

GY GROOVING SERIES

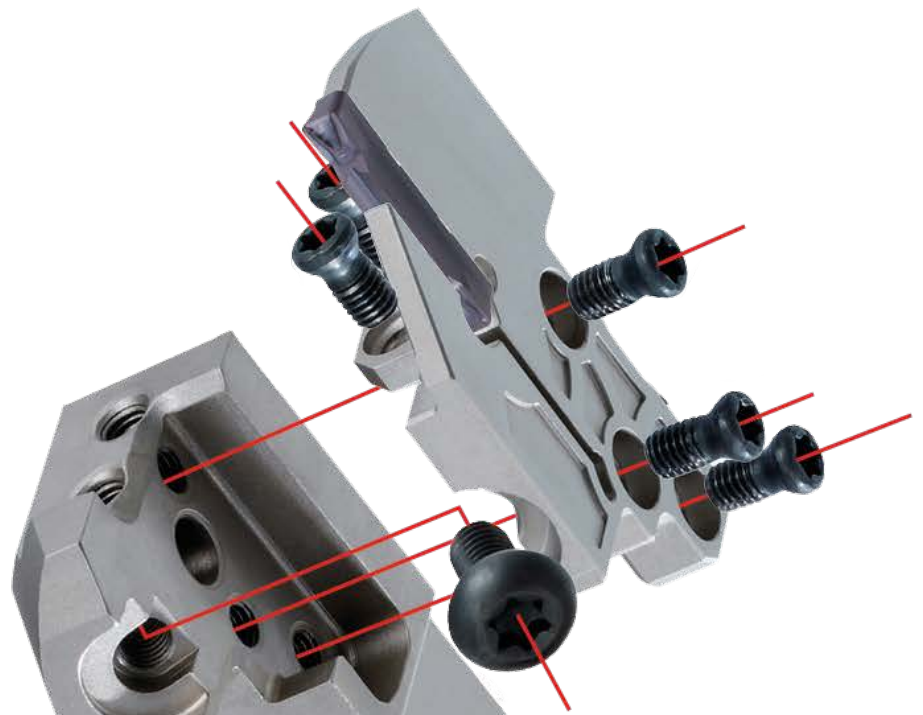
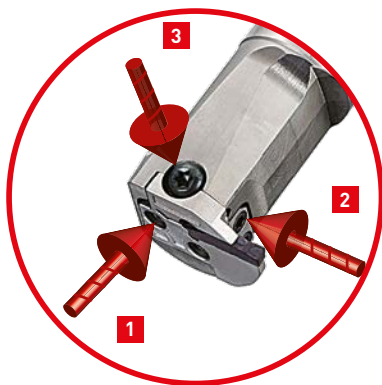
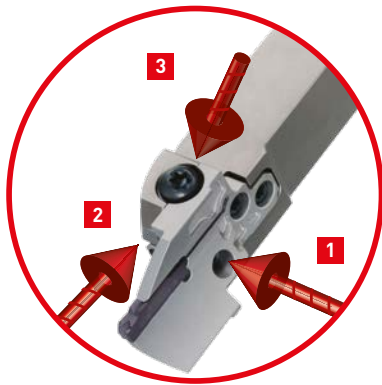
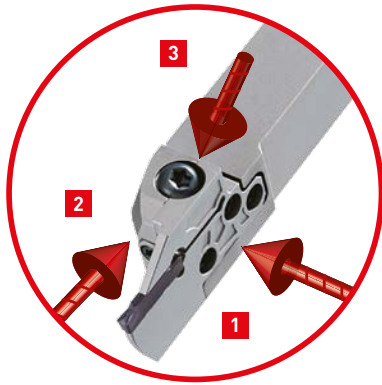
A WIDE SELECTION OF HOLDERS AND INSERTS AVAILABLE
FOR DIVERSE GROOVING APPLICATIONS



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TRIFORCE SYSTEM FOR INCREASED STABILITY AND PERFORMANCE



Mitsubishi Materials has developed an original and unique, modular blade system.

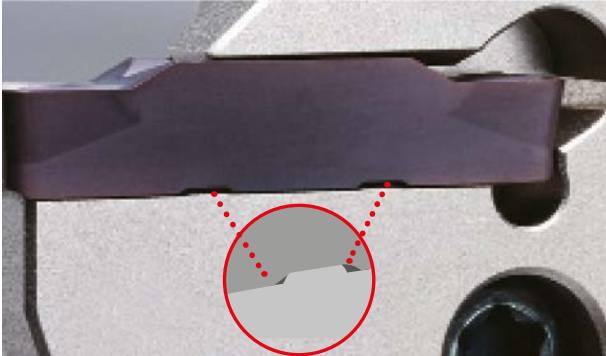
The TRIFORCE grooving system ensures the blade is securely fixed in 3 directions (side, front and top) giving high rigidity for a stable grooving performance.

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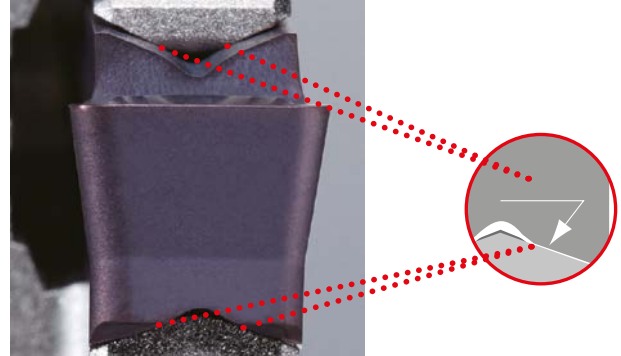
ORIGINAL INSERT DESIGN LEADING THE WAY TO NEW GROOVING APPLICATIONS

HIGHLY RELIABLE INSERT CLAMPING

Safety keys prevent insert movement.

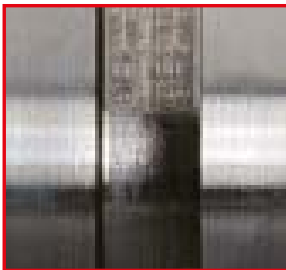


The convex geometry ensures high precision clamping.

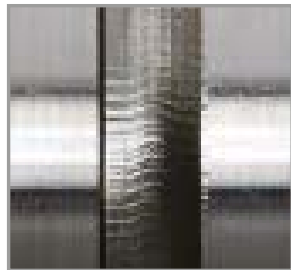


COMPARISON OF FINISHED SURFACE

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



GY

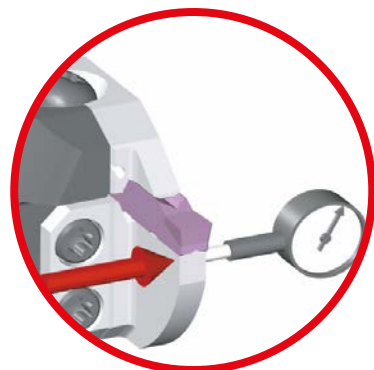
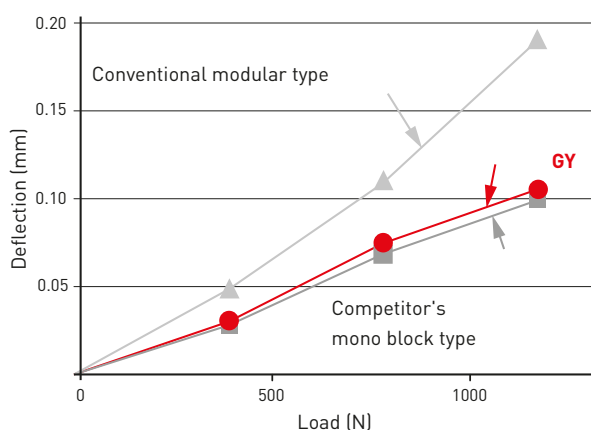


Conventional modular type

Material	SCM440
Insert width (mm)	5
Vc (m/min)	150
f (mm/rev.)	0.2
ap (mm)	23

RIGIDITY COMPARISON

The grooving system provides rigidity comparable to a monoblock type grooving tool.



Tool body for 5 mm width insert

GY GROOVING SERIES

A WIDE SELECTION OF INSERTS

CUTTING OFF



GU Chipbreaker
(For mild steel)



GS Chipbreaker
(Low feeds)



GM Chipbreaker
(Medium feeds)



R/L05-GM Breaker
(Medium feeds)



R08-GS Breaker
(Low feeds)



R15-GS Breaker
(Low feeds)



GL Breaker
(For aluminium
alloys)

GROOVING



GU Chipbreaker
(For mild steel)



GS Chipbreaker
(Low feeds)



GM Chipbreaker
(Medium feeds)



GFGS
(For hardened
materials)



GL Breaker
(For aluminium
alloys)

FOR MULTIFUNCTIONAL GROOVING



MF Chipbreaker
(G class)



MS Chipbreaker
(Low feeds)



MM Chipbreaker
(Medium feeds)

COPYING/RECESSING



BM Chipbreaker
(Medium feeds)



Breaker	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	MP9015	MP9025
GU Breaker			✓	✓		✓			
GS Breaker	✓	✓	✓	✓		✓			
GM Breaker			✓	✓	✓	✓		✓	✓
GL Breaker	✓								
MF Breaker	✓		✓	✓		✓			
MS Breaker			✓	✓	✓	✓			
MM Breaker			✓	✓	✓	✓		✓	✓
BM Breaker			✓	✓	✓	✓		✓	✓
Blank Insert	✓	✓				✓			
GFGS Honing (PCBN)							✓		

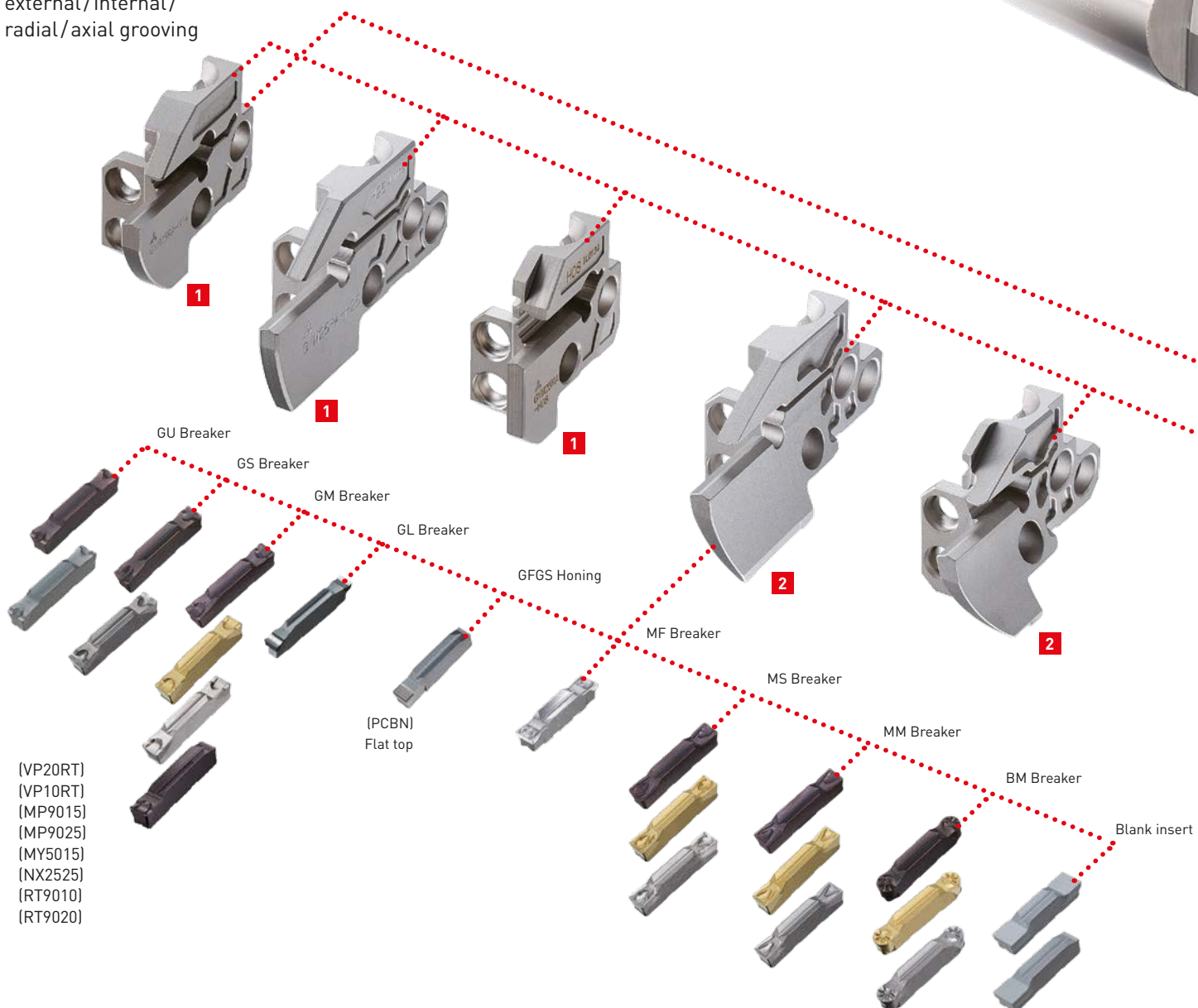
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CORRESPONDING BLADES TO A VARIETY OF MODULAR HOLDERS WITH DIFFERENT SHANK SIZES

MODULAR HOLDER FOR INTERNAL GROOVING

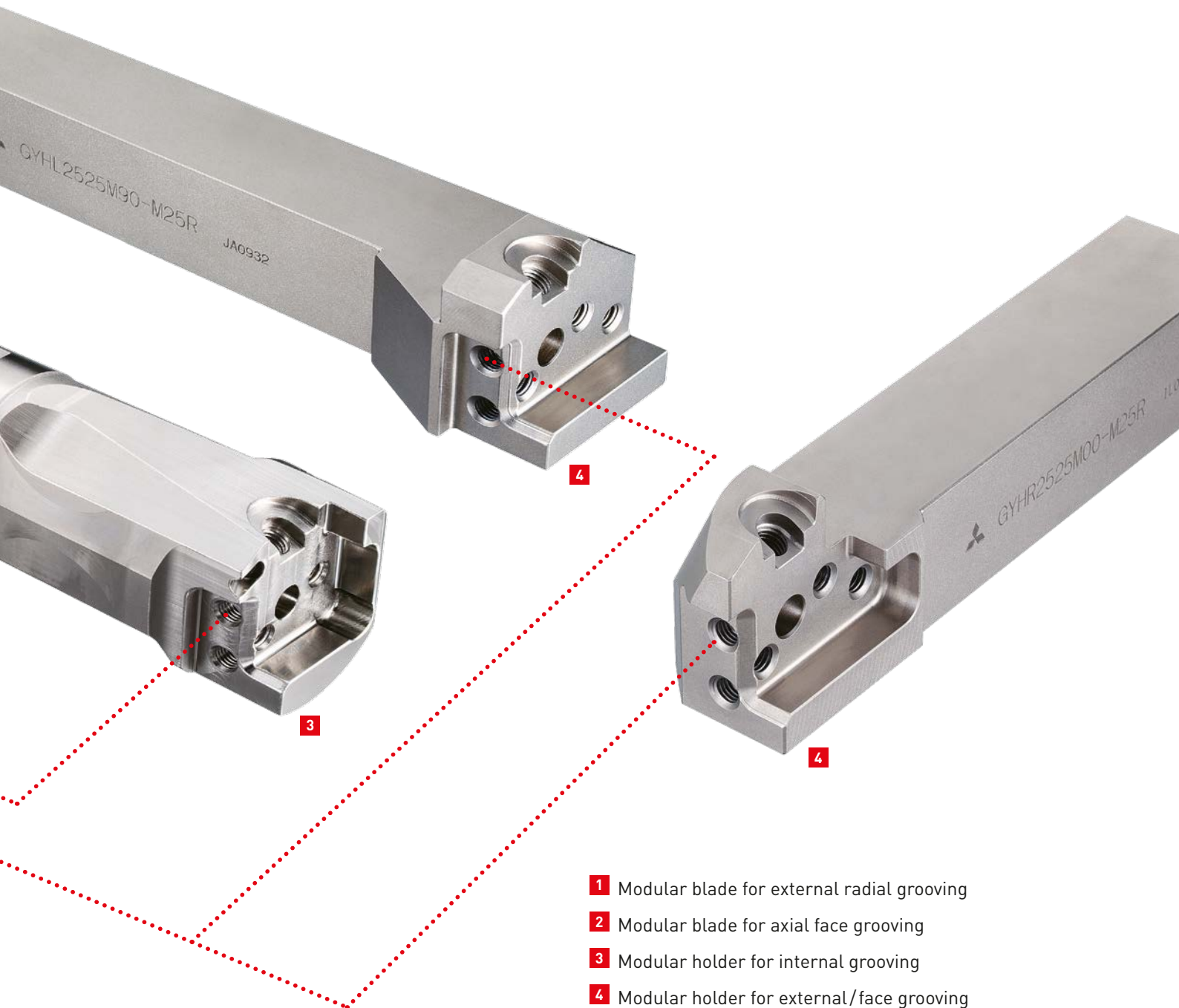
Easy to use modular blade system allows flexible tool management but maintains an overall strength comparable to a monoblock type holder.

Modular blade for
external/internal/
radial/axial grooving



MODULAR HOLDER FOR EXTERNAL/FACE GROOVING

A wide variety of products with assorted combinations to consolidate necessary tools for diverse grooving applications.



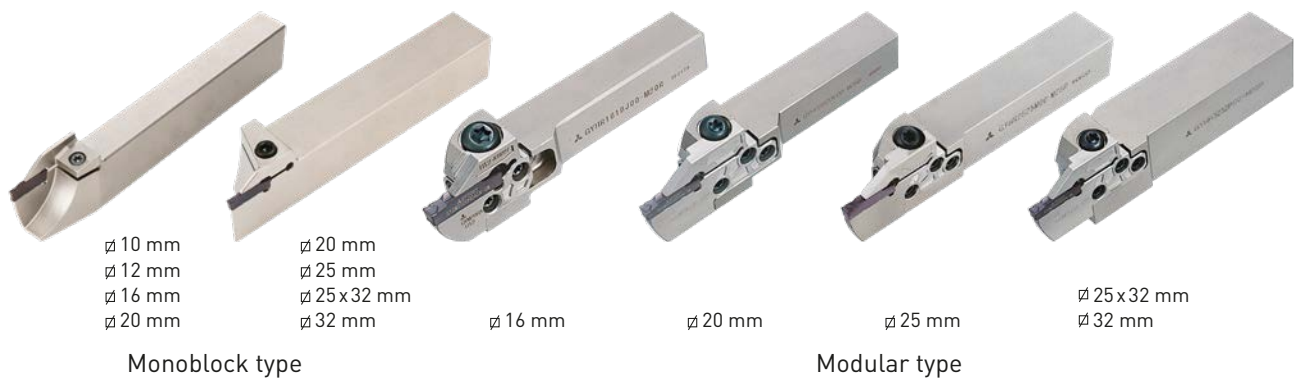
**A WIDE VARIETY OF PRODUCTS WITH ASSORTED
COMBINATIONS TO CONSOLIDATE NECESSARY TOOLS
FOR DIVERSE GROOVING APPLICATIONS.**

GY GROOVING 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.



Various depths of groove possible with a single tool using different modular blades.

Various sizes of face grooves from a wide array of modular blades.



External grooving

Face grooving

INTERNAL HOLDERS

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

Short shank types are stock standard.

Monoblock type

Modular type

Monoblock type

Modular type

Min. cutting diameter
 $\varnothing 25, \varnothing 32$



Min. cutting diameter
 $\varnothing 40, \varnothing 50, \varnothing 60, \varnothing 70$



Short

Standard

Short

Standard

GY GROOVING SERIES

MONOBLOCK HOLDERS FOR EXTERNAL GROOVING AND FOR SWISS TYPE LATHE MACHINES

Monoblock holder
∅ 20 mm × 20 mm
∅ 25 mm × 25 mm



For Swiss type lathes

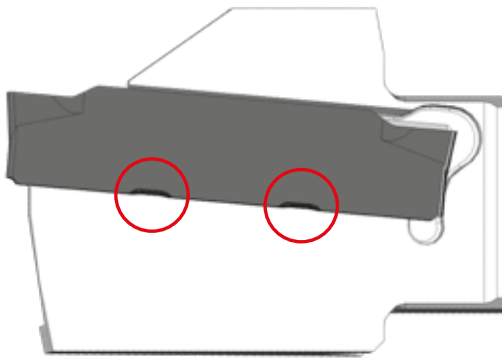
2 corner insert
Insert width 2.0 – 8.0 mm

GY GROOVING SERIES

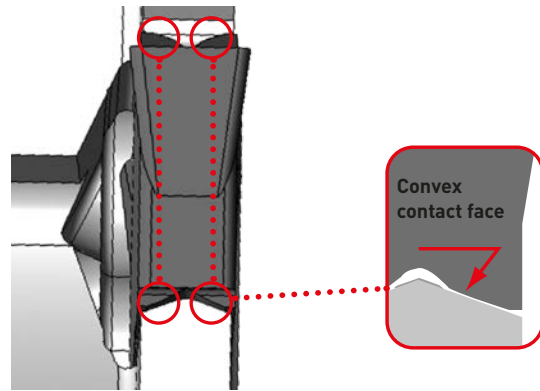
INNOVATIVE CLAMPING SYSTEM FOR SWISS TYPE LATHES ENSURES RELIABLE GROOVING

HIGHLY RELIABLE INSERT CLAMP

The safety key locks the insert and prevents movement.



The convex geometry ensures high precision clamping.

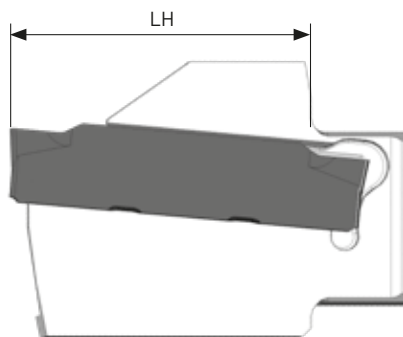


MONOBLOCK HOLDER FOR SWISS TYPE AUTOMATIC LATHES

The new geometry with greatly improved rigidity suppresses vibrations and dimensional changes thereby solves common cutting off problems.

OVERHANG LENGTH COMPATIBLE WITH SWISS TYPE AUTOMATIC LATHES

Head length corresponding to the maximum machining diameter of CNC Swiss type automatic lathes and turret machines.

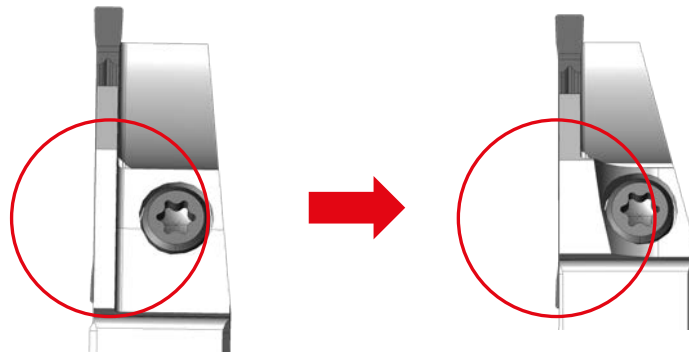


GY GROOVING SERIES

FEATURES OF THE HIGH-RIGIDITY HOLDER FOR SWISS TYPE LATHES

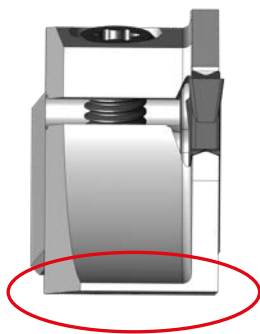
STRONG CLAMP BRIDGE

The strong design of the clamp bridge suppresses chatter and vibration.

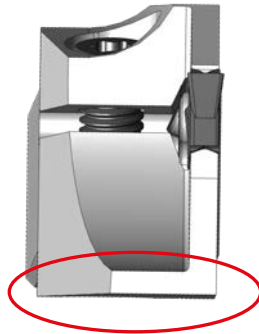


THICKER TOOL BASE

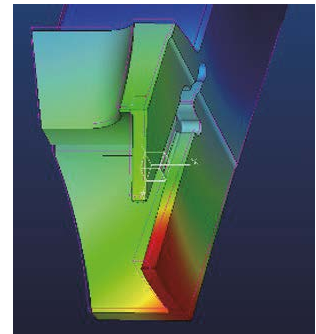
Tool deflection caused by cutting resistance is greatly reduced.



Analysis by simulation
Deflection measurement: 0.044 mm



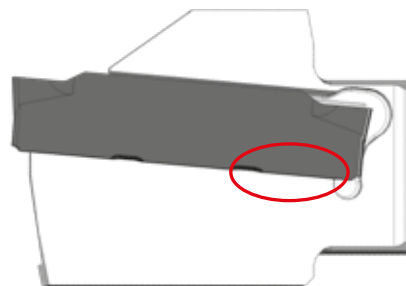
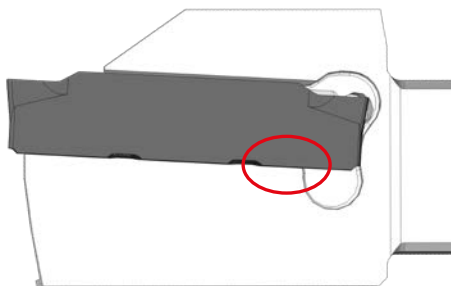
Analysis by simulation
Deflection measurement: 0.013 mm



Analysis by simulation

STRENGTHENING OF THE INSERT CLAMP

The seating face of the insert becomes wider reducing the deformation of the workpiece material.



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NEW LINE-UP

LOW RESISTANCE/LOW FEED BREAKER

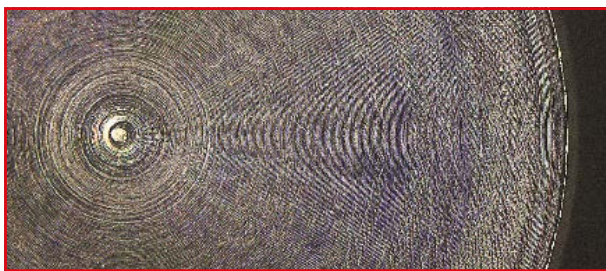
GS Breaker for lead angle 8° and 15°

By improving dimensional accuracy, the amount of remaining centre pip is reduced and good surface finishes are achieved.

CUTTING PERFORMANCE

SUS304 Comparison of cutting off and remaining material

COMPLETE CUTTING OFF



GY
GS breaker



Remaining pip in the centre: Ø 0.49 mm, Rz: 0.009 mm

NOT COMPLETELY CUT OFF

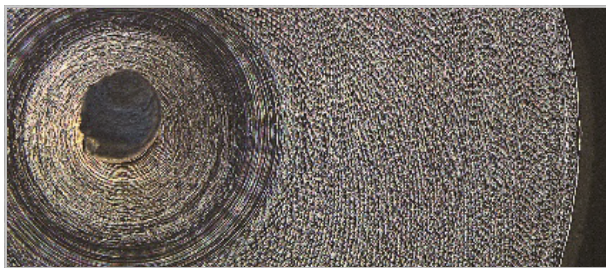


Conventional A



Remaining pip in the centre: Ø 0.58 mm, Rz: 0.043 mm

NOT COMPLETELY CUT OFF



Conventional B



Remaining pip in the centre: Ø 1.42 mm, Rz: 0.015 mm

Material	SUS304 Ø 16mm
Tool	CW = 2 mm Lead Angle 15°
Vc (m/min)	100
f (mm/rev)	0.03
Cutting mode	Wet cutting

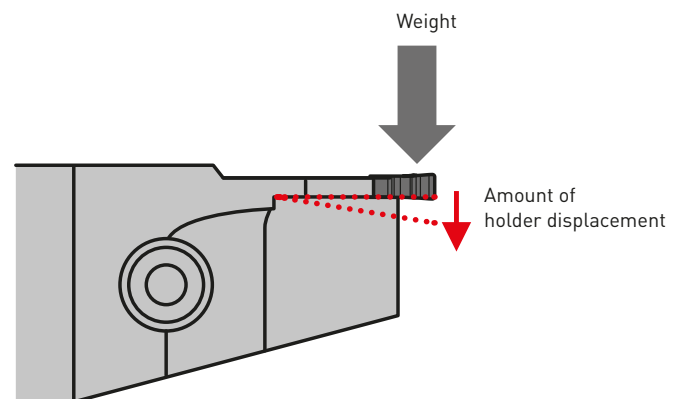
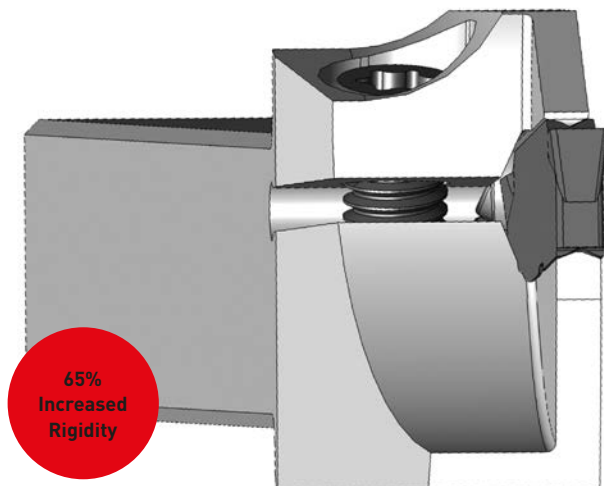
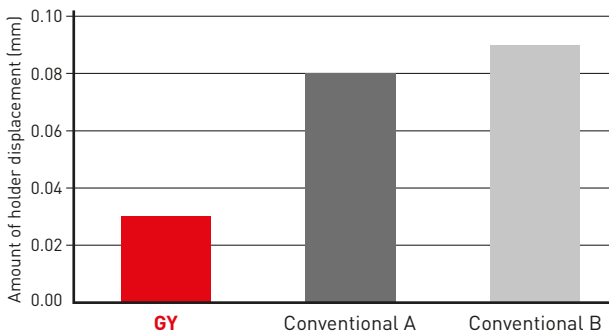
GY GROOVING SERIES

CUTTING PERFORMANCE FOR SWISS TYPE LATHES

TOOL HOLDER DEFLECTION COMPARISON

The high rigidity of the tool reduces chatter and vibration thereby improving the component surface finish and also reduces the remaining pip in the centre.

GY holder



GY GROOVING SERIES

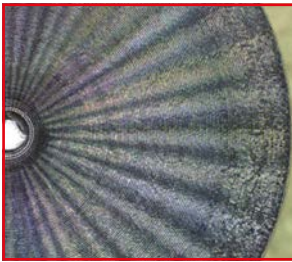
CUTTING PERFORMANCE FOR SWISS TYPE LATHES

SURFACE FINISH COMPARISON WHEN CUTTING OFF: 1.4301 X5CRN118-9

The high-rigidity holder suppresses vibration and tool deflection, improving the finished surface.

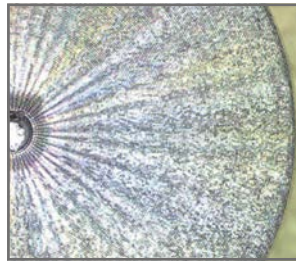
GY Holder

Rz 1.8 μm



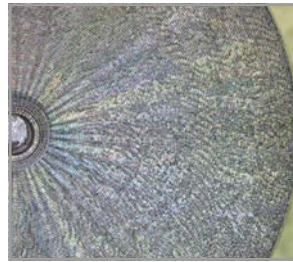
GY

Rz 5.6 μm



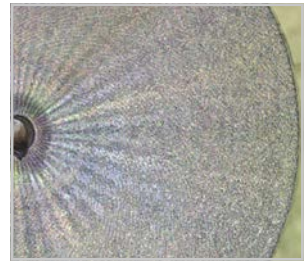
Conventional A

Rz 4.1 μm



Conventional B

Rz 5.7 μm



Conventional C

Material	1.4301 $\varnothing$ 25mm
Tool	CW = 2 mm RE = 0.2 mm 16 x 16
Vc (m/min)	120
f (mm/rev)	0.10
Cutting mode	Wet cutting

Excellent
surface
finish

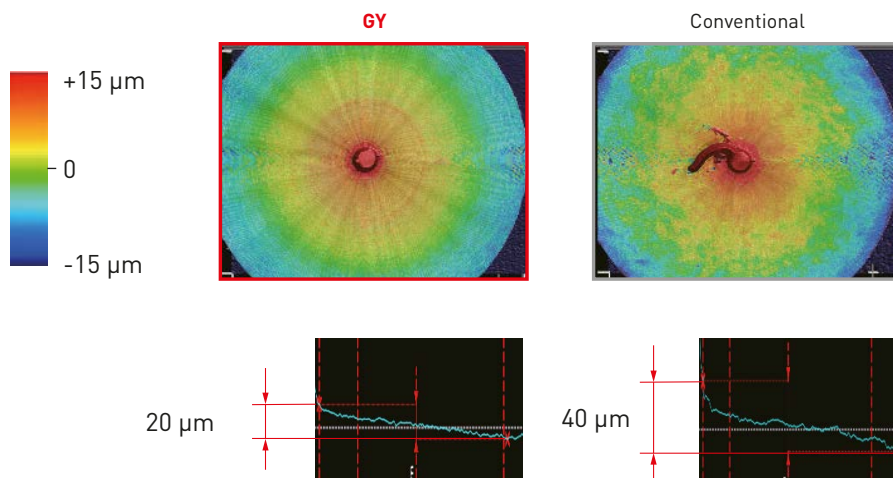
GY GROOVING SERIES

CUTTING PERFORMANCE FOR SWISS TYPE LATHES

COMPARISON OF THE ACCURACY OF THE WORKPIECE WHEN CUTTING OFF: 1.4301 X5CRNI18-9

GY Holder

Height difference colour



Displacement
reduced by 50%
compared to
conventional
products

Material	1.4301 $\varnothing$ 25mm
Tool	CW = 2 mm RE = 0.2 mm 16 x 16
Vc (m/min)	120
f (mm/rev)	0.10
Cutting mode	Wet cutting

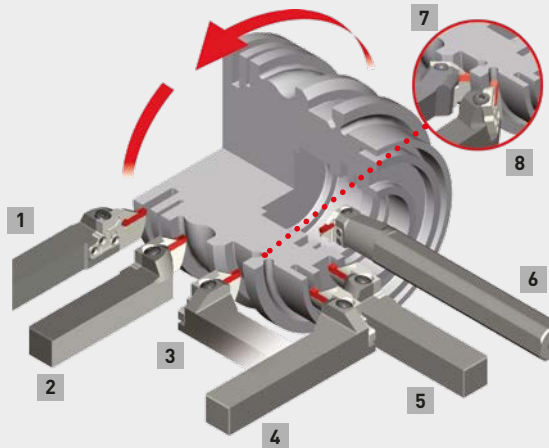
GY GROOVING SERIES

STEP 1 – SELECT AN APPLICATION

SELECT THE APPLICATION AND THE DIRECTION OF THE WORKPIECE ROTATION, THEN FOLLOW THE NEXT STEPS

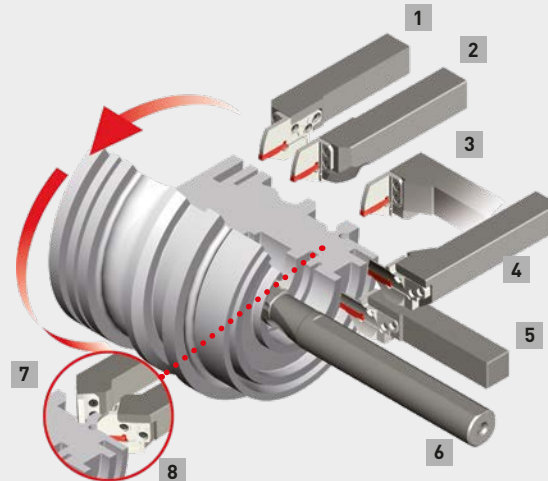
CLOCKWISE

Normal use



No.	Type	Angle	Hand	Page
1	External	0°	L	39
2	External	0°	R	39
3	External	90°	L	46
4	Face	90°	R	64

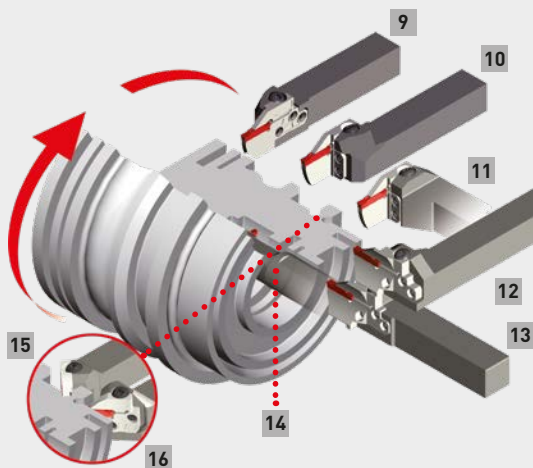
Reverse holder use



No.	Type	Angle	Hand	Page
5	Face	0°	L	49
6	Internal	90°	R	66
7	Recessing	50°	L	48
8	Recessing	50°	R	48

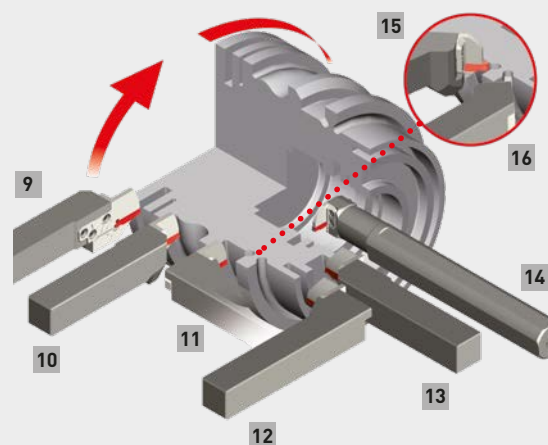
COUNTER CLOCKWISE

Normal use



No.	Type	Angle	Hand	Page
9	External	0°	R	39
10	External	0°	L	39
11	External	90°	R	46
12	Face	90°	L	64

Reverse holder use



No.	Type	Angle	Hand	Page
13	Face	0°	R	49
14	Internal	90°	L	66
15	Recessing	50°	R	48
16	Recessing	50°	L	48

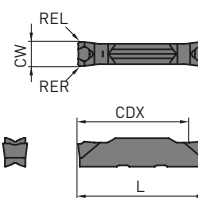
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STEP 2 – SELECT AN INSERT

- 1** Select an insert suitable for the machining application, then select the corresponding seat size. Seat size refers to the seat width of the modular blade.

INSERTS

Order number	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	MB8025	Seat size	CW	Tolerance	RE R/L	CDX	L	Geometry
FOR GROOVING / CUTTING OFF														
GY2M0200D020N-GU	●	●			●			D	2.00	±0.03	0.2	19.7	20.70	GU (For gummy steel)
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	



STEP 3 – SELECT A MODULAR HOLDER & A MODULAR BLADE

- 1** Proceed to the tool holder page in STEP 1, then go to the column of the seat size selected in STEP 2.
- 2** Select the hand of the tool holder.
- 3** Select a modular holder suitable for the machine used.
- 4** Select the maximum groove depth.
- 5** Select a modular blade that corresponds to **4**. When selecting a modular blade for face grooving note if the cutting diameter range is suitable.

3		5		1		4		2										
Order number Holder		Order number Modular blade		Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
	Stock																	
GYHR1616J00-M20R	●	GYM20RA-D06	●	D	2.00 2.24		6	12	R	16	16	104	28	44	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-D06	●						L	16	16	104	28	44	16	20	4	3
GYQR2020K00-D06	●	—							R	20	20	125	36	—	20	20.15	—	7
GYQL2020K00-D06	●	—							L	20	20	125	36	—	20	20.15	—	7
GYHR2020K00-M20R	●	GYM20RA-D06	●						R	20	20	119	28	43	20	23	—	1
GYHL2020K00-M20L	●	GYM20LA-D06	●						L	20	20	119	28	43	20	23	—	1
GYHR2020K00-M25R	●	GYM25RA-D06	●						R	20	20	117	31	52	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-D06	●						L	20	20	117	31	52	20	26	5	3
GYQR2525M00-D06	●	—							R	25	25	150	36	—	25	25.15	—	7

IDENTIFICATION

INSERT / BLADE / TOOL BLOCK

INSERT

	GY	2	M	0300	F	030	N	05	—	G	F	
Series description	Peripheral		Groove width		Seat size*1		Hand		Application 1			
	G Ground				C 1.50mm		N Neutral		G Grooving/ Cutting off			
	M Sintered		0150 1.50mm		D 2.00mm		R Right		M Multifunctional			
	B Blank		0200 2.00mm		E 2.24mm		L Left		B Copying (Ball nose)			
Number of teeth				2.39mm								
1 1 Edge type				2.50mm								
2 2 Edge type		0800 8.00mm		2.74mm								
				3.00mm								
				3.18mm								
				3.24mm								
				4.00mm								
				4.24mm								
				4.75mm								
				5.00mm								
				5.24mm								
				6.00mm								
				6.31mm								
				6.35mm								
				8.00mm								

PCBN INSERT

GY	1	G	0300	F	020	N	—	G	F	GS
										Honing type
										Application 3
										F Flat top

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

IDENTIFICATION

INSERT / BLADE / TOOL BLOCK

MODULAR BLADE

External/Internal/Recessing

	GY	M25	R	A	—	F	12	
Series description	Modular blade size	Hand	Modular blade type	Seat size*1	Max. groove depth*2			
	M20	R Right	A Standard type	D 2.00 mm	005 0.5 mm			
	M25	L Left	B Reinforced type	2.24 mm	06 6 mm			
			C External recessing	2.39 mm	:	:		
			D Face grooving	2.50 mm	25 25 mm			
				2.74 mm				
				3.00 mm				
				F 3.18 mm				
				3.24 mm				
				G 4.00 mm				
				4.24 mm				
				4.75 mm				
				H 5.00 mm				
				5.24 mm				
				6.00 mm				
				J 6.31 mm				
				6.35 mm				

FACE GROOVING

GY	M25	R	D	—	F	12	050	
								Min. groove diameter
								035 35 mm
								040 40 mm
								:
								250 250 mm

Note : Dimension symbols conforming to ISO13399.

*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.

*³ For internal grooving, refer to the maximum groove depth (CDX) on pages 94 – 96.

*⁴ GYM20R/LA-10, GYM20R/LA-12, GYM25R/LA-12 and GYM25R/LA-14 can be used for both external and internal grooving.

IDENTIFICATION

INSERT / BLADE / TOOL BLOCK

EXTERNAL / FACE GROOVING / RECESSING

Monoblock holder

	GY	P	R	2525	M	00	—	K	25	
Series description	Hand of holder		Shank diameter (H x W)		Holder length		Seat size*¹		Max. groove depth	
	R	Right	1010	10 mm x 10 mm	J	110 mm	C	1.50 mm	06	6 mm
	L	Left	1212	12 mm x 12 mm	JX	120 mm	D	2.00 mm	08	8 mm
			1616	16 mm x 16 mm	K	125 mm		2.24 mm	:	:
			2012	20 mm x 12 mm	M	150 mm		2.39 mm	25	25 mm
			2020	20 mm x 20 mm	P	170 mm	E	2.50 mm		
			2525	25 mm x 25 mm				2.74 mm		
			3225	32 mm x 25 mm				3.00 mm		
			3232	32 mm x 32 mm				3.18 mm		
Holder type					Angle (degree)					
P	With monoblock offset				00	0°	F	3.24 mm		
H	Modular holder				50	50°	G	4.00 mm		
					90	90°		4.24 mm		
							H	4.75 mm		
								5.00 mm		
								5.24 mm		
								6.00 mm		
							J	6.31 mm		
								6.35 mm		
							K	8.00 mm		

Modular holder

GY	H	R	2525	M	00	—	M25	R
							Modular blade size	Hand of modular blade
							M20	R Right
							M25	L Left

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

IDENTIFICATION

INSERT / BLADE / TOOL BLOCK

INTERNAL

Monoblock holder

	GY	A	R	20	K	90	A	—	F	06
Series description	Hand of holder		Shank diameter		Holder length		Angle (degree)		Max. groove depth	
	R Right		20 20 mm		K 125 mm		90 90°		06 6 mm	
	L Left		25 25 mm		L 140 mm				07 7 mm	
			32 32 mm		M 150 mm					
			40 40 mm		P 170 mm					
			50 50 mm		Q 180 mm					
					R 200 mm					
					S 250 mm					
					T 300 mm					
Holder Type							Neck length		Seat size*1	
A Monoblock							A 30 mm		D 2.00 mm	
D Modular holder							B 40 mm		2.24 mm	
							C 50 mm		2.39 mm	
							D 60 mm		2.50 mm	
							F 80 mm		2.74 mm	
									3.00 mm	
									F 3.18 mm	
									3.24 mm	
									4.00 mm	
									G 4.24 mm	
									4.75 mm	
									H 5.00 mm	
									5.24 mm	
									6.00 mm	
									J 6.31 mm	
									6.35 mm	

Modular holder

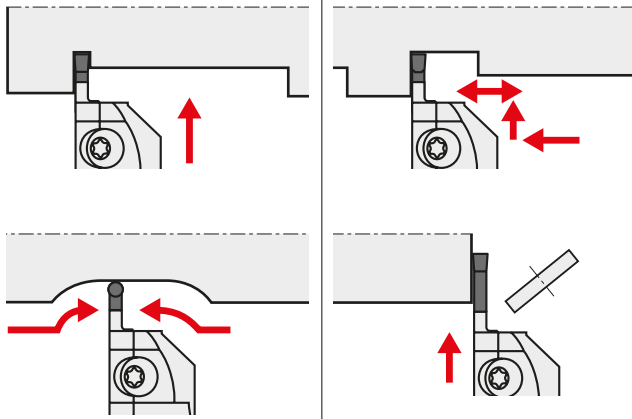
GY	D	R	40	M	90	D	—	M25	L
								Modular blade size	Hand of modular blade
								M20	R Right
								M25	L Left

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

GY GROOVING SERIES

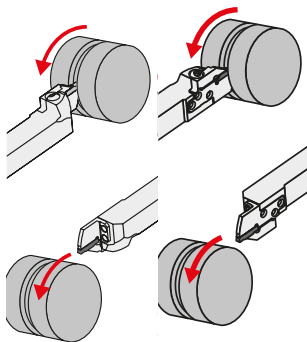
EXTERNAL GROOVING

00° TYPE HOLDER

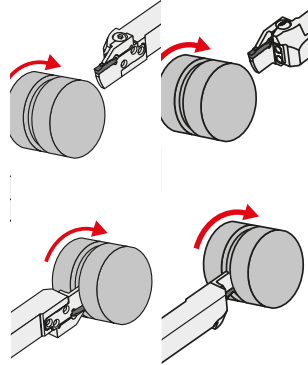


CUTTING MODE

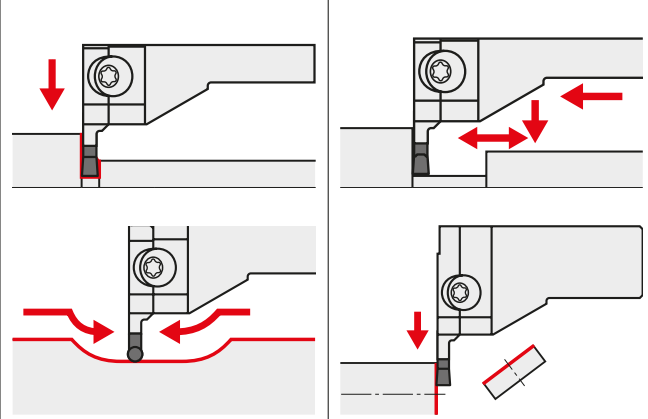
Clockwise



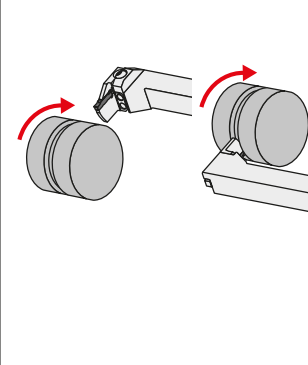
Anticlockwise



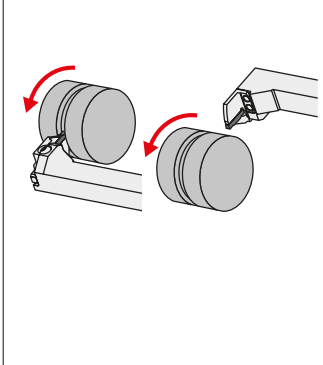
90° TYPE HOLDER



Anticlockwise

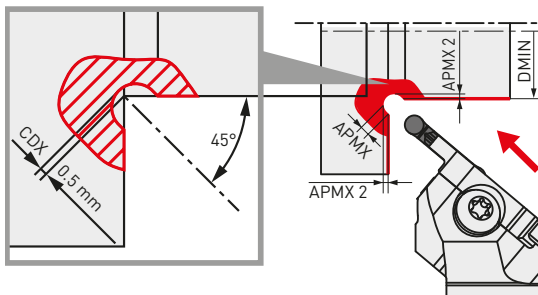


Clockwise



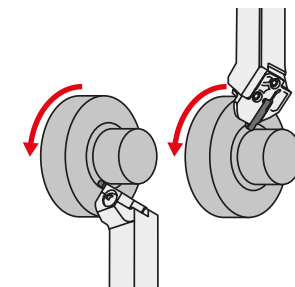
EXTERNAL RECESSING

50° TYPE HOLDER

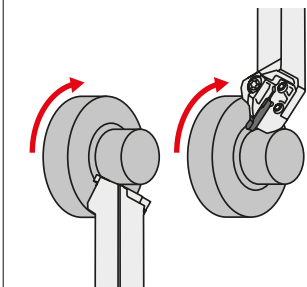


CUTTING MODE

Clockwise



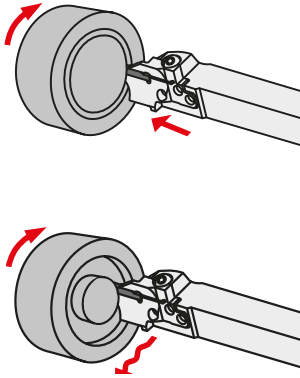
Anticlockwise



GY GROOVING SERIES

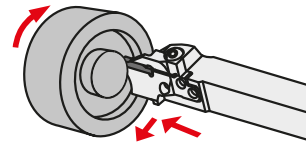
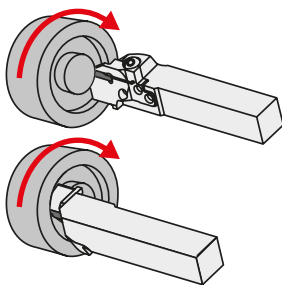
FACE GROOVING

00° TYPE HOLDER

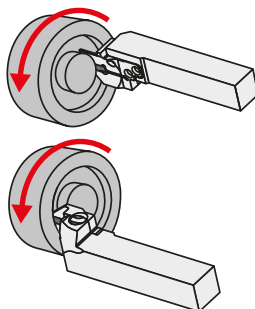


CUTTING MODE

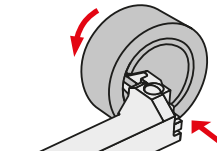
Anticlockwise



Clockwise

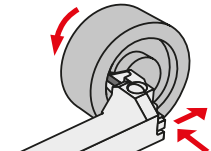
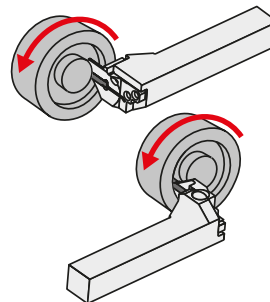


90° TYPE HOLDER

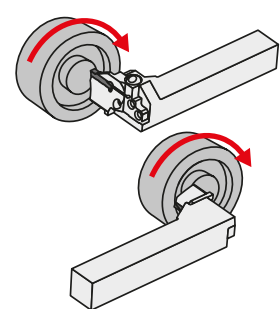


CUTTING MODE

Clockwise

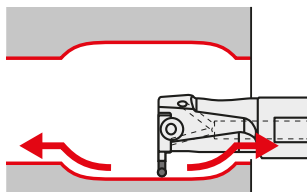
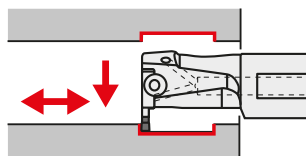
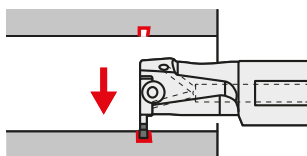


Anticlockwise



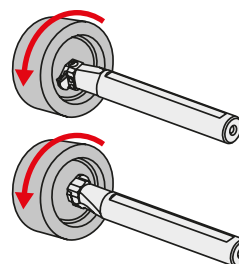
GROOVING

90° TYPE HOLDER

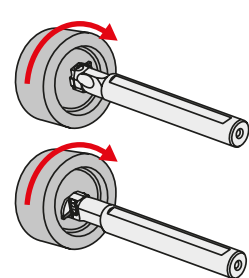


CUTTING MODE

Clockwise



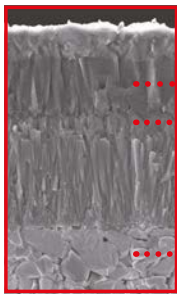
Anticlockwise



INSERT GRADES

P	M	K	S	H	N
NX2525	●			BC8110	RT9010
MY5015	●	MY5015	VP10RT RT9010 MP9015		
VP10RT	●	VP10RT	VP20RT RT9020 MP9025		
VP20RT	✱	VP20RT			

MY6125 NEW



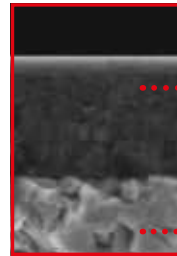
Increasing the coating thickness significantly improves wear resistance, while the latest coating technology, "Super TOUGH-Grip," ensures cutting edge stability.

"Super" Nano texture

Super Tough-Grip

Cemented carbide substrate

MP9015



PVD coated grade with a cemented carbide substrate. First recommendation for general applications on HRSA materials.

High Al-rich [Al,Ti]N Single layer coating technology

Special cemented carbide substrate

VP20RT (1st Recommendation)

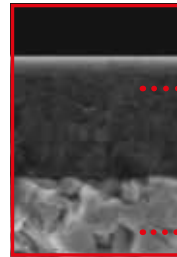


PVD coated grade suitable for a wide range of applications. The combination of a special tough cemented carbide substrate with MIRACLE coating provides an excellent balance of wear and fracture resistance.

MIRACLE coating

Carbide substrate (HRA90.5)

MP9025

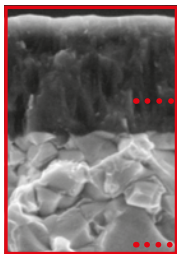


PVD coated grade with a tough cemented carbide substrate. It provides cutting edge stability for unstable applications on HRSA materials.

High Al-rich [Al,Ti]N Single layer coating technology

Special cemented carbide substrate

VP10RT (2nd Recommendation)

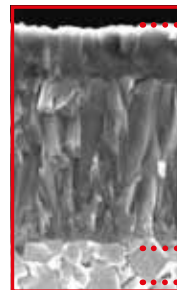


PVD coated grade with a cemented carbide substrate harder than VP20RT. For use on difficult-to-cut materials and for extending tool life.

MIRACLE coating

Carbide substrate (HRA92.0)

MY5015



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

CVD coating

Carbide substrate

RT9010

First recommended grade for titanium alloys.

BC8110

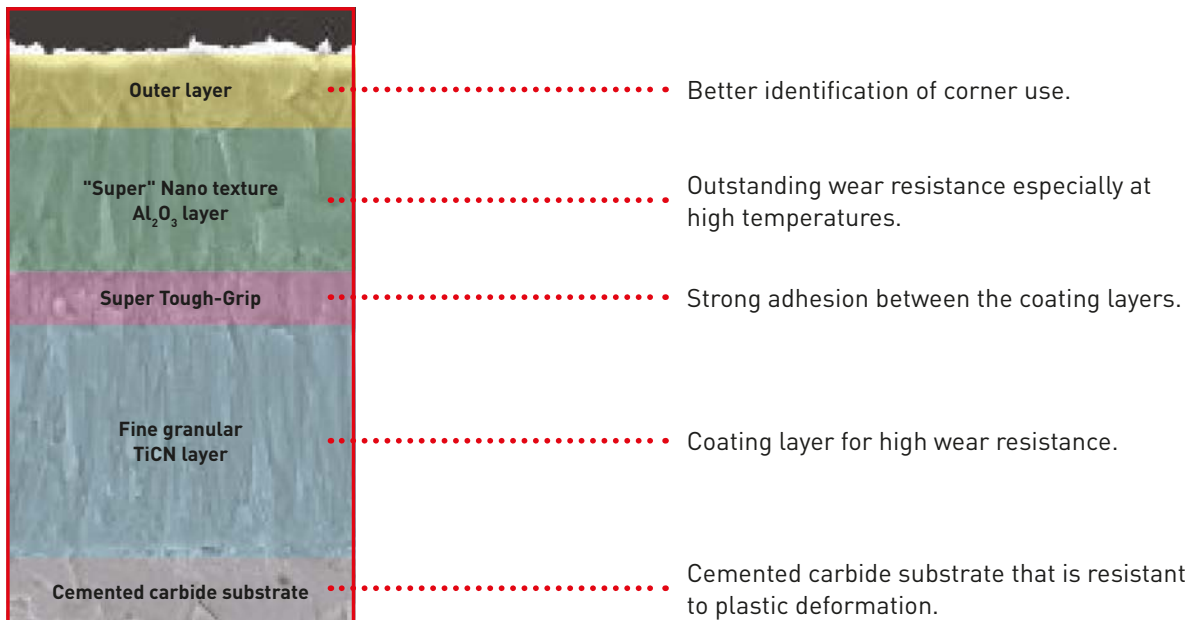
A coated PCBN grade for continuous cutting, which provides longer life when machining hardened steel.

NX2525

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

MY6125

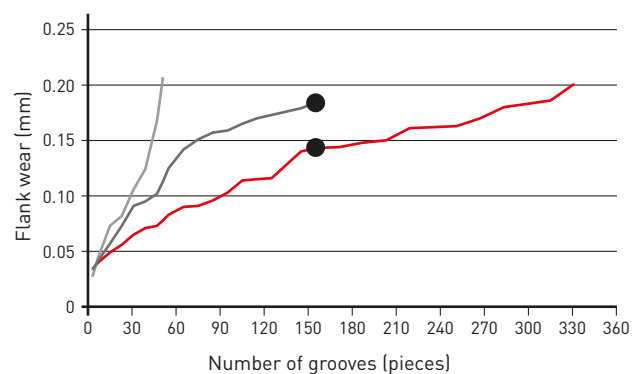
Adopting the optimal coating that delivers stability in high-speed machining of steel.
Suitable for grooving, side turning and parting off operations.



WEAR RESISTANCE COMPARISON WHEN CONTINUOUS, DEEP GROOVE MACHINING OF JIS S45C

Shows double the wear resistance properties compared to conventional product B.

Material	JIS S45C
Holder	GYHL2525M00-M25L
Insert	GY2M - 5 mm
Vc (m/min)	150
f (mm/rev.)	0.25
ap (mm)	20
Coolant	Wet cutting



● Photo taken after machining 155 pieces



MY6125

Flank wear = 0.14 mm



Conventional B

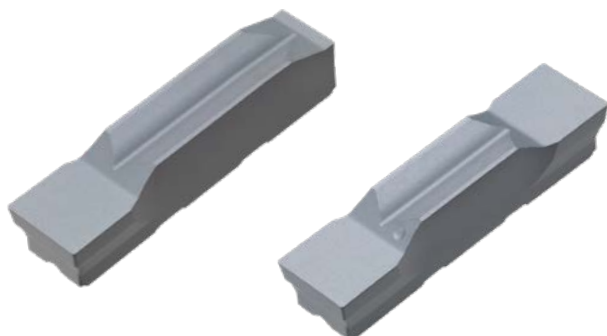
Flank wear = 0.18 mm

INSERT GRADES

Mild steel		Heat resistant alloy/Titanium alloy		Stainless steel	
P	Stable cutting without scale shallow-groove ↔ Unstable cutting with scale deep groove cutting off	S	Stable cutting without scale shallow-groove ↔ Unstable cutting with scale deep groove cutting off	M	Stable cutting without scale shallow-groove ↔ Unstable cutting with scale deep groove cutting off
Coated Carbide	MY6125 MY5015 VP10RT VP20RT	Coated Carbide	MP9015 MP9025	Coated Carbide	VP10RT VP20RT
Cermet	NX2525	Uncoated Carbide	RT9010		

Gray cast iron		Non-Ferrous metal		Hardened steel	
K	Stable cutting without scale shallow-groove ↔ Unstable cutting with scale deep groove cutting off	N	Stable cutting without scale shallow-groove ↔ Unstable cutting with scale deep groove cutting off	H	Stable cutting without scale shallow-groove ↔ Unstable cutting with scale deep groove cutting off
Coated Carbide	MY5015 MY6125 VP10RT VP20RT	Uncoated Carbide	RT9010	Coated Carbide	BC8110

BLANK INSERTS FOR CUSTOM GRINDING



1 Edge type

2 Edge type

RT9010/RT9020

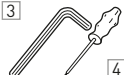
BLANK INSERT

First recommendation for blanks inserts is RT9020 due to the tougher carbide substrate that is suitable for a wider range of applications.

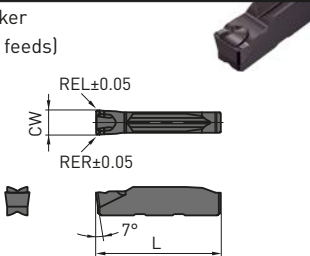
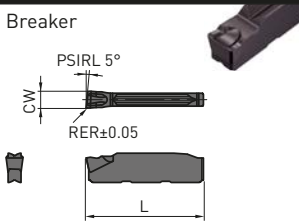
RT9010 has a harder substrate than RT9020 and is ideal for longer tool life on stable cutting applications.

Both grades are recommended to have a coating applied that is suitable for the required application.

SPARE PARTS

Holder			
	Clamp screw	Blade screw	Wrench
GYQR/L000-000	 HSC05030 (Clamp torque: 7.0N·m)	—	HKY40R
GYHR/L000-M20R/L		TS407 (Clamp torque: 3.5N·m)	 TKY30R  TKY15D
GYHR/L000-M25R/L	 GY06013M (Clamp torque: 6.0N·m)	TS55 (Clamp torque: 5.0N·m)	 TKY30R  TKY25D
GYPR/L00000-K25		—	 TKY30R
GYSR/L1010JX00			
	 CS350990T	—	 TKY10R
GYSR/L1212JX00			
GYSR/L1616JX00			
	 TS4SBL	—	 TKY15R
GYSR/L1915K00			
GYSR/L2012JX00	 CS350990T	—	 TKY10R
GYSR/L2020K00			
	 HSC05018	—	 HKY40R
GYSR/L2525K00			

INSERTS (SINGLE END)

Order number	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	MP9015	MP9025	Seat size	CW	Tolerance	RER/L	L	Geometry
GROOVING / CUTTING OFF															
GY1M0200D020N-GM			●	●	●			●	●	D	2.00	±0.03	0.2	20.70	GM Breaker (Medium feeds) 
GY1M0250E020N-GM			●	●	★			●	●	E	2.50	±0.03	0.2	20.70	
GY1M0300F030N-GM			●	●	●			●	●	F	3.00	±0.03	0.3	20.70	
GY1M0400G030N-GM			●	●	●			●	●	G	4.00	±0.04	0.3	25.65	
GY1M0500H040N-GM			●	●	●			●	●	H	5.00	±0.04	0.4	25.65	
CUTTING OFF															
GY1M0200D020R05-GM			●	●						D	2.00	±0.03	0.2	20.80	R/L05-GM Breaker 
GY1M0200D020L05-GM			★	●						D	2.00	±0.03	0.2	20.80	
GY1M0300F030R05-GM			●	●						F	3.00	±0.03	0.3	20.85	
GY1M0300F030L05-GM			●	●						F	3.00	±0.03	0.3	20.85	

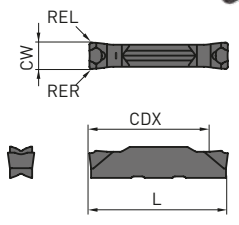
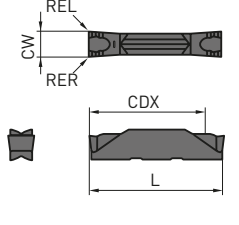
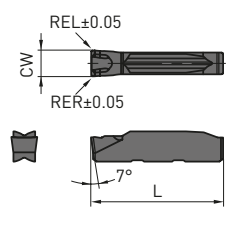
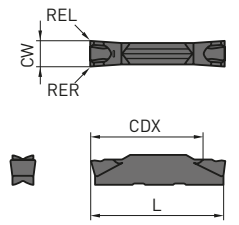
Left hand insert shown.

1/1

Left hand insert shown.

1/1

INSERTS

Order number	MY6125 NEW	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	MP9015	MP9025	Seat size	CW	Tolerance	RE R/L	CDX	L	LE	Geometry
GROOVING/CUTTING OFF																		
GY2M0200D020N-GU			●	●	●						D	2.00	±0.03	0.2	19.7	20.70	—	GU (For gummy steel) 
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	—	GS (Low feeds) 
GY2M0635J040N-GU			●	●	●						J	6.35	±0.04	0.4	24.2	25.65	—	
GY2M0120B010N-GS			●	●							B	1.20	±0.03	0.1	12.2	14.70	—	
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	—	
GY2M0800K030N-GS			●	●							K	8.00	±0.04	0.3	29.1	30.50	—	
GY1M0200D020N-GM			●	●	●			●	●		D	2.00	±0.03	0.2	—	20.70	—	GM (Medium feeds) 
GY1M0250E020N-GM			●	●	★			●	●		E	2.50	±0.03	0.2	—	20.70	—	
GY1M0300F030N-GM			●	●	●			●	●		F	3.00	±0.03	0.3	—	20.70	—	
GY1M0400G030N-GM			●	●	●			●	●		G	4.00	±0.04	0.3	—	25.65	—	
GY1M0500H040N-GM			●	●	●			●	●		H	5.00	±0.04	0.4	—	25.65	—	
GY2M0150C020N-GM	●		●	●	●			●	●		C	1.50	±0.03	0.2	13.9	14.70	—	GM (Medium feeds) 
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	—	
GY2M0800K050N-GM	●		●	●	●			●	●		K	8.00	±0.04	0.5	29.3	30.50	—	

1/4

*1 Groove width corresponding to the circlip.

Order number	MY6125 NEW	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	MP9015	MP9025	Seat size	CW	Tolerance	RE R/L	CDX	L	LE	Geometry
GROOVING/CUTTING OFF																		
GY2G0200D005N-GL	●										D	2.00	±0.02	0.05	19.5	21.05	—	GL Breaker
GY2G0250E005N-GL	●										E	2.50	±0.02	0.05	19.1	21.05	—	(For aluminium alloys)
GY2G0300F005N-GL	●										F	3.00	±0.02	0.05	18.9	21.05	—	
CUTTING OFF																		
GY1M0200D020R05-GM			● ●								D	2.00	±0.03	0.2	—	20.80	—	R/L05-GM Breaker
GY1M0200D020L05-GM			★ ●								D	2.00	±0.03	0.2	—	20.80	—	
GY1M0300F030R05-GM			● ●								F	3.00	±0.03	0.3	—	20.85	—	
GY1M0300F030L05-GM			● ●								F	3.00	±0.03	0.3	—	20.85	—	
Left hand insert shown.																		
GY2M0200D020R05-GM			● ●								D	2.00	±0.03	0.2	19.5	20.80	—	R/L05-GM Breaker
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	—	Right hand insert shown.
GY2M0120B010R05-GS			★ ★								B	1.20	±0.03	0.1	12.22	14.70	—	R/L05-GS Breaker (Low feeds)
R08-GS Breaker (Low feeds)																		
GY2G0150C010R08-GS			● ●								C	1.50	±0.02	0.1	13.17	15.20	—	
GY2G0200D020R08-GS			● ●								D	2.00	±0.03	0.2	18.85	21.30	—	
GY2G0250E020R08-GS			● ●								E	2.50	±0.03	0.2	19.04	21.50	—	
GY2G0300F020R08-GS			● ●								F	3.00	±0.03	0.2	18.62	21.50	—	
R15-GS Breaker (Low feeds)																		
GY2G0150C003R15-GS			● ●								C	1.50	±0.02	0.03	13.17	15.20	—	
GY2G0150C010R15-GS			● ●								C	1.50	±0.02	0.1	13.17	15.20	—	
GY2G0200D003R15-GS			● ●								D	2.00	±0.03	0.03	18.85	21.30	—	
GY2G0200D010R15-GS			● ●								D	2.00	±0.03	0.1	18.85	21.30	—	
GY2G0250E003R15-GS			● ●								E	2.50	±0.03	0.03	19.04	21.50	—	
GY2G0250E020R15-GS			● ●								E	2.50	±0.03	0.2	19.04	21.50	—	
GY2G0300F003R15-GS			● ●								F	3.00	±0.03	0.03	18.62	21.50	—	
GY2G0300F020R15-GS			● ●															

INSERTS

Order number	MY6125 NEW	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	MP9015	MP9025	Seat size	CW	Tolerance	RE R/L	CDX	L	LE	Geometry
GROOVING																		
GY1G0200D020N-GFGS								●			D	2.00	±0.03	0.2	—	20.70	2.7	(For hardened material)
GY1G0239E020N-GFGS								●			E	2.39	±0.03	0.2	—	20.70	2.7	
GY1G0250E020N-GFGS								●			E	2.50	±0.03	0.2	—	20.70	2.7	
GY1G0300F020N-GFGS								●			F	3.00	±0.03	0.2	—	20.70	2.7	
GY1G0318F020N-GFGS								●			F	3.18	±0.03	0.2	—	20.70	2.7	
GY1G0400G020N-GFGS								●			G	4.00	±0.03	0.2	—	25.65	2.7	
GY1G0475H020N-GFGS								●			H	4.75	±0.03	0.2	—	25.65	2.7	
GY1G0500H020N-GFGS								●			H	5.00	±0.03	0.2	—	25.65	2.7	
GY1G0600J020N-GFGS								●			J	6.00	±0.03	0.2	—	25.65	2.7	
MULTIFUNCTIONAL GROOVING																		
GY2G0200D020N-MF	●	●	●	●	●						D	2.00	±0.02	0.2	19.5	21.05	—	MF (Finishing)
GY2G0224D015N-MF ^{*1}	●	●	●	●	●						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	—	
GY2G0274E020N-MF ^{*1}	●	●	●	●	●						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	—	
GY2G0324F020N-MF ^{*1}	●	●	●	●	●						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	—	
GY2G0424G020N-MF ^{*1}	●	●	●	●	●						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	—	
GY2G0524H020N-MF ^{*1}	●	●	●	●	●						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	—	
GY2G0631J020N-MF ^{*1}	●	●	●	●	●						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	—	
GY2M0200D020N-MS	●		●	●	●	●					D	2.00	±0.03	0.2	19.1	20.70	—	MS (Low feeds)
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	—	
GY2M0800K080N-MS	●		●	●	●	●					K	8.00	±0.04	0.8	28.5	30.50	—	

*1 Groove width corresponding to the circlip.

● : Inventory maintained. ★ : Inventory maintained in Japan.

INSERTS

Order number	MY6125 NEW	RT9010	RT9020	VP10RT	VP20RT	MY5015	NX2525	BC8110	MP9015	MP9025	Seat size	CW	Tolerance	RE R/L	CDX	L	LE	Geometry	
MULTIFUNCTIONAL GROOVING																			
GY2M0200D020N-MM	●			●	●	●	●		●	●	D	2.00	±0.03	0.2	19.1	20.70	—	MM Breaker (Medium feeds)	
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	—		
GY2M0800K120N-MM	●			●	●	●	●		●	●	K	8.00	±0.04	1.2	28.1	30.50	—		
COPYING / FOR RECESSING																			
GY2M0200D100N-BM	●			●	●	●	●		●	●	D	2.00	±0.03	1.00	19.5	20.90	—	BM Breaker	
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	—		
GY2M0800K400N-BM	●			●	●	●	●		●	●	K	8.00	±0.04	4.00	26.5	30.80	—		
BLANK																			
GY2B0220D020N		●	●				●				D	2.20	±0.10	0.2	—	21.05	—		Flat top 2 Edge type
GY2B0250D020N		●	●				●				D	2.55	±0.10	0.2	—	21.28	—		
GY2B0270E020N		●	●				●				E	2.70	±0.10	0.2	—	21.05	—		
GY2B0300E020N		●	●				●				E	3.05	±0.10	0.2	—	21.28	—		
GY2B0340F020N		●	●				●				F	3.40	±0.10	0.2	—	21.05	—		
GY2B0360F020N		●	●				●				F	3.65	±0.10	0.2	—	21.28	—		
GY2B0420G020N		●	●				●				G	4.20	±0.10	0.2	—	26.00	—		
GY2B0460G020N		●	●				●				G	4.65	±0.10	0.2	—	26.18	—		
GY2B0520H020N		●	●				●				H	5.20	±0.10	0.2	—	26.00	—		
GY2B0560H020N		●	●				●				H	5.65	±0.10	0.2	—	26.18	—		
GY2B0655J020N		●	●				●				J	6.55	±0.10	0.2	—	26.00	—		
GY2B0680J020N		●	●				●				J	6.85	±0.10	0.2	—	26.18	—		
GY2B0880K020N		●	●				●				K	8.85	±0.10	0.2	—	30.88	—		
GY1B0220D020N		●	●				●				D	2.20	±0.10	0.2	—	21.07	—	1 Edge type	
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	—		
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 the customer.

GY GROOVING SERIES

EXTERNAL FOR SWISS TYPE LATHES

INSERT SELECTION

Seat size Insert type

B	GY○○0120B○○○○○-Breaker shown below
C	GY○○0150C○○○○○-Breaker shown below
D	GY○○0200/0224D○○○○○-Breaker shown below
E	GY○○0239/0250/0274E○○○○○-Breaker shown below
F	GY○○0300/0318/0324F○○○○○-Breaker shown below

For multifunctional grooving breaker

Seat size	CW	MF	MS	MM	BM
		(Finish)	(Low)	(Medium)	(Copying)
					Ball shape
D	2.00	●	●	●	●
	2.24	●			
	2.39	●			
E	2.50	●	●	●	●
	2.74	●			
	3.00				●
F	RE 0.2	●	●	●	
	RE 0.4	●	●	●	
	RE 0.8			●	
	3.18				●
	RE 0.2	●			
	RE 0.4	●			
	3.24	●			

For cutting off breaker

Seat size	CW	05-GS	08-GS	15-GS	05-GM
		(Low)	(Low)	(Low)	(Medium)
		R	R	R	R/L
B	1.20	★			
C	1.50		●	●	
D	2.00		●	●	
E	2.39		●	●	●
	2.50				
F	3.00		●	●	●
	3.18		●	●	●

For grooving/cutting off breaker

Seat size	CW	GU	GS	GM	GL	GFGS
		(For gummy steel)	(Low)	(Medium)	(Aluminium)	(Hardened steel)
		Neutral	Neutral	Neutral	Neutral	Neutral
B	1.20		●			
C	1.50		●	●		
D	2.00	●	●	●	●	●
E	2.39	●	●	●		●
	2.50	●	●	●	●	●
F	3.00	●	●	●	●	●
	3.18	●	●	●		●

CORRECT USE OF GY SERIES GS BREAKER

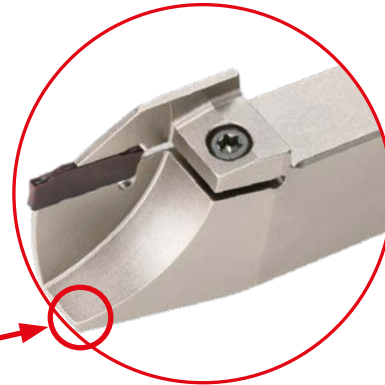
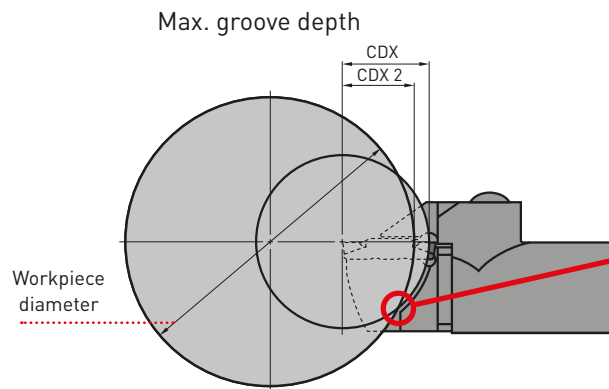
First recommendation



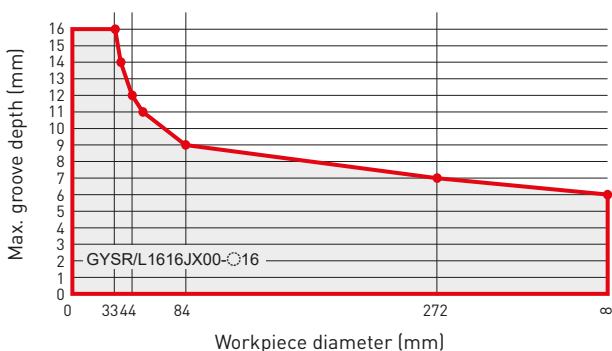
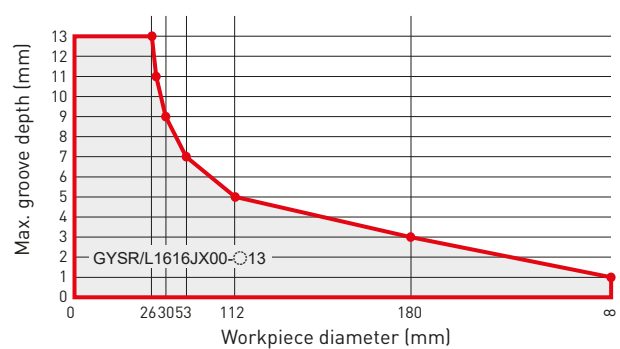
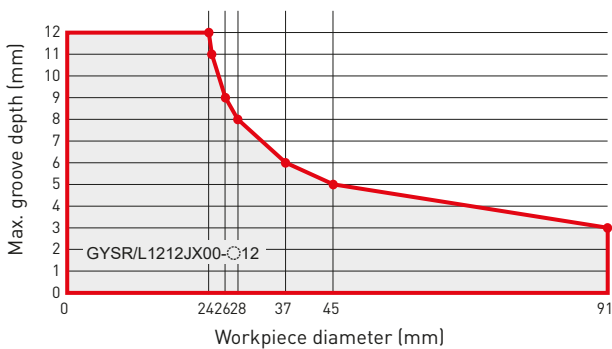
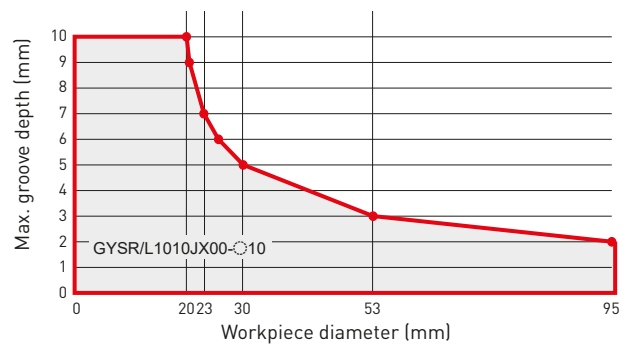
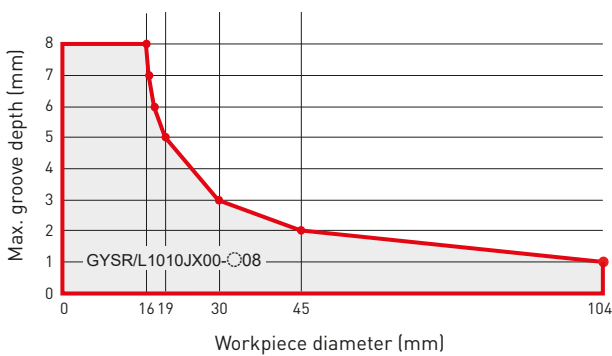
GY GROOVING SERIES

LIMITATION OF THE MAXIMUM GROOVE DEPTH FOR EXTERNAL SWISS TYPE LATHES

In the case of monoblock type holder for Swiss type lathes.
The maximum groove depth is limited by the workpiece diameter.



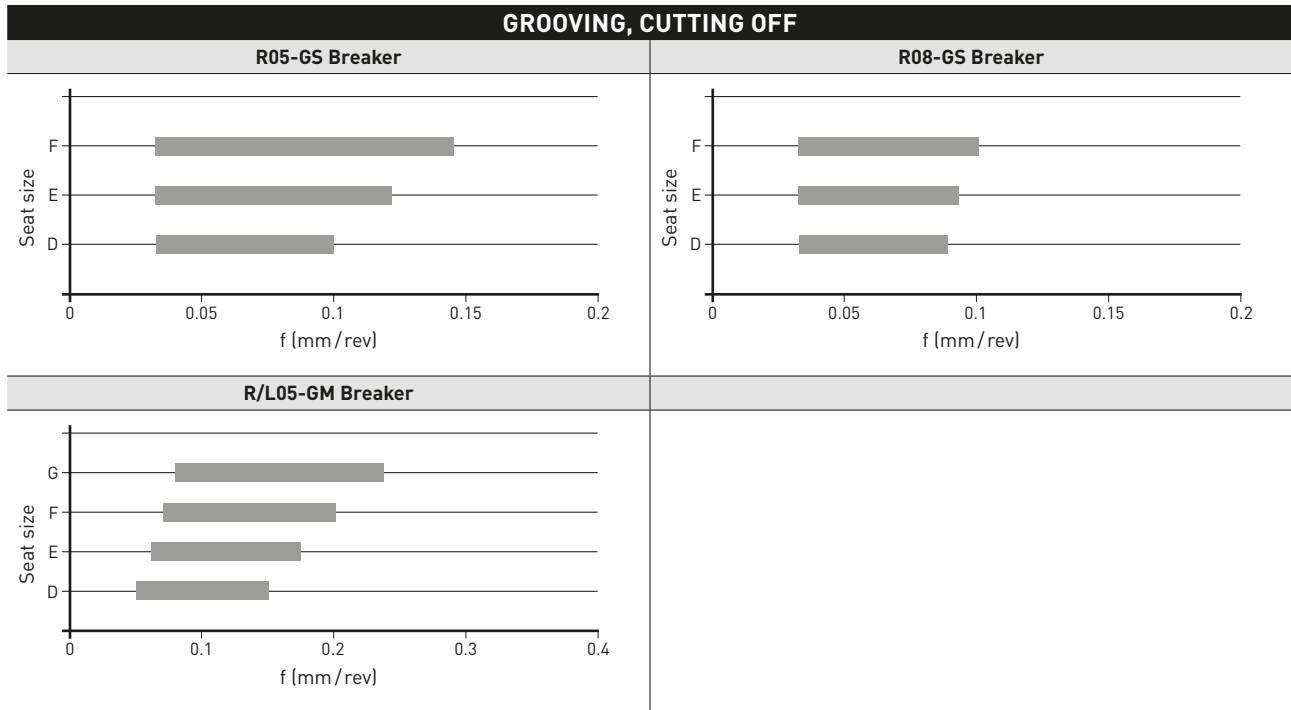
Due to interference, the maximum groove depth is limited by the workpiece diameter.



GY GROOVING SERIES

CUTTING OFF

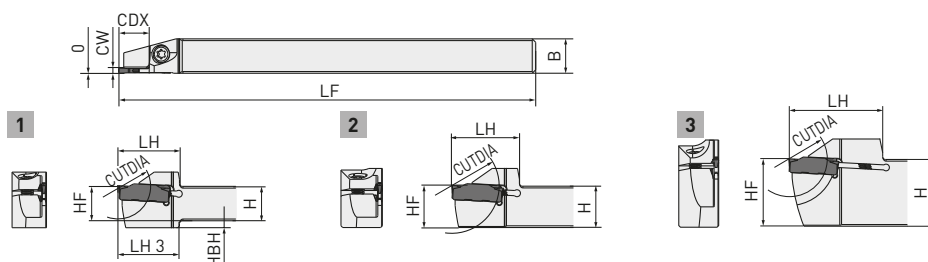
FEED PER REVOLUTION



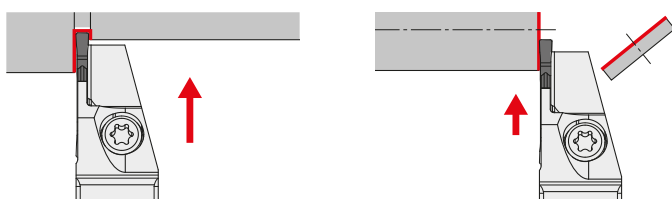
Chipbreaker	PSIPR	Hand	f (mm/rev)			
			Seat size D	Seat size E	Seat size F	Seat size G
R05-GS	5°	R	0.03 – 0.10	0.03 – 0.12	0.03 – 0.14	—
R08-GS	8°	R	0.03 – 0.08	0.03 – 0.09	0.03 – 0.10	—
R05-GM	5°	R/L	0.05 – 0.15	0.06 – 0.17	0.07 – 0.20	0.08 – 0.23

GY GROOVING SERIES

EXTERNAL FOR SWISS TYPE LATHES



Right hand tool holder shown.



Order number	Seat size	CW	CDX*2	CUTDIA	Hand	Stock	H	B	LF	LH	LH3	HF*1	HBH	Fig.
GYSR1010JX00-B08	B	1.20	8	16	R	●	10	10	120	17.5	17.5	10	2	1
GYSL1010JX00-B08					L	●	10	10	120	17.5	17.5	10	2	1
GYSR1212JX00-B08					R	●	12	12	120	19.5	—	12	—	2
GYSL1212JX00-B08					L	●	12	12	120	19.5	—	12	—	2
GYSR1212JX00-B12			12	24	R	●	12	12	120	19.5	19.5	12	2	1
GYSL1212JX00-B12					L	●	12	12	120	19.5	19.5	12	2	1
GYSR1616JX00-B08			8	16	R	●	16	16	120	25.0	—	16	—	2
GYSL1616JX00-B08					L	●	16	16	120	25.0	—	16	—	2
GYSR1616JX00-B13			13	26	R	●	16	16	120	25.0	—	16	—	2
GYSL1616JX00-B13					L	●	16	16	120	25.0	—	16	—	2
GYSR1010JX00-C08	C	1.50	8	16	R	●	10	10	120	17.5	17.5	10	2	1
GYSL1010JX00-C08					L	●	10	10	120	17.5	17.5	10	2	1
GYSR1212JX00-C08					R	●	12	12	120	19.5	—	12	—	2
GYSL1212JX00-C08					L	●	12	12	120	19.5	—	12	—	2
GYSR1212JX00-C12			12	24	R	●	12	12	120	19.5	19.5	12	2	1
GYSL1212JX00-C12					L	●	12	12	120	19.5	19.5	12	2	1
GYSR1616JX00-C13			13	26	R	●	16	16	120	25.0	—	16	—	2
GYSL1616JX00-C13					L	●	16	16	120	25.0	—	16	—	2
GYSR2012JX00-C13					R	★	20	12	120	28.0	—	20	—	3
GYSL2012JX00-C13					L	★	20	12	120	28.0	—	20	—	3
GYSR1010JX00-D10	D	2.00	10	20	R	★	10	10	120	17.5	17.5	10	2	1
GYSL1010JX00-D10					L	★	10	10	120	17.5	17.5	10	2	1
GYSR1212JX00-D12			12	24	R	●	12	12	120	19.5	19.5	12	2	1
GYSL1212JX00-D12					L	●	12	12	120	19.5	19.5	12	2	1
GYSR1616JX00-D13			13	26	R	●	16	16	120	25	—	16	—	2
GYSL1616JX00-D13					L	●	16	16	120	25	—	16	—	2
GYSR1616JX00-D16			16	32	R	★	16	16	120	28	—	16	—	2
GYSL1616JX00-D16					L	●	16	16	120	28	—	16	—	2

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

*2 The maximum groove depth is limited by the workpiece diameter.

1. Cutting mode will be shown on page 22.

EXTERNAL FOR SWISS TYPE LATHES

Order number	Seat size	CW	CDX* ²	CUTDIA	Hand	Stock	H	B	LF	LH	LH3	HF* ¹	HBH	Fig.
GYSR1915K00-D17	D	2.24	17	34	R	★	19.05	15.875	125	28	—	19.05	—	3
GYSL1915K00-D17					L	★	19.05	15.875	125	28	—	19.05	—	3
GYSR2012JX00-D17					R	★	20	12	120	28	—	20	—	3
GYSL2012JX00-D17					L	★	20	12	120	28	—	20	—	3
GYSR2020K00-D17					R	★	20	20	125	35	—	20	—	2
GYSL2020K00-D17					L	★	20	20	125	35	—	20	—	2
GYSR2525M00-D17					R	★	25	25	150	40	—	25	—	2
GYSL2525M00-D17					L	★	25	25	150	40	—	25	—	2
GYSR1010JX00-E10	E	2.39	10	20	R	★	10	10	120	17.5	17.5	10	2	1
GYSL1010JX00-E10					L	★	10	10	120	17.5	17.5	10	2	1
GYSR1212JX00-E12			12	24	R	★	12	12	120	19.5	19.5	12	2	1
GYSL1212JX00-E12					L	★	12	12	120	19.5	19.5	12	2	1
GYSR1616JX00-E13			13	26	R	★	16	16	120	25	—	16	—	2
GYSL1616JX00-E13					L	★	16	16	120	25	—	16	—	2
GYSR1616JX00-E16			16	32	R	★	16	16	120	28	—	16	—	2
GYSL1616JX00-E16					L	★	16	16	120	28	—	16	—	2
GYSR1915K00-E17		2.74	17	34	R	★	19.05	15.875	125	28	—	19.05	—	3
GYSL1915K00-E17					L	★	19.05	15.875	125	28	—	19.05	—	3
GYSR2012JX00-E17					R	★	20	12	120	28	—	20	—	3
GYSL2012JX00-E17					L	★	20	12	120	28	—	20	—	3
GYSR2020K00-E17					R	★	20	20	125	35	—	20	—	2
GYSL2020K00-E17					L	★	20	20	125	35	—	20	—	2
GYSR2525M00-E17					R	★	25	25	150	40	—	25	—	2
GYSL2525M00-E17					L	★	25	25	150	40	—	25	—	2
GYSR1212JX00-F12	F	3.00	12	24	R	★	12	12	120	19.5	19.5	12	2	1
GYSL1212JX00-F12					L	●	12	12	120	19.5	19.5	12	2	1
GYSR1616JX00-F13			13	26	R	★	16	16	120	25	—	16	—	2
GYSL1616JX00-F13					L	★	16	16	120	25	—	16	—	2
GYSR1616JX00-F16		3.18	16	32	R	●	16	16	120	28	—	16	—	2
GYSL1616JX00-F16					L	★	16	16	120	28	—	16	—	2
GYSR1915K00-F17		3.24	17	34	R	★	19.05	15.875	125	28	—	19.05	—	3
GYSL1915K00-F17					L	★	19.05	15.875	125	28	—	19.05	—	3
GYSR2012JX00-F17					R	★	20	12	120	28	—	20	—	3
GYSL2012JX00-F17					L	★	20	12	120	28	—	20	—	3

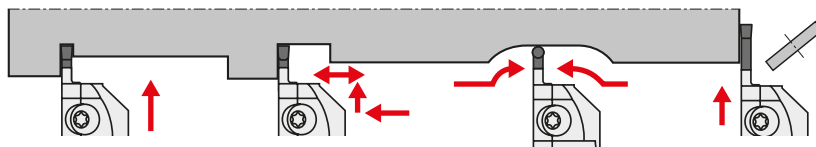
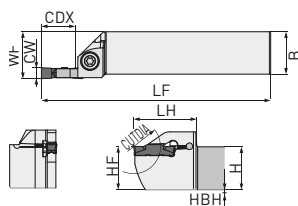
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*¹ Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.*² The maximum groove depth is limited by the workpiece diameter.

1. Cutting mode will be shown on page 22.

MONOBLOCK

EXTERNAL GROOVING



Right hand tool holder shown.

Order number	Seat size	CW	CDX	CUTDIA	Hand	Stock	H	B	LF	LH	HF	WF	HBH
GYQR2020K00-D06	D	2.00 2.24	6	12	R	●	20	20	125	36	20	20.15	—
GYQL2020K00-D06					L	●	20	20	125	36	20	20.15	—
GYQR2525M00-D06					R	●	25	25	150	36	25	25.15	—
GYQL2525M00-D06					L	●	25	25	150	36	25	25.15	—
GYQR2020K00-D18			18	36	R	●	20	20	125	39	20	20.10	—
GYQL2020K00-D18					L	●	20	20	125	39	20	20.10	—
GYQR2525M00-D20			20	40	R	●	25	25	150	41	25	25.15	—
GYQL2525M00-D20					L	●	25	25	150	41	25	25.15	—
GYQR2020K00-F06	F	3.00 3.18 3.24	6	12	R	●	20	20	125	36	20	20.30	—
GYQL2020K00-F06					L	●	20	20	125	36	20	20.30	—
GYQR2525M00-F06					R	●	25	25	150	36	25	25.30	—
GYQL2525M00-F06					L	●	25	25	150	36	25	25.30	—
GYQR2020K00-F18			18	36	R	●	20	20	125	39	20	20.25	—
GYQL2020K00-F18					L	●	20	20	125	39	20	20.25	—
GYQR2525M00-F20			20	40	R	●	25	25	150	41	25	25.25	—
GYQL2525M00-F20					L	●	25	25	150	41	25	25.25	—
GYQR2020K00-G08	G	4.00 4.24	8	16	R	●	20	20	125	41	20	20.35	—
GYQL2020K00-G08					L	●	20	20	125	41	20	20.35	—
GYQR2525M00-G08					R	●	25	25	150	41	25	25.35	—
GYQL2525M00-G08					L	●	25	25	150	41	25	25.35	—
GYQR2020K00-G25			25	50	R	●	20	20	125	46	20	20.35	4
GYQL2020K00-G25					L	●	20	20	125	46	20	20.35	4
GYQR2525M00-G25					R	●	25	25	150	46	25	25.35	—
GYQL2525M00-G25					L	●	25	25	150	46	25	25.35	—
GYQR2020K00-H08	H	4.75 5.00 5.24	8	6	R	●	20	20	125	41	20	20.35	—
GYQL2020K00-H08					L	●	20	20	125	41	20	20.35	—
GYQR2525M00-H08					R	●	25	25	150	41	25	25.35	—
GYQL2525M00-H08					L	●	25	25	150	41	25	25.35	—
GYQR2020K00-H25			25	50	R	●	20	20	125	46	20	20.35	4
GYQL2020K00-H25					L	●	20	20	125	46	20	20.35	4
GYQR2525M00-H25					R	●	25	25	150	46	25	25.35	—
GYQL2525M00-H25					L	●	25	25	150	46	25	25.35	—
GYQR2020K00-J08	J	6.00 6.31 6.35	8	16	R	●	20	20	125	41	20	20.35	—
GYQL2020K00-J08					L	●	20	20	125	41	20	20.35	—
GYQR2525M00-J08					R	●	25	25	150	41	25	25.35	—
GYQL2525M00-J08					L	●	25	25	150	41	25	25.35	—
GYQR2020K00-J25			25	50	R	●	20	20	125	46	20	20.35	4
GYQL2020K00-J25					L	●	20	20	125	46	20	20.35	4
GYQR2525M00-J25					R	●	25	25	150	46	25	25.35	—
GYQL2525M00-J25					L	●	25	25	150	46	25	25.35	—

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*1 The maximum groove depth varies according to the insert used.

Please refer to the maximum groove depth (CDX) of inserts on pages 29 – 32.

*2 The maximum cut off diameter CUTDIA varies according to the insert used.

The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.

1. Identification: page 18

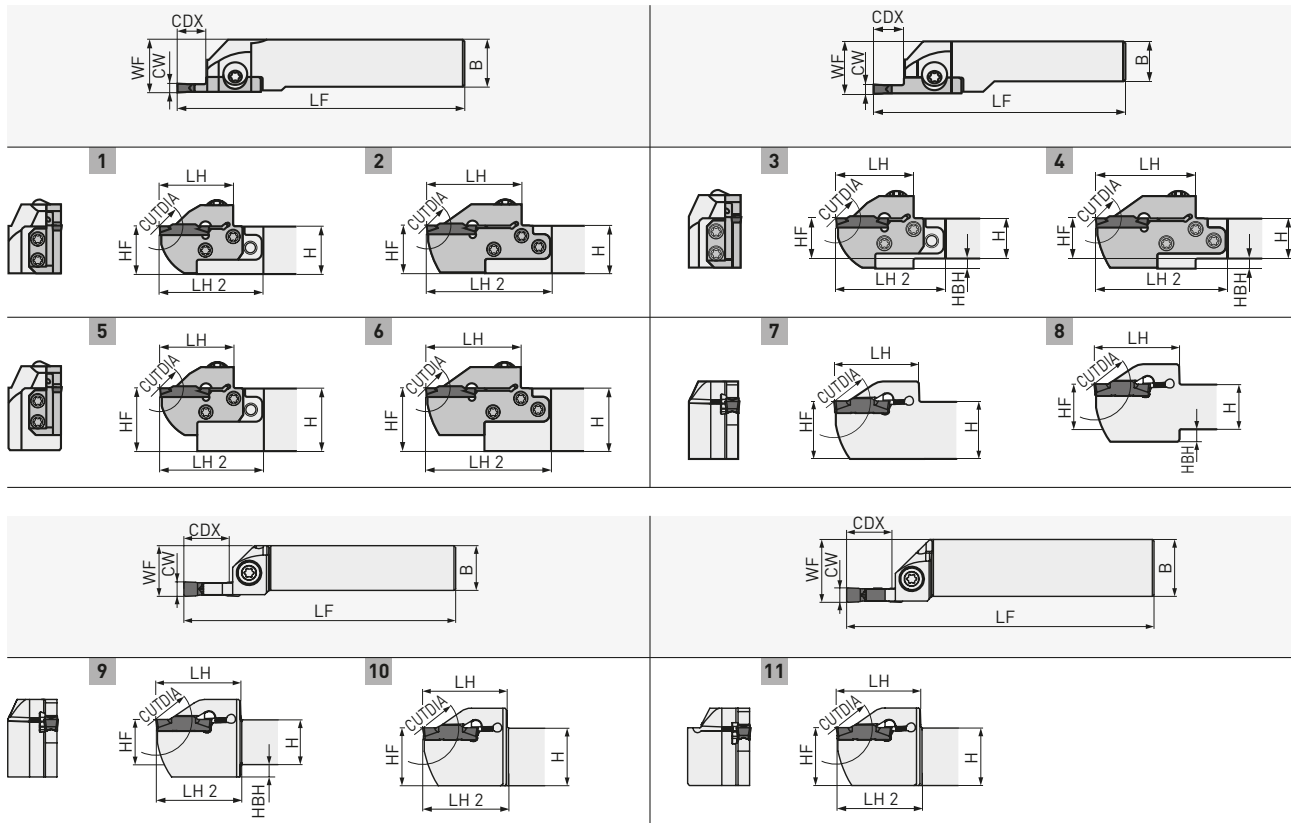
2. Spare parts: page 27

● : Inventory maintained. ★ : Inventory maintained in Japan.

GY GROOVING SERIES

EXTERNAL GROOVING

00° TYPE HOLDER



Right hand tool holder shown.

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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
GYHR1616J00-M20R	●	GYM20RA-D06	●	D	2.00 2.24	6	12	R	16	16	104	28	44	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-D06	●					L	16	16	104	28	44	16	20	4	3
GYQR2020K00-D06	●	-	-					R	20	20	125	36	-	20	20.15	-	7
GYQL2020K00-D06	●	-	-					L	20	20	125	36	-	20	20.15	-	7
GYHR2020K00-M20R	●	GYM20RA-D06	●					R	20	20	119	28	43	20	23	-	1
GYHL2020K00-M20L	●	GYM20LA-D06	●					L	20	20	119	28	43	20	23	-	1
GYHR2020K00-M25R	●	GYM25RA-D06	●					R	20	20	117	31	52	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-D06	●					L	20	20	117	31	52	20	26	5	3
GYQR2525M00-D06	●	-	-					R	25	25	150	36	-	25	25.15	-	7
GYQL2525M00-D06	●	-	-					L	25	25	150	36	-	25	25.15	-	7
GYHR2525M00-M25R	●	GYM25RA-D06	●					R	25	25	142	31	49	25	28	-	1
GYHL2525M00-M25L	●	GYM25LA-D06	●					L	25	25	142	31	49	25	28	-	1
GYHR3225P00-M25R	●	GYM25RA-D06	●					R	32	25	162	31	49	32	28	-	5
GYHL3225P00-M25L	●	GYM25LA-D06	●					L	32	25	162	31	49	32	28	-	5
GYHR3232P00-M25R	●	GYM25RA-D06	●					R	32	32	162	31	49	32	35	-	5
GYHL3232P00-M25L	●	GYM25LA-D06	●					L	32	32	162	31	49	32	35	-	5

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EXTERNAL GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
GYHR1616J00-M20R	●	GYM20RA-D10	●	D	2.00 2.24	10	20	R	16	16	110	34	50	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-D10	●					L	16	16	110	34	50	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-D10	●					R	20	20	125	34	49	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-D10	●					L	20	20	125	34	49	20	23	–	1
GYHR2020K00-M25R	●	GYM25RA-D12	●	D	2.00 2.24	12	24	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-D12	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-D12	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-D12	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-D12	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-D12	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-D12	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-D12	●					L	32	32	170	39	57	32	35	–	5
GYHR1616J00-M20R	●	GYM20RB-D18	●	D	2.00 2.24	18*4	36	R	16	16	116	40	56	16	20	4	4
GYHL1616J00-M20L	●	GYM20LB-D18	●					L	16	16	116	40	56	16	20	4	4
GYQR2020K00-D18	●	–						R	20	20	125	39	–	20	20.10	–	7
GYQL2020K00-D18	●	–						L	20	20	125	39	–	20	20.10	–	7
GYHR2020K00-M20R	●	GYM20RB-D18	●					R	20	20	131	40	55	20	23	–	2
GYHL2020K00-M20L	●	GYM20LB-D18	●					L	20	20	131	40	55	20	23	–	2
GYHR2020K00-M25R	●	GYM25RA-D20	●	D	2.00 2.24	20*1	40*2	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-D20	●					L	20	20	131	45	66	20	26	5	4
GYQR2525M00-D20	●	–						R	25	25	150	41	–	25	25.15	–	7
GYQL2525M00-D20	●	–						L	25	25	150	41	–	25	25.15	–	7
GYHR2525M00-M25R	●	GYM25RA-D20	●					R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-D20	●					L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-D20	●					R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-D20	●					L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-D20	●	E	2.39 2.50 2.74	6	12	R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-D20	●					L	32	32	176	45	63	32	35	–	6
GYHR1616J00-M20R	●	GYM20RA-E06	●					R	16	16	104	28	44	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-E06	●					L	16	16	104	28	44	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-E06	●					R	20	20	119	28	43	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-E06	●					L	20	20	119	28	43	20	23	–	1
GYHR2020K00-M25R	●	GYM25RA-E06	●					R	20	20	117	31	52	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-E06	●					L	20	20	117	31	52	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-E06	●					R	25	25	142	31	49	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-E06	●					L	25	25	142	31	49	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-E06	●					R	32	25	162	31	49	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-E06	●					L	32	25	162	31	49	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-E06	●					R	32	32	162	31	49	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-E06	●					L	32	32	162	31	49	32	35	–	5
GYHR1616J00-M20R	●	GYM20RA-E10	●	E	2.39 2.50 2.74	10	20	R	16	16	110	34	50	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-E10	●					L	16	16	110	34	50	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-E10	●					R	20	20	125	34	49	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-E10	●					L	20	20	125	34	49	20	23	–	1

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.

*2 The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.

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

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 77.

1. Identification: page 18

2. Spare parts: page 27

EXTERNAL GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF ^{*3}	LH ^{*3}	LH2	HF	WF ^{*3}	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RA-E12	●	E	2.39 2.50 2.74	12	24	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-E12	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-E12	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-E12	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-E12	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-E12	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-E12	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-E12	●					L	32	32	170	39	57	32	35	–	5
GYHR1616J00-M20R	●	GYM20RB-E18	●	E	2.39 2.50 2.74	18 ^{*4}	36	R	16	16	116	40	56	16	20	4	4
GYHL1616J00-M20L	●	GYM20LB-E18	●					L	16	16	116	40	56	16	20	4	4
GYHR2020K00-M20R	●	GYM20RB-E18	●					R	20	20	131	40	55	20	23	–	2
GYHL2020K00-M20L	●	GYM20LB-E18	●					L	20	20	131	40	55	20	23	–	2
GYHR2020K00-M25R	●	GYM25RA-E20	●	E	2.39 2.50 2.74	20 ^{*1}	40 ^{*2}	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-E20	●					L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RA-E20	●					R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-E20	●					L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-E20	●					R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-E20	●					L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-E20	●					R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-E20	●					L	32	32	176	45	63	32	35	–	6
GYHR1616J00-M20R	●	GYM20RA-F06	●	F	3.00 3.18 3.24	6	12	R	16	16	104	28	44	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-F06	●					L	16	16	104	28	44	16	20	4	3
GYQR2020K00-F06	●	–	●					R	20	20	125	36	–	20	20.30	–	7
GYQL2020K00-F06	●	–	●					L	20	20	125	36	–	20	20.30	–	7
GYHR2020K00-M20R	●	GYM20RA-F06	●					R	20	20	119	28	43	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-F06	●					L	20	20	119	28	43	20	23	–	1
GYHR2020K00-M25R	●	GYM25RA-F06	●					R	20	20	117	31	52	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-F06	●					L	20	20	117	31	52	20	26	5	3
GYQR2525M00-F06	●	–	●	F	3.00 3.18 3.24	6	12	R	25	25	150	36	–	25	25.30	–	7
GYQL2525M00-F06	●	–	●					L	25	25	150	36	–	25	25.30	–	7
GYHR2525M00-M25R	●	GYM25RA-F06	●					R	25	25	142	31	49	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-F06	●					L	25	25	142	31	49	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-F06	●					R	32	25	162	31	49	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-F06	●					L	32	25	162	31	49	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-F06	●					R	32	32	162	31	49	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-F06	●					L	32	32	162	31	49	32	35	–	5
GYHR1616J00-M20R	●	GYM20RA-F10	●	F	3.00 3.18 3.24	10	20	R	16	16	110	34	50	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-F10	●					L	16	16	110	34	50	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-F10	●					R	20	20	125	34	49	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-F10	●					L	20	20	125	34	49	20	23	–	1

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^{*1} The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.

^{*2} The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.

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

^{*4} The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 77.

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EXTERNAL GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF ^{*3}	LH ^{*3}	LH2	HF	WF ^{*3}	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RA-F12	●	F	3.00 3.18 3.24	12	24	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-F12	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-F12	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-F12	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-F12	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-F12	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-F12	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-F12	●					L	32	32	170	39	57	32	35	–	5
GYHR1616J00-M20R	●	GYM20RB-F18	●	F	3.00 3.18 3.24	18 ^{*4}	36	R	16	16	116	40	56	16	20	4	4
GYHL1616J00-M20L	●	GYM20LB-F18	●					L	16	16	116	40	56	16	20	4	4
GYQR2020K00-F18	●	–						R	20	20	125	39	–	20	20.25	–	7
GYQL2020K00-F18	●	–						L	20	20	125	39	–	20	20.25	–	7
GYHR2020K00-M20R	●	GYM20RB-F18	●					R	20	20	131	40	55	20	23	–	2
GYHL2020K00-M20L	●	GYM20LB-F18	●					L	20	20	131	40	55	20	23	–	2
GYHR2020K00-M25R	●	GYM25RA-F20	●	F	3.00 3.18 3.24	20 ^{*1}	40 ^{*2}	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-F20	●					L	20	20	131	45	66	20	26	5	4
GYQR2525M00-F20	●	–						R	25	25	150	41	–	25	25.25	–	7
GYQL2525M00-F20	●	–						L	25	25	150	41	–	25	25.25	–	7
GYHR2525M00-M25R	●	GYM25RA-F20	●					R	25	25	156	45	63	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-F20	●					L	25	25	156	45	63	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-F20	●					R	32	25	176	45	63	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-F20	●					L	32	25	176	45	63	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-F20	●					R	32	32	176	45	63	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-F20	●					L	32	32	176	45	63	32	35	–	6
GYQR2020K00-G08	●	–		G	4.00 4.24	8	16	R	20	20	125	41	–	20	20.35	–	7
GYQL2020K00-G08	●	–						L	20	20	125	41	–	20	20.35	–	7
GYHR2020K00-M25R	●	GYM25RA-G08	●					R	20	20	119	33	54	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-G08	●					L	20	20	119	33	54	20	26	5	3
GYQR2525M00-G08	●	–						R	25	25	150	41	–	25	25.35	–	7
GYQL2525M00-G08	●	–						L	25	25	150	41	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-G08	●					R	25	25	144	33	51	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-G08	●					L	25	25	144	33	51	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-G08	●	G	4.00 4.24	8	16	R	32	25	164	33	51	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-G08	●					L	32	25	164	33	51	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-G08	●					R	32	32	164	33	51	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-G08	●					L	32	32	164	33	51	32	35	–	5
GYHR1616J00-M20R	●	GYM20RA-G12	●	G	4.00 4.24	12	24	R	16	16	110	34	50	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-G12	●					L	16	16	110	34	50	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-G12	●					R	20	20	125	34	49	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-G12	●					L	20	20	125	34	49	20	23	–	1

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^{*1} The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.

^{*2} The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.

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

^{*4} The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 77.

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2. Spare parts: page 27



EXTERNAL GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	LH2	HF	WF*3	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RA-G14	●	G	4.00 4.24	14	28	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-G14	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-G14	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-G14	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-G14	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-G14	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-G14	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-G14	●					L	32	32	170	39	57	32	35	–	5
GYQR2020K00-G25	●	–	●	G	4.00 4.24	25*1	50*2	R	20	20	125	46	–	20	20.35	4	8
GYQL2020K00-G25	●	–	●					L	20	20	125	46	–	20	20.35	4	8
GYHR2020K00-M25R	●	GYM25RA-G25	●					R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-G25	●					L	20	20	136	50	71	20	26	5	4
GYQR2525M00-G25	●	–	●					R	25	25	150	46	–	25	25.35	–	7
GYQL2525M00-G25	●	–	●					L	25	25	150	46	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-G25	●					R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-G25	●					L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-G25	●					R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-G25	●					L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-G25	●					R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-G25	●					L	32	32	181	50	68	32	35	–	6
GYQR2020K00-H08	●	–	●	H	4.75 5.00 5.24	8	16	R	20	20	125	41	–	20	20.35	–	7
GYQL2020K00-H08	●	–	●					L	20	20	125	41	–	20	20.35	–	7
GYHR2020K00-M25R	●	GYM25RA-H08	●					R	20	20	119	33	54	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-H08	●					L	20	20	119	33	54	20	26	5	3
GYQR2525M00-H08	●	–	●					R	25	25	150	41	–	25	25.35	–	7
GYQL2525M00-H08	●	–	●					L	25	25	150	41	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-H08	●					R	25	25	144	33	51	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-H08	●					L	25	25	144	33	51	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-H08	●					R	32	25	164	33	51	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-H08	●					L	32	25	164	33	51	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-H08	●					R	32	32	164	33	51	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-H08	●					L	32	32	164	33	51	32	35	–	5
GYHR1616J00-M20R	●	GYM20RA-H12	●	H	4.75 5.00 5.24	12	24	R	16	16	110	34	50	16	20	4	3
GYHL1616J00-M20L	●	GYM20LA-H12	●					L	16	16	110	34	50	16	20	4	3
GYHR2020K00-M20R	●	GYM20RA-H12	●					R	20	20	125	34	49	20	23	–	1
GYHL2020K00-M20L	●	GYM20LA-H12	●					L	20	20	125	34	49	20	23	–	1

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.

*2 The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.

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

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 77.

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EXTERNAL GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF* ³	LH* ³	LH2	HF	WF* ³	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RA-H14	●	H	4.75 5.00 5.24	14	28	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-H14	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-H14	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-H14	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-H14	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-H14	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-H14	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-H14	●					L	32	32	170	39	57	32	35	–	5
GYQR2020K00-H25	●	–		H	4.75 5.00 5.24	25* ¹	50* ²	R	20	20	125	46	–	20	20.35	4	8
GYQL2020K00-H25	●	–						L	20	20	125	46	–	20	20.35	4	8
GYHR2020K00-M25R	●	GYM25RA-H25	●					R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-H25	●					L	20	20	136	50	71	20	26	5	4
GYQR2525M00-H25	●	–						R	25	25	150	46	–	25	25.35	–	7
GYQL2525M00-H25	●	–						L	25	25	150	46	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-H25	●					R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-H25	●					L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-H25	●					R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-H25	●					L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-H25	●					R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-H25	●					L	32	32	181	50	68	32	35	–	6
GYQR2020K00-J08	●	–		J	6.00 6.31 6.35	8	16	R	20	20	125	41	–	20	20.35	–	7
GYQL2020K00-J08	●	–						L	20	20	125	41	–	20	20.35	–	7
GYHR2020K00-M25R	●	GYM25RA-J08	●					R	20	20	119	33	54	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-J08	●					L	20	20	119	33	54	20	26	5	3
GYQR2525M00-J08	●	–						R	25	25	150	41	–	25	25.35	–	7
GYQL2525M00-J08	●	–						L	25	25	150	41	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-J08	●					R	25	25	144	33	51	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-J08	●					L	25	25	144	33	51	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-J08	●					R	32	25	164	33	51	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-J08	●					L	32	25	164	33	51	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-J08	●					R	32	32	164	33	51	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-J08	●					L	32	32	164	33	51	32	35	–	5
GYHR2020K00-M25R	●	GYM25RA-J14	●	J	6.00 6.31 6.35	14	28	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LA-J14	●					L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RA-J14	●					R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LA-J14	●					L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RA-J14	●					R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LA-J14	●					L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RA-J14	●					R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LA-J14	●					L	32	32	170	39	57	32	35	–	5

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*¹ The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.

*² The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.

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

*⁴ The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 77.

1. Identification: page 18

2. Spare parts: page 27



EXTERNAL GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF* ³	LH* ³	LH ₂	HF	WF* ³	HBH	Fig.
GYQR2020K00-J25	●	–		J	6.00 6.31 6.35	25* ¹	50* ²	R	20	20	125	46	–	20	20.35	4	8
GYQL2020K00-J25	●	–						L	20	20	125	46	–	20	20.35	4	8
GYHR2020K00-M25R	●	GYM25RA-J25	●					R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LA-J25	●					L	20	20	136	50	71	20	26	5	4
GYQR2525M00-J25	●	–						R	25	25	150	46	–	25	25.35	–	7
GYQL2525M00-J25	●	–						L	25	25	150	46	–	25	25.35	–	7
GYHR2525M00-M25R	●	GYM25RA-J25	●					R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LA-J25	●					L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RA-J25	●					R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LA-J25	●					L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RA-J25	●					R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LA-J25	●					L	32	32	181	50	68	32	35	–	6
GYPR2525M00-K25	●	–		K	8.00	25* ¹	50* ²	R	25	25	150	47	48	25	28	7	9
GYPL2525M00-K25	●	–						L	25	25	150	47	48	25	28	7	9
GYPR3225P00-K25	●	–						R	32	25	170	47	48	32	28	–	10
GYPL3225P00-K25	●	–						L	32	25	170	47	48	32	28	–	10
GYPR3232P00-K25	●	–						R	32	32	170	47	48	32	35	–	11
GYPL3232P00-K25	●	–						L	32	32	170	47	48	32	35	–	11

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*¹ The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.

*² The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.

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

*⁴ The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 77.

1. Identification: page 18

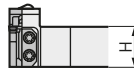
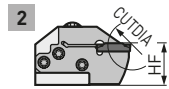
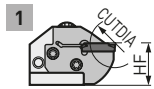
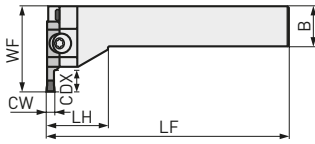
2. Spare parts: page 27



GY GROOVING SERIES

EXTERNAL GROOVING

90° TYPE HOLDER



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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	HF	WF*3	Fig.
GYHR2020K90-M20L	●	GYM20LA-D06	●	D	2.00 2.24	6	12	R	20	20	125	35	20	39	1
GYHL2020K90-M20R	●	GYM20RA-D06	●					L	20	20	125	35	20	39	1
GYHR2525M90-M25L	●	GYM25LA-D06	●					R	25	25	150	38	25	45	1
GYHL2525M90-M25R	●	GYM25RA-D06	●					L	25	25	150	38	25	45	1
GYHR2020K90-M20L	●	GYM20LA-D10	●			10	20	R	20	20	125	35	20	45	1
GYHL2020K90-M20R	●	GYM20RA-D10	●					L	20	20	125	35	20	45	1
GYHR2525M90-M25L	●	GYM25LA-D12	●			12	24	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-D12	●					L	25	25	150	38	25	53	1
GYHR2020K90-M20L	●	GYM20LB-D18	●			18*4	36	R	20	20	125	35	20	51	2
GYHL2020K90-M20R	●	GYM20RB-D18	●					L	20	20	125	35	20	51	2
GYHR2525M90-M25L	●	GYM25LA-D20	●	E	2.39 2.50 2.74	20*1	40*2	R	25	25	150	38	25	59	2
GYHL2525M90-M25R	●	GYM25RA-D20	●					L	25	25	150	38	25	59	2
GYHR2020K90-M20L	●	GYM20LA-E06	●			6	12	R	20	20	125	35	20	39	1
GYHL2020K90-M20R	●	GYM20RA-E06	●					L	20	20	125	35	20	39	1
GYHR2525M90-M25L	●	GYM25LA-E06	●					R	25	25	150	38	25	45	1
GYHL2525M90-M25R	●	GYM25RA-E06	●					L	25	25	150	38	25	45	1
GYHR2020K90-M20L	●	GYM20LA-E10	●			10	20	R	20	20	125	35	20	45	1
GYHL2020K90-M20R	●	GYM20RA-E10	●					L	20	20	125	35	20	45	1
GYHR2525M90-M25L	●	GYM25LA-E12	●			12	24	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-E12	●					L	25	25	150	38	25	53	1
GYHR2020K90-M20L	●	GYM20LB-E18	●			18*4	36	R	20	20	125	35	20	51	2
GYHL2020K90-M20R	●	GYM20RB-E18	●					L	20	20	125	35	20	51	2
GYHR2525M90-M25L	●	GYM25LA-E20	●	F	3.00 3.18 3.24	6	12	R	25	25	150	38	25	59	2
GYHL2525M90-M25R	●	GYM25RA-E20	●					L	25	25	150	38	25	59	2
GYHR2020K90-M20L	●	GYM20LA-F06	●					R	20	20	125	35	20	39	1
GYHL2020K90-M20R	●	GYM20RA-F06	●					L	20	20	125	35	20	39	1
GYHR2525M90-M25L	●	GYM25LA-F06	●					R	25	25	150	38	25	45	1
GYHL2525M90-M25R	●	GYM25RA-F06	●					L	25	25	150	38	25	45	1

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EXTERNAL GROOVING – 90° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	CUTDIA	Hand	H	B	LF*3	LH*3	HF	WF*3	Fig.
GYHR2020K90-M20L	●	GYM20LA-F10	●	F	3.00 3.18 3.24	10	20	R	20	20	125	35	20	45	1
GYHL2020K90-M20R	●	GYM20RA-F10	●					L	20	20	125	35	20	45	1
GYHR2525M90-M25L	●	GYM25LA-F12	●					R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-F12	●					L	25	25	150	38	25	53	1
GYHR2020K90-M20L	●	GYM20LB-F18	●	F	3.00 3.18 3.24	18*4	36	R	20	20	125	35	20	51	2
GYHL2020K90-M20R	●	GYM20RB-F18	●					L	20	20	125	35	20	51	2
GYHR2525M90-M25L	●	GYM25LA-F20	●					R	25	25	150	38	25	59	2
GYHL2525M90-M25R	●	GYM25RA-F20	●					L	25	25	150	38	25	59	2
GYHR2525M90-M25L	●	GYM25LA-G08	●	G	4.00 4.24	8	16	R	25	25	150	38	25	47	1
GYHL2525M90-M25R	●	GYM25RA-G08	●					L	25	25	150	38	25	47	1
GYHR2020K90-M20L	●	GYM20LA-G12	●			12	24	R	20	20	125	35	20	45	1
GYHL2020K90-M20R	●	GYM20RA-G12	●					L	20	20	125	35	20	45	1
GYHR2525M90-M25L	●	GYM25LA-G14	●			14	28	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-G14	●					L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LA-G25	●			25*1	50*2	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RA-G25	●					L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LA-H08	●	H	4.75 5.00 5.24	8	16	R	25	25	150	38	25	47	1
GYHL2525M90-M25R	●	GYM25RA-H08	●					L	25	25	150	38	25	47	1
GYHR2020K90-M20L	●	GYM20LA-H12	●			12	24	R	20	20	125	35	20	45	1
GYHL2020K90-M20R	●	GYM20RA-H12	●					L	20	20	125	35	20	45	1
GYHR2525M90-M25L	●	GYM25LA-H14	●			14	28	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-H14	●					L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LA-H25	●			25*1	25*2	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RA-H25	●					L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LA-J08	●	J	6.00 6.31 6.35	8	16	R	25	25	150	38	25	47	1
GYHL2525M90-M25R	●	GYM25RA-J08	●					L	25	25	150	38	25	47	1
GYHR2525M90-M25L	●	GYM25LA-J14	●			14	28	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RA-J14	●					L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LA-J25	●			25*1	25*2	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RA-J25	●					L	25	25	150	38	25	64	2

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.

*2 The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.

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

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 77.

1. Identification: page 18

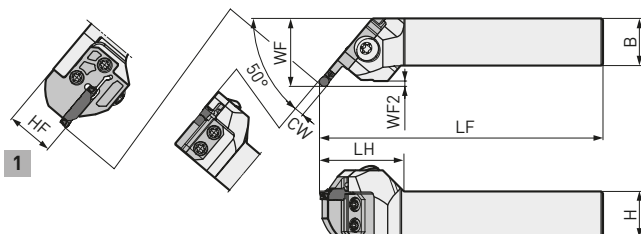
2. Spare parts: page 27



GY GROOVING SERIES

EXTERNAL RECESSING

50° TYPE HOLDER



Right hand tool holder shown.

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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DMIN	APMX	APMX 2	Hand	H	B	LF*2	LH*2	HF	WF*2	WF2*2	Fig.
GYHR2020K50-M20L	●	GYM20LC-D005	●	D	2.00	0.5	30	1.5	0.646	R	20	20	125	40	20	32	1.6	1
GYHL2020K50-M20R	●	GYM20RC-D005	●							L	20	20	125	40	20	32	1.6	1
GYHR2525M50-M25L	●	GYM25LC-D005	●							R	25	25	150	45	25	35	1.6	1
GYHL2525M50-M25R	●	GYM25RC-D005	●							L	25	25	150	45	25	35	1.6	1
GYHR2020K50-M20L	●	GYM20LC-E005	●	E	2.50			1.75	0.72	R	20	20	125	40	20	32	1.8	1
GYHL2020K50-M20R	●	GYM20RC-E005	●							L	20	20	125	40	20	32	1.8	1
GYHR2525M50-M25L	●	GYM25LC-E005	●							R	25	25	150	45	25	35	1.8	1
GYHL2525M50-M25R	●	GYM25RC-E005	●							L	25	25	150	45	25	35	1.8	1
GYHR2020K50-M20L	●	GYM20LC-F005	●	F	3.00 3.18			2	0.793	R	20	20	125	40	20	32	2.0	1
GYHL2020K50-M20R	●	GYM20RC-F005	●							L	20	20	125	40	20	32	2.0	1
GYHR2525M50-M25L	●	GYM25LC-F005	●							R	25	25	150	45	25	35	2.0	1
GYHL2525M50-M25R	●	GYM25RC-F005	●							L	25	25	150	45	25	35	2.0	1
GYHR2020K50-M20L	●	GYM20LC-G005	●	G	4.00			2.5	0.939	R	20	20	125	40	20	32	2.4	1
GYHL2020K50-M20R	●	GYM20RC-G005	●							L	20	20	125	40	20	32	2.4	1
GYHR2525M50-M25L	●	GYM25LC-G005	●							R	25	25	150	45	25	35	2.4	1
GYHL2525M50-M25R	●	GYM25RC-G005	●							L	25	25	150	45	25	35	2.4	1
GYHR2020K50-M20L	●	GYM20LC-H005	●	H	4.75 5.00		2.88	1.049	R	20	20	125	40	20	33	2.8	1	
GYHL2020K50-M20R	●	GYM20RC-H005	●						L	20	20	125	40	20	33	2.8	1	
GYHR2525M50-M25L	●	GYM25LC-H005	●						R	25	25	150	45	25	36	2.8	1	
GYHL2525M50-M25R	●	GYM25RC-H005	●						L	25	25	150	45	25	36	2.8	1	
GYHR2525M50-M25L	●	GYM25LC-J005	●	J	6.00 6.35		3.5	1.232	R	25	25	150	44	25	36	3.4	1	
GYHL2525M50-M25R	●	GYM25RC-J005	●						L	25	25	150	44	25	36	3.4	1	

1/

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The blade for external grooving and face grooving cannot be used due to interference with the workpiece.

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.

*2 The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.

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

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page 77.

1. Identification: page 18

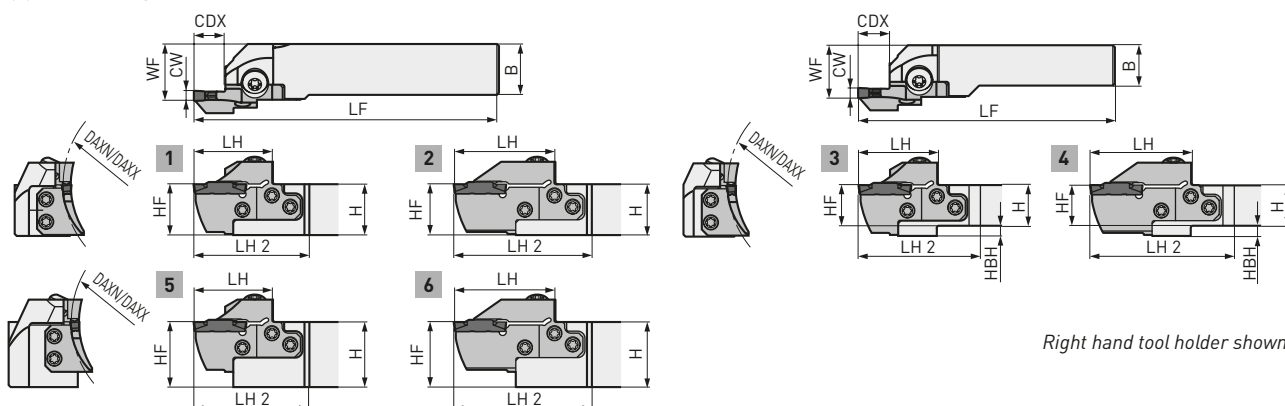
2. Spare parts: page 27



GY GROOVING SERIES

FACE GROOVING

00° TYPE HOLDER



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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-D12-040	●	D	2.00 2.24	12	40	50	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-040	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-040	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-D12-040	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-D12-040	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-D12-040	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-D12-040	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-D12-040	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-D12-050	●	D	2.00 2.24	12	50	60	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-050	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-050	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-D12-050	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-D12-050	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-D12-050	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-D12-050	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-D12-050	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-D12-060	●	D	2.00 2.24	12	60	75	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-060	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-060	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-D12-060	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-D12-060	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-D12-060	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-D12-060	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-D12-060	●						L	32	32	170	39	57	32	35	-	5

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-D12-075	●	D	2.00 2.24	12	75	100	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-075	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-075	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-D12-075	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-D12-075	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-D12-075	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-D12-075	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-D12-075	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-D12-100	●	D	2.00 2.24	12	100	150	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-100	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-100	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-D12-100	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-D12-100	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-D12-100	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-D12-100	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-D12-100	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-D12-135	●	D	2.00 2.24	12	135	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-135	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-135	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-D12-135	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-D12-135	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-D12-135	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-D12-135	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-D12-135	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-D12-180	●	D	2.00 2.24	12	180	250	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-D12-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-D12-180	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-D12-180	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-D12-180	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-D12-180	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-D12-180	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-D12-180	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-E12-040	●	E	2.39 2.50 2.74	12	40	50	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-040	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-040	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-E12-040	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-E12-040	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-E12-040	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-E12-040	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-E12-040	●						L	32	32	170	39	57	32	35	–	5

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.

2. Identification: page 18

3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-E12-050	●	E	2.39 2.50 2.74	12	50	60	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-050	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-050	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-E12-050	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-E12-050	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-E12-050	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-E12-050	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-E12-050	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-E12-060	●	E	2.39 2.50 2.74	12	60	75	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-060	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-060	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-E12-060	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-E12-060	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-E12-060	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-E12-060	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-E12-060	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-E12-075	●	E	2.39 2.50 2.74	12	75	100	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-075	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-075	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-E12-075	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-E12-075	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-E12-075	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-E12-075	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-E12-075	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-E12-100	●	E	2.39 2.50 2.74	12	100	150	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-100	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-100	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-E12-100	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-E12-100	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-E12-100	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-E12-100	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-E12-100	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-E12-135	●	E	2.39 2.50 2.74	12	135	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-135	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-135	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-E12-135	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-E12-135	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-E12-135	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-E12-135	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-E12-135	●						L	32	32	170	39	57	32	35	-	5

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-E12-180	●	E	2.39 2.50 2.74	12	180	250	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-E12-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-E12-180	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-E12-180	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-E12-180	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-E12-180	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-E12-180	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-E12-180	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-F12-035	●	F	3.00 3.18 3.24	12	35	40	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-035	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-035	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-035	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-035	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-035	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-035	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-035	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-F12-040	●	F	3.00 3.18 3.24	12	40	50	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-040	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-040	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-040	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-040	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-040	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-040	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-040	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-F12-050	●	F	3.00 3.18 3.24	12	50	60	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-050	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-050	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-050	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-050	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-050	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-050	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-050	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-F12-060	●	F	3.00 3.18 3.24	12	60	75	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-060	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-060	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-F12-060	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-F12-060	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-F12-060	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-F12-060	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-F12-060	●						L	32	32	170	39	57	32	35	–	5

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-F20-060	●	F	3.00 3.18 3.24	20*2	60	75	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-060	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-060	●						R	25	25	156	45	63	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-F20-060	●						L	25	25	156	45	63	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-F20-060	●						R	32	25	176	45	63	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-F20-060	●						L	32	25	176	45	63	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-F20-060	●						R	32	32	176	45	63	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-F20-060	●						L	32	32	176	45	63	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-F12-075	●	F	3.00 3.18 3.24	12	75	100	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-075	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-075	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-F12-075	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-F12-075	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-F12-075	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-F12-075	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-F12-075	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-F20-075	●	F	3.00 3.18 3.24	20*2	75	100	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-075	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-075	●						R	25	25	156	45	63	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-F20-075	●						L	25	25	156	45	63	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-F20-075	●						R	32	25	176	45	63	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-F20-075	●						L	32	25	176	45	63	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-F20-075	●						R	32	32	176	45	63	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-F20-075	●						L	32	32	176	45	63	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-F12-100	●	F	3.00 3.18 3.24	12	100	150	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-100	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-100	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-F12-100	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-F12-100	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-F12-100	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-F12-100	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-F12-100	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-F20-100	●	F	3.00 3.18 3.24	20*2	100	150	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-100	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-100	●						R	25	25	156	45	63	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-F20-100	●						L	25	25	156	45	63	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-F20-100	●						R	32	25	176	45	63	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-F20-100	●						L	32	25	176	45	63	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-F20-100	●						R	32	32	176	45	63	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-F20-100	●						L	32	32	176	45	63	32	35	-	6

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-F12-135	●	F	3.00 3.18 3.24	12	135	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-135	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-135	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-F12-135	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-F12-135	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-F12-135	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-F12-135	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-F12-135	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-F20-135	●	F	3.00 3.18 3.24	20*2	135	200	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-135	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-135	●						R	25	25	156	45	63	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-F20-135	●						L	25	25	156	45	63	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-F20-135	●	F	3.00 3.18 3.24	20*2	135	200	R	32	25	176	45	63	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-F20-135	●						L	32	25	176	45	63	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-F20-135	●						R	32	32	176	45	63	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-F20-135	●						L	32	32	176	45	63	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-F12-180	●	F	3.00 3.18 3.24	12	180	250	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-180	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-F12-180	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-F12-180	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-F12-180	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-F12-180	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-F12-180	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-F20-180	●	F	3.00 3.18 3.24	20*2	180	250	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-180	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-180	●						R	25	25	156	45	63	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-F20-180	●						L	25	25	156	45	63	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-F20-180	●						R	32	25	176	45	63	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-F20-180	●						L	32	25	176	45	63	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-F20-180	●						R	32	32	176	45	63	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-F20-180	●						L	32	32	176	45	63	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-F12-225	●	F	3.00 3.18 3.24	12	225	999	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-F12-225	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-F12-225	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-F12-225	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-F12-225	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-F12-225	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-F12-225	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-F12-225	●						L	32	32	170	39	57	32	35	-	5

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-F20-225	●	F	3.00 3.18 3.24	20*2	225	999	R	20	20	131	45	66	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-F20-225	●						L	20	20	131	45	66	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-F20-225	●						R	25	25	156	45	63	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-F20-225	●						L	25	25	156	45	63	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-F20-225	●						R	32	25	176	45	63	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-F20-225	●						L	32	25	176	45	63	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-F20-225	●						R	32	32	176	45	63	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-F20-225	●						L	32	32	176	45	63	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-G14-040	●	G	4.00 4.24	14	40	50	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-040	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-040	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-G14-040	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-G14-040	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-G14-040	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-G14-040	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-G14-040	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-G14-050	●	G	4.00 4.24	14	50	60	R	20	20	125	39	60	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G14-050	●						L	20	20	125	39	60	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G14-050	●						R	25	25	150	39	57	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-G14-050	●						L	25	25	150	39	57	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-G14-050	●						R	32	25	170	39	57	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-G14-050	●						L	32	25	170	39	57	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-G14-050	●						R	32	32	170	39	57	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-G14-050	●						L	32	32	170	39	57	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-G14-060	●	G	4.00 4.24	14	60	85	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-060	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-060	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-G14-060	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-G14-060	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-G14-060	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-G14-060	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-G14-060	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-G25-060	●	G	4.00 4.24	25*2	60	85	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-060	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-060	●						R	25	25	161	50	68	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-G25-060	●						L	25	25	161	50	68	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-G25-060	●	G	4.00 4.24	25*2	60	85	R	32	25	181	50	68	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-G25-060	●						L	32	25	181	50	68	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-G25-060	●						R	32	32	181	50	68	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-G25-060	●						L	32	32	181	50	68	32	35	-	6

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-G14-085	●	G	4.00 4.24	14	85	125	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-085	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-085	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-G14-085	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-G14-085	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-G14-085	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-G14-085	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-G14-085	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-G25-085	●	G	4.00 4.24	25*2	85	125	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-085	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-085	●						R	25	25	161	50	68	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-G25-085	●						L	25	25	161	50	68	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-G25-085	●						R	32	25	181	50	68	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-G25-085	●						L	32	25	181	50	68	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-G25-085	●						R	32	32	181	50	68	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-G25-085	●						L	32	32	181	50	68	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-G14-125	●	G	4.00 4.24	14	125	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-125	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-125	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-G14-125	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-G14-125	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-G14-125	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-G14-125	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-G14-125	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-G25-125	●	G	4.00 4.24	25*2	125	200	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-125	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-125	●						R	25	25	161	50	68	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-G25-125	●						L	25	25	161	50	68	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-G25-125	●						R	32	25	181	50	68	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-G25-125	●						L	32	25	181	50	68	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-G25-125	●						R	32	32	181	50	68	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-G25-125	●						L	32	32	181	50	68	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-G14-180	●	G	4.00 4.24	14	180	280	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-180	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-G14-180	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-G14-180	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-G14-180	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-G14-180	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-G14-180	●						L	32	32	170	39	57	32	35	-	5

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.

2. Identification: page 18

3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-G25-180	●	G	4.00 4.24	25*2	180	280	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-180	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-180	●						R	25	25	161	50	68	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-G25-180	●						L	25	25	161	50	68	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-G25-180	●						R	32	25	181	50	68	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-G25-180	●						L	32	25	181	50	68	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-G25-180	●						R	32	32	181	50	68	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-G25-180	●						L	32	32	181	50	68	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-G14-250	●	G	4.00 4.24	14	250	999	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-250	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-250	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-G14-250	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-G14-250	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-G14-250	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-G14-250	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-G14-250	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-G25-250	●	G	4.00 4.24	25*2	250	999	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-250	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-250	●						R	25	25	161	50	68	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-G25-250	●						L	25	25	161	50	68	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-G25-250	●	G	4.00 4.24	25*2	250	999	R	32	25	181	50	68	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-G25-250	●						L	32	25	181	50	68	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-G25-250	●						R	32	32	181	50	68	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-G25-250	●						L	32	32	181	50	68	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-G14-180	●	H	4.75 5.00 5.24	14	50	60	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-180	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-G14-180	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-G14-180	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-G14-180	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-G14-180	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-G14-180	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-G25-180	●	H	4.75 5.00 5.24	14	60	85	R	20	20	125	39	60	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-G25-180	●						L	20	20	125	39	60	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-G25-180	●						R	25	25	150	39	57	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-G25-180	●						L	25	25	150	39	57	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-G25-180	●						R	32	25	170	39	57	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-G25-180	●						L	32	25	170	39	57	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-G25-180	●						R	32	32	170	39	57	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-G25-180	●						L	32	32	170	39	57	32	35	-	6

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-G14-250	●	H	4.75 5.00 5.24	25*2	60	85	R	20	20	136	50	71	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-G14-250	●						L	20	20	136	50	71	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-G14-250	●						R	25	25	161	50	68	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-G14-250	●						L	25	25	161	50	68	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-G14-250	●						R	32	25	181	50	68	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-G14-250	●						L	32	25	181	50	68	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-G14-250	●						R	32	32	181	50	68	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-G14-250	●						L	32	32	181	50	68	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-H14-085	●	H	4.75 5.00 5.24	14	85	125	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-H14-085	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-H14-085	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-H14-085	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-H14-085	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-H14-085	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-H14-085	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-H14-085	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-H25-085	●	H	4.75 5.00 5.24	25*2	85	125	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-H25-085	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-H25-085	●						R	25	25	161	50	68	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-H25-085	●						L	25	25	161	50	68	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-H25-085	●						R	32	25	181	50	68	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-H25-085	●						L	32	25	181	50	68	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-H25-085	●						R	32	32	181	50	68	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-H25-085	●						L	32	32	181	50	68	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-H14-125	●	H	4.75 5.00 5.24	14	125	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-H14-125	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-H14-125	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-H14-125	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-H14-125	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-H14-125	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-H14-125	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-H14-125	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-H25-125	●	H	4.75 5.00 5.24	25*2	125	200	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-H25-125	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-H25-125	●						R	25	25	161	50	68	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-H25-125	●						L	25	25	161	50	68	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-H25-125	●						R	32	25	181	50	68	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-H25-125	●						L	32	25	181	50	68	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-H25-125	●						R	32	32	181	50	68	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-H25-125	●						L	32	32	181	50	68	32	35	-	6

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-H14-180	●	H	4.75 5.00 5.24	14	180	280	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-H14-180	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-H14-180	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-H14-180	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-H14-180	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-H14-180	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-H14-180	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-H14-180	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-H25-180	●	H	4.75 5.00 5.24	25*2	180	280	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-H25-180	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-H25-180	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-H25-180	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-H25-180	●	H	4.75 5.00 5.24	25*2	180	280	R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-H25-180	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-H25-180	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-H25-180	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-H14-250	●	H	4.75 5.00 5.24	14	250	999	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-H14-250	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-H14-250	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-H14-250	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-H14-250	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-H14-250	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-H14-250	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-H14-250	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-H25-250	●	H	4.75 5.00 5.24	25*2	250	999	R	20	20	136	50	71	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-H25-250	●						L	20	20	136	50	71	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-H25-250	●						R	25	25	161	50	68	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-H25-250	●						L	25	25	161	50	68	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-H25-250	●						R	32	25	181	50	68	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-H25-250	●						L	32	25	181	50	68	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-H25-250	●						R	32	32	181	50	68	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-H25-250	●						L	32	32	181	50	68	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-J14-050	●	J	6.00 6.31 6.35	14	50	70	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-J14-050	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-J14-050	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-J14-050	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-J14-050	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-J14-050	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-J14-050	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-J14-050	●						L	32	32	170	39	57	32	35	–	5

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-J14-070	●	J	6.00 6.31 6.35	14	70	110	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-J14-070	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-J14-070	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-J14-070	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-J14-070	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-J14-070	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-J14-070	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-J14-070	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-J25-070	●	J	6.00 6.31 6.35	25*2	70	110	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-J25-070	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-J25-070	●						R	25	25	161	50	68	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-J25-070	●						L	25	25	161	50	68	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-J25-070	●						R	32	25	181	50	68	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-J25-070	●						L	32	25	181	50	68	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-J25-070	●						R	32	32	181	50	68	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-J25-070	●						L	32	32	181	50	68	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-J14-110	●	J	6.00 6.31 6.35	14	110	200	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-J14-110	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-J14-110	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-J14-110	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-J14-110	●	J	6.00 6.31 6.35	14	110	200	R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-J14-110	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-J14-110	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-J14-110	●						L	32	32	170	39	57	32	35	-	5
GYHR2020K00-M25R	●	GYM25RD-J25-110	●	J	6.00 6.31 6.35	25*2	110	200	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-J25-110	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-J25-110	●						R	25	25	161	50	68	25	28	-	2
GYHL2525M00-M25L	●	GYM25LD-J25-110	●						L	25	25	161	50	68	25	28	-	2
GYHR3225P00-M25R	●	GYM25RD-J25-110	●						R	32	25	181	50	68	32	28	-	6
GYHL3225P00-M25L	●	GYM25LD-J25-110	●						L	32	25	181	50	68	32	28	-	6
GYHR3232P00-M25R	●	GYM25RD-J25-110	●						R	32	32	181	50	68	32	35	-	6
GYHL3232P00-M25L	●	GYM25LD-J25-110	●						L	32	32	181	50	68	32	35	-	6
GYHR2020K00-M25R	●	GYM25RD-J14-170	●	J	6.00 6.31 6.35	14	170	280	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-J14-170	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-J14-170	●						R	25	25	150	39	57	25	28	-	1
GYHL2525M00-M25L	●	GYM25LD-J14-170	●						L	25	25	150	39	57	25	28	-	1
GYHR3225P00-M25R	●	GYM25RD-J14-170	●						R	32	25	170	39	57	32	28	-	5
GYHL3225P00-M25L	●	GYM25LD-J14-170	●						L	32	25	170	39	57	32	28	-	5
GYHR3232P00-M25R	●	GYM25RD-J14-170	●						R	32	32	170	39	57	32	35	-	5
GYHL3232P00-M25L	●	GYM25LD-J14-170	●						L	32	32	170	39	57	32	35	-	5

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 00° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	LH 2	HF	WF*1	HBH	Fig.
GYHR2020K00-M25R	●	GYM25RD-J25-170	●	J	6.00 6.31 6.35	25*2	170	280	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-J25-170	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-J25-170	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-J25-170	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-J25-170	●						R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-J25-170	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-J25-170	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-J25-170	●						L	32	32	181	50	68	32	35	–	6
GYHR2020K00-M25R	●	GYM25RD-J14-250	●	J	6.00 6.31 6.35	14	250	999	R	20	20	125	39	60	20	26	5	3
GYHL2020K00-M25L	●	GYM25LD-J14-250	●						L	20	20	125	39	60	20	26	5	3
GYHR2525M00-M25R	●	GYM25RD-J14-250	●						R	25	25	150	39	57	25	28	–	1
GYHL2525M00-M25L	●	GYM25LD-J14-250	●						L	25	25	150	39	57	25	28	–	1
GYHR3225P00-M25R	●	GYM25RD-J14-250	●						R	32	25	170	39	57	32	28	–	5
GYHL3225P00-M25L	●	GYM25LD-J14-250	●						L	32	25	170	39	57	32	28	–	5
GYHR3232P00-M25R	●	GYM25RD-J14-250	●						R	32	32	170	39	57	32	35	–	5
GYHL3232P00-M25L	●	GYM25LD-J14-250	●						L	32	32	170	39	57	32	35	–	5
GYHR2020K00-M25R	●	GYM25RD-J25-250	●	J	6.00 6.31 6.35	25*2	250	999	R	20	20	136	50	71	20	26	5	4
GYHL2020K00-M25L	●	GYM25LD-J25-250	●						L	20	20	136	50	71	20	26	5	4
GYHR2525M00-M25R	●	GYM25RD-J25-250	●						R	25	25	161	50	68	25	28	–	2
GYHL2525M00-M25L	●	GYM25LD-J25-250	●						L	25	25	161	50	68	25	28	–	2
GYHR3225P00-M25R	●	GYM25RD-J25-250	●						R	32	25	181	50	68	32	28	–	6
GYHL3225P00-M25L	●	GYM25LD-J25-250	●						L	32	25	181	50	68	32	28	–	6
GYHR3232P00-M25R	●	GYM25RD-J25-250	●						R	32	32	181	50	68	32	35	–	6
GYHL3232P00-M25L	●	GYM25LD-J25-250	●						L	32	32	181	50	68	32	35	–	6

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.

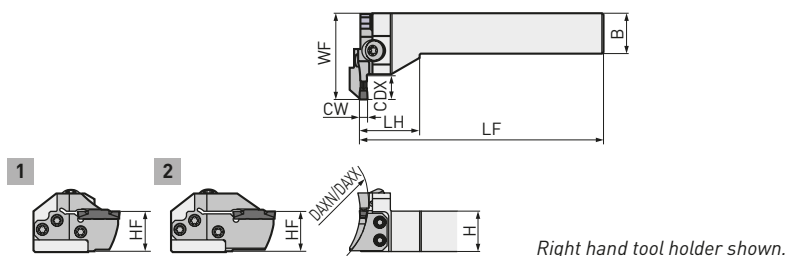


1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.
2. Identification: page 18
3. Spare parts: page 27

GY GROOVING SERIES

FACE GROOVING

90° TYPE HOLDER



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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	LF*1	LH*1	HF	WF*1	Fig.
GYHR2525M90-M25L	●	GYM25LD-D12-040	●	D	2.00 2.24	12	40	50	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-040	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-050	●			12	50	60	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-050	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-060	●			12	60	75	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-060	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-075	●			12	75	100	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-075	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-100	●			12	100	150	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-100	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-135	●			12	135	200	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-D12-135	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-D12-180	●	E	2.39 2.50 2.74	12	40	50	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-040	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-050	●			12	50	60	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-050	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-060	●			12	60	75	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-060	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-075	●			12	75	100	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-075	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-100	●			12	100	150	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-100	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-135	●			12	135	200	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-135	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-E12-180	●			12	180	250	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-E12-180	●						L	25	25	150	38	25	53	1

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 90° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	L ^{*1}	LH ^{*1}	HF	WF ^{*1}	Fig.
GYHR2525M90-M25L	●	GYM25LD-F12-035	●	F	3.00 3.18 3.24	12	35	40	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-035	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F12-040	●			12	40	50	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-040	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F12-050	●			12	50	60	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-050	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F12-060	●			12	60	75	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-060	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-060	●			20*2	60	75	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-060	●						L	25	25	150	38	38	59	2
GYHR2525M90-M25L	●	GYM25LD-F12-075	●			12	75	100	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-075	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-075	●			20*2	75	100	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-075	●						L	25	25	150	38	38	59	2
GYHR2525M90-M25L	●	GYM25LD-F12-100	●			12	100	150	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-100	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-100	●			20*2	100	150	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-100	●						L	25	25	150	38	38	59	2
GYHR2525M90-M25L	●	GYM25LD-F12-135	●			12	135	200	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-135	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-135	●			20*2	135	200	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-135	●						L	25	25	150	38	38	59	2
GYHR2525M90-M25L	●	GYM25LD-F12-180	●			12	180	250	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-180	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-180	●			20*2	180	250	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-180	●						L	25	25	150	38	38	59	2
GYHR2525M90-M25L	●	GYM25LD-F12-225	●			12	225	999	R	25	25	150	38	38	53	1
GYHL2525M90-M25R	●	GYM25RD-F12-225	●						L	25	25	150	38	38	53	1
GYHR2525M90-M25L	●	GYM25LD-F20-225	●			20*2	225	999	R	25	25	150	38	38	59	2
GYHL2525M90-M25R	●	GYM25RD-F20-225	●						L	25	25	150	38	38	59	2

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 90° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	Lf*1	LH*1	HF	WF*1	Fig.
GYHR2525M90-M25L	●	GYM25LD-G14-040	●	G	4.00 4.24	14	40	50	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-040	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G14-050	●			14	50	60	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-050	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G14-060	●			14	60	85	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-060	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G25-060	●			25*2	60	85	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-G25-060	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-G14-085	●			14	85	125	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-085	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G25-085	●			25*2	85	125	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-G25-085	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-G14-125	●			14	125	200	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-125	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G25-125	●			25*2	125	200	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-G25-125	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-G14-180	●			14	180	280	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-180	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G25-180	●			25*2	180	280	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-G25-180	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-G14-250	●			14	250	999	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-G14-250	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-G25-250	●			25*2	250	999	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-G25-250	●						L	25	25	150	38	25	64	2

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.
2. Identification: page 18
3. Spare parts: page 27

FACE GROOVING – 90° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX	DAXN	DAXX	Hand	H	B	L ^{*1}	LH ^{*1}	HF	WF ^{*1}	Fig.
GYHR2525M90-M25L	●	GYM25LD-H14-050	●	H	4.75 5.00 5.24	14	50	60	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-050	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H14-060	●			14	60	85	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-060	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H25-060	●			25*2	60	85	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-H25-060	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-H14-085	●			14	85	125	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-085	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H25-085	●			25*2	85	125	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-H25-085	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-H14-125	●			14	125	200	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-125	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H25-125	●			25*2	125	200	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-H25-125	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-H14-180	●			14	180	280	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-180	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H25-180	●			25*2	180	280	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-H25-180	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-H14-250	●			14	250	999	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-H14-250	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-H25-250	●			25*2	250	999	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-H25-250	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-J14-050	●	J	6.00 6.31 6.35	14	50	70	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-J14-050	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-J14-070	●			14	70	110	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-J14-070	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-J25-070	●			25*2	70	110	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-J25-070	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-J14-110	●			14	110	200	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-J14-110	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-J25-110	●			25*2	110	200	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-J25-110	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-J14-170	●			14	170	280	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-J14-170	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-J25-170	●			25*2	170	280	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-J25-170	●						L	25	25	150	38	25	64	2
GYHR2525M90-M25L	●	GYM25LD-J14-250	●			14	250	999	R	25	25	150	38	25	53	1
GYHL2525M90-M25R	●	GYM25RD-J14-250	●						L	25	25	150	38	25	53	1
GYHR2525M90-M25L	●	GYM25LD-J25-250	●			25*2	250	999	R	25	25	150	38	25	64	2
GYHL2525M90-M25R	●	GYM25RD-J25-250	●						L	25	25	150	38	25	64	2

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*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29–32.



1. The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29–32.
2. Identification: page 18
3. Spare parts: page 27

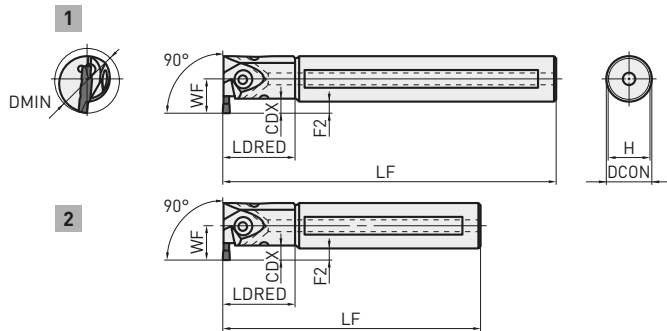
GY GROOVING SERIES

INTERNAL GROOVING

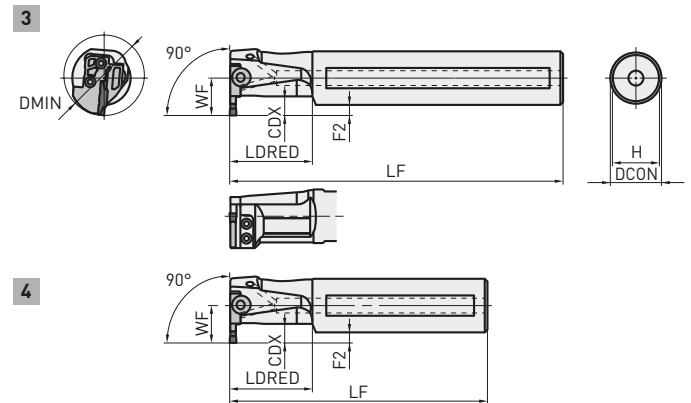
90° TYPE HOLDER

- Monoblock type (Air/coolant through)

- Modular blade type (Air/coolant through)



Right hand tool holder shown.



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

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX*3	DMIN	Hand	DCON	LF*2	LDRED*2	WF*2	F2*2	H	Fig.
GYAR20K90A-D06	●	-	-	D	2.00 2.24	6	25	R	20	125	30	14.5	4.5	18	2
GYAL20K90A-D06	●	-	-					L	20	125	30	14.5	4.5	18	2
GYAR20Q90A-D06	●	-	-			6	25	R	20	180	30	14.5	4.5	18	1
GYAL20Q90A-D06	●	-	-					L	20	180	30	14.5	4.5	18	1
GYAR25K90B-D06	●	-	-			6	32	R	25	125	40	19	6.5	23	2
GYAL25K90B-D06	●	-	-					L	25	125	40	19	6.5	23	2
GYAR25R90B-D06	●	-	-			6	32	R	25	200	40	19	6.5	23	1
GYAL25R90B-D06	●	-	-					L	25	200	40	19	6.5	23	1
GYDR32L90C-M20L	●	GYM20LA-D10	●			4 - 9.5*1	40	R	32	140	50	22	6	30	4
GYDL32L90C-M20R	●	GYM20RA-D10	●					L	32	140	50	22	6	30	4
GYDR32S90C-M20L	●	GYM20LA-D10	●			4 - 9.5*1	40	R	32	250	50	22	6	30	3
GYDL32S90C-M20R	●	GYM20RA-D10	●					L	32	250	50	22	6	30	3
GYDR40M90D-M20L	●	GYM20LA-D10	●			5.5 - 9.5*1	50	R	40	150	60	28	8	37	4
GYDL40M90D-M20R	●	GYM20RA-D10	●					L	40	150	60	28	8	37	4
GYDR40T90D-M20L	●	GYM20LA-D10	●			5.5 - 9.5*1	50	R	40	300	60	28	8	37	3
GYDL40T90D-M20R	●	GYM20RA-D10	●					L	40	300	60	28	8	37	3
GYDR40M90D-M25L	●	GYM25LA-D12	●			7 - 11.5*1	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-D12	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-D12	●			7 - 11.5*1	60	R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-D12	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-D12	●			7 - 11.5*1	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-D12	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-D12	●			7 - 11.5*1	70	R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-D12	●					L	50	300	80	34	9	47	3

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INTERNAL GROOVING – 90° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX ^{*3}	DMIN	Hand	DCON	LF ^{*2}	LDRED ^{*2}	WF ^{*2}	F2 ^{*2}	H	Fig.
GYAR20K90A-E06	●	-	-	E	2.39 2.50 2.74	6	25	R	20	125	30	14.5	4.5	18	2
GYAL20K90A-E06	●	-	-					L	20	125	30	14.5	4.5	18	2
GYAR20Q90A-E06	●	-	-			6	25	R	20	180	30	14.5	4.5	18	1
GYAL20Q90A-E06	●	-	-					L	20	180	30	14.5	4.5	18	1
GYAR25K90B-E06	●	-	-			6	32	R	25	125	40	19	6.5	23	2
GYAL25K90B-E06	●	-	-					L	25	125	40	19	6.5	23	2
GYAR25R90B-E06	●	-	-			6	32	R	25	200	40	19	6.5	23	1
GYAL25R90B-E06	●	-	-					L	25	200	40	19	6.5	23	1
GYDR32L90C-M20L	●	GYM20LA-E10	●			4 – 9.5 ^{*1}	40	R	32	140	50	22	6	30	4
GYDL32L90C-M20R	●	GYM20RA-E10	●					L	32	140	50	22	6	30	4
GYDR32S90C-M20L	●	GYM20LA-E10	●			4 – 9.5 ^{*1}	40	R	32	250	50	22	6	30	3
GYDL32S90C-M20R	●	GYM20RA-E10	●					L	32	250	50	22	6	30	3
GYDR40M90D-M20L	●	GYM20LA-E10	●			5.5 – 9.5 ^{*1}	50	R	40	150	60	28	8	37	4
GYDL40M90D-M20R	●	GYM20RA-E10	●					L	40	150	60	28	8	37	4
GYDR40T90D-M20L	●	GYM20LA-E10	●			5.5 – 9.5 ^{*1}	50	R	40	300	60	28	8	37	3
GYDL40T90D-M20R	●	GYM20RA-E10	●					L	40	300	60	28	8	37	3
GYDR40M90D-M25L	●	GYM25LA-E12	●			7 – 11.5 ^{*1}	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-E12	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-E12	●			7 – 11.5 ^{*1}	60	R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-E12	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-E12	●			7 – 11.5 ^{*1}	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-E12	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-E12	●			7 – 11.5 ^{*1}	70	R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-E12	●					L	50	300	80	34	9	47	3
GYAR20K90A-F06	●	-	-	F	3.00 3.18 3.24	6	25	R	20	125	30	14.5	4.5	18	2
GYAL20K90A-F06	●	-	-					L	20	125	30	14.5	4.5	18	2
GYAR20Q90A-F06	●	-	-			6	25	R	20	180	30	14.5	4.5	18	1
GYAL20Q90A-F06	●	-	-					L	20	180	30	14.5	4.5	18	1
GYAR25K90B-F06	●	-	-			6	32	R	25	125	40	19	6.5	23	2
GYAL25K90B-F06	●	-	-					L	25	125	40	19	6.5	23	2
GYAR25R90B-F06	●	-	-			6	32	R	25	200	40	19	6.5	23	1
GYAL25R90B-F06	●	-	-					L	25	200	40	19	6.5	23	1
GYDR32L90C-M20L	●	GYM20LA-F10	●			4 – 9.5 ^{*1}	40	R	32	140	50	22	6	30	4
GYDL32L90C-M20R	●	GYM20RA-F10	●					L	32	140	50	22	6	30	4
GYDR32S90C-M20L	●	GYM20LA-F10	●			4 – 9.5 ^{*1}	40	R	32	250	50	22	6	30	3
GYDL32S90C-M20R	●	GYM20RA-F10	●					L	32	250	50	22	6	30	3
GYDR40M90D-M20L	●	GYM20LA-F10	●			5.5 – 9.5 ^{*1}	50	R	40	150	60	28	8	37	4
GYDL40M90D-M20R	●	GYM20RA-F10	●					L	40	150	60	28	8	37	4
GYDR40T90D-M20L	●	GYM20LA-F10	●			5.5 – 9.5 ^{*1}	50	R	40	300	60	28	8	37	3
GYDL40T90D-M20R	●	GYM20RA-F10	●					L	40	300	60	28	8	37	3
GYDR40M90D-M25L	●	GYM25LA-F12	●			7 – 11.5 ^{*1}	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-F12	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-F12	●			7 – 11.5 ^{*1}	60	R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-F12	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-F12	●			7 – 11.5 ^{*1}	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-F12	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-F12	●			7 – 11.5 ^{*1}	70	R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-F12	●					L	50	300	80	34	9	47	3

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^{*1} The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.

^{*2} The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.

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

1. Identification: page 18

2. Spare parts: page 27

INTERNAL GROOVING – 90° TYPE HOLDER

Order number Holder	Stock	Order number Modular blade	Stock	Seat size	CW	CDX* ³	DMIN	Hand	DCON	LF* ²	LDRED* ²	WF* ²	F2* ²	H	Fig.
GYAR25K90B-G07	●	–	–	G	4.00 4.24	7	32	R	25	125	40	19	6.5	23	2
GYAL25K90B-G07	●	–	–					L	25	125	40	19	6.5	23	2
GYAR25R90B-G07	●	–	–			7	32	R	25	200	40	19	6.5	23	1
GYAL25R90B-G07	●	–	–					L	25	200	40	19	6.5	23	1
GYDR32L90C-M20L	●	GYM20LA-G12	●			4.5 – 11.5* ¹	40	R	32	140	50	22	6	30	4
GYDL32L90C-M20R	●	GYM20RA-G12	●					L	32	140	50	22	6	30	4
GYDR32S90C-M20L	●	GYM20LA-G12	●			4.5 – 11.5* ¹	40	R	32	250	50	22	6	30	3
GYDL32S90C-M20R	●	GYM20RA-G12	●					L	32	250	50	22	6	30	3
GYDR40M90D-M20L	●	GYM20LA-G12	●			6 – 11.5* ¹	50	R	40	150	60	28	8	37	4
GYDL40M90D-M20R	●	GYM20RA-G12	●					L	40	150	60	28	8	37	4
GYDR40T90D-M20L	●	GYM20LA-G12	●			6 – 11.5* ¹	50	R	40	300	60	28	8	37	3
GYDL40T90D-M20R	●	GYM20RA-G12	●					L	40	300	60	28	8	37	3
GYDR40M90D-M25L	●	GYM25LA-G14	●			7.5 – 13* ¹	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-G14	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-G14	●			7.5 – 13* ¹	60	R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-G14	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-G14	●			7.5 – 13* ¹	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-G14	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-G14	●			7.5 – 13* ¹	70	R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-G14	●					L	50	300	80	34	9	47	3
GYAR25K90B-H07	●	–	–	H	4.75 5.00 5.24	7	32	R	25	125	40	19	6.5	23	2
GYAL25K90B-H07	●	–	–					L	25	125	40	19	6.5	23	2
GYAR25R90B-H07	●	–	–					R	25	200	40	19	6.5	23	1
GYAL25R90B-H07	●	–	–					L	25	200	40	19	6.5	23	1
GYDR32L90C-M20L	●	GYM20LA-H12	●	H	4.75 5.00 5.24	4.5 – 11.5* ¹	40	R	32	140	50	22	6	30	4
GYDL32L90C-M20R	●	GYM20RA-H12	●					L	32	140	50	22	6	30	4
GYDR32S90C-M20L	●	GYM20LA-H12	●					R	32	250	50	22	6	30	3
GYDL32S90C-M20R	●	GYM20RA-H12	●					L	32	250	50	22	6	30	3
GYDR40M90D-M20L	●	GYM20LA-H12	●			6 – 11.5* ¹	50	R	40	150	60	28	8	37	4
GYDL40M90D-M20R	●	GYM20RA-H12	●					L	40	150	60	28	8	37	4
GYDR40T90D-M20L	●	GYM20LA-H12	●					R	40	300	60	28	8	37	3
GYDL40T90D-M20R	●	GYM20RA-H12	●					L	40	300	60	28	8	37	3
GYDR40M90D-M25L	●	GYM25LA-H14	●			7.5 – 13* ¹	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-H14	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-H14	●					R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-H14	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-H14	●			7.5 – 13* ¹	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-H14	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-H14	●					R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-H14	●					L	50	300	80	34	9	47	3
GYDR40M90D-M25L	●	GYM25LA-J14	●	J	6.00 6.31 6.35	7.5 – 13* ¹	60	R	40	150	60	28	8	37	4
GYDL40M90D-M25R	●	GYM25RA-J14	●					L	40	150	60	28	8	37	4
GYDR40T90D-M25L	●	GYM25LA-J14	●			7.5 – 13* ¹	60	R	40	300	60	28	8	37	3
GYDL40T90D-M25R	●	GYM25RA-J14	●					L	40	300	60	28	8	37	3
GYDR50P90F-M25L	●	GYM25LA-J14	●			7.5 – 13* ¹	70	R	50	170	80	34	9	47	4
GYDL50P90F-M25R	●	GYM25RA-J14	●					L	50	170	80	34	9	47	4
GYDR50T90F-M25L	●	GYM25LA-J14	●			7.5 – 13* ¹	70	R	50	300	80	34	9	47	3
GYDL50T90F-M25R	●	GYM25RA-J14	●					L	50	300	80	34	9	47	3

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*¹ The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages 29 – 32.

*² The maximum cut off diameter CUTDIA varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages 29 – 32.

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

1. Identification: page 18

2. Spare parts: page 27

GY GROOVING SERIES

RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED (FOR EXTERNAL GROOVING AND CUTTING OFF)

	Material	Hardness	Grade	Vc		
P	Mild steel	<160HB	VP20RT	155 (100 – 220)		
			VP10RT	170 (110 – 230)		
			NX2525	150 (90 – 210)		
	Carbon steel	160 – 280HB	VP20RT	120 (80 – 180)		
			VP10RT	140 (90 – 190)		
			MY6125	230 (160 – 300)		
			MY5015	180 (110 – 250)		
			NX2525	120 (70 – 170)		
			Alloy steel	≥280HB	VP20RT	100 (60 – 140)
					VP10RT	110 (70 – 150)
	MY6125	185 (110 – 260)				
			MY5015	150 (90 – 210)		
			NX2525	95 (55 – 135)		
M	Stainless steel	<270HB	VP20RT	100 (60 – 140)		
			VP10RT	110 (70 – 150)		
K	Gray cast iron	Tensile strength ≤300MPa	VP20RT	120 (80 – 180)		
			VP10RT	140 (90 – 190)		
			MY5015	120 (140 – 300)		
			MY6125	260 (170 – 350)		
	Ductile cast iron	Tensile strength ≤800MPa	VP20RT	100 (60 – 140)		
			VP10RT	110 (70 – 150)		
			MY5015	150 (90 – 210)		
		MY6125	185 (110 – 260)			
N	Aluminium alloy (A6061, 7075)	Content Si<5 %	RT9010	350 (200 – 500)		
	Aluminium alloy (AC4B)	Content 5 %≤Si≤10 %	RT9010	350 (200 – 500)		
	Aluminium alloy (ADC12, A390)	Content Si>10 %	RT9010	150 (100 – 200)		
S	Heat resistant alloy Titanium alloy	—	MP9015	70 (40 – 100)		
			MP9025	60 (30 – 90)		
			VP20RT	45 (30 – 60)		
			VP10RT	55 (40 – 70)		
			RT9010	55 (40 – 70)		
H	Hardened steel	≥50HRC	BC8110	90 (80 – 120)		

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1. VP20RT is the first recommended grade for materials other than hardened steel.
2. For VP10RT, VP20RT, MP9015, MP9025, MY5015, MY6125, wet cutting is recommended.
3. GL Chipbreaker is not recommended for face grooving.

GY GROOVING SERIES FOR EXTERNAL SWISS TYPE LATHES

RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED (FOR EXTERNAL GROOVING AND CUTTING OFF)

Material		Hardness	Grade	Vc
P	Mild steel	<160HB	VP20RT	155 (100 – 220)
			VP10RT	170 (110 – 230)
			NX2525	150 (90 – 210)
	Carbon steel Alloy steel	160 – 280HB	VP20RT	120 (80 – 180)
			VP10RT	140 (90 – 190)
			MY6125	230 (160 – 300)
			MY5015	180 (110 – 250)
			NX2525	120 (70 – 170)
			≥280HB	VP20RT
		VP10RT		110 (70 – 150)
		MY6125		185 (110 – 260)
		MY5015	150 (90 – 210)	
NX2525	95 (55 – 135)			
M	Stainless steel	≤270HB	VP20RT	100 (60 – 140)
			VP10RT	110 (70 – 150)
K	Gray cast iron	Tensile strength ≤300MPa	VP20RT	120 (80 – 180)
			VP10RT	140 (90 – 190)
			MY5015	120 (140 – 300)
			MY6125	260 (170 – 350)
	Ductile cast iron	Tensile strength ≤800MPa	VP20RT	100 (60 – 140)
			VP10RT	110 (70 – 150)
			MY5015	150 (90 – 210)
MY6125	185 (110 – 260)			
N	Aluminium alloy (A6061, 7075)	Content Si<5 %	RT9010	250 (200 – 500)
	Aluminium alloy (AC4B)	Content 5 %≤Si≤10 %	RT9010	250 (200 – 500)
	Aluminium alloy (ADC12, A390)	Content Si>10 %	RT9010	150 (100 – 200)
S	Heat resistant alloy Titanium alloy	—	MP9015	70 (40 – 100)
			MP9025	60 (30– 90)
			VP20RT	45 (30– 60)
			VP10RT	55 (40– 70)
			RT9010	55 (40– 70)
H	Hardened steel	≥50HRC	BC8110	100 (80 – 120)

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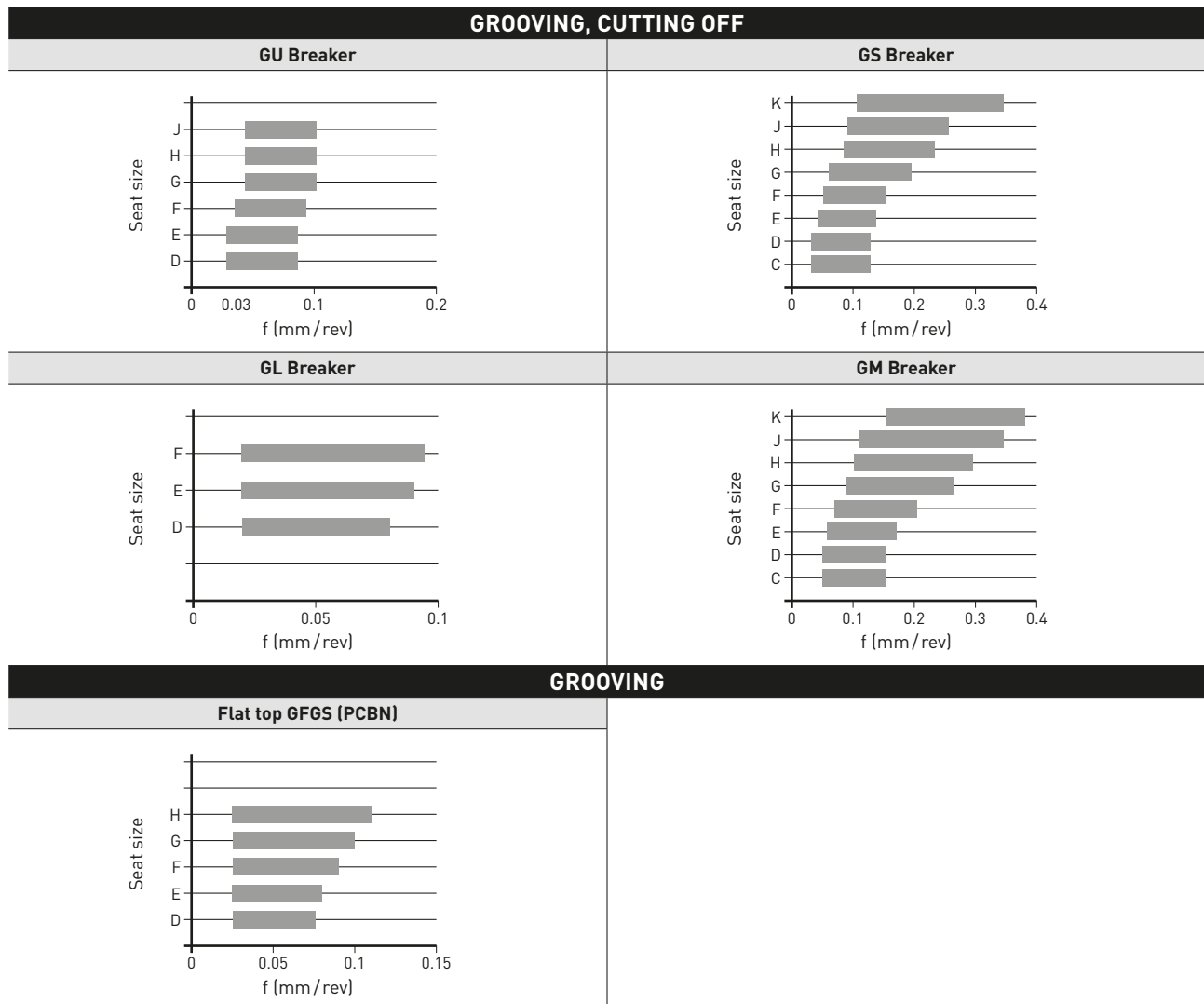
1/1

1. For VP10RT, VP20RT, MP9015, MP9025 and MY5015, wet cutting is recommended.

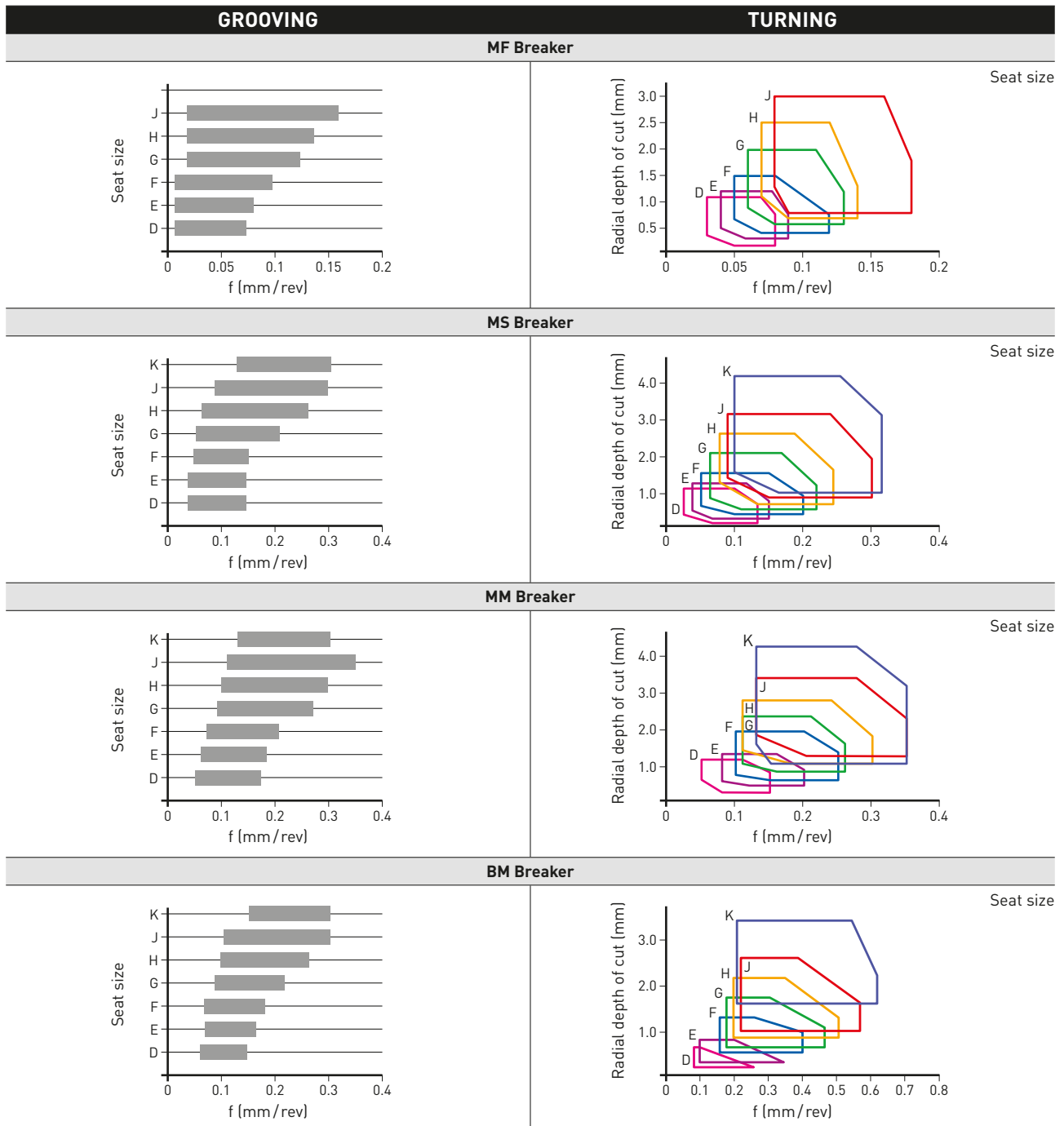
RECOMMENDED FEED RATE

RECOMMENDED CUTTING CONDITIONS (FOR EXTERNAL GROOVING)

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



RECOMMENDED FEED RATE AND DEPTH OF CUT



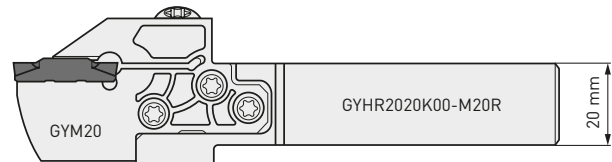
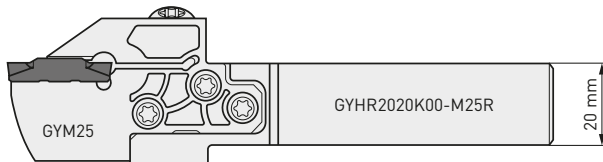
Seat size	C	D	E	F	G	H	J	K
Insert width (mm)	1.50	2.00	2.39	3.00	4.00	4.75	6.00	8.00
	—	2.24	2.50	3.18	4.24	5.00	6.31	—
	—	—	2.74	3.24	—	5.24	6.35	—

RECOMMENDED FEED RATE

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

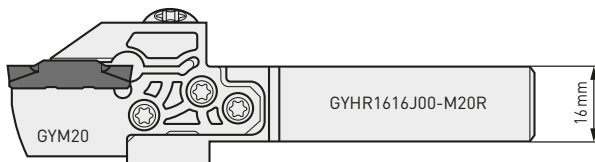
DECREASE THE FEED RATE BY 20 %

[20 mm x 20 mm Square holder]

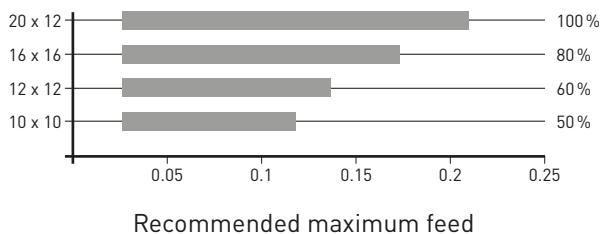


DECREASE THE FEED RATE BY 40 %

[16 mm x 16 mm Square holder]



IN THE CASE OF MONOBLOCK TYPE HOLDER FOR SWISS STYLE LATHES

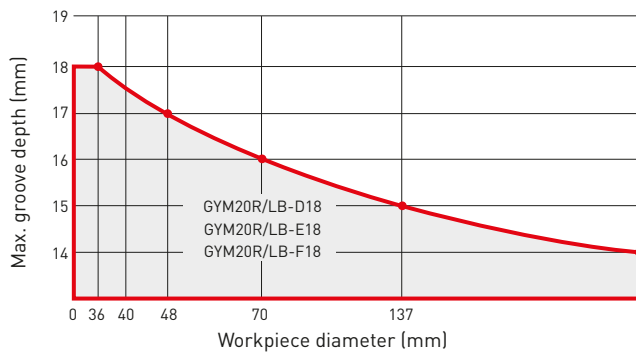


Please refer to the tables above on recommended cutting conditions for external grooving. Apply the percentage ratio shown on each shank size with the values in the table.

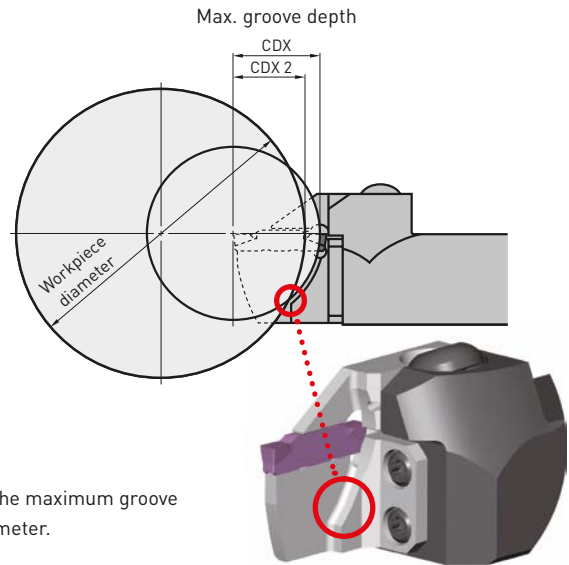
RECOMMENDED DEPTH OF CUT

LIMITATION OF THE MAXIMUM GROOVE DEPTH (FOR EXTERNAL GROOVING)

- When using the modular blade GYM○○○R/LA-○○○
- The maximum groove depth is not limited by the workpiece diameter.
- When using the modular blade GYM○○○R/LB-○○○
- The maximum groove depth is limited by the workpiece diameter.



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



GY GROOVING SERIES FOR EXTERNAL SWISS TYPE LATHES

RECOMMENDED CUTTING SPEED (M/MIN) (FOR EXTERNAL RECESSING)

Material	Hardness	Grade	Vc
P	Mild steel	VP20RT	130 (80 – 180)
		VP10RT	140 (90 – 190)
	Carbon steel Alloy steel	VP20RT	100 (60 – 140)
		VP10RT	110 (70 – 150)
		MY6125	180 (110 – 250)
		MY5015	150 (90 – 210)
		NX2525	95 (55 – 135)
		VP20RT	90 (50 – 110)
		VP10RT	90 (60 – 120)
	280 – 350HB	MY6125	145 (100 – 190)
		MY5015	120 (80 – 160)
		NX2525	75 (45 – 105)
M	Stainless steel	VP20RT	80 (50 – 110)
		VP10RT	90 (60 – 120)
K	Gray cast iron	VP20RT	100 (60 – 140)
		VP10RT	110 (70 – 150)
		MY5015	150 (90 – 210)
		MY6125	180 (110 – 250)
	Ductile cast iron	VP20RT	80 (50 – 110)
		VP10RT	30 (60 – 120)
		MY5015	120 (80 – 160)
S	Titanium alloy Heat resistant alloy	MY6125	145 (100 – 190)
		MP9015	70 (40 – 100)
		MP9025	60 (30 – 90)
		VP20RT	45 (30 – 60)
		VP10RT	55 (40 – 70)
		VP20RT	45 (30 – 60)
		VP10RT	55 (40 – 70)

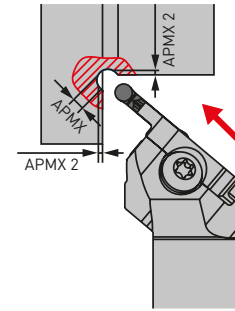
1/1

1. VP20RT is the first recommended grade for materials other than hardened steel.
2. For VP10RT, VP20RT, MP9015, MP9025, MY5015, MY6125, wet cutting is recommended.

RECOMMENDED FEED RATE AND DEPTH OF CUT

DISTANCE FROM THE WORKPIECE TO THE RECESS DEPTH

Grooving width CW	Recessing depth APMX	Distance workpiece to the recess depth APMX 2
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

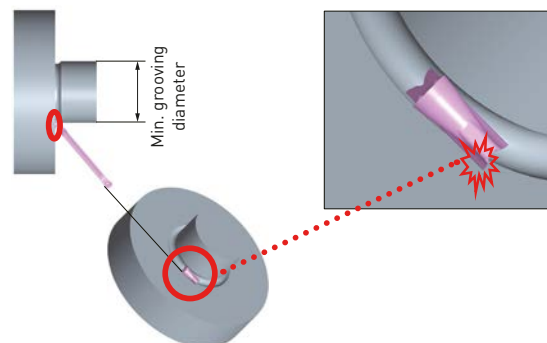
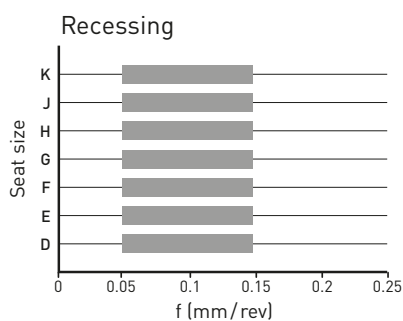


BM BREAKER

MINIMUM GROOVING DIAMETER

Ensure the tool is suitable for the diameter being machined. Refer to the Min. Grooving Diameter DMIN as shown in the table on page 48 to avoid a collision with the workpiece as shown below.

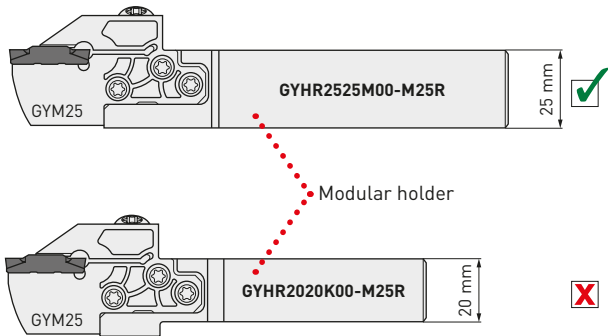
Recommended feed rate and depth of cut



TOOL SELECTION

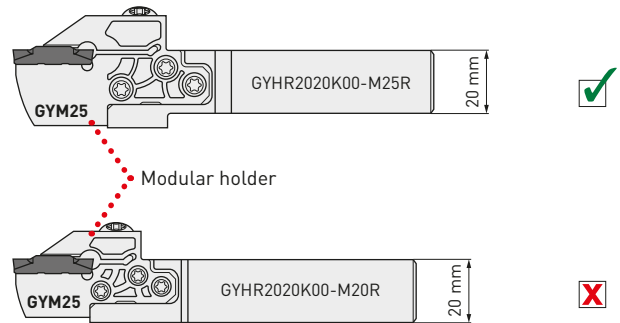
NOTES WHEN SELECTING THE TOOL BODY

MODULAR HOLDER



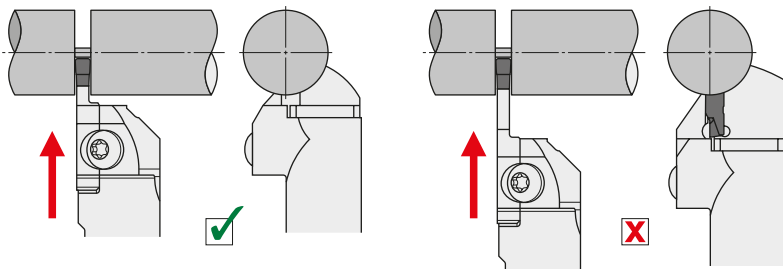
To ensure sufficient clamping rigidity, select a modular holder with the largest possible shank size.

MODULAR BLADE



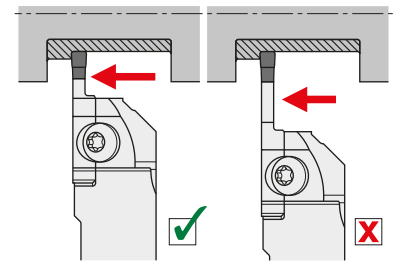
If there is no restriction for use, select the largest modular blade with the highest stability for the same shank size.

MODULAR BLADE



Select the shortest possible blade suitable for the application.

MODULAR BLADE

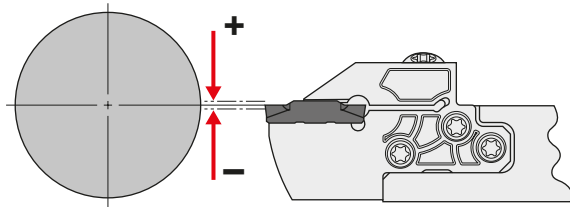


Select the shortest possible blade suitable for the application.

TOOL SELECTION

NOTES WHEN SETTING THE TOOL

SETTING OF CUTTING EDGE HEIGHT



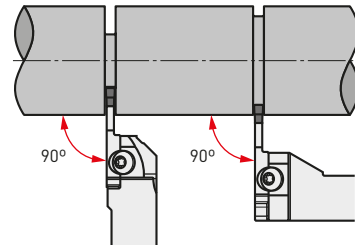
Grooving / Cross-feed machining

Set the cutting edge height to ± 0.1 mm parallel to the central axis.

Cutting off

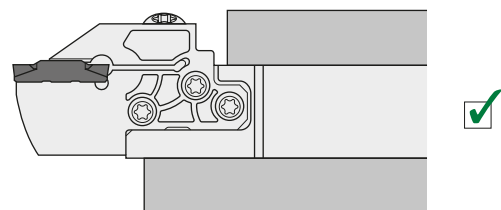
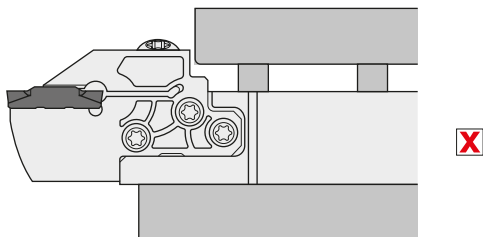
Set the cutting edge height to 0 – +0.2 mm parallel to the central axis.

TOOL BODY SETTING ANGLE



Set the insert perpendicular to the central axis.

OVERHANG

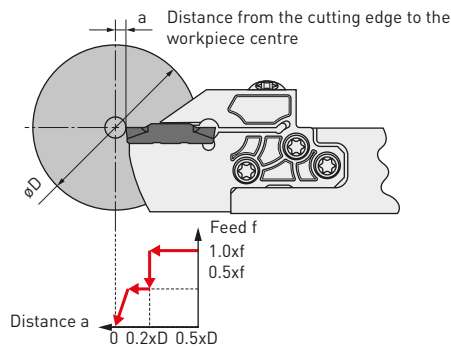


When setting the tool, ensure that the overhang is as short as possible and avoid contact of the tool post with the top clamp as shown in the figures above.

MACHINING RECOMMENDATIONS

NOTES FOR CUTTING OFF

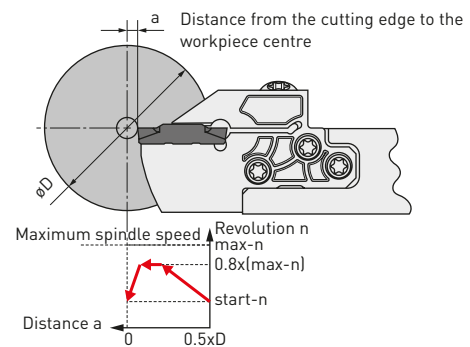
FEED



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.

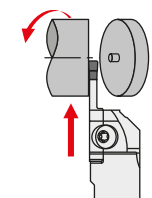
REVOLUTION



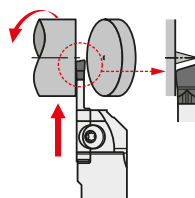
When using constant cutting speed during a cutting off cycle, it is recommended to limit the spindle speed to 80 % of maximum to ensure stability.

To prevent the workpiece from being expelled, lower the spindle speed before finishing the grooving operation.

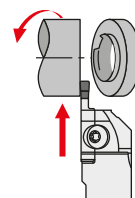
INSERT



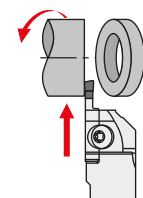
Neutral insert



Handed insert



Neutral insert



Handed 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.

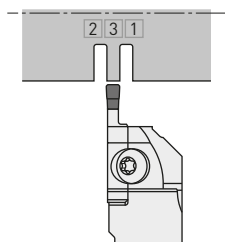
With a handed insert, machining tends to be less stable when compared to using a neutral insert.

Pay special attention to avoid fracturing of the cutting edge and decrease the feed when necessary.

MACHINING RECOMMENDATIONS

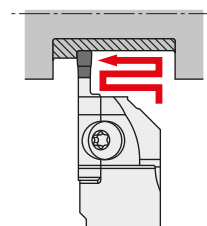
NOTES ON MULTI-FUNCTIONAL MACHINING (MS AND MM BREAKERS)

MACHINING NARROW GROOVES



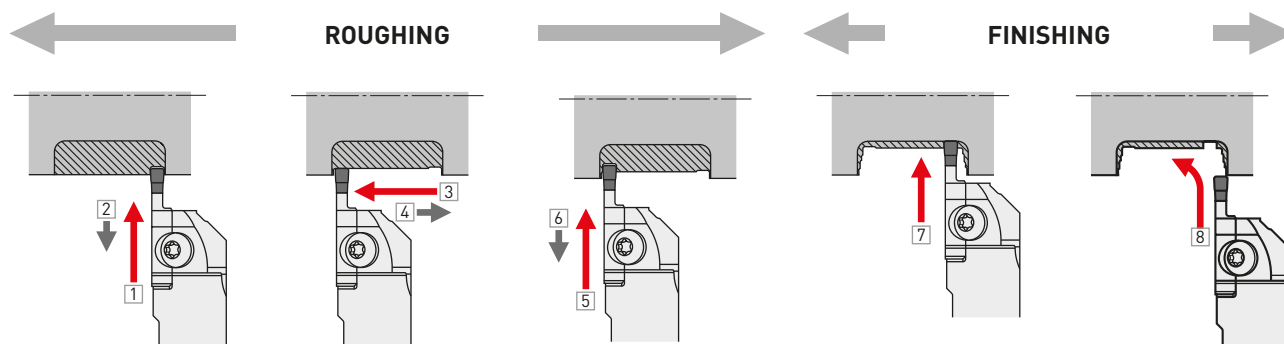
It is recommended to carry out plunging in several passes. Following the steps above makes it difficult for chips to elongate. This also improves the accuracy of workpiece wall surface.

MACHINING WIDE GROOVES



It is recommended that cross-feed machining is used.

MACHINING WIDE GROOVES



1 Carry out grooving.

2 Retract the tool approx 0.1 mm.

3 Carry out cross feed machining.

4 Retract the tool approx 0.1 mm.

5 Carry out grooving.

6 Retract the tool approx 0.1 mm.
* Repeat the steps z-n.

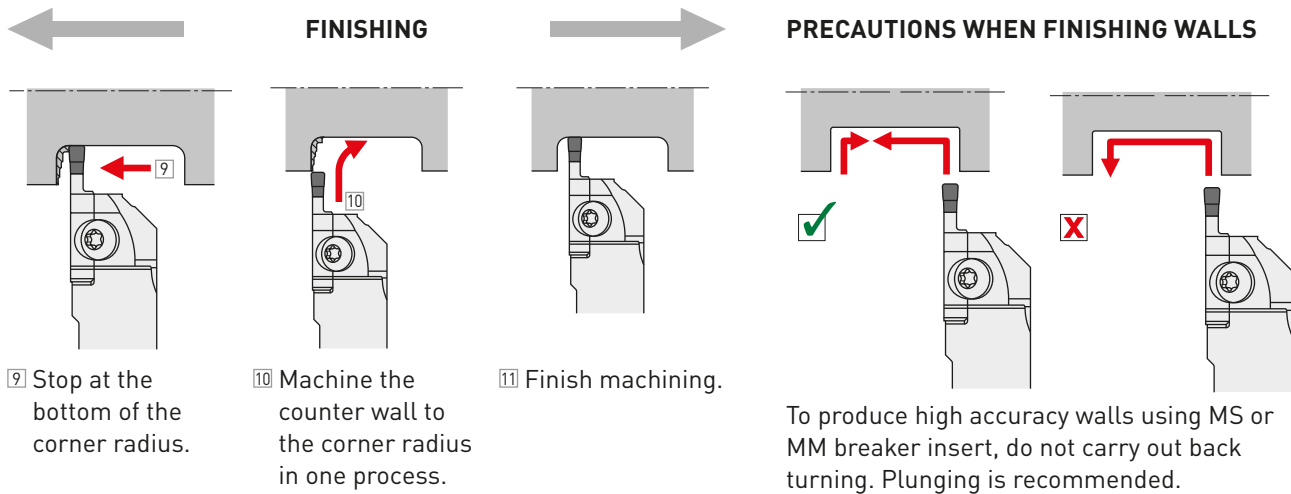
7 Carry out grooving to the end point of the corner radius.

8 Machining of the wall surface, corner radius and bottom face should be carried out in one process.

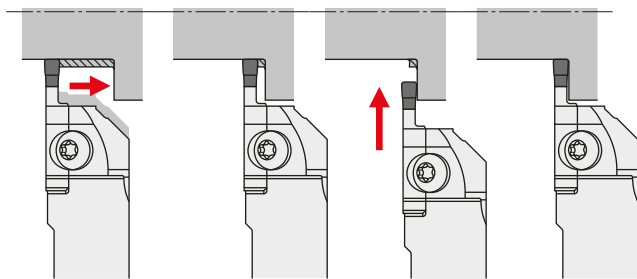
MACHINING RECOMMENDATIONS

NOTES ON MULTI-FUNCTIONAL MACHINING (MS AND MM BREAKERS)

MACHINING WIDE GROOVES

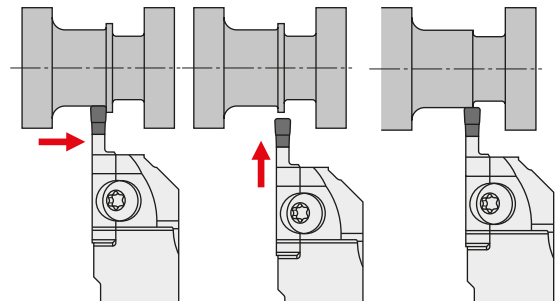


WALL MACHINING



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

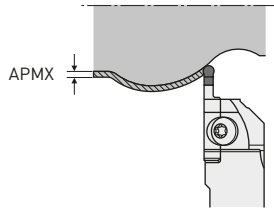


When a ring remains in a cross feed end process, finish cross feed machining 1 – 1.5 mm short of the end point, then remove the ring by plunging.

MACHINING RECOMMENDATIONS

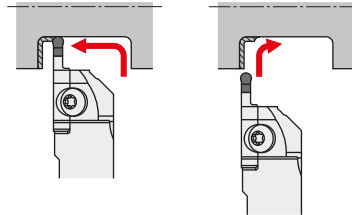
NOTES ON MULTI-FUNCTIONAL MACHINING (BM BREAKER)

COPYING



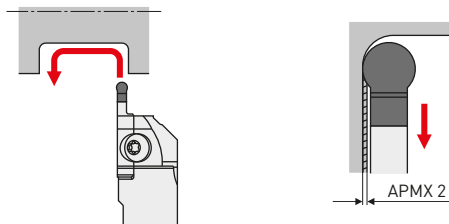
With the BM breaker insert, 3 dimensional copying is possible.
Set the depth of cut (APMX) to 40 % less than the insert width.

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 (APMX 2) when back turning, refer to the table on the right.

Insert	APMX 2
GY2M0200D100N-BM	0.05
GY2M0250E125N-BM	0.10
GY2M0300F150N-BM	0.15
GY2M0318F159N-BM	0.20
GY2M0400G200N-BM	0.24
GY2M0475H238N-BM	0.30
GY2M0500H250N-BM	0.40
GY2M0600J300N-BM	
GY2M0635J318N-BM	
GY2M0800K400N-BM	

GY GROOVING SERIES FOR EXTERNAL SWISS TYPE LATHES

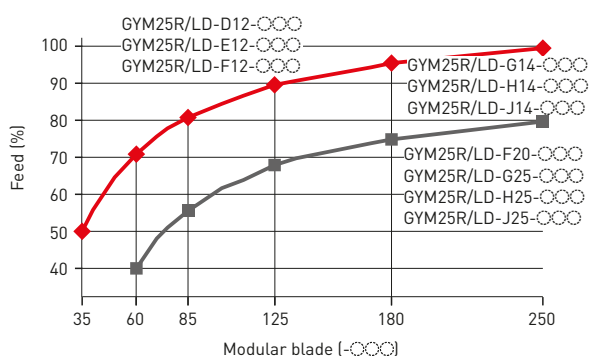
RECOMMENDED CUTTING SPEED (M / MIN) (FOR FACE GROOVING)

Material	Hardness	Grade	Vc
P	Mild steel	VP20RT	130 (80 – 180)
		VP10RT	140 (90 – 190)
		NX2525	120 (70 – 170)
	Carbon steel Alloy steel	VP20RT	100 (60 – 140)
		VP10RT	110 (70 – 150)
		MY6125	180 (110 – 250)
		MY5015	150 (90 – 210)
		NX2525	95 (55 – 135)
		VP20RT	80 (50 – 110)
		VP10RT	90 (60 – 120)
	$\geq 280\text{HB}$	MY6125	145 (100 – 190)
		MY5015	120 (80 – 160)
		NX2525	75 (45 – 105)
M	Stainless steel	VP20RT	80 (50 – 110)
		VP10RT	90 (60 – 120)
K	Gray cast iron	VP20RT	100 (60 – 140)
		VP10RT	110 (70 – 150)
		MY5015	150 (90 – 210)
	Ductile cast iron	MY6125	180 (110 – 250)
		VP20RT	80 (50 – 110)
		VP10RT	90 (60 – 120)
S	Heat resistant alloy Titanium alloy	MY5015	120 (80 – 160)
		MY6125	145 (100 – 190)
		MP9015	70 (40 – 100)
		MP9025	60 (30 – 90)
		VP20RT	45 (30 – 60)
		VP10RT	55 (40 – 70)
H	Hardened steel	RT9010	55 (40 – 70)
		BC8110	80 (60 – 100)

1/1

1. VP20RT is the first recommended grade for materials other than hardened steel.
2. For VP10RT, VP20RT, MP9015, MP9025, MY5015, MY6125, wet cutting is recommended.

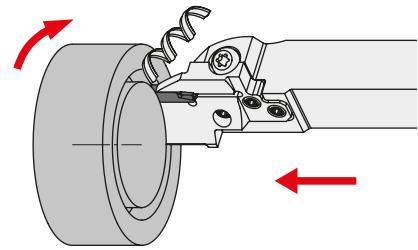
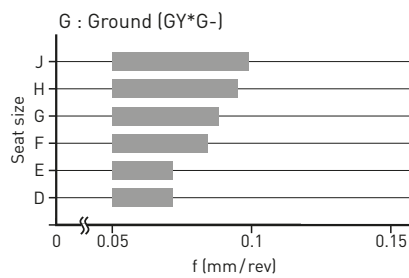
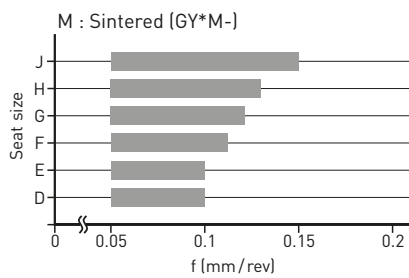
RELATIONSHIP BETWEEN THE MODULAR BLADE AND FEED PER ROTATION (FOR FACE GROOVING)



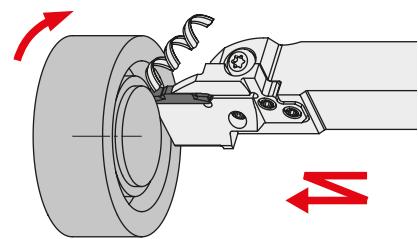
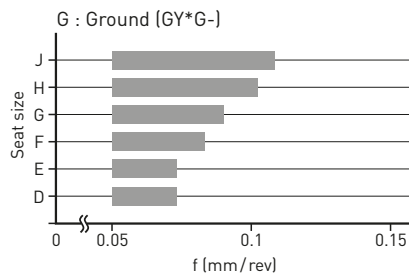
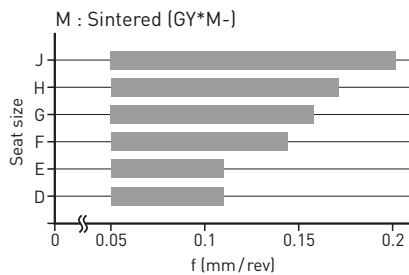
1. Adjust the feed per rotation in the cutting conditions to the percentage shown in the table above.

RECOMMENDED CUTTING CONDITIONS (FOR FACE GROOVING)

FACE GROOVING

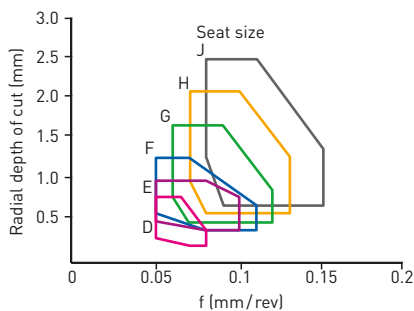


FACE PLUNGING

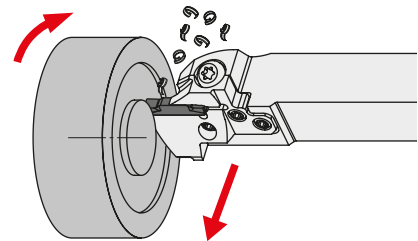


* After the 1st plunge, the width of cut should be set narrower than insert width CW.

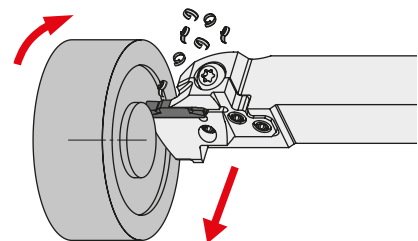
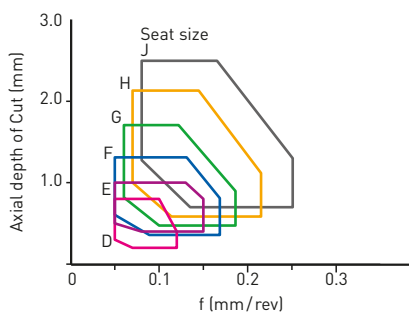
TRAVERSE MACHINING (MF BREAKER)



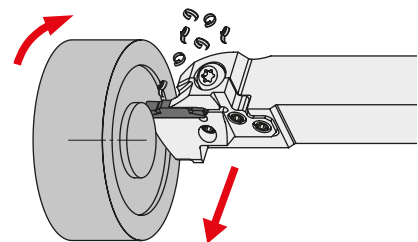
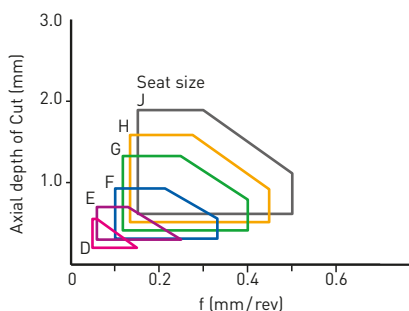
Seat size		Seat size	
Insert width (mm)		Insert width (mm)	
D	2.00	G	4.00
	2.24		4.24
E	2.39	H	4.75
	2.50		5.00
	2.74		5.24
F	3.00	J	6.00
	3.18		6.31
	3.24		6.35



TRAVERSE MACHINING (MM/MS BREAKER)



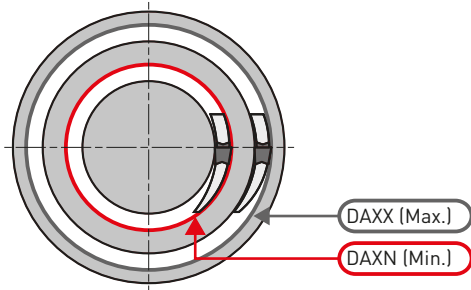
TRAVERSE MACHINING (BM BREAKER)



TOOL SELECTION

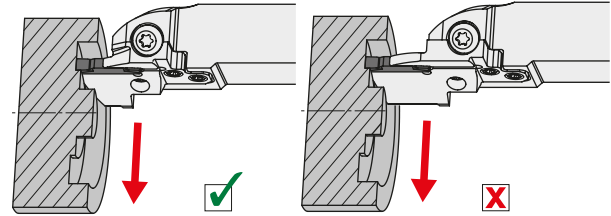
NOTES WHEN SELECTING THE TOOL BODY

MODULAR BLADE (1)



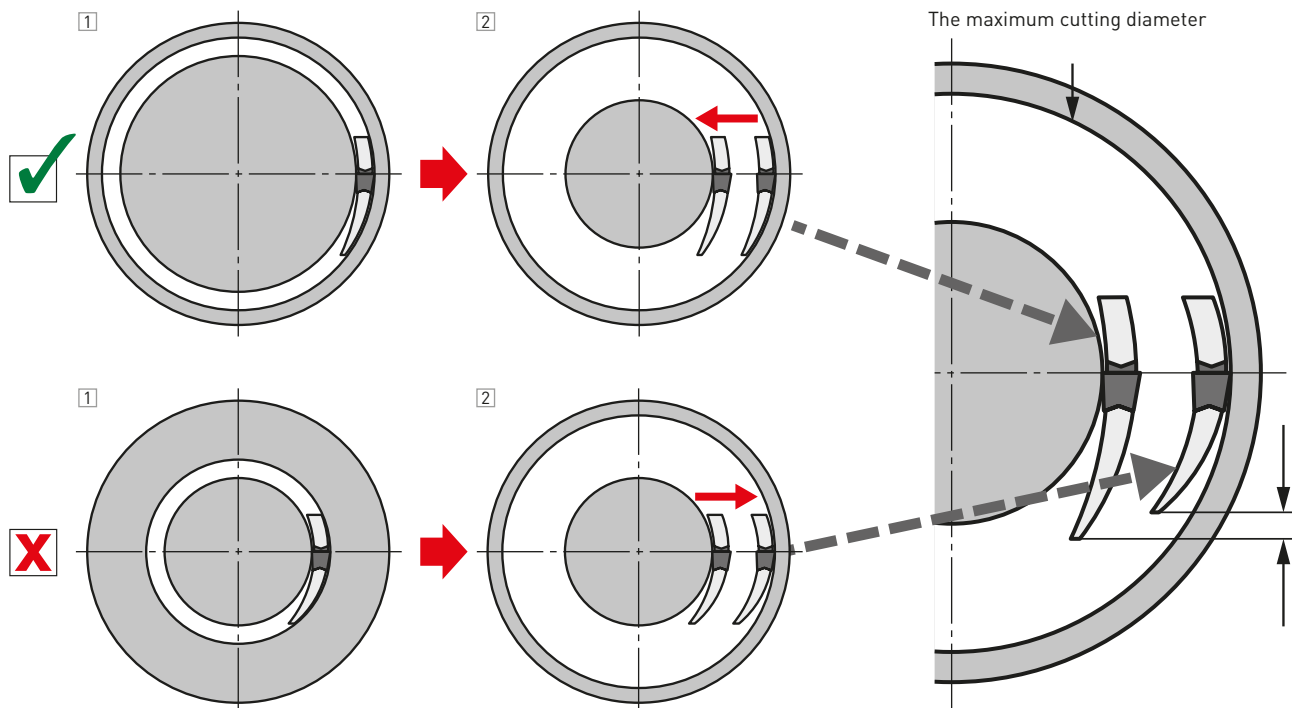
Select a modular blade for face grooving, so that the cutting diameter at the first pass is within the range of DAXN minimum and DAXX maximum that are described in the table of dimensions.

MODULAR BLADE (2)



Select the shortest possible blade suitable for the application.

MODULAR BLADE (3)



Select the largest size blade within the maximum cutting diameter of the workpiece.
Machine from the outer diameter towards the centre.



Increased machining stability and rigidity is possible if a modular blade with the largest possible back metal is used.

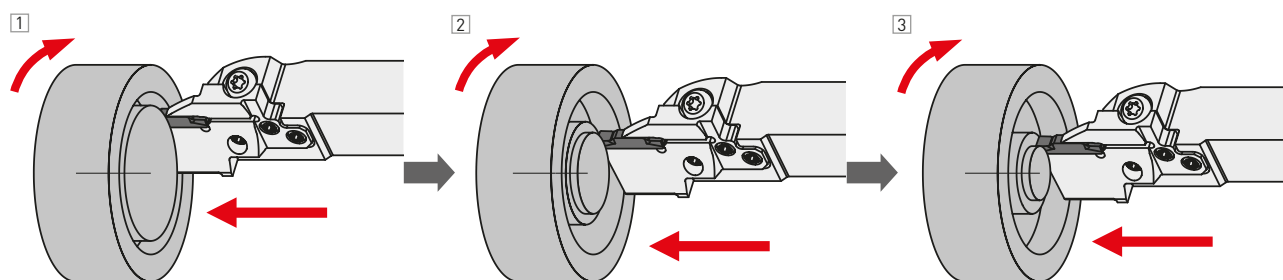
TOOL SELECTION

NOTES WHEN SELECTING THE TOOL BODY

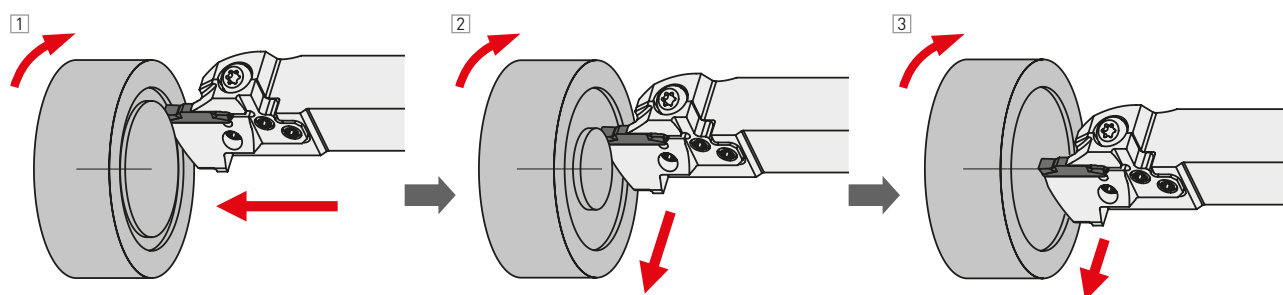
MODULAR BLADE (3)

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

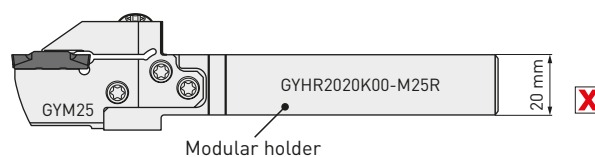
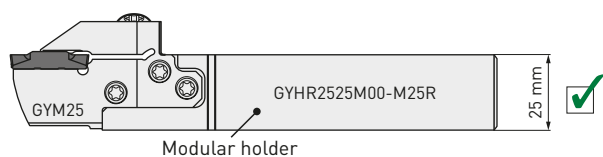
When plunging in several passes.



When combining plunging and infeed machining.



MODULAR HOLDER

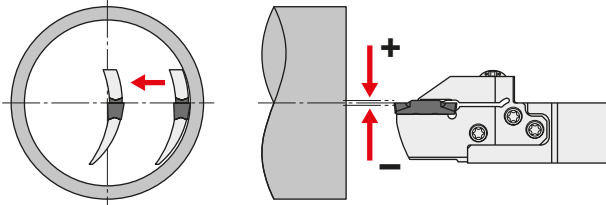


1. To ensure sufficient clamping rigidity, select a modular holder with the largest possible shank size.

TOOL SELECTION

NOTES WHEN SETTING THE TOOL

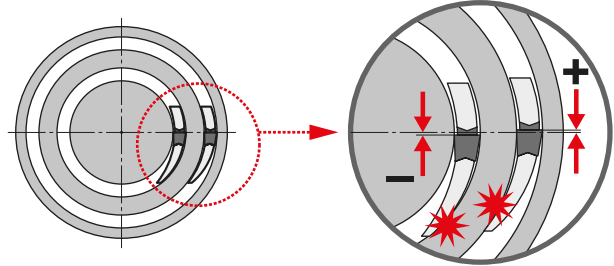
SETTING THE CUTTING EDGE HEIGHT



Set the cutting edge height to ± 0.1 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.

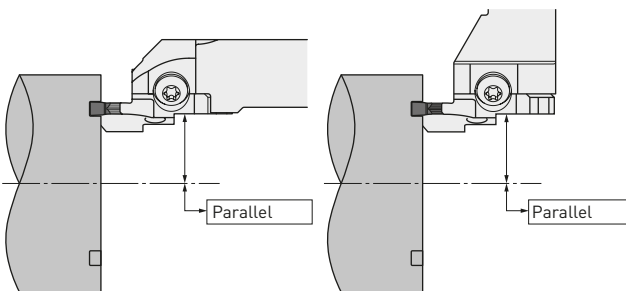
WHEN INTERFERING THE WALL OF GROOVE AND THE MODULAR BLADE



If interference occurs even when the correct blade is used, the cutting edge height could be incorrect.

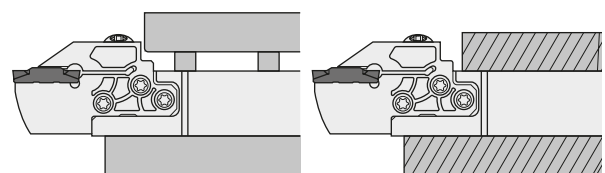
When interference occurs on the inner side of the blade, the cutting edge height is set too high. When interference occurs on the outer side of the blade, the cutting edge height is set too low.

SETTING THE TOOL



Set the insert parallel to the central axis.

TOOL OVERHANG



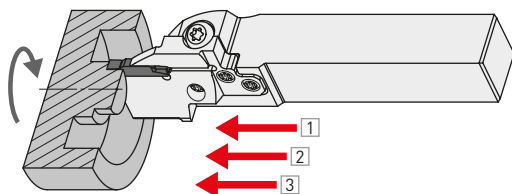
When setting the tool, ensure that the overhang is as short as possible and avoid contact of the tool post with the top clamp as shown in the figures above.

MACHINING RECOMMENDATIONS

NOTES WHEN FACE GROOVING (1)

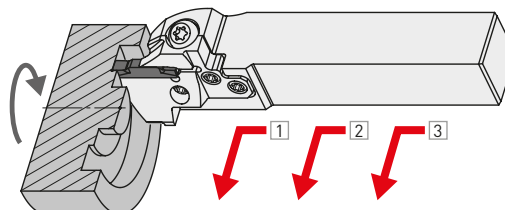
Always machine from the outer diameter towards the centre.

MACHINING NARROW GROOVES



Plunging in several passes is recommended.

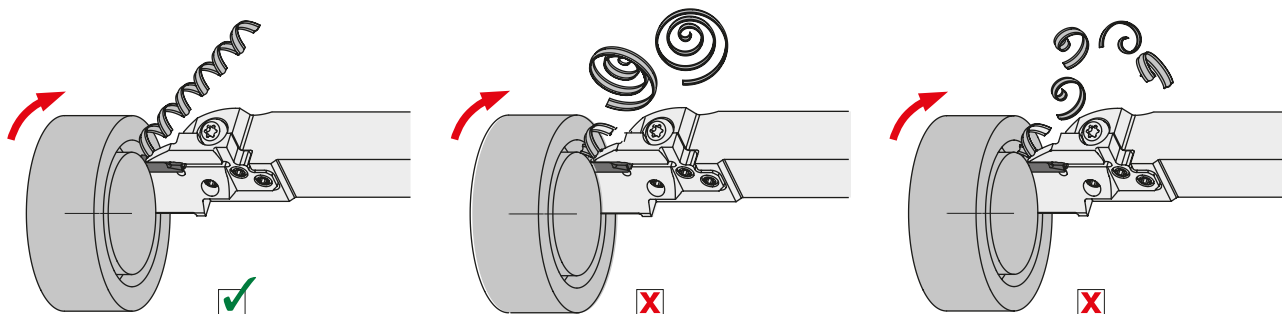
MACHINING WIDE GROOVES



Cross feed machining is recommended.

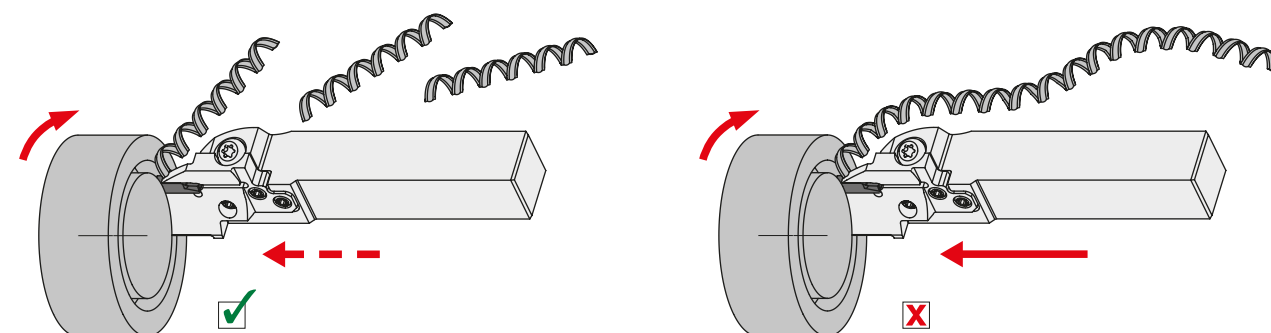
NOTES WHEN FACE GROOVING (2)

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)

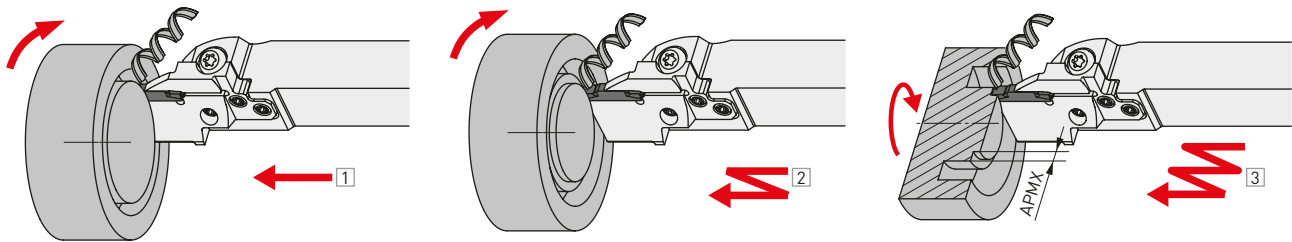


When chips become too long, use peck feed to break them into a suitable length.

MACHINING RECOMMENDATIONS

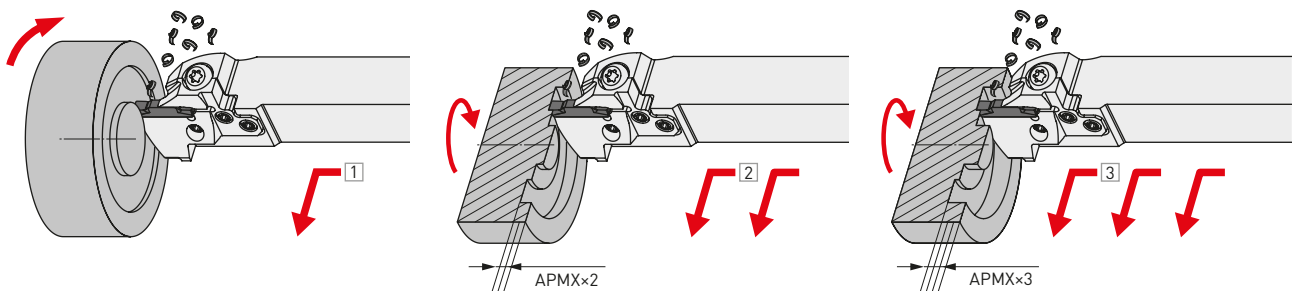
NOTES WHEN FACE GROOVING (1)

NOTES WHEN WIDE FACE GROOVING BY PLUNGING IN SEVERAL PASSES.



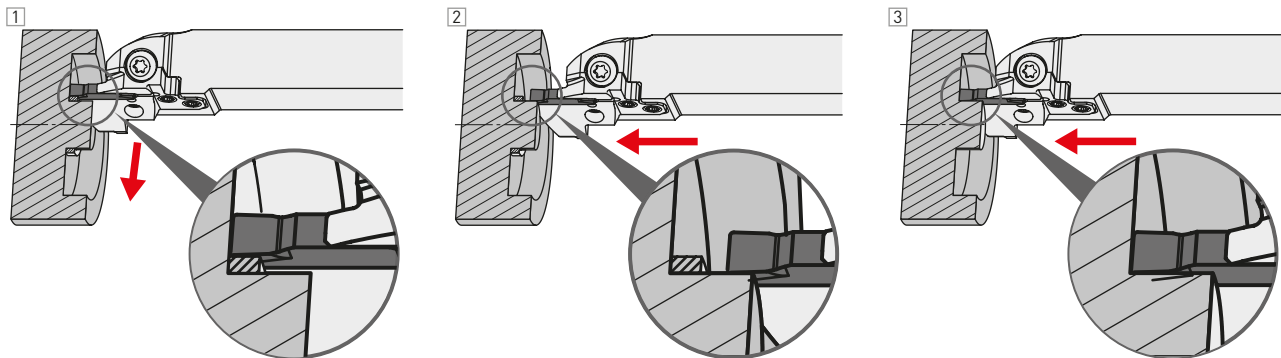
When machining a face groove in several passes, machine from the outer diameter towards the centre so that space for discharging chips is created to prevent insert damage caused by chip jamming. Plunging width of cut is recommended to be set at 60 – 80 % of the insert width. This enhances the effect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

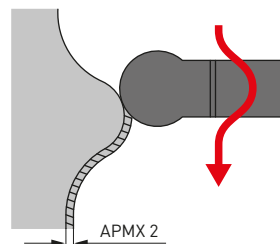
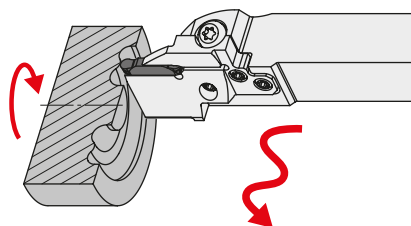


When infeed machining at the bottom of a deep groove, chips may interfere on the cutting edge near the centre wall. In such cases, stop infeed machining just before the centre wall (at a point less than the insert width) then remove the remaining material by plunging.

MACHINING RECOMMENDATIONS

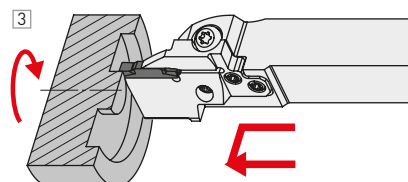
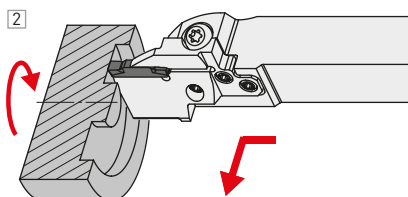
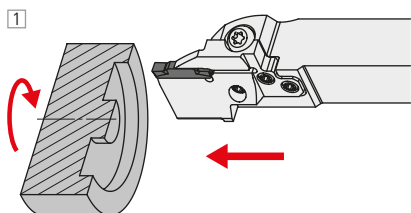
NOTES WHEN FACE GROOVING (1)

NOTES WHEN FACE COPYING (BM BREAKER)



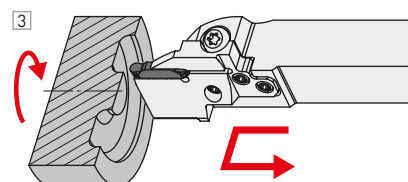
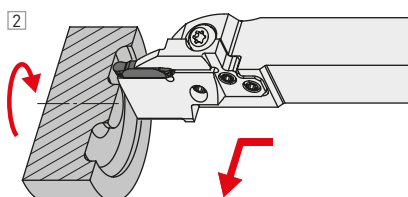
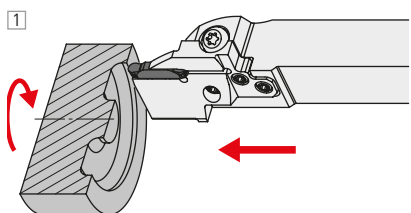
With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (APMX 2) to 30 % less than the insert width.

FINISHING (1)

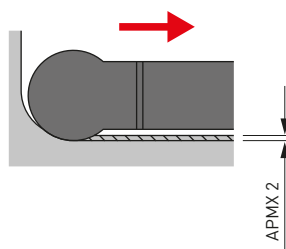


When finish cutting, machine continuously from the outer wall to the bottom of the groove, then finally plunge cut the centre wall.

FINISHING (2) (BM BREAKER)



Carry out finishing in one process. For the depth of cut (APMX 2) when back turning, refer to the table on the right.



Insert	APMX 2
GY2M0200D100N-BM	0.10
GY2M0250E125N-BM	
GY2M0300F150N-BM	
GY2M0318F159N-BM	0.15
GY2M0400G200N-BM	
GY2M0475H238N-BM	0.20
GY2M0500H250N-BM	
GY2M0600J300N-BM	0.25
GY2M0635J318N-BM	

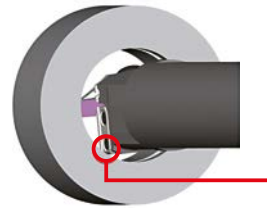
LIMITATION OF THE MAXIMUM GROOVE DEPTH (FOR INTERNAL GROOVING)

When using the monoblock type

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

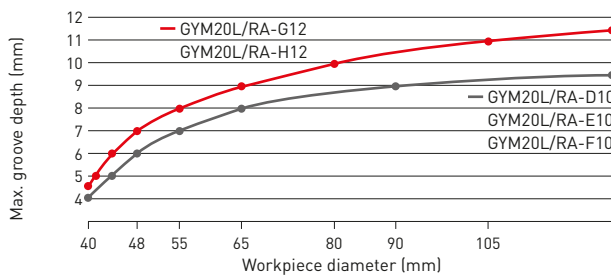
When using the modular blade type

The maximum groove depth is limited by the cutting diameter.

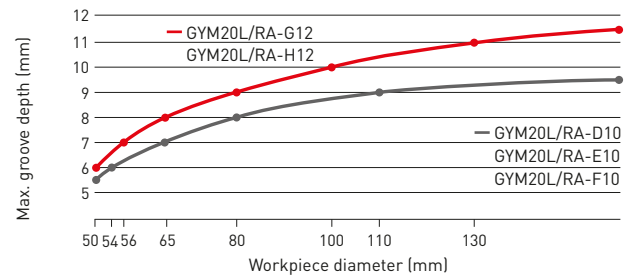


Due to interference of this part, the maximum groove depth is limited by the cutting diameter.

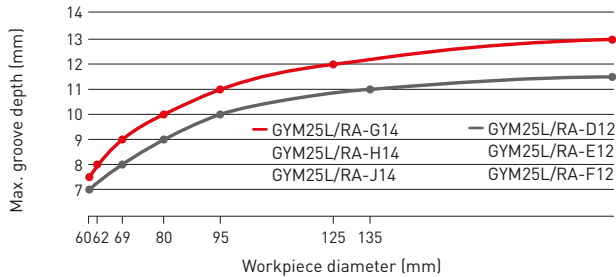
Shank diameter = 32 mm (GYM20 Blade)



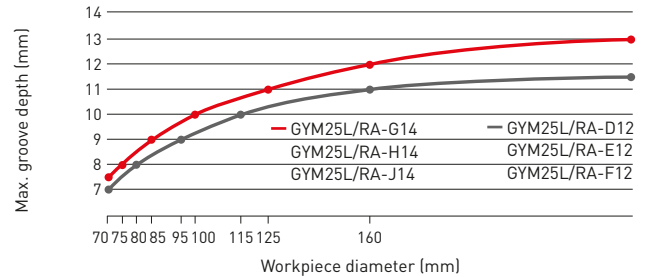
Shank diameter = 40 mm (GYM20 Blade)



Shank diameter = 40 mm (GYM25 Blade)



Shank diameter = 50 mm (GYM25 Blade)



GY GROOVING SERIES FOR EXTERNAL SWISS TYPE LATHES

RECOMMENDED CUTTING SPEED (M / MIN) (FOR INTERNAL GROOVING)

Material	Hardness	Grade	Vc	
P	Mild steel	VP20RT	130 (80 – 180)	
		VP10RT	140 (90 – 190)	
		NX2525	120 (70 – 170)	
	Carbon steel Alloy steel	160 – 280HB	VP20RT	100 (60 – 140)
			VP10RT	110 (70 – 150)
			MY5015	150 (90 – 210)
			MY6125	180 (110 – 250)
			NX2525	95 (55 – 135)
			VP20RT	80 (50 – 110)
		≥280HB	VP10RT	90 (60 – 120)
			MY6125	145 (100 – 190)
			MY5015	120 (80 – 160)
	NX2525	75 (45 – 105)		
M	Stainless steel	VP20RT	80 (50 – 110)	
		VP10RT	90 (60 – 120)	
K	Gray cast iron	VP20RT	100 (60 – 140)	
		VP10RT	110 (70 – 150)	
		MY5015	150 (90 – 210)	
		MY6125	180 (110 – 250)	
	Ductile cast iron	VP20RT	80 (50 – 110)	
		VP10RT	90 (60 – 120)	
		MY5015	120 (80 – 160)	
		MY6125	145 (100 – 190)	
S	Heat resistant alloy Titanium alloy	MP9015	70 (40 – 100)	
		MP9025	60 (30 – 90)	
		VP20RT	45 (30 – 60)	
		VP10RT	55 (40 – 70)	
		RT9010	55 (40 – 70)	
H	Hardened steel	≥50HRC	BC8110	80 (60 – 100)

1/1

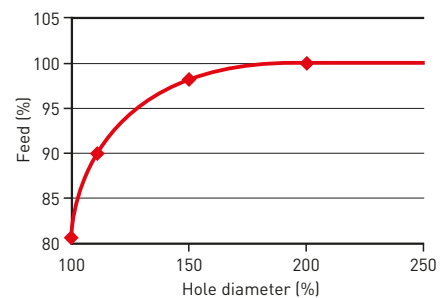
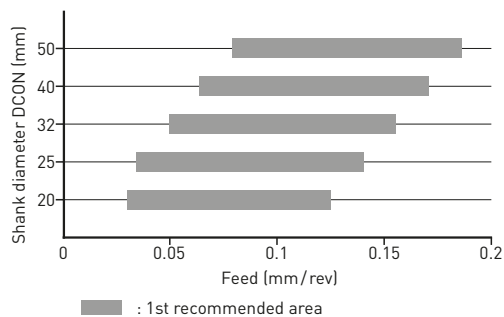
1/1

1. VP20RT is the first recommended grade for materials other than hardened steel.
2. For VP10RT, VP20RT, MP9015, MP9025, MY5015, MY6125, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS

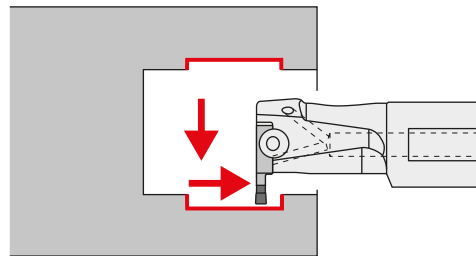
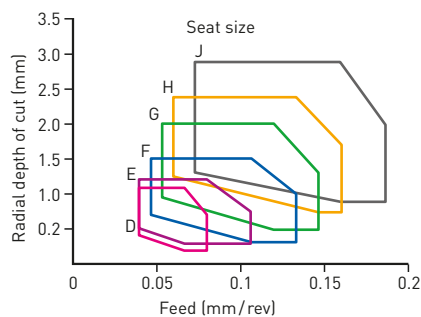
FOR INTERNAL GROOVING

Grooving



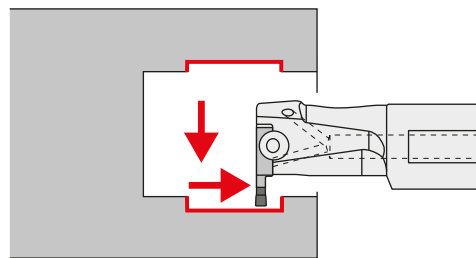
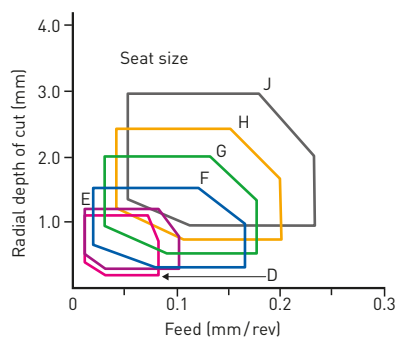
The cutting diameter 100 % represents the minimum cutting diameter (DMIN).
The graph on the left shows the cutting conditions when setting the feed to 100 %.

Traverse machining (MF Breaker)



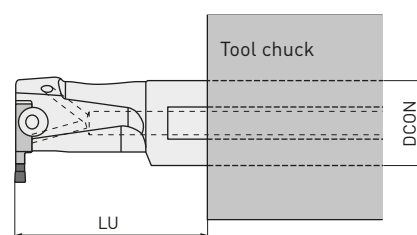
When traverse machining a blind hole, it is recommended to carry out back turning considering chip disposal.

Traverse machining (MM/MS Breaker)



When traverse machining a blind hole, it is recommended to carry out back turning considering chip disposal.
The above cutting conditions are for when using the tool overhang (LU) 1.6 – 2.0 times larger than the shank diameter (DCON). (L/D=1.6 – 2.0).
When using L/D larger than 2.0, reduce the cutting conditions.

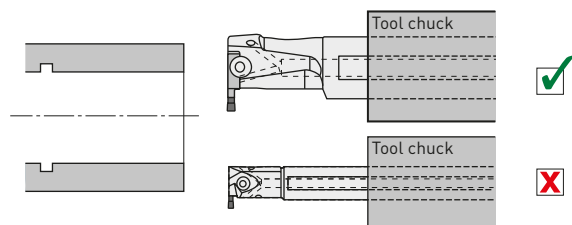
Seat size	Insert width (mm)
D	2.00 / 2.24
E	2.39 / 2.50 / 2.74
F	3.00 / 3.18 / 3.24
G	4.00 / 4.24
H	4.75 / 5.00 / 5.24
J	6.00 / 6.31 / 6.35



TOOL SELECTION

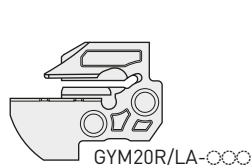
NOTES WHEN SELECTING THE TOOL BODY

HOLDER

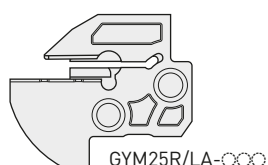


When the overhang is the same, select a holder with the largest possible shank size to ensure sufficient clamping rigidity.

MODULAR BLADE (1)



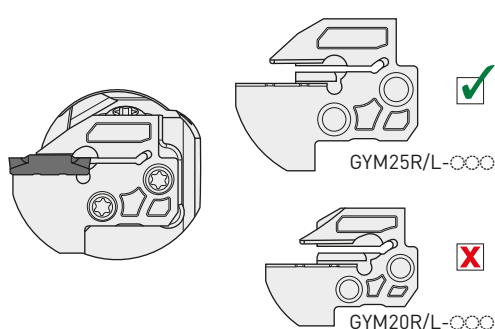
GYM20R/LA-D10
GYM20R/LA-E10
GYM20R/LA-F10
GYM20R/LA-G12
GYM20R/LA-H12



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

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

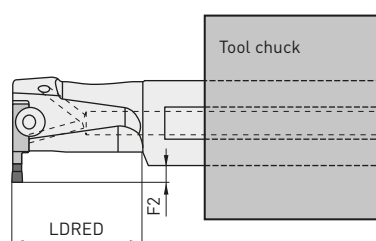
MODULAR BLADE (2)



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

NOTES WHEN SETTING THE TOOL

OVERHANG



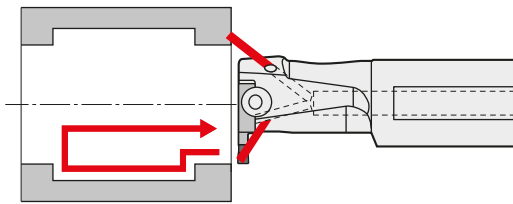
The maximum groove depth is limited to the dimension LDRED. When machining with longer overhangs, refer to the dimension F2 of the tool used.

MACHINING RECOMMENDATIONS

NOTES ON MULTI-FUNCTION MACHINING (MS AND MM BREAKERS)

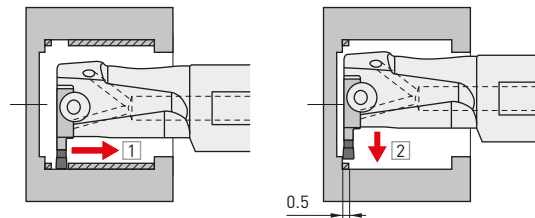
For internal grooving, the machining methods for external grooving (39) can be used, but please note the following precautions.

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 x is 0.5 mm.

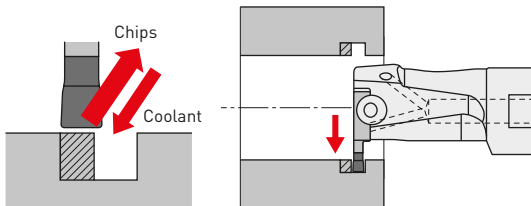
MACHINING WIDE GROOVES



GROOVING

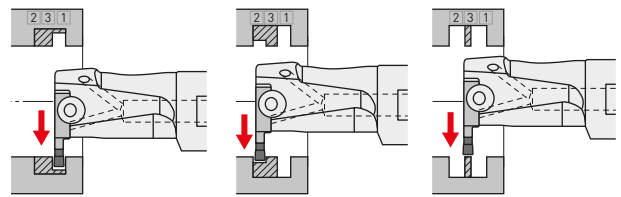


When the cutting edge width is $x \geq$ groove width



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.

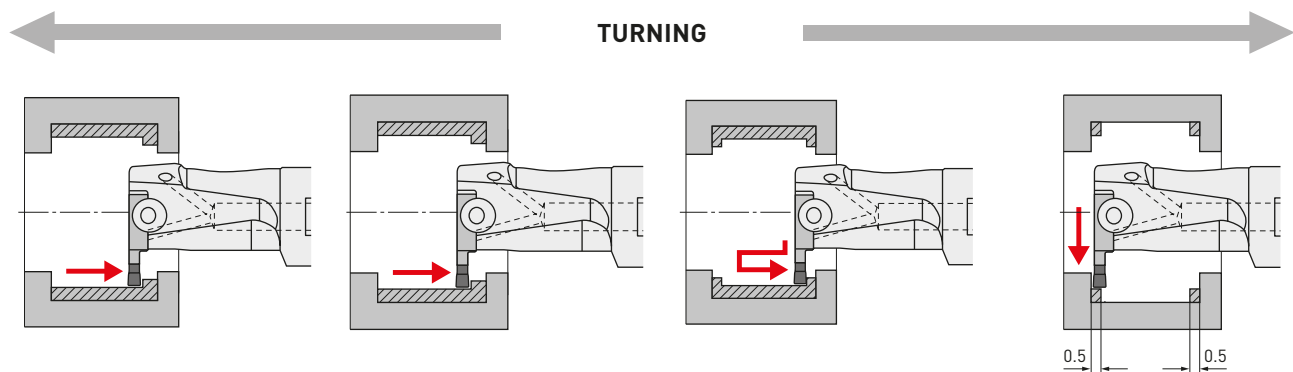
When the cutting edge width is $x <$ groove width



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

MACHINING RECOMMENDATIONS

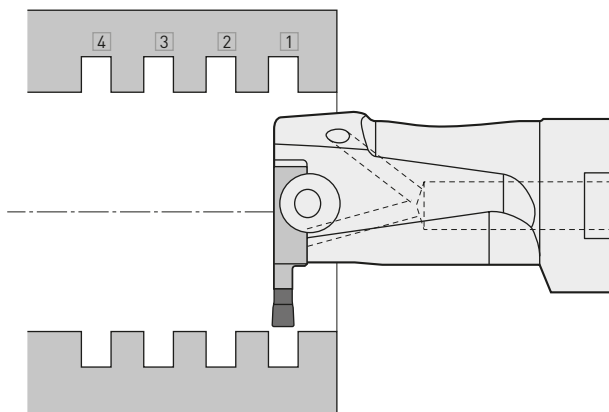
NOTES ON MULTI-FUNCTION MACHINING (MS AND MM BREAKERS)



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.

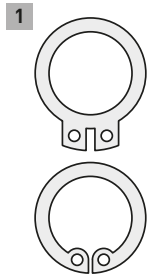
MACHINING INSTRUCTION



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

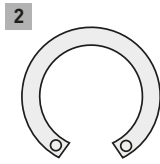
REFERENCE MATERIAL

CIRCLIP STANDARDS



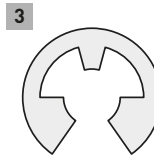
C type circlip

**ANSI B27.7/27.8 (US) /
BS 3673 (UK) / DIN 471/
472 (DE) / NF E 22 163 (FR) /
UNI 7435/7438 (IT)**



C type retaining ring

JIS B 2804 (JP)



E type circlip

N1* AMERICAN**

Fig.	For shaft		For hole	
	Width	Tolerance	Width	Tolerance
	0.5		9	
	0.7		1.1	
	0.8		1.3	
	0.9		1.6	+0.14 0
	1.1	+0.14 0	1.85	
	1.3		2.15	
1	1.6* ³		2.65	
2	1.85* ³		3.15	
	2.15* ¹		4.15	+0.18 0
	2.65* ¹		5.15	
	3.15* ¹		6.2	+0.22 0
	4.15* ¹	+0.18 0		
	5.15* ¹			
	6.2* ¹	+0.22 0		
	0.32	+0.05 0		
	0.5			
3	0.7	+0.10 0		
	1.0			
	1.2	+0.14 0		
	1.4			

Fig.	For shaft		For hole	
	Width	Tolerance	Width	Tolerance
	1.15			
	1.35			
	1.75* ³	+0.14 0		
	1.95* ²			
	2.2* ¹			
	2.7* ¹			
1	3.2* ¹	+0.18 0		
2	4.2* ¹			
	0.3			
	0.4	+0.05 0		
	0.5			
3	0.7	+0.10 0		
	0.9			
	1.15			
	1.75* ³	+0.14 0		
	2.2* ¹			

Fig.	For shaft		For hole	
	Width	Tolerance	Width	Tolerance
	0.305	+0.051 0	0.457	+0.051 0
	0.457		0.737	
	0.737	+0.076 0	0.991	+0.076 0
	0.991		1.168	
	1.168	+0.102 0	1.422	+0.102 0
	1.422		1.727* ³	
1	1.727* ³		2.184* ¹	
2	2.184* ¹	+0.127 0	2.616* ³	+0.102 0
	2.616* ³		3.048* ³	
	3.048* ³	+0.152 0		
	3.531* ³			
	0.305			
	0.457	+0.151 0		
	0.584			
3	0.737			
	0.991	+0.076 0		
	1.168			
	1.422	+0.102 0		
	1.727* ³			

*¹ G-class insert with MF breaker is available for single-step machining.

*² Conventional GY series insert is available for single-step machining.

*³ Machined in multiple steps or by cross feed machining.

REFERENCE MATERIAL

O-RING STANDARDS											
DIN 3770/3771 (De)						JIS B 2401 (JP) ISO 3601					
General		For oil pressure		For air pressure		General		For oil pressure		For air pressure	
Width	Tolerance	Width	Tolerance	Width	Tolerance	Width	Tolerance	Width	Tolerance	Width	Tolerance
STATIC USE						STATIC USE					
		1.9* ³	+0.1 0								
		2.3* ³									
		2.9* ²	+0.15 0								
		3.6* ³	+0.2 0								
		4.5* ³									
DYNAMIC USE						DYNAMIC USE					
		5.5* ³	+0.3 0			2.5		2.4		2.2	
		7.0* ³				3.2		3.6		3.4	
		8.6* ³	+0.4 0			4.7	+0.14 0	4.8	+0.25 0	4.6	+0.25 0
		10.7* ³	+0.5 0			7.5		7.1		6.9	
						11.1		9.5		9.3	

O-RING STANDARDS											
SMS 1586/1588 (Se) / BS 1806/4518 (UK)						SAE AS-568 (US)					
General		For oil pressure		For air pressure		General		For oil pressure		For air pressure	
Width	Tolerance	Width	Tolerance	Width	Tolerance	Width	Tolerance	Width	Tolerance	Width	Tolerance
STATIC USE						STATIC USE					
3.2	+0.2 0	2.3		2.3		2.54					
4.0		3.1		3.1		3.18					
		3.7	+0.2 0	3.7	+0.2 0	4.32	+0.13 0				
		6.4		6.4		6.1					
		9.0		9.0		8.0					
DYNAMIC USE						DYNAMIC USE					
7.5	+0.2 0					2.39					
11.0						3.58					
						4.78	+0.25 0				
						7.14					
						9.58					

*¹ G-class insert with MF breaker is available for single-step machining.

*² Conventional GY series insert is available for single-step machining.

*³ Machined in multiple steps or by cross feed machining.

SYMBOLS

 Recommended cutting conditions	MACHINING TYPE
NEW Completely new products or expansions released in the current Spring or Autumn product launch and are not included in the latest version of the General Catalogue.	 Roughing
NEW Products or expansions that have already been introduced in one of the previous Spring or Autumn product launches but are not included in the latest General Catalogue.	 Medium cutting
APPLICATION	 Light cutting
 Face milling	 Pre-finishing
 Chamfer milling	 Finishing
 Shoulder milling with R	 Fine-finishing
 Face milling close to a wall	TOOL MATERIAL
 Shoulder milling	 Ultra micro grain carbide Ultra micro grain carbide substrate material.
 Side milling	 Cubic boron nitride Mitsubishi Materials' original CBN material.
 Slot milling	 Ceramic For high speed efficient machining of super alloys due to the excellent high temperature strength property.
 Ramping	 High hardness powder metallurgy HSS High hardness powder metallurgy HSS substrate material.
 Pocket milling	 High grade high alloy HSS High grade high alloy HSS substrate material.
 Slot milling with R	 Cobalt high speed steel Cobalt high speed steel substrate material.
 Copy milling	 High speed steel High speed steel substrate material.
 T-Slot milling	

SYMBOLS

COATING



SMART MIRACLE coating

New smooth and dense coating technology for high efficiency milling of difficult to cut materials.



CRN coating

Newly developed CrN coating for Copper Electrodes machining.



Violet coating

Increased tool life of 2-3 times more than TiN coated products.



DP coating

New generation coating suitable for a wide range of materials.



MIRACLE coating

The original Miracle (Al,Ti)N coating. Also suitable for dry cutting.



[Al, Ti]N coating

[Al,Ti]N highly versatile application range.



[Al,Ti,Cr]N multi-layer coating

For carbon, alloy and hardened steels.



IMPACT MIRACLE coating

Single phase nano crystal coating technology has higher film hardness and heat resistance.



MIRACLE coating

The original MIRACLE (Al,Ti)N coating. Also suitable for dry cutting.



VFR coating

The [AlCrSi]N/[AlTiSi]N PVD multilayer coating is ideal for machining of extremely hard materials up to 70 HRC.



DLC coating

Hardness similar to CVD diamond coating achieved with high adhesion strength.



Diamond coating

Suitable for CFRP and CFRP-aluminium materials.



Diamond coating

Suitable for graphite machining.



Diamond coating

The original CVD diamond coating.



CVD Diamond coating

Unique multi-layer micro-grain diamond crystal control technology drastically improves wear resistance and smoothness.

CUTTING EDGE PROPERTIES



Sharp corner edge

Indicates the end mill has a sharp corner edge.



Gash land

Indicates the end mill cutting edge has a protective chamfer.



Rake angle



Helix angle

Indicates the helix angle of the end mill.



Point angle

Indicates the drill point angle.



Roughing flute geometry



Variable helix



Rounded gash



Corner angle

WEB THINNING



X type point geometry

X web thinning used at the drill point.



XR type point geometry

XR web thinning used at the drill point.



S type point geometry

Easy cutting geometry.



N type point geometry

Effective when the point web is thick.



Chipbreaker

SYMBOLS

TOLERANCES



Tolerance of taper angle
Indicates the tolerance of the taper angle.



R tolerance
Indicates the radial tolerance of a ball nose end mill.



R tolerance
Indicates the radial tolerance of the corner radius.



R tolerance
Indicates the radial tolerance of a cutter with a corner radius.



Outside diameter tolerance
Indicates the diameter tolerance of the end mill.



Peak tolerance
Indicates the tolerance for the end diameter.



Shank diameter tolerance



Shank diameter tolerance



Drill tolerance / diameter

COOLANT HOLES



External coolant



Internal coolant



Internal coolant



Centered, internal coolant hole



Radial, internal coolant holes



Internal coolant holes



Internal coolant holes

MEMO

MEMO

EUROPEAN SALES COMPANIES

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