	R	
					GYM25RD-F12-060	R	49,50
					GYM25RD-F12-075	R	
					GYM25RD-F20-060	R	
					GYM25RD-F20-075	R	51,52
					GYM25RD-F12-100	R	
					GYM25RD-F12-135	R	
				G	GYM25RD-F20-100	R	53,54
					GYM25RD-F20-135	R	
					GYM25RD-F20-180	R	55,56
					GYM25RD-F20-225	R	
					GYM25RD-F20-180	R	57,58
					GYM25RD-F20-225	R	
					GYM25RD-G14-040	R	59,60
					GYM25RD-G14-050	R	
					GYM25RD-G14-060	R	61,62
					GYM25RD-G25-060	R	
				H	GYM25RD-G14-085	R	63,64
					GYM25RD-G14-125	R	
					GYM25RD-G25-085	R	65,66
					GYM25RD-G25-125	R	
					GYM25RD-G14-180	R	67,68
					GYM25RD-G14-250	R	
					GYM25RD-G25-180	R	
					GYM25RD-G25-250	R	
					GYM25RD-H14-050	R	
					GYM25RD-H14-060	R	
					GYM25RD-H25-060	R	
				J	GYM25RD-H14-085	R	
					GYM25RD-H14-125	R	65,66
					GYM25RD-H25-085	R	
					GYM25RD-H25-125	R	67,68
					GYM25RD-H14-180	R	
					GYM25RD-H14-250	R	
					GYM25RD-H25-180	R	
					GYM25RD-H25-250	R	
					GYM25RD-J14-050	R	65,66
					GYM25RD-J14-070	R	
					GYM25RD-J14-110	R	67,68
					GYM25RD-J25-070	R	
					GYM25RD-J25-110	R	
					GYM25RD-J14-170	R	
					GYM25RD-J14-250	R	
					GYM25RD-J25-170	R	
					GYM25RD-J25-250	R	

Modular Type Holder		Cutting Mode	Angle of holder	Seat Size	Modular Blade		Page
Order Number	Hand (R/L)				Order Number	Hand (R/L)	
GYHR1616J00-M20R	R	Ext.	00°	D	GYM20RA-D06	R	15,16
					GYM20RA-D10	R	
					GYM20RB-D18	R	
				E	GYM20RA-E06	R	17,18
					GYM20RA-E10	R	
					GYM20RB-E18	R	
				F	GYM20RA-F06	R	19,20
					GYM20RA-F10	R	
					GYM20RB-F18	R	
				G	GYM20RA-G12	R	21,22
					GYM20RA-H12	R	
					GYM20RA-H12	R	
GYHL1616J00-M20L	L	Ext.	00°	D	GYM20LA-D06	L	15,16
					GYM20LA-D10	L	
					GYM20LB-D18	L	
				E	GYM20LA-E06	L	17,18
					GYM20LA-E10	L	
					GYM20LB-E18	L	
				F	GYM20LA-F06	L	19,20
					GYM20LA-F10	L	
					GYM20LB-F18	L	
				G	GYM20LA-G12	L	21,22
					GYM20LA-H12	L	
					GYM20LA-H12	L	
GYHR2020K00-M20R	R	Ext.	00°	D	GYM20RA-D06	R	15,16
					GYM20RA-D10	R	
					GYM20RB-D18	R	
				E	GYM20RA-E06	R	17,18
					GYM20RA-E10	R	
					GYM20RB-E18	R	
				F	GYM20RA-F06	R	19,20
					GYM20RA-F10	R	
					GYM20RB-F18	R	
				G	GYM20RA-G12	R	21,22
					GYM20RA-H12	R	
					GYM20RA-H12	R	
GYHL2020K00-M20L	L	Ext.	00°	D	GYM20LA-D06	L	15,16
					GYM20LA-D10	L	
					GYM20LB-D18	L	
				E	GYM20LA-E06	L	17,18
					GYM20LA-E10	L	
					GYM20LB-E18	L	
				F	GYM20LA-F06	L	19,20
					GYM20LA-F10	L	
					GYM20LB-F18	L	
				G	GYM20LA-G12	L	21,22
					GYM20LA-H12	L	
					GYM20LA-H12	L	
GYHR2020K00-M25R	R	Ext.	00°	D	GYM25RA-D06	R	15,16
					GYM25RA-D12	R	
					GYM25RA-D20	R	
				E	GYM25RA-E06	R	17,18
					GYM25RA-E12	R	
					GYM25RA-E20	R	
				F	GYM25RA-F06	R	19,20
					GYM25RA-F12	R	
					GYM25RA-F20	R	
				G	GYM25RA-G08	R	21,22
					GYM25RA-G14	R	
					GYM25RA-G25	R	
				H	GYM25RA-H08	R	23,24
					GYM25RA-H14	R	
					GYM25RA-H25	R	
				J	GYM25RA-J08	R	25,26
					GYM25RA-J14	R	
					GYM25RA-J25	R	

QUICK INDEX

QUICK INDEX

Modular Blades Selection Chart (For External and Internal Grooving)

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page
	Order Number	Hand (R/L)	Order Number	Hand (R/L)			
J	GYM25RA-J08	R	GYHR2020K00-M25R	R	Ext.	00°	25,26
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R			
	GYM25LA-J08	L	GYHL2020K00-M25L	L	Ext.	00°	25,26
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L			
	GYM25RA-J14	R	GYHR2525M90-M25L	R	Ext.	00°	25,26
			GYHR2020K00-M25R	R			
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R	Int.	90°	33,34
			GYHL2525M90-M25R	L			
			GYDL40M90D-M25R	L			
			GYDL50P90F-M25R	L			
	GYM25LA-J14	L	GYDL50T90F-M25R	L	Ext.	00°	25,26
			GYHL2020K00-M25L	L			
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L	Int.	90°	85,86
			GYHR2525M90-M25L	R			
			GYDR40M90D-M25L	R			
			GYDR40T90D-M25L	R			
	GYM25RA-J25	R	GYDR50P90F-M25L	R	Ext.	00°	25,26
			GYHR2020K00-M25R	R			
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
	GYM25LA-J25	L	GYHR3232P00-M25R	R	Ext.	00°	25,26
			GYHL2525M90-M25R	L			
			GYHL2020K00-M25L	L			
			GYHL2525M00-M25L	L			

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page
	Order Number	Hand (R/L)	Order Number	Hand (R/L)			
H	GYM20RA-H12	R	GYHR1616J00-M20R	R	Ext.	00°	23,24
			GYHR2020K00-M20R	R			
			GYHL2020K90-M20R	L			
			GYDL32L90C-M20R	L			
	GYM20LA-H12	L	GYDL32S90C-M20R	L	Int.	90°	85,86
			GYDL40M90D-M20R	L			
			GYDL40T90D-M20R	L			
			GYHL1616J00-M20L	L	Ext.	00°	23,24
	GYM25RA-H08	R	GYHL2020K00-M20L	L			
			GYHR2020K90-M20L	R			
			GYDR32L90C-M20L	R			
			GYDR32S90C-M20L	R	Int.	90°	85,86
	GYM25LA-H08	L	GYDR40M90D-M20L	R			
			GYDR40T90D-M20L	R			
			GYHR2020K00-M25R	R	Ext.	00°	23,24
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R	Int.	90°	33,34
	GYM25RA-H14	R	GYHL2525M90-M25R	L			
			GYHL2020K00-M25L	L	Ext.	00°	23,24
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
	GYM25LA-H14	L	GYHL3232P00-M25L	L	Int.	90°	85,86
			GYHR2525M90-M25L	R			
			GYDR40M90D-M25L	R			
			GYDR40T90D-M25L	R	Ext.	00°	23,24
	GYM25RA-H25	R	GYDR50P90F-M25L	R			
			GYHR2020K00-M25R	R			
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R	Int.	90°	33,34
	GYM25LA-H25	L	GYHL2525M90-M25R	L			
			GYHL2020K00-M25L	L	Ext.	00°	23,24
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L			

QUICK INDEX

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page
	Order Number	Hand (R/L)	Order Number	Hand (R/L)			
G	GYM20RA-G12	R	GYHR1616J00-M20R	R	Ext.	00°	21,22
			GYHR2020K00-M20R	R		90°	31,32
			GYHL2020K90-M20R	L			
			GYDL32L90C-M20R	L	Int.	90°	83,84
			GYDL32S90C-M20R	L			
			GYDL40M90D-M20R	L			
	GYM20LA-G12	L	GYHL1616J00-M20L	L	Ext.	00°	21,22
			GYHL2020K00-M20L	L		90°	31,32
			GYHR2020K90-M20L	R			
			GYDR32L90C-M20L	R	Int.	90°	83,84
			GYDR32S90C-M20L	R			
			GYDR40M90D-M20L	R			
	GYM25RA-G08	R	GYHR2020K00-M25R	R	Ext.	00°	21,22
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R			
	GYM25LA-G08	L	GYHL2020K00-M25L	L	Ext.	00°	21,22
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L			
	GYM25RA-G14	R	GYHR2020K00-M25R	R	Ext.	00°	21,22
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R			
			GYHL2525M90-M25R	L	Int.	90°	31,32
			GYDL40M90D-M25R	L			
			GYDL40T90D-M25R	L			
			GYDL50P90F-M25R	L			
	GYM25LA-G14	L	GYHL2020K00-M25L	L	Ext.	00°	21,22
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L			
			GYHR2525M90-M25L	R	Int.	90°	31,32
			GYDR40M90D-M25L	R			
			GYDR40T90D-M25L	R			
			GYDR50P90F-M25L	R			
	GYM25RA-G25	R	GYHR2020K00-M25R	R	Ext.	00°	21,22
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R			
	GYM25LA-G25	L	GYHL2020K00-M25L	L	Ext.	00°	21,22
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L			

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page
	Order Number	Hand (R/L)	Order Number	Hand (R/L)			
F	GYM20RA-F06	R	GYHR1616J00-M20R	R	Ext.	00°	19,20
			GYHR2020K00-M20R	R		90°	31,32
			GYHL2020K90-M20R	L			
	GYM20LA-F06	L	GYHL1616J00-M20L	L	Ext.	00°	19,20
			GYHL2020K00-M20L	L		90°	31,32
			GYHR2020K90-M20L	R			
	GYM20RA-F10	R	GYHR1616J00-M20R	R	Ext.	00°	19,20
			GYHR2020K00-M20R	R		90°	31,32
			GYHL2020K90-M20R	L			
			GYDL32L90C-M20R	L	Int.	90°	83,84
			GYDL32S90C-M20R	L			
			GYDL40M90D-M20R	L			
	GYM20LA-F10	L	GYHL1616J00-M20L	L	Ext.	00°	19,20
			GYHL2020K00-M20L	L		90°	31,32
			GYHR2020K90-M20L	R			
			GYDR32L90C-M20L	R			
	GYM20RB-F18	R	GYHR1616J00-M20R	R	Ext.	00°	19,20
			GYHR2020K00-M20R	R		90°	31,32
			GYHL2020K90-M20R	L			
			GYHL1616J00-M20L	L	Ext.	00°	19,20
	GYM20LB-F18	L	GYHL2020K00-M20L	L		90°	31,32
			GYHR2020K90-M20L	R			
	GYM25RA-F06	R	GYHR2020K00-M25R	R	Ext.	00°	19,20
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R			
	GYM25LA-F06	L	GYHL2020K00-M25L	L	Ext.	00°	19,20
			GYHL2525M00-M25L	L		90°	31,32
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L			
	GYM25RA-F12	R	GYHR2020K00-M25R	R	Ext.	00°	19,20
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R			
			GYHL2525M90-M25R	L	Int.	90°	31,32
			GYDL40M90D-M25R	L			
			GYDL40T90D-M25R	L			
			GYDL50P90F-M25R	L			
	GYM25LA-F12	L	GYHL2020K00-M25L	L	Ext.	00°	19,20
			GYHL2525M00-M25L	L		90°	31,32
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L			
			GYHR2525M90-M25L	R	Int.	90°	83,84
			GYDR40M90D-M25L	R			
			GYDR40T90D-M25L	R			
			GYDR50P90F-M25L	R			
	GYM25RA-F20	R	GYHR2020K00-M25R	R	Ext.	00°	19,20
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R			
	GYM25LA-F20	L	GYHL2020K00-M25L	L	Ext.	00°	19,20
			GYHL2525M00-M25L	L		90°	31,32
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L			

QUICK INDEX

Modular Blades Selection Chart (For External and Internal Grooving)

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page
	Order Number	Hand (R/L)	Order Number	Hand (R/L)			
E	GYM20RA-E06	R	GYHR1616J00-M20R	R	Ext.	00°	17,18
			GYHR2020K00-M20R	R		90°	29,30
			GYHL2020K90-M20R	L			
	GYM20LA-E06	L	GYHL1616J00-M20L	L	Ext.	00°	17,18
			GYHL2020K00-M20L	L		90°	29,30
			GYHR2020K90-M20L	R			
	GYM20RA-E10	R	GYHR1616J00-M20R	R	Ext.	00°	17,18
			GYHR2020K00-M20R	R		90°	29,30
			GYHL2020K90-M20R	L			
			GDDL32L90C-M20R	L	Int.	90°	81,82
			GDDL32S90C-M20R	L			
			GDDL40M90D-M20R	L			
			GDDL40T90D-M20R	L			
	GYM20LA-E10	L	GYHL1616J00-M20L	L	Ext.	00°	17,18
			GYHL2020K00-M20L	L		90°	29,30
			GYHR2020K90-M20L	R			
			GDDL32L90C-M20L	R	Int.	90°	81,82
			GDDL32S90C-M20L	R			
			GDDL40M90D-M20L	R			
			GDDL40T90D-M20L	R			
	GYM20RB-E18	R	GYHR1616J00-M20R	R	Ext.	00°	17,18
			GYHR2020K00-M20R	R		90°	29,30
			GYHL2020K90-M20R	L			
	GYM20LB-E18	L	GYHL1616J00-M20L	L	Ext.	00°	17,18
			GYHL2020K00-M20L	L		90°	29,30
			GYHR2020K90-M20L	R			
	GYM25RA-E06	R	GYHR2020K00-M25R	R	Ext.	00°	17,18
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R		90°	29,30
	GYM25LA-E06	L	GYHL2020K00-M25L	L	Ext.	00°	17,18
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L		90°	29,30
	GYM25RA-E12	R	GYHR2020K00-M25R	R	Ext.	00°	17,18
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R		90°	29,30
			GYHL2525M90-M25R	L	Int.	90°	81,82
			GDDL40M90D-M25R	L			
			GDDL40T90D-M25R	L			
			GDDL50P90F-M25R	L			
	GYM25LA-E12	L	GYHL2020K00-M25L	L	Ext.	00°	17,18
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L		90°	29,30
			GYHR2525M90-M25L	R	Int.	90°	81,82
			GDDL40M90D-M25L	R			
			GDDL40T90D-M25L	R			
			GDDL50P90F-M25L	R			
	GYM25RA-E20	R	GYHR2020K00-M25R	R	Ext.	00°	17,18
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHL2525M90-M25R	L		90°	29,30
	GYM25LA-E20	L	GYHL2020K00-M25L	L	Ext.	00°	17,18
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L		90°	29,30

Seat Size	Modular Blade		Modular Type Holder		Cutting Mode	Angle of holder	Page
	Order Number	Hand (R/L)	Order Number	Hand (R/L)			
D	GYM20RA-D06	R	GYHR1616J00-M20R	R	Ext.	00°	15,16
			GYHR2020K00-M20R	R		90°	29,30
			GYHL2020K90-M20R	L			
	GYM20LA-D06	L	GYHL1616J00-M20L	L	Ext.	00°	15,16
			GYHL2020K00-M20L	L		90°	29,30
			GYHR2020K90-M20L	R			
	GYM20RA-D10	R	GYHR1616J00-M20R	R	Ext.	00°	15,16
			GYHR2020K00-M20R	R		90°	29,30
			GYHL2020K90-M20R	L			
			GDDL32L90C-M20R	L	Int.	90°	79,80
			GDDL32S90C-M20R	L			
			GDDL40M90D-M20R	L			
	GYM20LA-D10	L	GYHL1616J00-M20L	L	Ext.	00°	15,16
			GYHL2020K00-M20L	L		90°	29,30
			GYHR2020K90-M20L	R			
			GDDL32L90C-M20L	R	Int.	90°	79,80
			GDDL32S90C-M20L	R			
			GDDL40M90D-M20L	R			
	GYM20RB-D18	R	GYHR1616J00-M20R	R	Ext.	00°	15,16
			GYHR2020K00-M20R	R		90°	29,30
			GYHL2020K90-M20R	L			
	GYM20LB-D18	L	GYHL1616J00-M20L	L	Ext.	00°	15,16
			GYHL2020K00-M20L	L		90°	29,30
			GYHR2020K90-M20L	R			
	GYM25RA-D06	R	GYHR2020K00-M25R	R	Ext.	00°	15,16
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHL2525M90-M25R	L		90°	29,30
	GYM25LA-D06	L	GYHL2020K00-M25L	L	Ext.	00°	15,16
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L		90°	29,30
	GYM25RA-D12	R	GYHR2020K00-M25R	R	Ext.	00°	15,16
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHR3232P00-M25R	R		90°	29,30
			GYHL2525M90-M25R	L	Int.	90°	79,80
			GDDL40T90D-M20R	L			
			GDDL40M90D-M25R	L			
			GDDL40T90D-M25R	L			
	GYM25LA-D12	L	GYHL2020K00-M25L	L	Ext.	00°	15,16
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L		90°	29,30
			GYHR2525M90-M25L	R	Int.	90°	79,80
			GDDL40T90D-M20L	R			
			GDDL40M90D-M25L	R			
			GDDL40T90D-M25L	R			
	GYM25RA-D20	R	GYHR2020K00-M25R	R	Ext.	00°	15,16
			GYHR2525M00-M25R	R			
			GYHR3225P00-M25R	R			
			GYHL2525M90-M25R	L		90°	29,30
	GYM25LA-D20	L	GYHL2020K00-M25L	L	Ext.	00°	15,16
			GYHL2525M00-M25L	L			
			GYHL3225P00-M25L	L			
			GYHL3232P00-M25L	L		90°	29,30

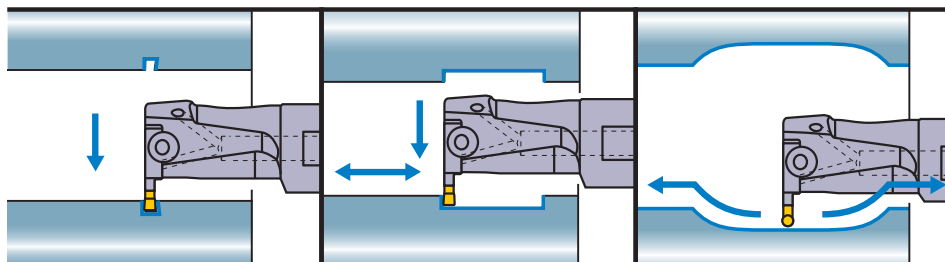
QUICK INDEX

Memo

Handwriting practice area with horizontal dotted lines.

QUICK INDEX (INTERNAL GROOVING)

90° L type holder



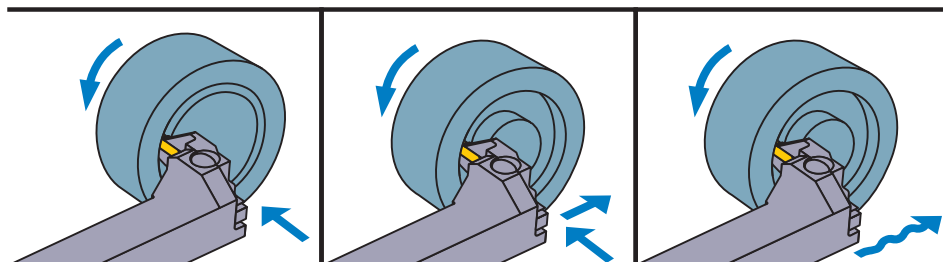
Insert Width W ₃ (mm)	Min. Cut Diameter D ₁ (mm)	Max. Groove Depth a _r (mm)	Page
2.00 2.24	25	6.0	P79,80
	32		
	40	4.0-9.5 *1	
	50	5.5-9.5 *1	
	60	7.0-11.5 *1	
	70		
2.39 2.50 2.74	25	6.0	P81,82
	32		
	40	4.0-9.5 *1	
	50	5.5-9.5 *1	
	60	7.0-11.5 *1	
	70		
3.00 3.18 3.24	25	6.0	P83,84
	32		
	40	4.0-9.5 *1	
	50	5.5-9.5 *1	
	60	7.0-11.5 *1	
	70		
4.00 4.24	32	7.0	P83,84
	40	4.5-11.5 *1	
	50	6.0-11.5 *1	
	60	7.5-13.0 *1	
	70		
4.75 5.00 5.24	32	7.0	P85,86
	40	4.5-11.5 *1	
	50	6.0-11.5 *1	
	60	7.5-13.0 *1	
	70		
6.00 6.31	60	7.5-13.0 *1	
	70		

*1 The maximum groove depth varies according to the cutting diameter D₁. For details, please refer to page 101.

QUICK
INDEX

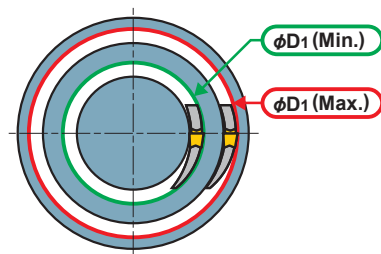
QUICK INDEX (FACE GROOVING)

90° L type holder



Notes when selecting a modular blade (1)

- Select a modular blade for face grooving, so that the cutting diameter at the first pass is within the range of D1 minimum and D1 maximum that are described in the table of dimensions.



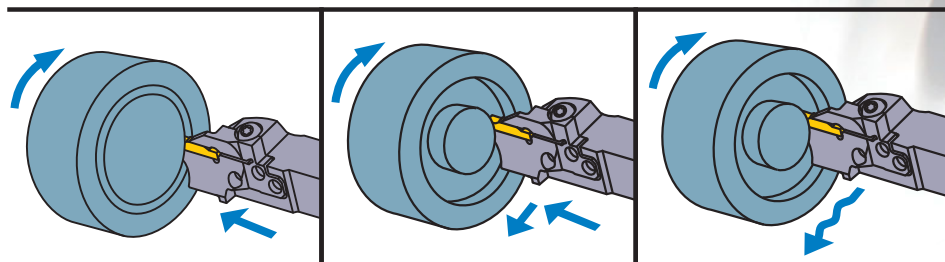
How to choose a modular blade by insert width and diameter

Insert Width W ₃ (mm)	Cutting Diameter at the First Pass øD ₁ (mm)									
	ø40	ø50	ø60	ø70	ø80	ø90	ø100	ø150	ø200	ø300
2.00 2.24		ø40-50 P69,70	ø50-60 P69,70	ø60-75 P69,70	ø75-100 P69,70		ø100-150 P69,70		ø180-250 P69,70	
2.39 2.50 2.74								ø135-200 P69,70		
3.00 3.18 3.24	ø35-40 P71,72	ø40-50 P71,72	ø50-60 P71,72	ø60-75 P71,72	ø75-100 P71,72		ø100-150 P71,72		ø180-250 P71,72	
								ø135-200 P71,72		ø225-999 P71,72
4.00 4.24		ø40-50 P73,74	ø50-60 P73,74	ø60-85 P73,74	ø85-125 P73,74		ø125-200 P73,74		ø180-280 P73,74	ø250-999 P73,74
4.75 5.00 5.24			ø50-60 P75,76	ø60-85 P75,76	ø85-125 P75,76		ø125-200 P75,76		ø180-280 P75,76	ø250-999 P75,76
6.00 6.31 6.35			ø50-70 P77,78	ø70-110 P77,78	ø110-200 P77,78		ø170-280 P77,78		ø250-999 P77,78	

All face grooving holders are modular types.
The blades can only be used for face grooving.
Compatible with 00° type face grooving holder.

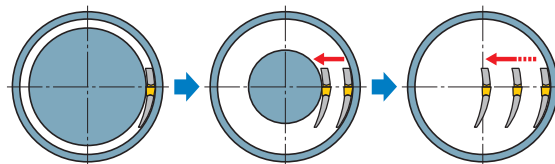
QUICK INDEX (FACE GROOVING)

00° type holder



Notes when selecting a modular blade (2)

- When machining wide face grooves, select a modular blade suitable for the maximum diameter and machine from the outer diameter towards the centre.
- When machining toward the centre, there is no restriction on the cutting diameter.
- For details, please refer to page 97.



How to choose a modular blade by insert width and diameter

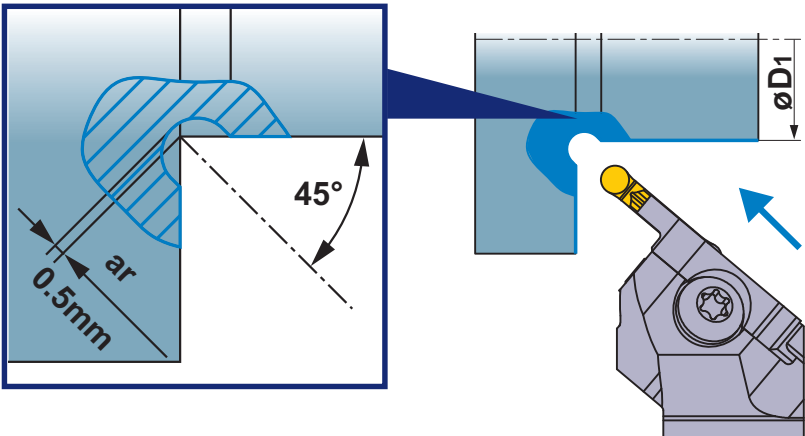
Insert Width W ₃ (mm)	Cutting Diameter at the First Pass ϕD_1 (mm)									
	$\phi 40$	$\phi 50$	$\phi 60$	$\phi 70$	$\phi 80$	$\phi 90$	$\phi 100$	$\phi 150$	$\phi 200$	$\phi 300$...
2.00 2.24		$\phi 40-50$ P37,38	$\phi 50-60$ P37,38	$\phi 60-75$ P37,38	$\phi 75-100$ P37,38		$\phi 100-150$ P39,40		$\phi 180-250$ P39,40	
2.39 2.50 2.74		$\phi 40-50$ P41,42	$\phi 50-60$ P41,42	$\phi 60-75$ P41,42	$\phi 75-100$ P41,42		$\phi 100-150$ P43,44		$\phi 180-250$ P43,44	
3.00 3.18 3.24	$\phi 35-40$ P45,46	$\phi 40-50$ P45,46	$\phi 50-60$ P45,46	$\phi 60-75$ P47,48	$\phi 75-100$ P47,48		$\phi 100-150$ P49,50		$\phi 180-250$ P51,52	
4.00 4.24		$\phi 40-50$ P53,54	$\phi 50-60$ P53,54	$\phi 60-85$ P53,54	$\phi 85-125$ P55,56		$\phi 125-200$ P55,56		$\phi 250-999$ P57,58	
4.75 5.00 5.24			$\phi 50-60$ P59,60	$\phi 60-85$ P59,60	$\phi 85-125$ P61,62		$\phi 125-200$ P61,62		$\phi 250-999$ P63,64	
6.00 6.31 6.35			$\phi 50-70$ P65,66	$\phi 70-110$ P65,66	$\phi 110-200$ P65,66				$\phi 250-999$ P67,68	

All face grooving holders are modular types.
The blades can only be used for face grooving.
Compatible with 90° L type face grooving holder.

QUICK
INDEX

QUICK INDEX (EXTERNAL RECESSING)

Recessing type holder

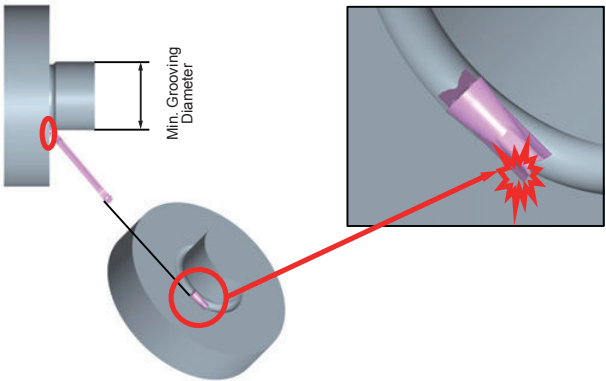


Min. Cut Diameter D1 (mm)	Insert Width W3 (mm)	Max. Groove Depth ar (mm)	Page
30	2.00	0.5	P35,36
	2.50		
	3.00		
	3.18		
20	4.00		
	5.00		
	6.00		
	6.35		

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

Minimum grooving diameter

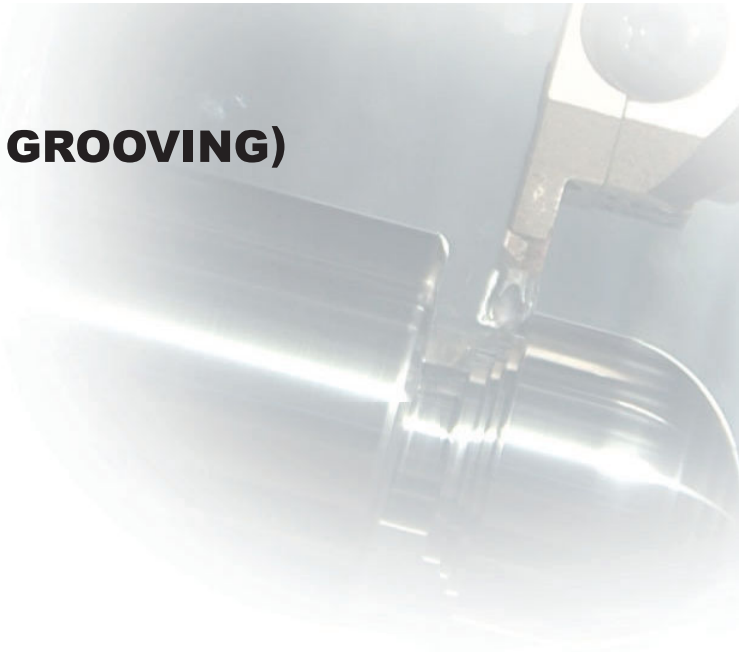
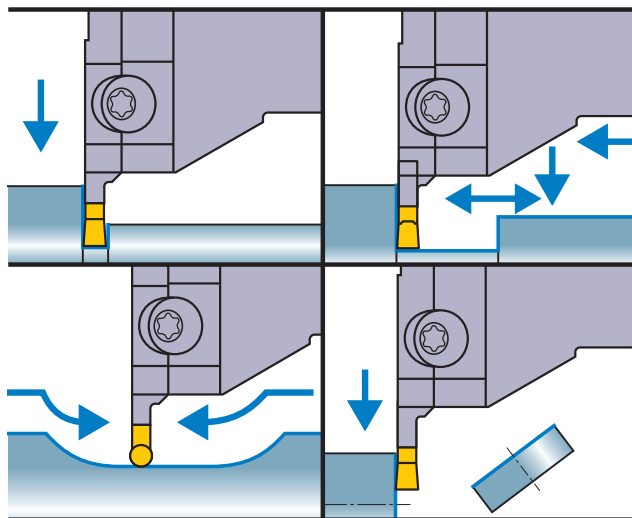
Ensure the tool is suitable for the diameter being machined. Refer to the Min. Grooving Diameter D1 as shown in the table on the first page to avoid a collision with the workpiece as shown below.



QUICK
INDEX

QUICK INDEX (EXTERNAL GROOVING)

90° L type holder



Insert Width W ₃ (mm)	Max. Groove Depth ar (mm)	Max. Cut Off Diameter D ₁ (mm)	Page
2.00 2.24	6	12	P29,30
	10	20	
	12	24	
	18 *3	36	
	20 *1	40 *2	
2.39 2.50 2.74	6	12	
	10	20	
	12	24	
	18 *3	36	
	20 *1	40 *2	
3.00 3.18 3.24	6	12	P31,32
	10	20	
	12	24	
	18 *3	36	
	20 *1	40 *2	
4.00 4.24	8	16	
	12	24	
	14	28	
	25 *1	50 *2	
4.75 5.00 5.24	8	16	P33,34
	12	24	
	14	28	
	25 *1	50 *2	
6.00 6.31 6.35	8	16	
	14	28	
	25 *1	50 *2	

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

*2 The maximum cut off diameter D₁ varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

*3 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

The modular blade is compatible with 00° type and Internal holders. >Q9

QUICK
INDEX

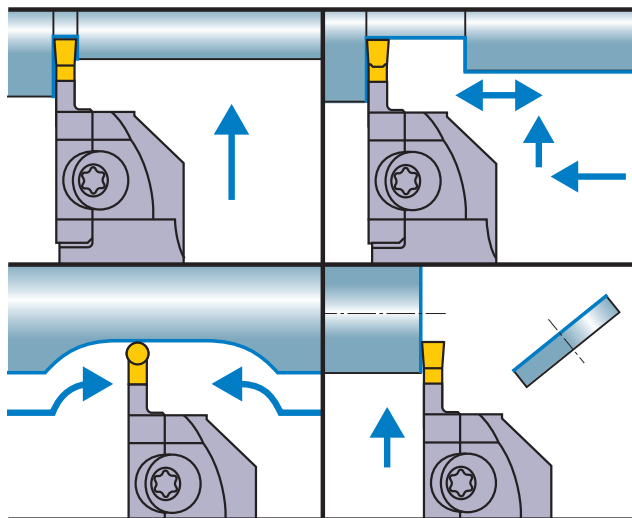
In the reverse
page order

CUTTING CONDITIONS > P87
INSTRUCTION MANUAL > P91

Q3

QUICK INDEX (EXTERNAL GROOVING)

00° type holder



Insert Width W ₃ (mm)	Max. Groove Depth ar (mm)	Max. Cut Off Diameter D ₁ (mm)	Page
2.00 2.24	6	12	P15,16
	10	20	
	12	24	
	18 *3	36	
	20 *1	40 *2	
2.39 2.50 2.74	6	12	P17,18
	10	20	
	12	24	
	18 *3	36	
	20 *1	40 *2	
3.00 3.18 3.24	6	12	P19,20
	10	20	
	12	24	
	18 *3	36	
	20 *1	40 *2	
4.00 4.24	8	16	P21,22
	12	24	
	14	28	
	25 *1	50 *2	
4.75 5.00 5.24	8	16	P23,24
	12	24	
	14	28	
	25 *1	50 *2	
6.00 6.31 6.35	8	16	P25,26
	14	28	
	25 *1	50 *2	
8.00	25 *1	50 *2	P27,28

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.

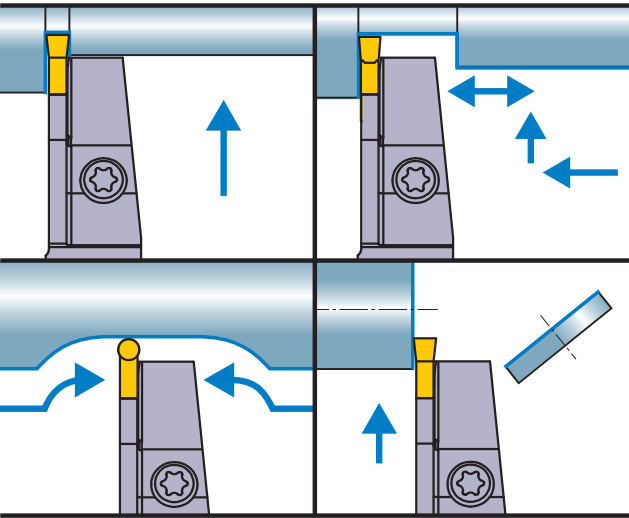
*2 The maximum cut off diameter D₁ varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.

*3 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

The modular blade is compatible with 90° L type and Internal holders. >Q9

QUICK INDEX (EXTERNAL GROOVING for Swiss style lathes)

00° type holder



Max. Groove Depth ar (mm) *3	Max. Cut Off Diameter D1 (mm)	Holder		Insert Width W3 (mm)	Page
		H1	B		
11	22	10	10	1.50	P13,14
				2.00	
13	26	12	12	2.24	
				2.39	
17 *1	34 *2	16	16	2.50	
				3.00	
18 *1	36 *2	20	12	3.18	
				3.24	

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 9 to 11.
*2 The maximum cut off diameter D1 varies according to the insert used. The cut off diameter is double the maximum groove depth (ar) of inserts on pages 9 to 11.
*3 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 89.

QUICK
INDEX

Grooving System

GY Series QUICK INDEX

Side B

QUICK INDEX Q1

* Side B page begins from this side.

Q2 EXTERNAL GROOVING
00° type holder

Q3 EXTERNAL GROOVING
90° L type holder

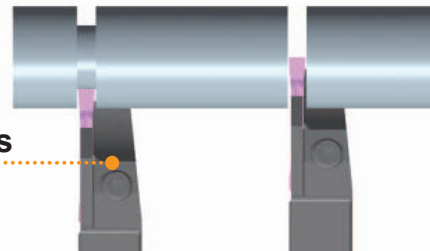
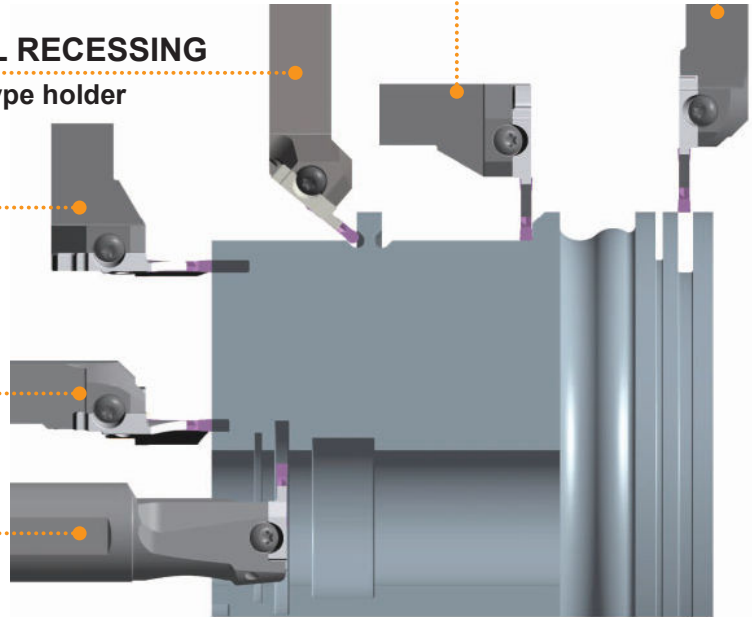
Q4 EXTERNAL RECESSING
Recessing type holder

Q6 FACE GROOVING
90° L type holder

Q5 FACE GROOVING
00° type holder

Q7 INTERNAL GROOVING
90° L type holder

Q1 EXTERNAL GROOVING for Swiss style lathes
00° type holder



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.

 **MITSUBISHI MATERIALS CORPORATION**



**COMPLETE
METALWORKING
SOLUTIONS**

(800) 991-4225

www.ahbinc.com

ISO Certified

customerservice@ahbinc.com

<http://www.mitsubishicarbide.com/en/>
(Tools specifications subject to change without notice.)

EXP-09-N212
2014.7.E(-)