

GUIDE TO GROOVING TOOLS

Section organization

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

[For External Grooving]

[For Internal Grooving & Threading]

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

INDICATION OF HOLDER TYPE ACCORDING TO APPLICATION indicates the holder types, such as 00° type or 90° type.

PRODUCT SECTION

GROOVING SYSTEM

GY SERIES (EXTERNAL GROOVING)

1-1 00° type holder (inch)

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

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number			
						Holder	Modular Blade	Stock	Fig.
.079 .088	236	.472		Modular	R	GYHRUS10B00-M20R	GYM20RA-D06	C	C
					L	HLUS10B00-M20L	GY20LA-D06	C	C
					R	HRUS12C00-M20R	GY12RA-D06	A	A
					L	HLUS12C00-M20L	GY12LA-D06	A	A
					R	HRUS12C00-M25R	GY12RA-D06	A	A
					L	HLUS12C00-M25L	GY12LA-D06	A	A
	394	.787		Modular	R	HRUS16D00-M25R	GY16RA-D06	A	A
					L	HLUS16D00-M25L	GY16LA-D06	A	A
					R	GRUS16D00-D06	—	G	G
					L	QLUS16D00-D06	—	G	G
					R	HRUS20D00-M25R	GY20RA-D06	E	E
					L	HLUS20D00-M25L	GY20LA-D06	E	E
472	.945		Modular	R	HRUS24E00-M25R	GY24RA-D06	E	E	
				L	HLUS24E00-M25L	GY24LA-D06	E	E	
				R	HRUS10B00-M20R	GY20RA-D10	C	C	
				L	HLUS10B00-M20L	GY20LA-D10	C	C	
				R	HRUS12C00-M25R	GY12RA-D12	C	C	
				L	HLUS12C00-M25L	GY12LA-D12	C	C	
709	1.417		Modular	R	HRUS16D00-M25R	GY16RA-D12	E	E	
				L	HLUS16D00-M25L	GY16LA-D12	E	E	
				R	HRUS20D00-M25R	GY20RA-D12	E	E	
				L	HLUS20D00-M25L	GY20LA-D12	E	E	
				R	HRUS10B00-M20R	GY20RB-D18	D	D	
				L	HLUS10B00-M20L	GY20LB-D18	D	D	
787	1.575		Modular	R	HRUS12C00-M25R	GY12RA-D20	D	D	
				L	HLUS12C00-M25L	GY12LA-D20	D	D	
				R	HRUS16D00-M25R	GY16RA-D20	B	B	
				L	HLUS16D00-M25L	GY16LA-D20	B	B	
				R	HRUS20D00-M25R	GY20RA-D20	F	F	
				L	HLUS20D00-M25L	GY20LA-D20	F	F	
800	1.600		Mono Block	R	GRUS16D00-D20	—	G	G	
				L	QLUS16D00-D20	—	G	G	

F020 • Inventory maintained.

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

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

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

TITLE OF PRODUCT

GEOMETRY

INTERNAL GROOVING

STHN/O TYPE

5-STHN/O Internal grooving, Threading, Boring

- Multi-clamp type.
- Precision class insert.
- Positive insert produces a good finished surface.
- Holder is capable of performing both grooving and threading.
- Economical due to the use of 3 cutting edges.

Order Number	Stock	Insert Number	Dimensions (inch)						Wrench	
			DCON	LF	WF	GAMF	DMIN	CDX		
S16-STHNR/L-3	●	●	32	1,000	10,00	656	10"	1,250	057, 156	GTS1 TKY10F
S20-STHNR/L-4	●	●	43	1,250	12,00	843	10"	1,750	156, 234	GTS2 TKY20F
S24-STHNR/L-4	●	●	43	1,500	14,00	968	10"	2,250	156, 234	GTS2 TKY20F
S32-STHNR/L-4	●	●	43	2,000	14,00	1,218	10"	3,000	156, 234	GTS2 TKY20F
S32-STHOR/L-5	●	●	54	2,000	14,00	1,250	0	4,000	297	GTS3 TKY20F

(Note) Please use left hand insert for right hand holder and right hand insert for left hand holder.
*1 Refer to inserts (PDP7) dimensions for CDX.

INSERTS (GROOVING)

Order Number	Stock	Coated	Carbide	Dimensions (inch)						Geometry
				CW	IC	S	PDP7	RE		
TNMC32NGR032	E	●	●	.032	.375	.125	.057	≤ .003		
TNMC32NGR032	E	●	●	.032	.375	.125	.057	≤ .003		
TNMC32NGR063	E	●	●	.063	.375	.125	.156	≤ .003		
TNMC32NGR063	E	●	●	.063	.375	.125	.156	≤ .003		
TNMC32NGR063	E	●	●	.063	.500	.188	.156	≤ .003		
TNMC32NGR063	E	●	●	.063	.500	.188	.156	≤ .003		
TNMC32NGR094	E	●	●	.094	.500	.188	.156	≤ .003		
TNMC32NGR094	E	●	●	.094	.500	.188	.156	≤ .003		
TNMC32NGR125	E	●	●	.125	.500	.188	.234	≤ .003		
TNMC32NGR125	E	●	●	.125	.500	.188	.234	≤ .003		
TNMC32NGR156	E	●	●	.156	.500	.188	.234	≤ .003		
TNMC32NGR156	E	●	●	.156	.500	.188	.234	≤ .003		
TNMC34NGR187	E	●	●	.187	.625	.250	.297	≤ .003		
TNMC34NGR187	E	●	●	.187	.625	.250	.297	≤ .003		

INSERTS (THREADING)

Order Number	Stock	Coated	Carbide	Min. Pitch (T.P.I.)	Dimensions (inch)			Geometry
					IC	S	RE	
TNMC32NV	E	●	●	8	.375	.125	.004	
TNMC34NV	E	●	●	6	.500	.187	.004	
TNMC34NV	E	●	●	4	.625	.250	.004	

SPARE PARTS → M001
TECHNICAL DATA → N001 F211

STANDARDS FOR APPLICABLE INSERTS indicates stock status, dimensions, etc. for applicable inserts.

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

TURNING

GROOVING TOOLS

CLASSIFICATION (EXTERNAL CUTTING).....	F002
CLASSIFICATION (INTERNAL CUTTING).....	F003

STANDARD

GY HOLDER (GROOVING)

CLASSIFICATION OF GY HOLDER.....	F004
HOW TO SELECT GY HOLDER.....	F008
IDENTIFICATION OF GY SERIES	F010

GY INSERTS	F013
GY HOLDER (EXTERNAL).....	F018
GY HOLDER (FACE GROOVING).....	F066
GY HOLDER (INTERNAL).....	F150
GY HOLDER (EXTERNAL GROOVING PSC TYPE)	F166

MTVO HOLDER (EXTERNAL GROOVING).....	F210
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S-STHN/O HOLDER (INTERNAL GROOVING)	F211
FSL51/52 HOLDER (INTERNAL GROOVING).....	F212
S-SL5N HOLDER (INTERNAL GROOVING).....	F213

MICRO-MINI TWIN BORING BARS





CG TYPE (INTERNAL GROOVING).....	F215
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Arranged by Alphabetical order.







F215	CG
F212	FSL5
F018	GY (Holders)
F013	GY (Inserts)
F214	MLG (Inserts)
F214	MLT (Inserts)
F210	MTVO
F213	S-SL5N
F211	S [○] ○-STHN
F211	S [○] ○-STHO
F210	TNMC (Inserts)

CLASSIFICATION

EXTERNAL CUTTING

Name of Tool Holder	Insert Shape	Features	Groove Width According to Cutting Mode (inch)					Page
			Shallow Grooving	Deep Grooving	Cutting Off	Copying	Recessing	
GY Holder 		<ul style="list-style-type: none"> ● Modular type. ● Clamp-on type. ● High accuracy and rigidity due to the modular blade. (Tri-lock system) ● Various insert types. ● Mono block type. ● Spring clamp type. 	.059"	.079" (2.0mm)	.079" (2.0mm)	.079" (2.0mm)	.079" (2.0mm)	F018
			.088"				.088"	
			.094"				.094"	
			.098" (2.5mm)	.098" (2.5mm)	.098" (2.5mm)	.098" (2.5mm)	.098" (2.5mm)	
			.108"				.108"	
			.118" (3.0mm)	.118" (3.0mm)	.118" (3.0mm)	.118" (3.0mm)	.118" (3.0mm)	
			.125"	.125"	.125"	.125"	.125"	
			.128"				.128"	
			.157" (4.0mm)	.157" (4.0mm)	.157" (4.0mm)	.157" (4.0mm)	.157" (4.0mm)	
			.167"				.167"	
			.187"	.187"	.187"	.187"	.187"	
			.197" (5.0mm)	.197" (5.0mm)	.197" (5.0mm)	.197" (5.0mm)	.197" (5.0mm)	
			.206"				.206"	
			.236" (6.0mm)	.236" (6.0mm)	.236" (6.0mm)	.236" (6.0mm)	.236" (6.0mm)	
			.248"				.248"	
			.250"	.250"	.250"	.250"	.250"	
			.315" (8mm)	.315" (8mm)				
MTVO Holder 		<ul style="list-style-type: none"> ● Multi-clamp type. ● Precision class insert. ● Positive insert produces a good finished surface. ● Holder is capable of performing both grooving and threading. ● Economical due to the use of 3 cutting edges. 	.032"					F210
			.063"					
			.094"					
			.125"					
			.156"					
			.187"					

INTERNAL CUTTING

Name of Tool Holder	Insert Shape	Features	DMIN (inch)	CW (inch)	CDX (inch)	Page
GY 		<ul style="list-style-type: none"> ● Modular type. ● Clamp-on type. ● High accuracy and rigidity due to the modular blade. (Tri-lock system) ● Various insert types. ● Mono block type. ● Spring clamp type. 	.984" (25mm)	.079" (2.0mm) .088" .094" .098" (2.5mm) .108" .118" (3.0mm) .125" .128" .157" (4.0mm) .167" .187" .197" (5.0mm) .206" .236" (6.0mm) .248" .250"	.157" .512"	F150
STHN/O 		<ul style="list-style-type: none"> ● Screw-on type. ● Precision class insert. ● Positive insert produces a good finished surface. ● Holder is capable of performing both grooving and threading. ● Economical due to the use of 3 cutting edges. 	1.250"	.032" .063" .094" .125" .156" .187"	.060" .297"	F211
FSL5 S-SL5 		<ul style="list-style-type: none"> ● Screw-on type. ● Precision class insert. ● Holder is capable of performing both grooving and threading. ● Maximum groove depth .118inch. 	.394"	.047" (1.2mm) .059" (1.5mm) .062" .079" (2.0mm) .094" .118" (3.0mm) .125" .156" .157" (4.0mm)	.039" .118"	F212
MICRO-MINI TWIN Boring Bars 	—	<ul style="list-style-type: none"> ● Solid carbide type. ● Economical due to single holder with two cutting edges. 	.118"	.04" .08"	.04" .08"	F215
MICRO-MINI Boring Bars 	—	<ul style="list-style-type: none"> ● Solid carbide type. ● Insert can be ground to suit the application. 	.126"	.08" .12"	.04" .08"	E031

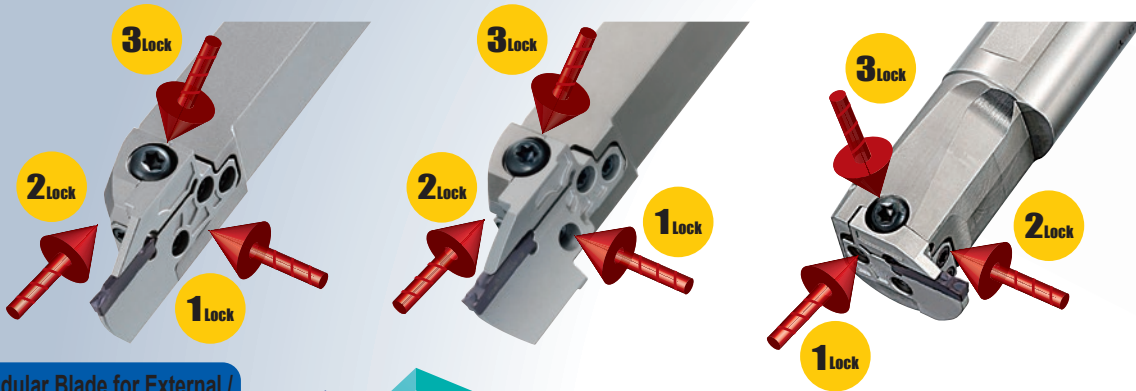
FEATURES OF THE GY SERIES

TRI-LOCK System for increased stability and performance!

● Innovative TRI-LOCK System

- Mitsubishi Materials has developed a modular blade that is totally original and incomparable.*
TRI-LOCK system ensures that the modular blade is securely located from 3 directions (side, front and top). This leads to high rigidity clamping and stable grooving.

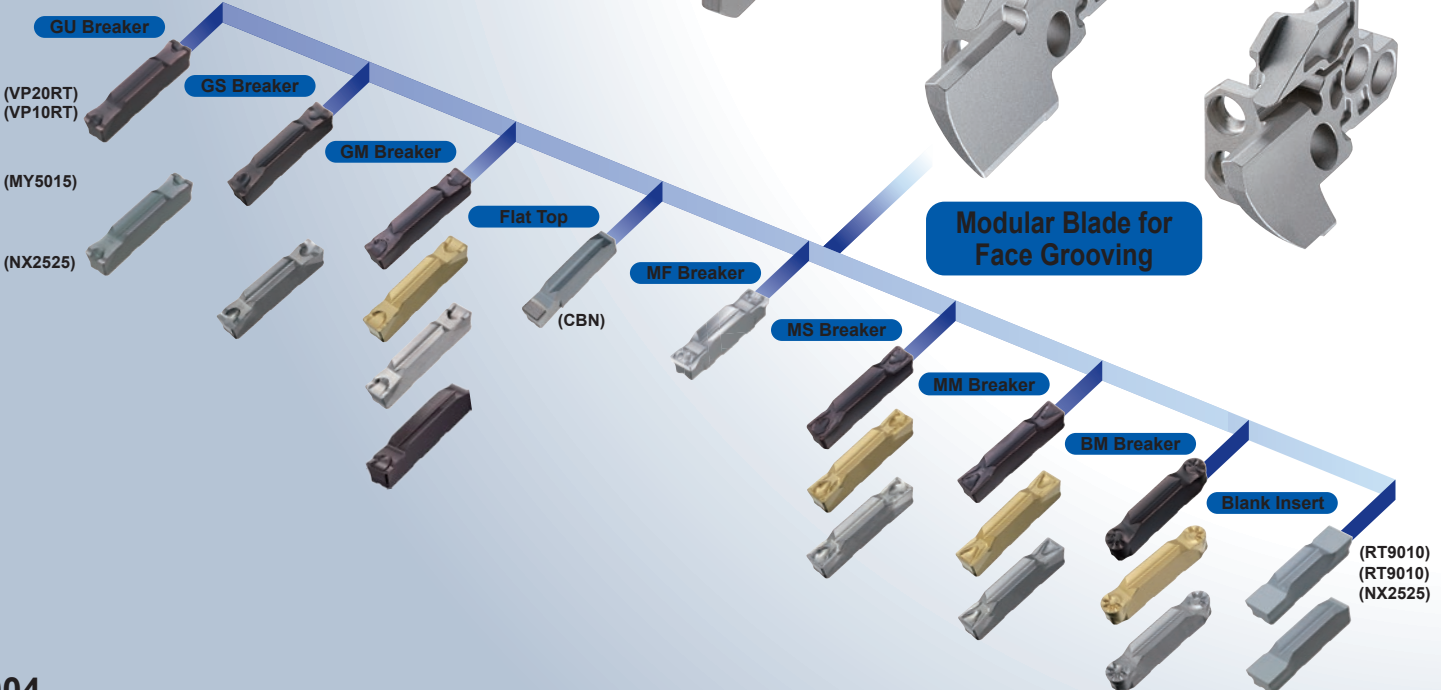
*Mitsubishi Materials study data



Modular Blade for External / Internal Grooving

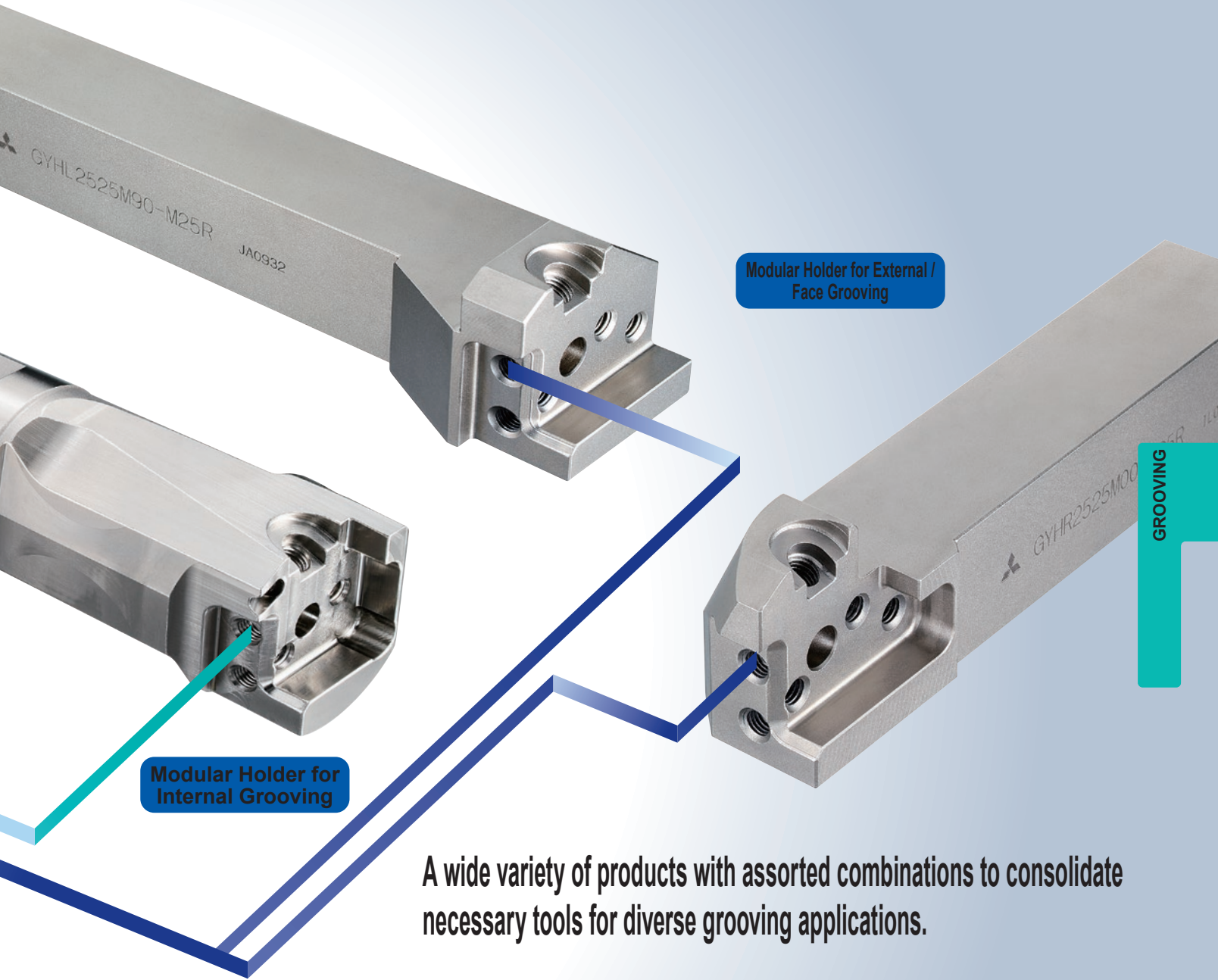
Modular Blade for External Grooving

Modular Blade for Face Grooving



GROOVING

GY series offers ultimate rigidity and accuracy for stable grooving applications.
Modular system allows for high flexibility while maintaining overall strength comparable to a mono block type holder.



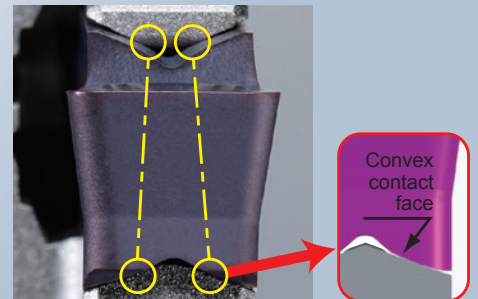
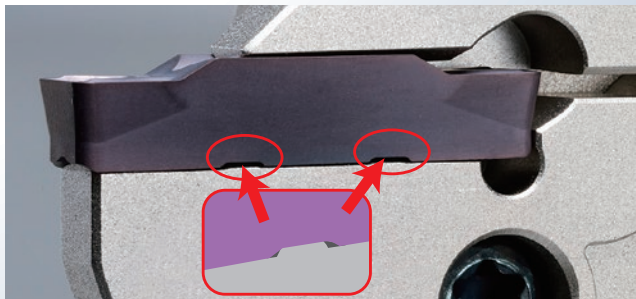
A wide variety of products with assorted combinations to consolidate necessary tools for diverse grooving applications.

New insert design leading the way for new grooving applications !

● Highly reliable insert clamping

● Safety keys prevent insert movement.

● The convex geometry ensures high precision clamping.

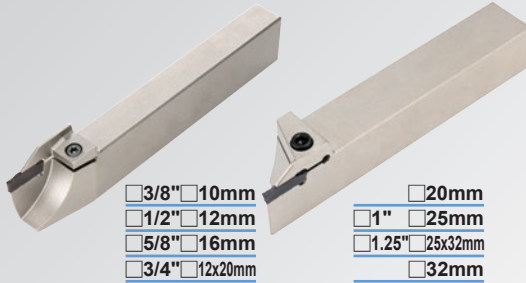


GY SERIES

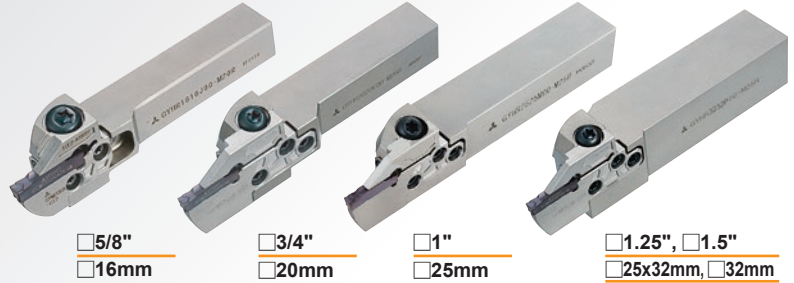
A wide selection of holders and inserts available for diverse grooving applications.

External • Face holders

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



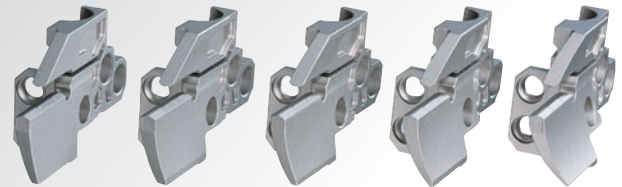
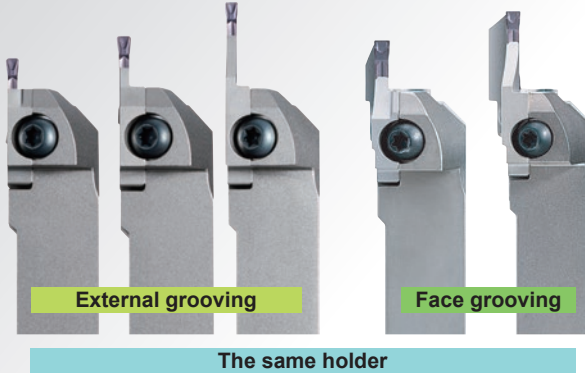
Mono block type



Modular type

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

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

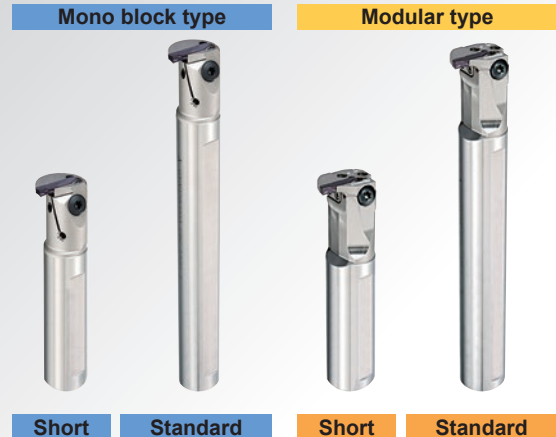


Internal holders

● A wide range of holders available from minimum diameter of $\varnothing 25\text{mm}$.

● Short shank types are stock standard.

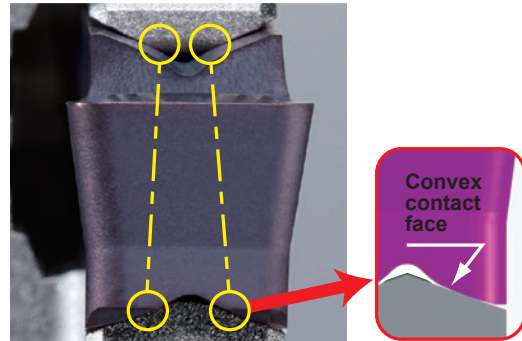
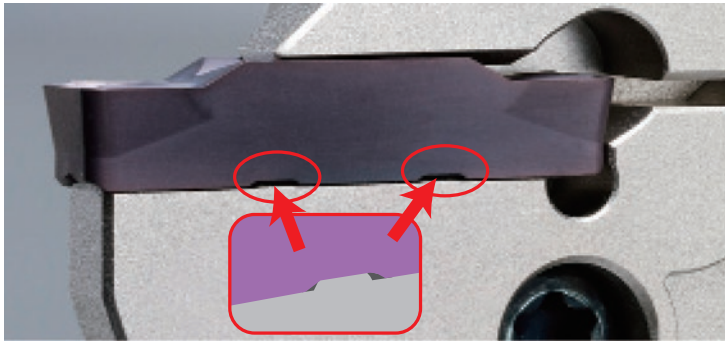
Mono block type	Modular type
Min. cutting diameter (Inch)	Min. cutting diameter (Inch)
$\varnothing 1.000"$	$\varnothing 1.625"$
$\varnothing 1.250"$	$\varnothing 2.000"$
	$\varnothing 2.500"$
	$\varnothing 2.750"$
(Metric)	(Metric)
$\varnothing 25\text{mm}$	$\varnothing 40\text{mm}$
$\varnothing 32\text{mm}$	$\varnothing 50\text{mm}$
	$\varnothing 60\text{mm}$
	$\varnothing 70\text{mm}$



Original insert design leading the way to new grooving applications !

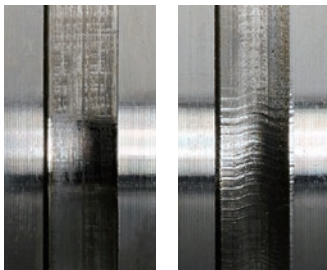
● Highly reliable insert clamping
Safety keys prevent insert movement.

The convex geometry ensures high precision clamping.



Face grooving test results

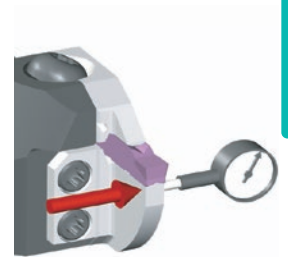
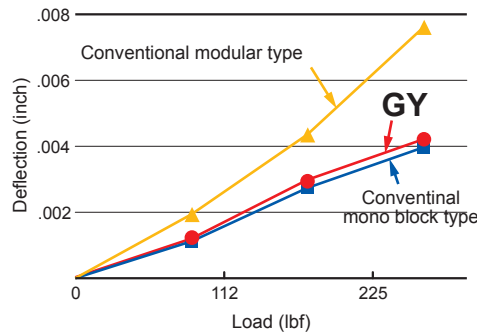
GY series can achieve stable machining at the cutting conditions which created vibration with a conventional modular type tool.



<Cutting Conditions>
Work material : AISI 4140
Insert width : .197"
Cutting speed : 490 SFM
Feed : .008 IPR
Groove depth : .906"

Rigidity comparison

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



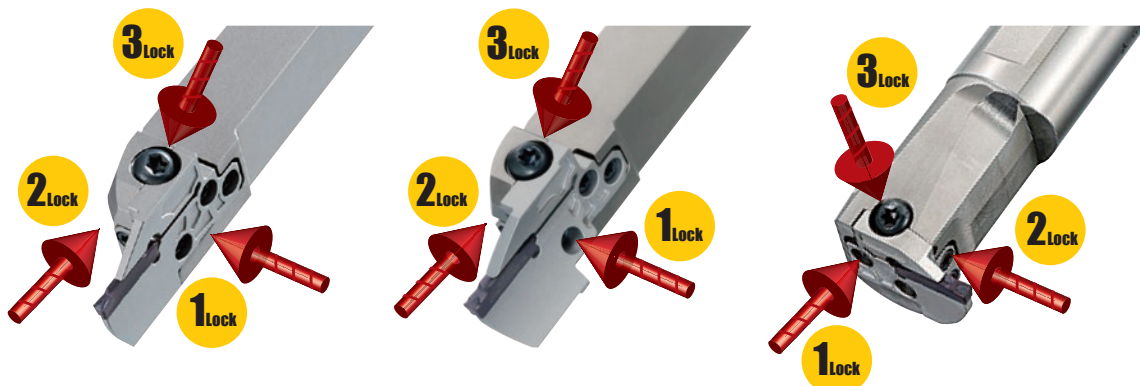
(Tool body for .197" insert)

GROOVING

New TRI-LOCK System for increased stability and performance!

● TRI-LOCK System

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

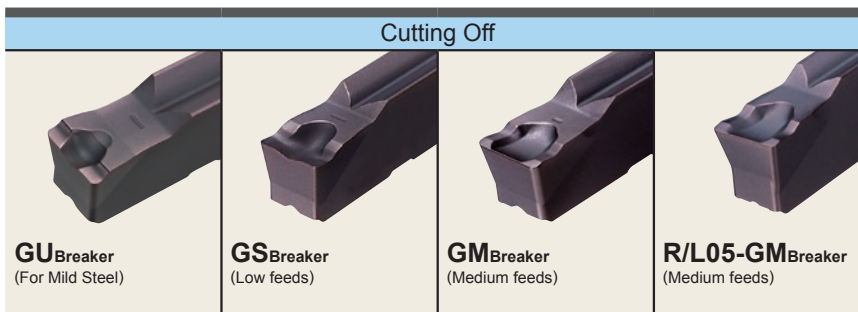
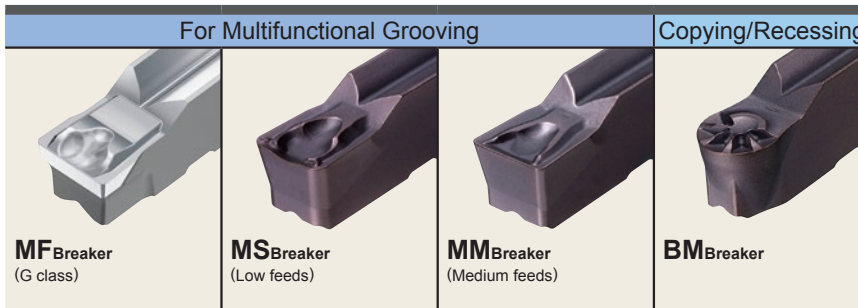
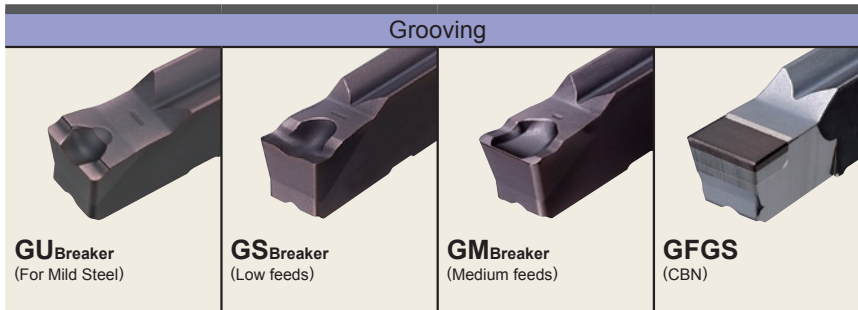


GROOVING SYSTEM

INSERT

● A WIDE SELECTION OF INSERTS

● Breaker system



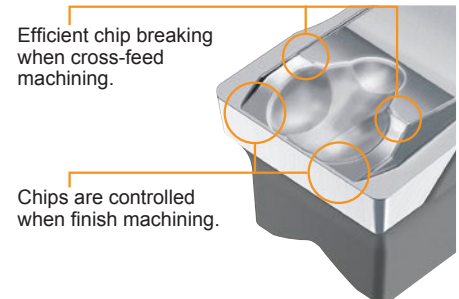
● Selection of groove widths



● Different corner radii available



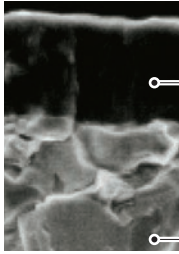
● MF Breaker



● INSERT GRADE

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

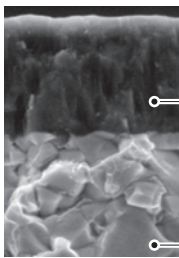
Note1) VP20RT is the first recommended grade for materials other than hardened steel.
 Note2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

VP20RT (1st Recommendation)

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

MIRACLE Coating

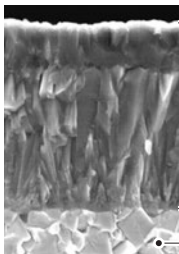
Carbide substrate (HRA90.5)

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

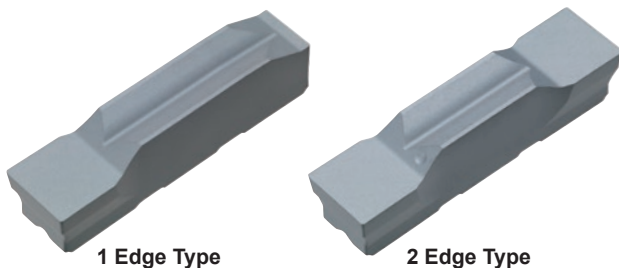
- MY5015 is a CVD coated grade with excellent wear resistance even at high temperatures. It provides longer tool life when machining cast and ductile cast irons. Also suitable for high speed continuous cutting of steels.

CVD Coated Carbide

Carbide substrate

BLANK INSERTS

- Blank inserts for custom grinding



1 Edge Type

2 Edge Type

* Blank inserts to be ground by customers.

RT9010

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

NX2525

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

BC8110

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

MB8025

- MB8025 is a sintered CBN grade for hardened steel.

RT9010/RT9020 for blank insert

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

IDENTIFICATION OF GY SERIES

Insert



① Series Description

② Number of Teeth	
1	1 Edge Type
2	2 Edge Type

③ Peripheral	
G	Ground
M	Sintered
B	Blank

④ Groove Width		
	Inch	Metric
0150	.059"	1.50mm
0200	.079"	2.00mm
⋮	⋮	⋮
0800	.315"	8.00mm

⑤ Seat Size *1

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

⑥ Corner Radius

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

⑨ Application 1

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

⑩ Application 2

U	For Gummy Steel
F	Finishing
S	Low feeds
M	Medium feeds

⑧ Lead angle (R/L type insert)

05	5°
----	----

⑦ Hand

N	Neutral
R	Right
L	Left

CBN INSERT



⑪ Application 3

F	Flat Top
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⑫ Honing Type

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

Modular blade

● EXTERNAL/INTERNAL/RECESSING



① Series Description

② Modular Blade Size	
M20	
M25	

③ Hand	
R	Right
L	Left

④ Modular Blade Type	
A	Standard Type
B	Reinforced Type
C	External Recessing
D	Face Grooving

⑤ Seat Size *1		
	Inch	Metric
D	.079" .088"	2.00mm 2.24mm
E	.094" .098" .108"	2.39mm 2.50mm 2.74mm
F	.118" .125" .128"	3.00mm 3.18mm 3.24mm
G	.157" .167"	4.00mm 4.24mm
H	.187" .197" .206"	4.75mm 5.00mm 5.24mm
J	.236" .248" .250"	6.00mm 6.31mm 6.35mm

⑥ Max. Groove Depth *2		
	Inch	Metric
005	.197"	0.5mm
06	.236"	6mm
⋮	⋮	⋮
25	.984"	25mm

● FACE GROOVING



⑦ Min. Groove Diameter

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

Note: Dimension symbols conforming to ISO13399.
See pages PR5-PR8 for details.

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

*2 The maximum groove depth is a value when used for external grooving and changes according to the insert used.

For internal grooving, refer to the maximum groove depth on pages F150—F165.

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

EXTERNAL/FACE GROOVING/RECESSING

● MONO BLOCK HOLDER

(Inch) **GY** **P** **R** **US16** **D** **00** - **K** **25**
 (Metric) **2525** **M**

① Series Description

② Holder Type	
S	Mono Block Holder for Small Lathe
P	Offset Mono Block Holder
Q	Zero Offset Mono Block Holder
H	Modular Type Holder

③ Hand of Holder	
R	Right
L	Left

④ Holder Size			
	Inch		Metric
US06	.375"x.375"	1010	10mmx10mm
US08	.500"x.500"	1212	12mmx12mm
US10	.625"x.625"	1616	16mmx16mm
US12	.750"x.750"	2012	20mmx12mm
US16	1.000"x1.000"	2020	20mmx20mm
US20	1.250"x1.250"	2525	25mmx25mm
US24	1.500"x1.500"	3225	32mmx25mm
		3232	32mmx32mm

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

⑥ Angle (degree)	
00	0°
50	50°
90	90°

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

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

● MODULAR TYPE HOLDER

(Inch) **GY** **H** **R** **US16** **M** **00** - **M25** **R**
 (Metric) **2525**

⑨ Modular Blade Size	
M20	
M25	

⑩ Hand of Modular Blade	
R	Right
L	Left

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

INTERNAL

● MONO BLOCK HOLDER

(Inch) **GY** **A** **R** **US16** **K** **90** **A** - **F** **06**
 (Metric) **20**

① Series Description

② Holder Type	
A	Mono Block
D	Modular Type Holder

③ Hand of Holder	
R	Right
L	Left

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

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

⑥ Angle (degree)	
90	90°

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

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

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

● MODULAR TYPE HOLDER

(Inch) **GY** **D** **R** **US20** **M** **90** **D** - **M25** **L**
 (Metric) **40**

⑩ Modular Blade Size	
M20	
M25	

⑪ Hand of Modular Blade	
R	Right
L	Left

IDENTIFICATION OF GY-PSC Holder

EXTERNAL
● GY-PSC HOLDER

① **C4** - ② **GY** ③ **H** ④ **R** ⑤ **EX** ⑥ **00** - ⑦ **M25** ⑧ **R**

① Coupling Size	② Series Description	③ Holder Type	④ Hand of Holder	⑤ Functional Length	⑥ Angle (degree)	⑦ Modular Blade Size	⑧ Hand of Modular Blade
C3		H	R Right L Left	CX 2.165" D 2.362" DX 2.559" E 2.756" EX 2.953" F 3.150"	00 0° 90 90°	M20 M25	R Right L Left

① Coupling Size

⑤ Functional Length

Reference data

L dimension tolerance conversion table

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

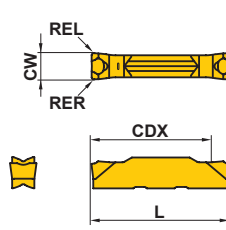
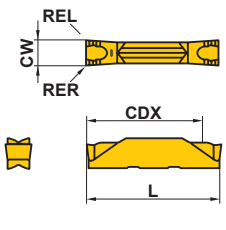
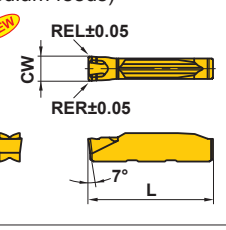
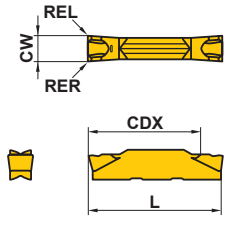
*1 This value is used at the described holder dimension.

*2 when there is no applicable breaker.

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

GY INSERTS

INSERTS

Applications	Geometry	Order Number	Stock								Seat Size	Dimensions (inch)				
			Coated		Cermet	Carbide		CBN		CW		RER/L	CDX	L	*1	
			VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020	BC8110	MB8025						Grooving Width
			For Grooving / Cutting off													
GU Breaker (For mild steel) 	GY2M0200D020N-GU	● ● ●								D	.079	±.0012	.008	.776	.815	
	GY2M0239E020N-GU	● ● ●								E	.094	±.0012	.008	.780	.815	
	GY2M0250E020N-GU	● ● ●								E	.098	±.0012	.008	.768	.815	
	GY2M0300F030N-GU	● ● ●								F	.118	±.0012	.012	.760	.815	
	GY2M0318F030N-GU	● ● ●								F	.125	±.0012	.012	.760	.815	
	GY2M0400G030N-GU	● ● ●								G	.157	±.0016	.012	.953	1.010	
	GY2M0475H040N-GU	● ● ●								H	.187	±.0016	.016	.953	1.010	
	GY2M0500H040N-GU	● ● ●								H	.197	±.0016	.016	.953	1.010	
	GY2M0600J040N-GU	● ● ●								J	.236	±.0016	.016	.953	1.010	
	GY2M0635J040N-GU	● ● ●								J	.250	±.0016	.016	.953	1.010	
GS Breaker (Low feeds) 	GY2M0150C010N-GS	● ● ●								C	.059	±.0012	.004	.528	.579	
	GY2M0200D020N-GS	● ● ●								D	.079	±.0012	.008	.736	.815	
	GY2M0239E020N-GS	● ● ●								E	.094	±.0012	.008	.728	.815	
	GY2M0250E020N-GS	● ● ●								E	.098	±.0012	.008	.728	.815	
	GY2M0300F020N-GS	● ● ●								F	.118	±.0012	.008	.728	.815	
	GY2M0318F020N-GS	● ● ●								F	.125	±.0012	.008	.728	.815	
	GY2M0400G020N-GS	● ● ●								G	.157	±.0016	.008	.941	1.010	
	GY2M0475H030N-GS	● ● ●								H	.187	±.0016	.012	.941	1.010	
	GY2M0500H030N-GS	● ● ●								H	.197	±.0016	.012	.945	1.010	
	GY2M0600J030N-GS	● ● ●								J	.236	±.0016	.012	.949	1.010	
GM Breaker (Medium feeds) 	GY1M0200D020N-GM	● ● ●								D	.079	±.0012	.008	—	.815	
	GY1M0250E020N-GM	● ● ●								E	.098	±.0012	.008	—	.815	
	GY1M0300F030N-GM	● ● ●								F	.118	±.0012	.012	—	.815	
	GY1M0400G030N-GM	● ● ●								G	.157	±.0016	.012	—	1.010	
	GY1M0500H040N-GM	● ● ●								H	.197	±.0016	.016	—	1.010	
	GM Breaker (Medium feeds) 	GY2M0150C020N-GM	● ● ●								C	.059	±.0012	.008	.547	.579
		GY2M0200D020N-GM	● ● ●								D	.079	±.0012	.008	.764	.815
		GY2M0239E020N-GM	● ● ●								E	.094	±.0012	.008	.764	.815
		GY2M0250E020N-GM	● ● ●								E	.098	±.0012	.008	.764	.815
		GY2M0300F030N-GM	● ● ●								F	.118	±.0012	.012	.764	.815
GY2M0318F030N-GM		● ● ●								F	.125	±.0012	.012	.764	.815	
GY2M0400G030N-GM		● ● ●								G	.157	±.0016	.012	.961	1.010	
GY2M0475H040N-GM		● ● ●								H	.187	±.0016	.016	.957	1.010	
GY2M0500H040N-GM		● ● ●								H	.197	±.0016	.016	.957	1.010	
GY2M0600J040N-GM		● ● ●								J	.236	±.0016	.016	.957	1.010	
GY2M0635J040N-GM	● ● ●								J	.250	±.0016	.016	.957	1.010		
GY2M0800K050N-GM	● ● ●								K	.315	±.0016	.020	1.154	1.201		

*1 Groove width corresponding to the circlip.

GROOVING

● : Inventory maintained. (10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

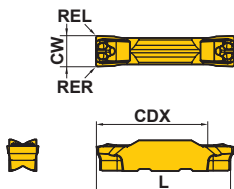
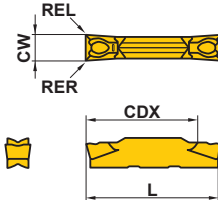
F013

GY INSERTS

INSERTS

Applications	Geometry	Order Number	Stock								Seat Size	Dimensions (inch)								
			Coated		Cermet		Carbide		CBN			CW		RER/L	CDX	L	LE			
			VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020	BC8110	MB8025		Grooving Width	Tolerance							
For Cutting off	R/L05-GM Breaker Left hand insert shown.	GY1M0200D020R05-GM	●	●								D	.079	±.0012	.008	—	.819	—		
		GY1M0200D020L05-GM	●	●									D	.079	±.0012	.008	—	.819	—	
		GY1M0300F030R05-GM	●	●									F	.118	±.0012	.012	—	.821	—	
		GY1M0300F030L05-GM	●	●									F	.118	±.0012	.012	—	.821	—	
	R/L05-GM Breaker Right hand insert shown.	GY2M0200D020R05-GM	●	●									D	.079	±.0012	.008	.768	.819	—	
		GY2M0200D020L05-GM	●	●									D	.079	±.0012	.008	.768	.819	—	
		GY2M0250E020R05-GM	●	●									E	.098	±.0012	.008	.768	.820	—	
		GY2M0250E020L05-GM	●	●									E	.098	±.0012	.008	.768	.820	—	
		GY2M0300F030R05-GM	●	●									F	.118	±.0012	.012	.768	.821	—	
		GY2M0300F030L05-GM	●	●									F	.118	±.0012	.012	.768	.821	—	
		GY2M0400G030R05-GM	●	●									G	.157	±.0016	.012	.965	1.018	—	
		GY2M0400G030L05-GM	●	●									G	.157	±.0016	.012	.965	1.018	—	
	GY2M0500H040R05-GM	●	●									H	.197	±.0016	.016	.965	1.022	—		
GY2M0500H040L05-GM	●	●									H	.197	±.0016	.016	.965	1.022	—			
For Grooving	Flat Top (For Hardened material) 	GY1G0200D020N-GFGS									●	●	D	.079	±.0012	.008	—	.815	.106	
		GY1G0239E020N-GFGS										●	●	E	.094	±.0012	.008	—	.815	.106
		GY1G0250E020N-GFGS										●	●	E	.098	±.0012	.008	—	.815	.106
		GY1G0300F020N-GFGS										●	●	F	.118	±.0012	.008	—	.815	.106
		GY1G0318F020N-GFGS										●	●	F	.125	±.0012	.008	—	.815	.106
		GY1G0400G020N-GFGS										●	●	G	.157	±.0012	.008	—	1.010	.106
		GY1G0475H020N-GFGS										●	●	H	.187	±.0012	.008	—	1.010	.106
		GY1G0500H020N-GFGS										●	●	H	.197	±.0012	.008	—	1.010	.106
		GY1G0600J020N-GFGS										●		J	.236	±.0012	.008	—	1.010	.106

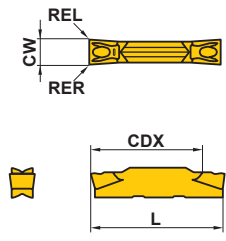
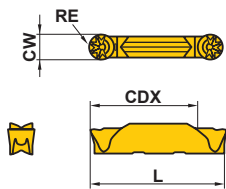
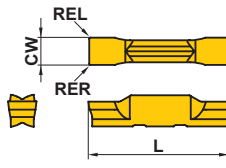
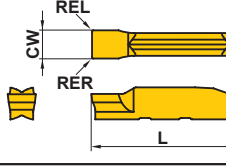
*1 Groove width corresponding to the circlip.

Applications	Geometry	Order Number	Stock								Seat Size	Dimensions (inch)					
			Coated		Cermet		Carbide		CBN			CW		RER/L	CDX	L	
			VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020	BC8110	MB8025		Grooving Width	Tolerance				
			*1														
For Multifunctional Grooving	MF Breaker (Finishing) 	GY2G0200D020N-MF	●	●	●	●					D	.079	±.0008	.008	.768	.829	
		*1GY2G0224D015N-MF	●	●	●	●					D	.088	±.0008	.006	.780	.829	
		GY2G0239E020N-MF	●	●	●	●					E	.094	±.0008	.008	.756	.829	
		GY2G0250E020N-MF	●	●	●	●					E	.098	±.0008	.008	.764	.829	
		*1GY2G0274E020N-MF	●	●	●	●					E	.108	±.0008	.008	.776	.829	
		GY2G0300F020N-MF	●	●	●	●					F	.118	±.0008	.008	.768	.829	
		GY2G0300F040N-MF	●	●	●	●					F	.118	±.0008	.016	.760	.829	
		GY2G0318F020N-MF	●	●	●	●					F	.125	±.0008	.008	.768	.829	
		GY2G0318F040N-MF	●	●	●	●					F	.125	±.0008	.016	.760	.829	
		*1GY2G0324F020N-MF	●	●	●	●					F	.128	±.0008	.008	.768	.829	
		GY2G0400G020N-MF	●	●	●	●					G	.157	±.0008	.008	.980	1.022	
		GY2G0400G040N-MF	●	●	●	●					G	.157	±.0008	.016	.972	1.022	
		GY2G0400G080N-MF	●	●	●	●					G	.157	±.0008	.031	.957	1.022	
		*1GY2G0424G020N-MF	●	●	●	●					G	.167	±.0008	.008	.980	1.022	
		GY2G0475H020N-MF	●	●	●	●					H	.187	±.0008	.008	.961	1.022	
		GY2G0475H040N-MF	●	●	●	●					H	.187	±.0008	.016	.953	1.022	
		GY2G0475H080N-MF	●	●	●	●					H	.187	±.0008	.031	.937	1.022	
		GY2G0500H020N-MF	●	●	●	●					H	.197	±.0008	.008	.961	1.022	
		GY2G0500H040N-MF	●	●	●	●					H	.197	±.0008	.016	.953	1.022	
		GY2G0500H080N-MF	●	●	●	●					H	.197	±.0008	.031	.937	1.022	
		*1GY2G0524H020N-MF	●	●	●	●					H	.206	±.0008	.008	.961	1.022	
		GY2G0600J020N-MF	●	●	●	●					J	.236	±.0008	.008	.961	1.022	
		GY2G0600J040N-MF	●	●	●	●					J	.236	±.0008	.016	.953	1.022	
		GY2G0600J080N-MF	●	●	●	●					J	.236	±.0008	.031	.937	1.022	
		*1GY2G0631J020N-MF	●	●	●	●					J	.248	±.0008	.008	.961	1.022	
		GY2G0635J020N-MF	●	●	●	●					J	.250	±.0008	.008	.961	1.022	
		GY2G0635J040N-MF	●	●	●	●					J	.250	±.0008	.016	.953	1.022	
		GY2G0635J080N-MF	●	●	●	●					J	.250	±.0008	.031	.937	1.022	
		MS Breaker (Low feeds) 	GY2M0200D020N-MS	●	●	●	●					D	.079	±.0012	.008	.752	.815
			GY2M0250E020N-MS	●	●	●	●					E	.098	±.0012	.008	.752	.815
GY2M0300F020N-MS	●		●	●	●					F	.118	±.0012	.008	.756	.815		
GY2M0300F040N-MS	●		●	●	●					F	.118	±.0012	.016	.744	.815		
GY2M0400G020N-MS	●		●	●	●					G	.157	±.0016	.008	.953	1.010		
GY2M0400G040N-MS	●		●	●	●					G	.157	±.0016	.016	.941	1.010		
GY2M0500H040N-MS	●		●	●	●					H	.197	±.0016	.016	.941	1.010		
GY2M0500H080N-MS	●		●	●	●					H	.197	±.0016	.031	.925	1.010		
GY2M0600J040N-MS	●		●	●	●					J	.236	±.0016	.016	.941	1.010		
GY2M0600J080N-MS	●		●	●	●					J	.236	±.0016	.031	.925	1.010		
GY2M0800K080N-MS	●	●	●						K	.315	±.0016	.031	1.122	1.201			

*1 Groove width corresponding to the circlip.

GY INSERTS

INSERTS

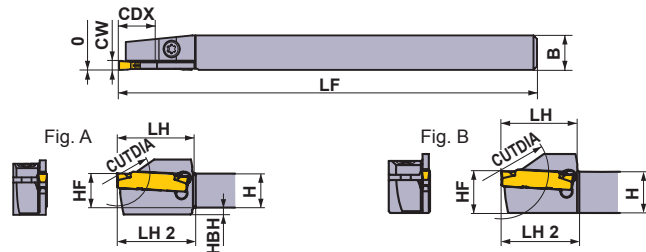
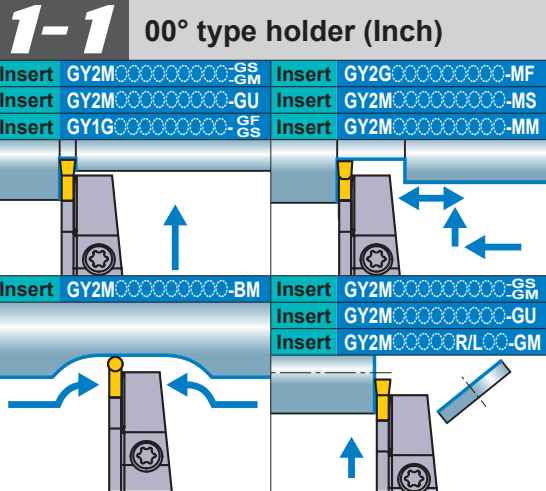
Applications	Geometry	Order Number	Stock								Seat Size	Dimensions (inch)					
			Coated		Cermet		Carbide		CBN			CW		RE RER/L	CDX	L	
			VP10RT	VP20RT	MY5015	NX2525	RT9010	RT9020	BC8110	MB8025		Grooving Width	Tolerance				
For Multifunctional Grooving	MM Breaker (Medium feeds) 	GY2M0200D020N-MM	●	●	●	●						D	.079	±.0012	.008	.752	.815
		GY2M0250E020N-MM	●	●	●	●						E	.098	±.0012	.008	.752	.815
		GY2M0300F020N-MM	●	●	●	●						F	.118	±.0012	.008	.752	.815
		GY2M0300F040N-MM	●	●	●	●						F	.118	±.0012	.016	.744	.815
		GY2M0300F080N-MM	●	●	●	●						F	.118	±.0012	.031	.728	.815
		GY2M0400G020N-MM	●	●	●	●						G	.157	±.0016	.008	.949	1.010
		GY2M0400G040N-MM	●	●	●	●						G	.157	±.0016	.016	.941	1.010
		GY2M0400G080N-MM	●	●	●	●						G	.157	±.0016	.031	.925	1.010
		GY2M0500H040N-MM	●	●	●	●						H	.197	±.0016	.016	.941	1.010
		GY2M0500H080N-MM	●	●	●	●						H	.197	±.0016	.031	.925	1.010
		GY2M0600J040N-MM	●	●	●	●						J	.236	±.0016	.016	.941	1.010
		GY2M0600J080N-MM	●	●	●	●						J	.236	±.0016	.031	.925	1.010
		GY2M0800K080N-MM	●	●	●							K	.315	±.0016	.031	1.122	1.201
GY2M0800K120N-MM	●	●	●							K	.315	±.0016	.047	1.106	1.201		
For Copying / Reversing	BM Breaker 	GY2M0200D100N-BM	●	●	●	●						D	.079	±.0012	.039	.768	.815
		GY2M0250E125N-BM	●	●	●	●						E	.098	±.0012	.049	.760	.815
		GY2M0300F150N-BM	●	●	●	●						F	.118	±.0012	.059	.748	.823
		GY2M0318F159N-BM	●	●	●	●						F	.125	±.0012	.063	.744	.823
		GY2M0400G200N-BM	●	●	●	●						G	.157	±.0016	.079	.921	1.016
		GY2M0475H238N-BM	●	●	●	●						H	.187	±.0016	.094	.902	1.016
		GY2M0500H250N-BM	●	●	●	●						H	.197	±.0016	.098	.898	1.016
		GY2M0600J300N-BM	●	●	●	●						J	.236	±.0016	.118	.886	1.020
		GY2M0635J318N-BM	●	●	●	●						J	.250	±.0016	.125	.878	1.020
GY2M0800K400N-BM	●	●	●							K	.315	±.0016	.157	1.043	1.213		
Blank	2 Edge Type 	GY2B0220D020N				★	★	★				D	.087	±.0039	.008	—	.829
		GY2B0270E020N				★	★	★				E	.106	±.0039	.008	—	.829
		GY2B0340F020N				★	★	★				F	.134	±.0039	.008	—	.829
		GY2B0420G020N				★	★	★				G	.165	±.0039	.008	—	1.024
		GY2B0520H020N				★	★	★				H	.205	±.0039	.008	—	1.024
		GY2B0655J020N				★	★	★				J	.258	±.0039	.008	—	1.024
	1 Edge Type 	GY1B0220D020N				★	★	★				D	.087	±.0039	.008	—	.827
		GY1B0270E020N				★	★	★				E	.106	±.0039	.008	—	.827
		GY1B0340F020N				★	★	★				F	.134	±.0039	.008	—	.827
		GY1B0420G020N				★	★	★				G	.165	±.0039	.008	—	1.020
		GY1B0520H020N				★	★	★				H	.205	±.0039	.008	—	1.020
		GY1B0655J020N				★	★	★				J	.258	±.0039	.008	—	1.020

*2 Blank inserts to be ground by customers.

Memo

A series of horizontal dotted lines for writing, spanning the width of the page.

GY SERIES (EXTERNAL GROOVING for Swiss style lathes)





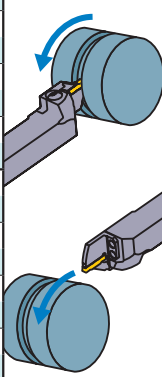
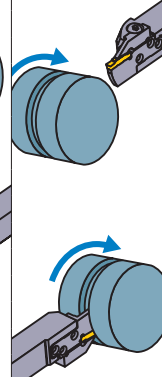
Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number		Fig.
						Holder	Stock	
C	.059	.433	.866	Mono Block	R	GYSRUS06B00-C11	●	A
				Mono Block	L	GYSLUS06B00-C11	●	A
		.512	1.024	Mono Block	R	GYSRUS08B00-C13	●	B
				Mono Block	L	GYSLUS08B00-C13	●	B
		.669 *1	1.338 *2	Mono Block	R	GYSRUS10B00-C17	●	B
				Mono Block	L	GYSLUS10B00-C17	●	B
D	.079	.433	.866	Mono Block	R	GYSRUS06B00-D11	●	A
				Mono Block	L	GYSLUS06B00-D11	●	A
		.512	1.024	Mono Block	R	GYSRUS08B00-D13	●	B
				Mono Block	L	GYSLUS08B00-D13	●	B
		.669 *1	1.338 *2	Mono Block	R	GYSRUS10B00-D17	●	B
				Mono Block	L	GYSLUS10B00-D17	●	B
	.088	.433	.866	Mono Block	R	GYSRUS12B00-D17	●	B
				Mono Block	L	GYSLUS12B00-D17	●	B
		.512	1.024	Mono Block	R	GYSRUS10B00-E11	●	A
				Mono Block	L	GYSLUS10B00-E11	●	A
		.669 *1	1.338 *2	Mono Block	R	GYSRUS08B00-E13	●	B
				Mono Block	L	GYSLUS08B00-E13	●	B
E	.094 .098 .108	.433	.866	Mono Block	R	GYSRUS10B00-E17	●	B
				Mono Block	L	GYSLUS10B00-E17	●	B
		.512	1.024	Mono Block	R	GYSRUS12B00-E17	●	B
				Mono Block	L	GYSLUS12B00-E17	●	B
		.669 *1	1.338 *2	Mono Block	R	GYSRUS10B00-E20	●	B
				Mono Block	L	GYSLUS10B00-E20	●	B
F	.118 .125 .128	.512	1.024	Mono Block	R	GYSRUS12B00-E20	●	B
				Mono Block	L	GYSLUS12B00-E20	●	B
		.669 *1	1.338 *2	Mono Block	R	GYSRUS08B00-F13	●	B
				Mono Block	L	GYSLUS08B00-F13	●	B
		.787 *1	1.574 *2	Mono Block	R	GYSRUS10B00-F17	●	B
				Mono Block	L	GYSLUS10B00-F17	●	B
.128	1.574 *2	Mono Block	R	GYSRUS12B00-F17	●	B		
		Mono Block	L	GYSLUS12B00-F17	●	B		
F	.118 .125 .128	.512	1.024	Mono Block	R	GYSRUS10B00-F20	●	B
				Mono Block	L	GYSLUS10B00-F20	●	B
		.669 *1	1.338 *2	Mono Block	R	GYSRUS12B00-F20	●	B
				Mono Block	L	GYSLUS12B00-F20	●	B
		.787 *1	1.574 *2	Mono Block	R	GYSRUS10B00-F20	●	B
				Mono Block	L	GYSLUS10B00-F20	●	B

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
 *4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page F188.

SPARE PARTS

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

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

Select an Insert

Seat Size	Insert Number
C	GY001150C0000-Breaker
D	GY00200/0224D0000-Breaker
E	GY00239/0250/0274E0000-Breaker
F	GY00300/0318/0324F0000-Breaker

For Grooving/Cutting off > F013, F014

Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
C	.059", 1.50mm		●	●		
D	.079", 2.00mm	●	●	●	●	●
E	.094", 2.39mm	●	●	●	●	●
	.098", 2.50mm	●	●	●	●	●
F	.118", 3.00mm	●	●	●	●	●
	.125", 3.18mm	●	●	●	●	●

For Multifunctional Grooving > F015, F016

Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●			
	.094", 2.39mm	●			
E	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			
F	.118", 3.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24mm	●			

● : Gauge insert shown dimensions

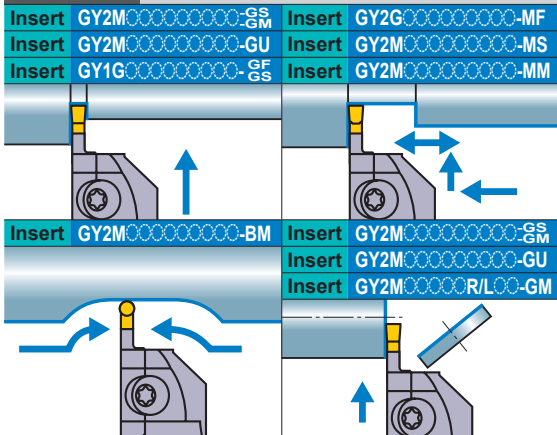
IDENTIFICATION > F010, F011

CUTTING CONDITIONS > F186

INSTRUCTION MANUAL > F191

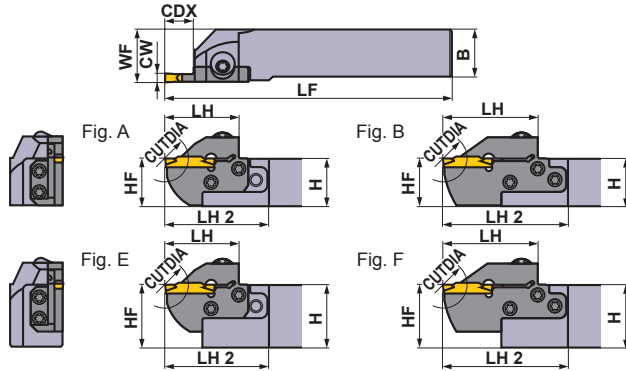
GY SERIES (EXTERNAL GROOVING)

1-1 00° type holder (Inch)



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

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



Right hand tool holder shown.

GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	.079 .088	.236	.472	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-D06	●	C
				L	GYHLUS10B00-M20L	●	GYM20LA-D06	●	C	
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-D06	●	A
				L	GYHLUS12C00-M20L	●	GYM20LA-D06	●	A	
				Modular	R	GYHRUS12C00-M25R	●	GYM25RA-D06	●	C
				L	GYHLUS12C00-M25L	●	GYM25LA-D06	●	C	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-D06	●	A
				L	GYHLUS16D00-M25L	●	GYM25LA-D06	●	A	
				Mono Block	R	GYQRUS16D00-D06	●	—	—	G
				L	GYQLUS16D00-D06	●	—	—	G	
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-D06	●	E
				L	GYHLUS20D00-M25L	●	GYM25LA-D06	●	E	
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-D06	●	E		
		L	GYHLUS24E00-M25L	●	GYM25LA-D06	●	E			
		.394	.787	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-D10	●	C
				L	GYHLUS10B00-M20L	●	GYM20LA-D10	●	C	
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-D10	●	A
				L	GYHLUS12C00-M20L	●	GYM20LA-D10	●	A	
		.472	.945	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-D12	●	C
				L	GYHLUS12C00-M25L	●	GYM25LA-D12	●	C	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-D12	●	A
				L	GYHLUS16D00-M25L	●	GYM25LA-D12	●	A	
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-D12	●	E
				L	GYHLUS20D00-M25L	●	GYM25LA-D12	●	E	
Modular	R			GYHRUS24E00-M25R	●	GYM25RA-D12	●	E		
L	GYHLUS24E00-M25L			●	GYM25LA-D12	●	E			
.709 ^{*4}	1.417	Modular	R	GYHRUS10B00-M20R	●	GYM20RB-D18	●	D		
		L	GYHLUS10B00-M20L	●	GYM20LB-D18	●	D			
		Modular	R	GYHRUS12C00-M20R	●	GYM20RB-D18	●	B		
		L	GYHLUS12C00-M20L	●	GYM20LB-D18	●	B			
.787 ^{*1}	1.575 ^{*2}	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-D20	●	D		
		L	GYHLUS12C00-M25L	●	GYM25LA-D20	●	D			
		Mono Block	R	GYQRUS16D00-D20	●	—	—	G		
		L	GYQLUS16D00-D20	●	—	—	G			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RA-D20	●	B		
		L	GYHLUS16D00-M25L	●	GYM25LA-D20	●	B			
		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-D20	●	F		
		L	GYHLUS20D00-M25L	●	GYM25LA-D20	●	F			
Modular	R	GYHRUS24E00-M25R	●	GYM25RA-D20	●	F				
	L	GYHLUS24E00-M25L	●	GYM25LA-D20	●	F				

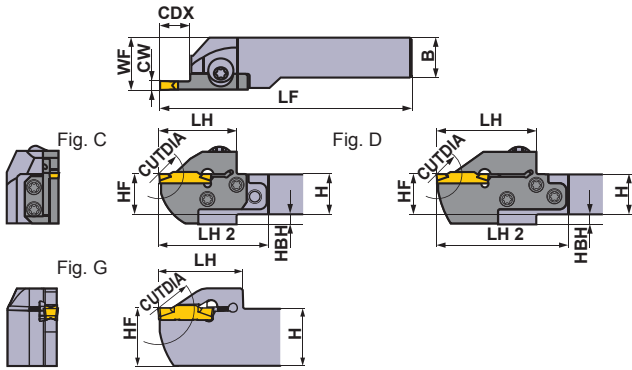
*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

*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 F013 to F016.

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

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page F189.

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



Right hand tool holder shown.

SPARE PARTS

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

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

Select an Insert

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

For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
	CW	Neutral	Neutral	Neutral	Hand	Neutral
D	.079", 2.00mm	●	●	●	●	●

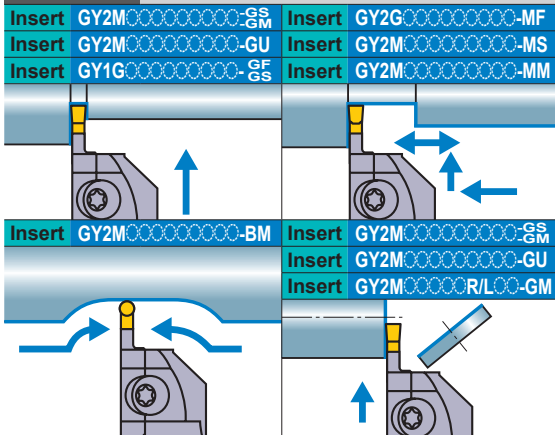
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW	Ball nose			
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●			

● : Gauge insert shown dimensions

GROOVING

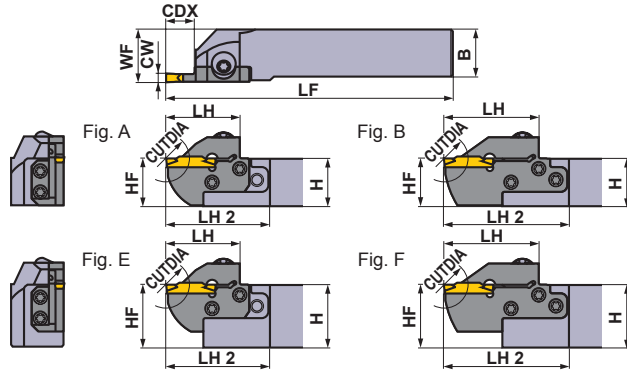
GY SERIES (EXTERNAL GROOVING)

1-1 00° type holder (Inch)



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

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



Right hand tool holder shown.

GROOVING

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

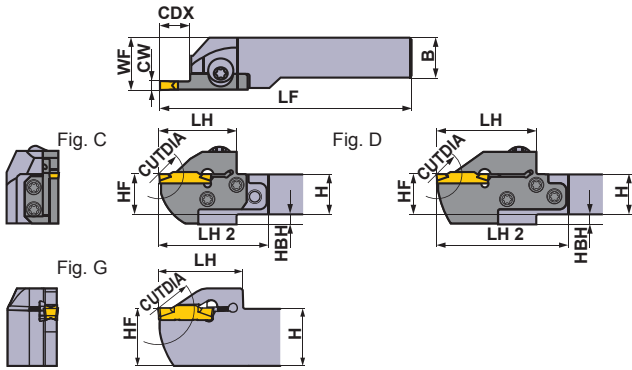
*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

*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 F013 to F016.

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

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page F189.

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



Right hand tool holder shown.

SPARE PARTS

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

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

Select an Insert

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

For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
E	.094", 2.39mm	●	●	●	●	●
	.098", 2.50mm	●	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			

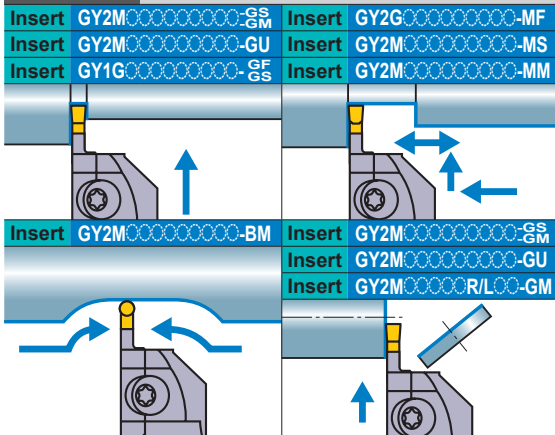
● : Gauge insert shown dimensions

GROOVING

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

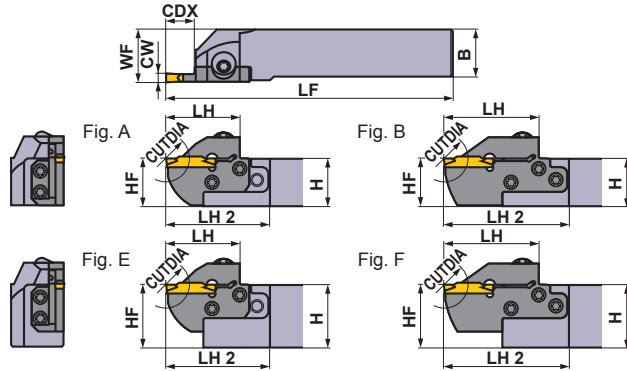
GY SERIES (EXTERNAL GROOVING)

1-1 00° type holder (Inch)



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

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



Right hand tool holder shown.

GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	.236	.472	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-F06	●	C
				L	GYHLUS10B00-M20L	●	GYM20LA-F06	●	C	
				Modular	R	GYHRUS12C00-M20R	●	GYM20RA-F06	●	A
				L	GYHLUS12C00-M20L	●	GYM20LA-F06	●	A	
				Modular	R	GYHRUS12C00-M25R	●	GYM25RA-F06	●	C
				L	GYHLUS12C00-M25L	●	GYM25LA-F06	●	C	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-F06	●	A
		L	GYHLUS16D00-M25L	●	GYM25LA-F06	●	A			
		Mono Block	R	GYQRUS16D00-F06	●	—	—	G		
		L	GYQLUS16D00-F06	●	—	—	G			
		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-F06	●	E		
		L	GYHLUS20D00-M25L	●	GYM25LA-F06	●	E			
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-F06	●	E		
		L	GYHLUS24E00-M25L	●	GYM25LA-F06	●	E			
	.394	.472	.787	Modular	R	GYHRUS10B00-M20R	●	GYM20RA-F10	●	C
				L	GYHLUS10B00-M20L	●	GYM20LA-F10	●	C	
		Modular	R	GYHRUS12C00-M20R	●	GYM20RA-F10	●	A		
		L	GYHLUS12C00-M20L	●	GYM20LA-F10	●	A			
		Modular	R	GYHRUS12C00-M25R	●	GYM25RA-F12	●	C		
		L	GYHLUS12C00-M25L	●	GYM25LA-F12	●	C			
	.709 ^{*4}	.472	.945	Modular	R	GYHRUS10B00-M20R	●	GYM25RA-F12	●	A
				L	GYHLUS10B00-M20L	●	GYM25LA-F12	●	A	
				Modular	R	GYHRUS20D00-M25R	●	GYM25RA-F12	●	E
				L	GYHLUS20D00-M25L	●	GYM25LA-F12	●	E	
Modular		R	GYHRUS24E00-M25R	●	GYM25RA-F12	●	E			
L		GYHLUS24E00-M25L	●	GYM25LA-F12	●	E				
.787 ^{*1}		1.417	1.575 ^{*2}	Modular	R	GYHRUS10B00-M20R	●	GYM20RB-F18	●	D
				L	GYHLUS10B00-M20L	●	GYM20LB-F18	●	D	
	Modular		R	GYHRUS12C00-M20R	●	GYM20RB-F18	●	B		
	L		GYHLUS12C00-M20L	●	GYM20LB-F18	●	B			
.787 ^{*1}	1.417	1.575 ^{*2}	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-F20	●	D	
			L	GYHLUS12C00-M25L	●	GYM25LA-F20	●	D		
			Mono Block	R	GYQRUS16D00-F20	●	—	—	G	
			L	GYQLUS16D00-F20	●	—	—	G		
	Modular	R	GYHRUS16D00-M25R	●	GYM25RA-F20	●	B			
	L	GYHLUS16D00-M25L	●	GYM25LA-F20	●	B				
	Modular	R	GYHRUS20D00-M25R	●	GYM25RA-F20	●	F			
	L	GYHLUS20D00-M25L	●	GYM25LA-F20	●	F				
.787 ^{*1}	1.417	1.575 ^{*2}	Modular	R	GYHRUS24E00-M25R	●	GYM25RA-F20	●	F	
			L	GYHLUS24E00-M25L	●	GYM25LA-F20	●	F		

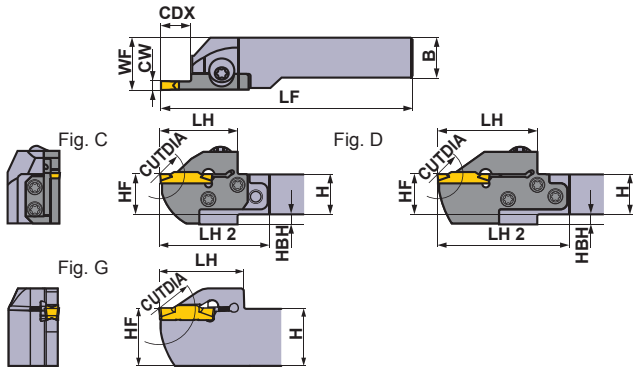
*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

*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 F013 to F016.

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

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page F189.

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



Right hand tool holder shown.

SPARE PARTS

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

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

Select an Insert

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

For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
F	.118", 3.00mm	●	●	●	●	●
	.125", 3.18mm	●	●	●	●	●

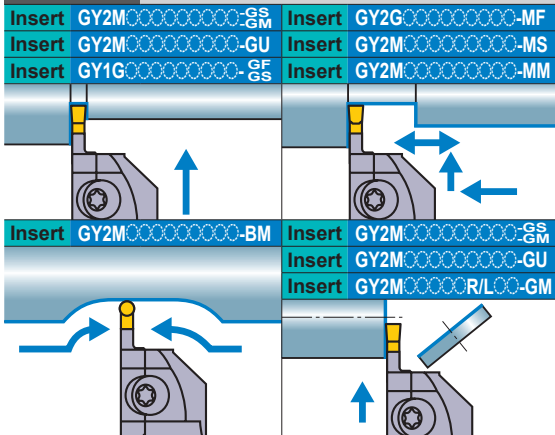
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
F	.118", 3.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24mm	●			

● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

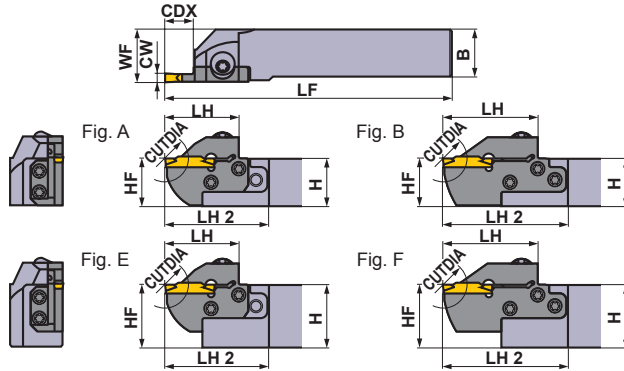
GY SERIES (EXTERNAL GROOVING)

1-1 00° type holder (Inch)



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

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



Right hand tool holder shown.

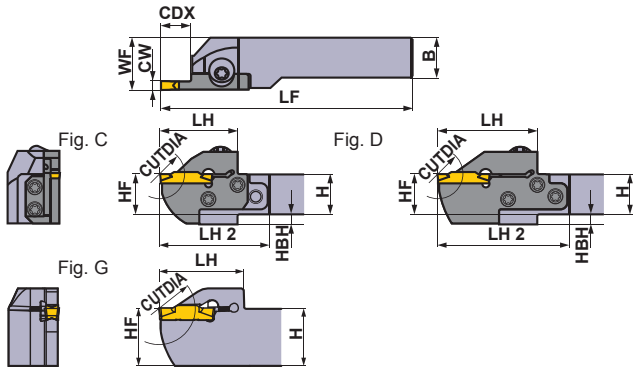
Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
G	.157 .167	.315	.630	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-G08	●	C
				Modular	L	GYHLUS12C00-M25L	●	GYM25LA-G08	●	C
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-G08	●	A
				Modular	L	GYHLUS16D00-M25L	●	GYM25LA-G08	●	A
				Mono Block	R	GYQRUS16D00-G08	●	—	—	G
				Mono Block	L	GYQLUS16D00-G08	●	—	—	G
		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-G08	●	E		
		Modular	L	GYHLUS20D00-M25L	●	GYM25LA-G08	●	E		
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-G08	●	E		
		Modular	L	GYHLUS24E00-M25L	●	GYM25LA-G08	●	E		
		Modular	R	GYHRUS10B00-M20R	●	GYM20RA-G12	●	C		
		Modular	L	GYHLUS10B00-M20L	●	GYM20LA-G12	●	C		
	Modular	R	GYHRUS12C00-M20R	●	GYM20RA-G12	●	A			
	Modular	L	GYHLUS12C00-M20L	●	GYM20LA-G12	●	A			
	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-G14	●	C			
	Modular	L	GYHLUS12C00-M25L	●	GYM25LA-G14	●	C			
	Modular	R	GYHRUS16D00-M25R	●	GYM25RA-G14	●	A			
	Modular	L	GYHLUS16D00-M25L	●	GYM25LA-G14	●	A			
	Modular	R	GYHRUS20D00-M25R	●	GYM25RA-G14	●	E			
	Modular	L	GYHLUS20D00-M25L	●	GYM25LA-G14	●	E			
	Modular	R	GYHRUS24E00-M25R	●	GYM25RA-G14	●	E			
	Modular	L	GYHLUS24E00-M25L	●	GYM25LA-G14	●	E			
	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-G25	●	D			
	Modular	L	GYHLUS12C00-M25L	●	GYM25LA-G25	●	D			
Mono Block	R	GYQRUS16D00-G25	●	—	—	G				
Mono Block	L	GYQLUS16D00-G25	●	—	—	G				
Modular	R	GYHRUS16D00-M25R	●	GYM25RA-G25	●	B				
Modular	L	GYHLUS16D00-M25L	●	GYM25LA-G25	●	B				
Modular	R	GYHRUS20D00-M25R	●	GYM25RA-G25	●	F				
Modular	L	GYHLUS20D00-M25L	●	GYM25LA-G25	●	F				
Modular	R	GYHRUS24E00-M25R	●	GYM25RA-G25	●	F				
Modular	L	GYHLUS24E00-M25L	●	GYM25LA-G25	●	F				

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

*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 F013 to F016.

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

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



Right hand tool holder shown.

SPARE PARTS

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

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

Select an Insert

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

For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
G	.157", 4.00mm	●	●	●	●	●

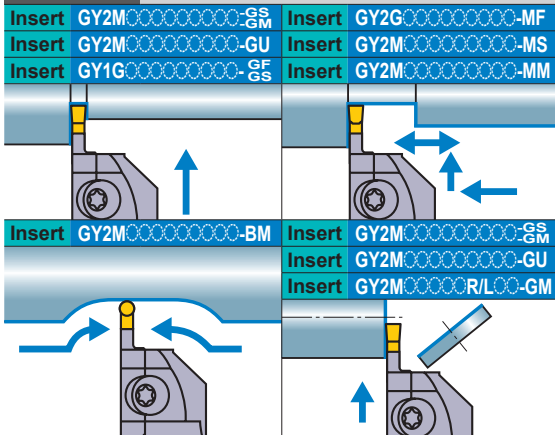
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
G	.157", 4.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●		●	
G	.167", 4.24mm	●			

● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

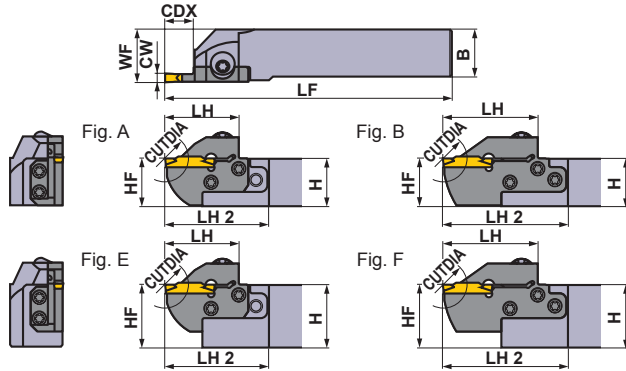
GY SERIES (EXTERNAL GROOVING)

1-1 00° type holder (Inch)



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

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



Right hand tool holder shown.

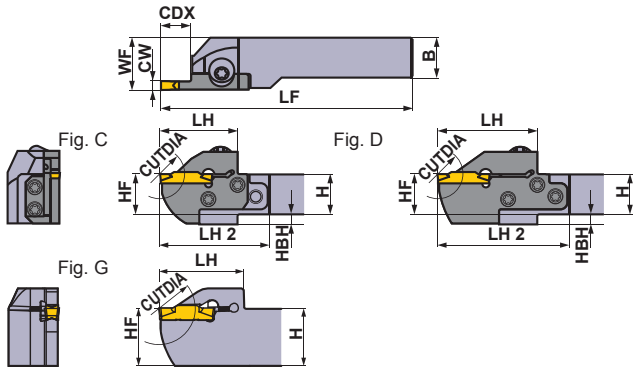
Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	.315	.630	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-H08	●	C
				L	GYHLUS12C00-M25L	●	GYM25LA-H08	●	C	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RA-H08	●	A
				L	GYHLUS16D00-M25L	●	GYM25LA-H08	●	A	
				Mono Block	R	GYQRUS16D00-H08	●	—	—	G
				L	GYQLUS16D00-H08	●	—	—	G	
		Modular	R	GYHRUS20D00-M25R	●	GYM25RA-H08	●	E		
		L	GYHLUS20D00-M25L	●	GYM25LA-H08	●	E			
		Modular	R	GYHRUS24E00-M25R	●	GYM25RA-H08	●	E		
		L	GYHLUS24E00-M25L	●	GYM25LA-H08	●	E			
		Modular	R	GYHRUS10B00-M20R	●	GYM20RA-H12	●	C		
		L	GYHLUS10B00-M20L	●	GYM20LA-H12	●	C			
	Modular	R	GYHRUS12C00-M20R	●	GYM20RA-H12	●	A			
	L	GYHLUS12C00-M20L	●	GYM20LA-H12	●	A				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-H14	●	C			
	L	GYHLUS12C00-M25L	●	GYM25LA-H14	●	C				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RA-H14	●	A			
	L	GYHLUS16D00-M25L	●	GYM25LA-H14	●	A				
	Modular	R	GYHRUS20D00-M25R	●	GYM25RA-H14	●	E			
	L	GYHLUS20D00-M25L	●	GYM25LA-H14	●	E				
	Modular	R	GYHRUS24E00-M25R	●	GYM25RA-H14	●	E			
	L	GYHLUS24E00-M25L	●	GYM25LA-H14	●	E				
	Modular	R	GYHRUS12C00-M25R	●	GYM25RA-H25	●	D			
	L	GYHLUS12C00-M25L	●	GYM25LA-H25	●	D				
Mono Block	R	GYQRUS16D00-H25	●	—	—	G				
L	GYQLUS16D00-H25	●	—	—	G					
Modular	R	GYHRUS16D00-M25R	●	GYM25RA-H25	●	B				
L	GYHLUS16D00-M25L	●	GYM25LA-H25	●	B					
Modular	R	GYHRUS20D00-M25R	●	GYM25RA-H25	●	F				
L	GYHLUS20D00-M25L	●	GYM25LA-H25	●	F					
Modular	R	GYHRUS24E00-M25R	●	GYM25RA-H25	●	F				
L	GYHLUS24E00-M25L	●	GYM25LA-H25	●	F					

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

*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 F013 to F016.

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

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



Right hand tool holder shown.

SPARE PARTS

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

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

Select an Insert

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

For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
H	.187", 4.75mm	●	●	●	●	●
	.197", 5.00mm	●	●	●	●	●

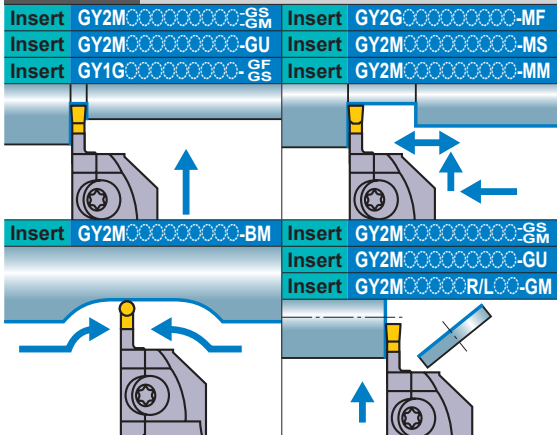
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
H	.187", 4.75mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
H	.197", 5.00mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24mm	●			

● : Gauge insert shown dimensions

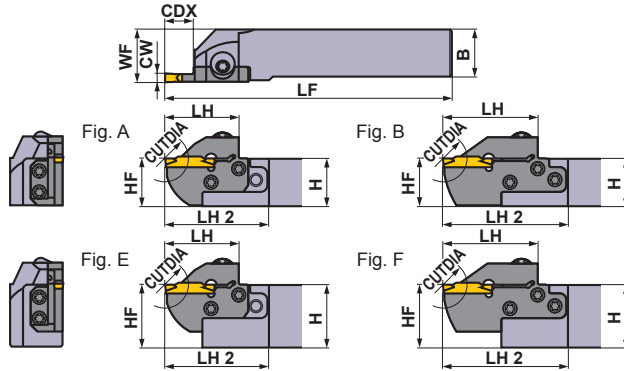
IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING)

1-1 00° type holder (Inch)



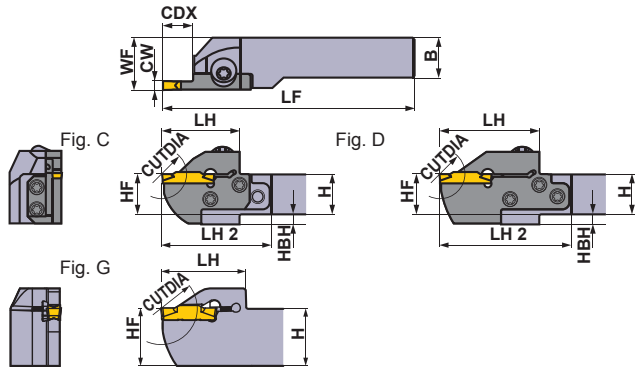
(Note 1) For modular blades and holders, please order separately.
 (Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

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

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.



Right hand tool holder shown.

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

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

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

Select an Insert

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

For Grooving/Cutting off > F013						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
J	236", 6.00mm	●	●	●		
	250", 6.35mm	●	●	●		

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
J	236", 6.00mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	248", 6.31mm	●			
	250", 6.35mm				●
J	RE .008"	●			
	RE .016"	●			
	RE .031"	●			

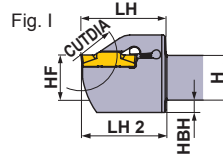
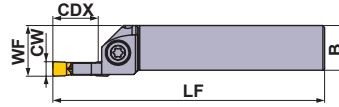
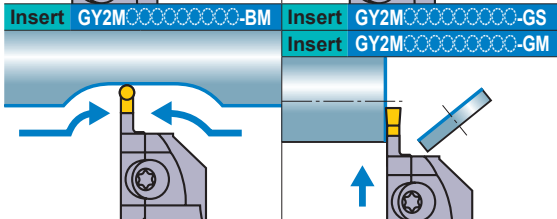
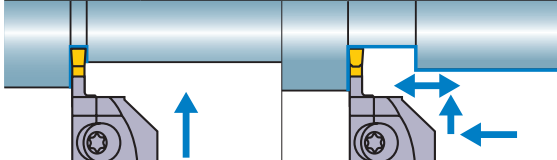
● : Gauge insert shown dimensions

GROOVING

GY SERIES (EXTERNAL GROOVING)

1-1 00° type holder (Inch)

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

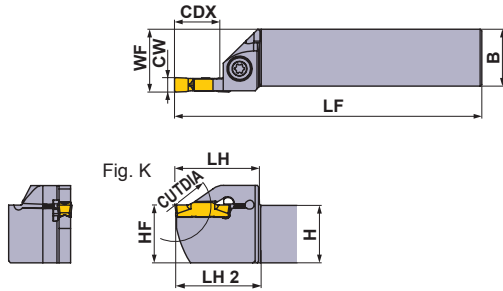


Right hand tool holder shown.

GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
K	.315	*1 .984	*2 1.968	Mono Block	R	GYPRUS16D00-K25	●	—	—	I
				Mono Block	L	GYP LUS16D00-K25	●	—	—	I
				Mono Block	R	GYPRUS20D00-K25	●	—	—	K
				Mono Block	L	GYP LUS20D00-K25	●	—	—	K

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.



Right hand tool holder shown.

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

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

Select an Insert

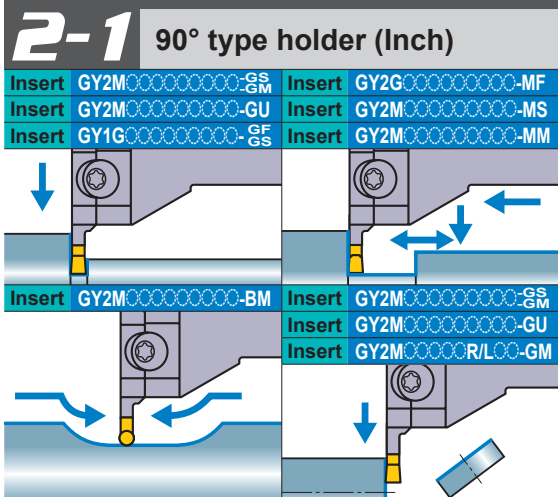
Seat Size	Insert Number
K	GY○○0800K○○○○-Breaker

For Grooving/Cutting off > F013						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
	CW	Neutral	Neutral	Neutral	Hand	Neutral
K	.315", 8.00mm		●	●		

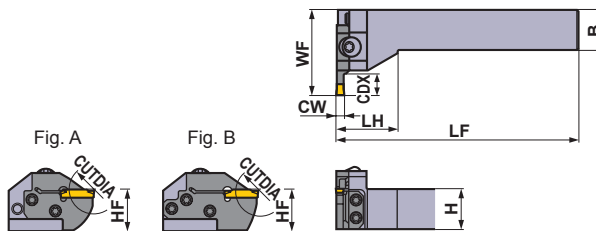
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				
K	.315", 8.00mm RE .031" RE .047"		●	●	●

● : Gauge insert shown dimensions

GY SERIES (EXTERNAL GROOVING)



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






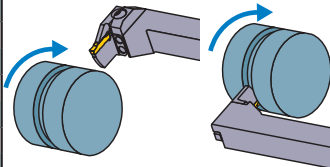
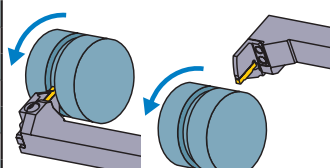
Right hand tool holder shown.

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

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

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

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

Select an Insert

Seat Size	Insert Number
D	GY000200/0224D000000-Breaker
E	GY000239/0250/0274E000000-Breaker

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
D	.079", 2.00mm	●	●	●	●	●
E	.094", 2.39mm	●	●	●	●	●
	.098", 2.50mm	●	●	●	●	●

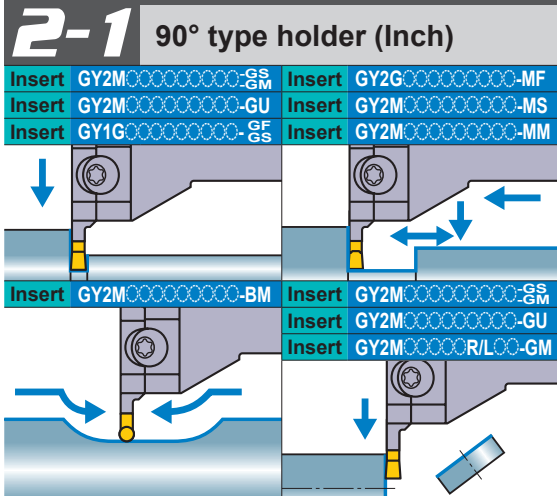
		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●			
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			

● : Gauge insert shown dimensions

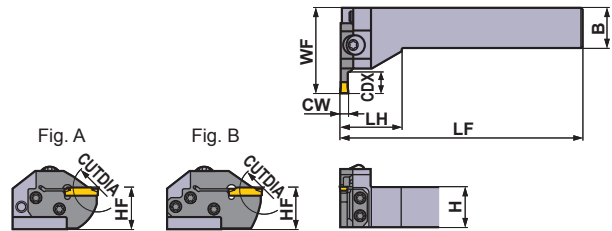
GROOVING

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING)



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






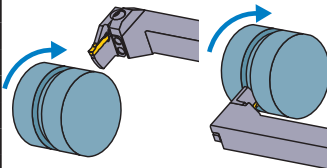
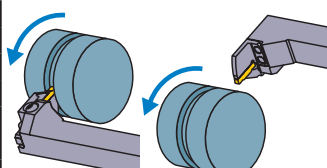
Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	.236	.472	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-F06	●	A
					L	GYHLUS12C90-M20R	●	GYM20RA-F06	●	A
				Modular	R	GYHRUS16D90-M25L	●	GYM25LA-F06	●	A
					L	GYHLUS16D90-M25R	●	GYM25RA-F06	●	A
		.394	.787	Modular	R	GYHRUS12C90-M20L	●	GYM20LA-F10	●	A
					L	GYHLUS12C90-M20R	●	GYM20RA-F10	●	A
				Modular	R	GYHRUS16D90-M25L	●	GYM25LA-F12	●	A
					L	GYHLUS16D90-M25R	●	GYM25RA-F12	●	A
.709 *4	1.417	Modular	R	GYHRUS12C90-M20L	●	GYM20LB-F18	●	B		
			L	GYHLUS12C90-M20R	●	GYM20RB-F18	●	B		
		Modular	R	GYHRUS16D90-M25L	●	GYM25LA-F20	●	B		
			L	GYHLUS16D90-M25R	●	GYM25RA-F20	●	B		
G	.157 .167	.315	.630	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-G08	●	A
					L	GYHLUS16D90-M25R	●	GYM25RA-G08	●	A
				Modular	R	GYHRUS12C90-M20L	●	GYM20LA-G12	●	A
					L	GYHLUS12C90-M20R	●	GYM20RA-G12	●	A
		.551	1.102	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-G14	●	A
					L	GYHLUS16D90-M25R	●	GYM25RA-G14	●	A
				Modular	R	GYHRUS16D90-M25L	●	GYM25LA-G25	●	B
					L	GYHLUS16D90-M25R	●	GYM25RA-G25	●	B
.984 *1	1.969 *2	Modular	R	GYHRUS16D90-M25L	●	GYM25LA-G25	●	B		
			L	GYHLUS16D90-M25R	●	GYM25RA-G25	●	B		

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

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

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

Select an Insert

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

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
F	.118", 3.00mm	●	●	●	●	●
	.125", 3.18mm	●	●	●	●	●
G	.157", 4.00mm	●	●	●	●	●

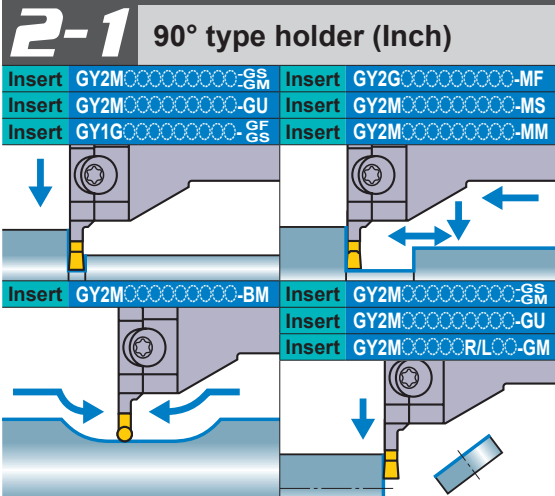
		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
F	.118", 3.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18mm				●
	RE .008"	●			
G	RE .016"	●			
	.128", 3.24mm	●			
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●		●	
	.157", 4.24mm	●			●

● : Gauge insert shown dimensions

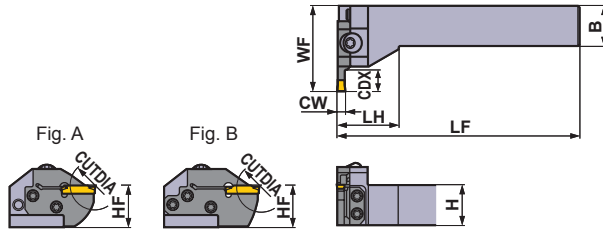
IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GROOVING

GY SERIES (EXTERNAL GROOVING)



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






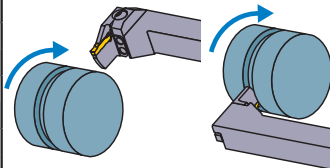
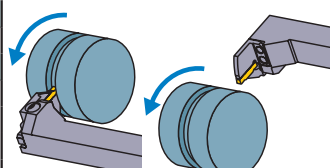
Right hand tool holder shown.

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

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and WF values may vary.

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

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

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

Select an Insert

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

For Grooving/Cutting off > F013, F014

Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
H	.187", 4.75mm	●	●	●		●
	.197", 5.00mm	●	●	●	●	●
J	.236", 6.00mm	●	●	●		
	.250", 6.35mm	●	●	●		

For Multifunctional Grooving > F015, F016

Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
H	.187", 4.75mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00mm				●
J	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.206", 5.24mm	●			
	.236", 6.00mm				●
J	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.248", 6.31mm	●			
	.250", 6.35mm				●
J	RE .008"	●			
	RE .016"	●			
	RE .031"	●			

● : Gauge insert shown dimensions

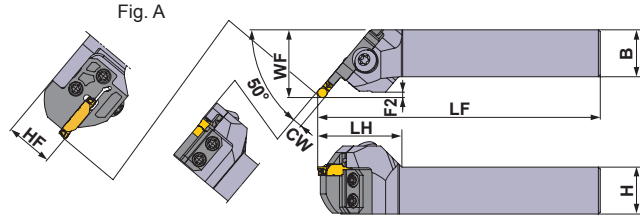
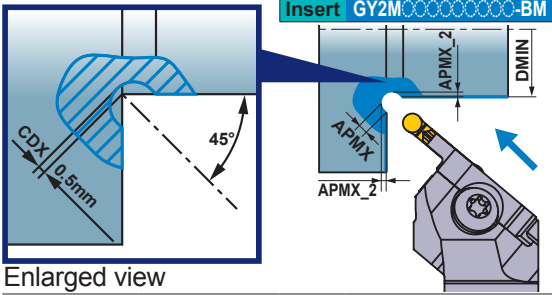
IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GROOVING

GY SERIES (EXTERNAL RECESSING)

3-1 50° type holder (Inch)

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






Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	DMIN (inch)	APMX (inch)	APMX_2 (inch)	Type	Hand (R/L)	Order Number				Fig.	
								Holder	Stock	Modular Blade	Stock		
D	.079	.020	1.181	.059	.025	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-D005	●	A	
	L						GYHLUS12C50-M20R	●	GYM20RC-D005	●	A		
Modular	R					GYHRUS16D50-M25L	●	GYM25LC-D005	●	A			
	L					GYHLUS16D50-M25R	●	GYM25RC-D005	●	A			
E	.094			.098	.069	.028	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-E005	●	A
	L							GYHLUS12C50-M20R	●	GYM20RC-E005	●	A	
Modular	.108			R	GYHRUS16D50-M25L	●	GYM25LC-E005	●	A				
				L	GYHLUS16D50-M25R	●	GYM25RC-E005	●	A				
F	.118			.125	.082	.032	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-F005	●	A
	L							GYHLUS12C50-M20R	●	GYM20RC-F005	●	A	
Modular	.128			R	GYHRUS16D50-M25L	●	GYM25LC-F005	●	A				
				L	GYHLUS16D50-M25R	●	GYM25RC-F005	●	A				
G	.157	.167	.098	.037	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-G005	●	A		
	L					GYHLUS12C50-M20R	●	GYM20RC-G005	●	A			
Modular		R			GYHRUS16D50-M25L	●	GYM25LC-G005	●	A				
		L			GYHLUS16D50-M25R	●	GYM25RC-G005	●	A				
H	.187	.197	.787	.113	Modular	R	GYHRUS12C50-M20L	●	GYM20LC-H005	●	A		
	L					GYHLUS12C50-M20R	●	GYM20RC-H005	●	A			
Modular	.206	R			GYHRUS16D50-M25L	●	GYM25LC-H005	●	A				
		L			GYHLUS16D50-M25R	●	GYM25RC-H005	●	A				
J	.236	.248	.144	.051	Modular	R	GYHRUS16D50-M25L	●	GYM25LC-J005	●	A		
	L					GYHLUS16D50-M25R	●	GYM25RC-J005	●	A			
	.250												

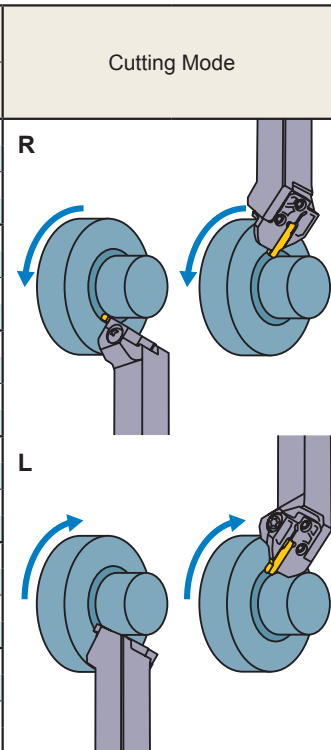
*1 Blades for external and face grooving cannot be used since it interferes with work materials.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, WF and F2 values may vary.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHR/LUS12C50-M20R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY25D
GYHR/LUS16D50-M25R/L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) *2						
	H	B	LF	LH	HF	WF	F2
	.750	.750	5.007	1.632	.750	1.232	.076
	.750	.750	5.007	1.632	.750	1.232	.076
	1.000	1.000	6.007	1.819	1.000	1.357	.076
	1.000	1.000	6.007	1.819	1.000	1.357	.076
	.750	.750	5.003	1.628	.750	1.241	.084
	.750	.750	5.003	1.628	.750	1.241	.084
	1.000	1.000	6.003	1.815	1.000	1.366	.084
	1.000	1.000	6.003	1.815	1.000	1.366	.084
	.750	.750	5.000	1.625	.750	1.250	.094
	.750	.750	5.000	1.625	.750	1.250	.094
	1.000	1.000	6.000	1.813	1.000	1.375	.094
	1.000	1.000	6.000	1.813	1.000	1.375	.094
	.750	.750	4.989	1.614	.750	1.265	.109
	.750	.750	4.989	1.614	.750	1.265	.109
	1.000	1.000	5.989	1.802	1.000	1.390	.109
	1.000	1.000	5.989	1.802	1.000	1.390	.109
	.750	.750	4.980	1.605	.750	1.281	.125
	.750	.750	4.980	1.605	.750	1.281	.125
	1.000	1.000	5.980	1.792	1.000	1.406	.125
	1.000	1.000	5.980	1.792	1.000	1.406	.125
	1.000	1.000	5.978	1.791	1.000	1.429	.148
	1.000	1.000	5.978	1.791	1.000	1.429	.148



Select an Insert

Insert Number
GY2M○○○○○○○○○N-BM

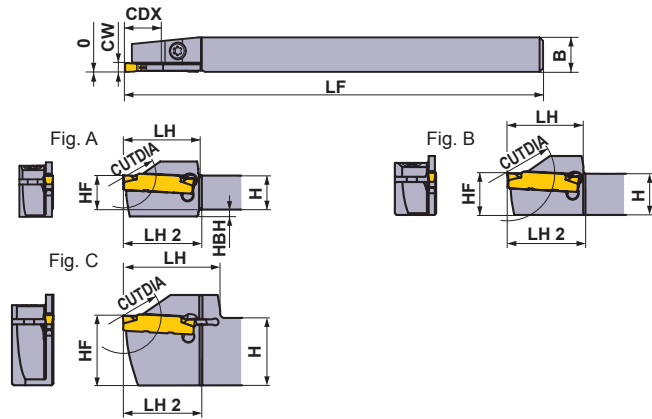
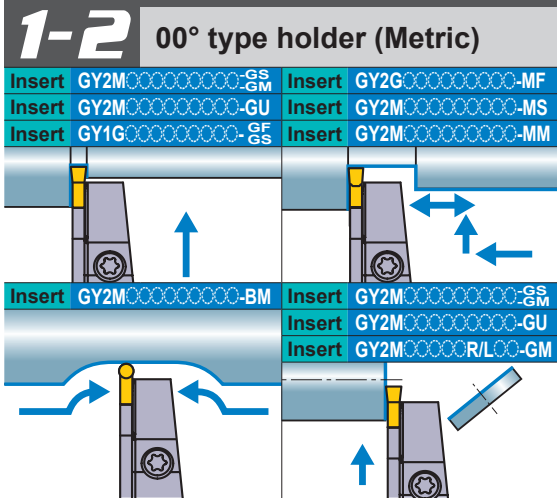
For Multifunctional Grooving > F016		
Seat Size	Breaker	BM
	CW	Ball nose
D	.079", 2.00mm	●
E	.098", 2.50mm	●
F	.118", 3.00mm	●
	.125", 3.18mm	●
G	.157", 4.00mm	●
H	.187", 4.75mm	●
	.197", 5.00mm	●
J	.236", 6.00mm	●
	.250", 6.35mm	●

● : Gauge insert shown dimensions

GROOVING

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F190
 INSTRUCTION MANUAL > F190

GY SERIES (EXTERNAL GROOVING for Swiss style lathes)





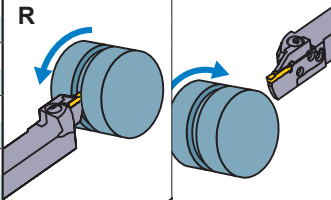
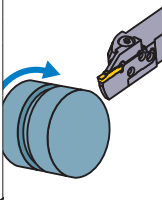
Right hand tool holder shown.

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

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and LH 2 values may vary.
 *4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page F188.

SPARE PARTS

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

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

Select an Insert

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

For Grooving/Cutting off > F013, F014		GU	GS	GM	05-GM	GFGS
Seat Size	Breaker	Neutral	Neutral	Neutral	Hand	Neutral
	CW					
C	.059", 1.50mm		●	●		
D	.079", 2.00mm	●	●	●	●	●
E	.094", 2.39mm	●	●	●		●
	.098", 2.50mm	●	●	●	●	●
F	.118", 3.00mm	●	●	●	●	●
	.125", 3.18mm	●	●	●		●

For Multifunctional Grooving > F015, F016		MF	MS	MM	BM
Seat Size	Breaker				Ball nose
	CW				
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●			
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			
F	.118", 3.00mm				●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm			●	
	.125", 3.18mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	.128", 3.24mm	●			

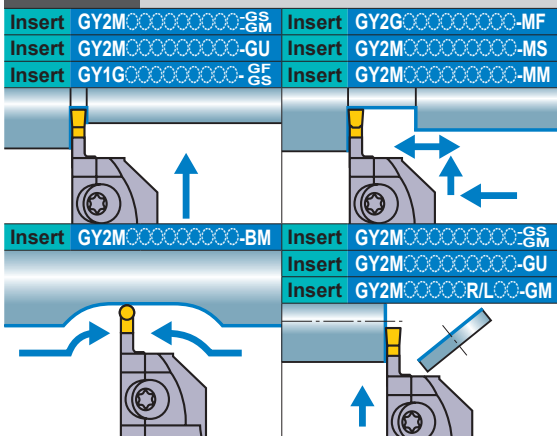
● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING)

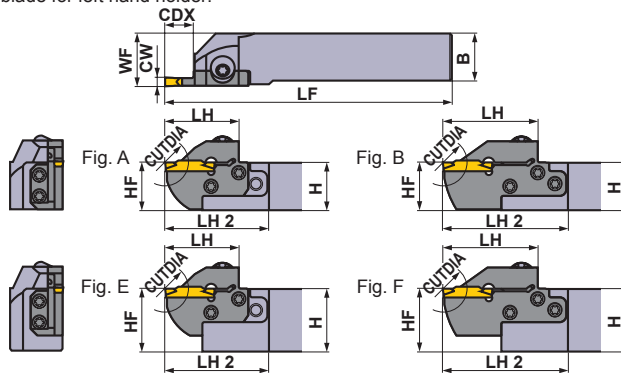
1-2

00° type holder (Metric)



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

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



Right hand tool holder shown.

GROOVING

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

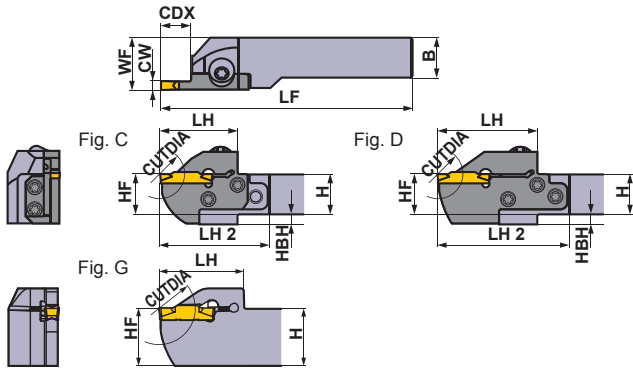
*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

*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 F013 to F016.

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

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page F189.

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



Right hand tool holder shown.

SPARE PARTS

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

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

Select an Insert

Seat Size	Insert Number
D	GY0200/0224D-Breaker

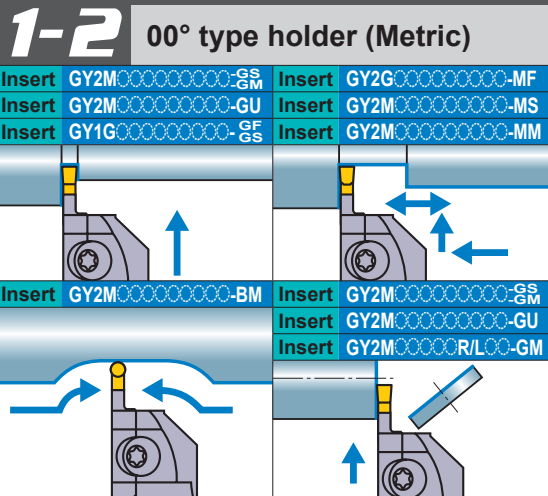
		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
	CW	Neutral	Neutral	Neutral	Hand	Neutral
D	.079", 2.00mm	●	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
	CW				
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●			

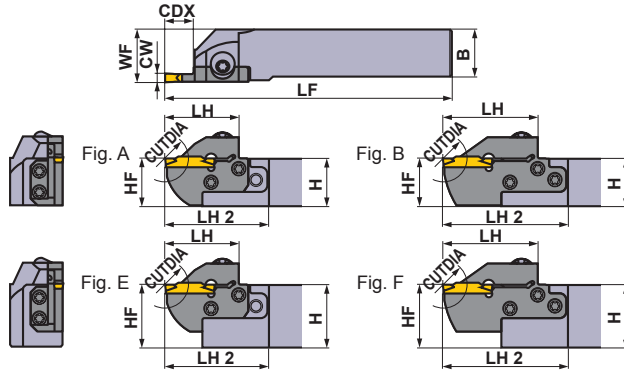
● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING)



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



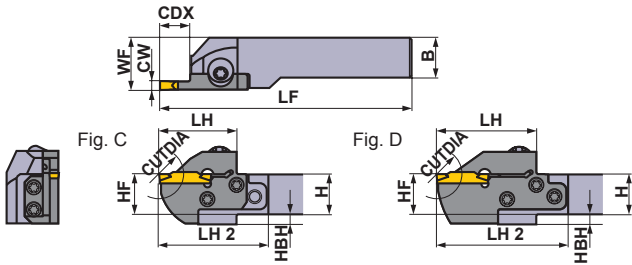
Right hand tool holder shown.

GROOVING

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

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.
 *4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page F189.

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



Right hand tool holder shown.

SPARE PARTS

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

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

Select an Insert

Seat Size	Insert Number
E	GY0239/0250/0274E-Breaker

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
E	.094", 2.39mm	●	●	●	●	●
	.098", 2.50mm	●	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			

● : Gauge insert shown dimensions

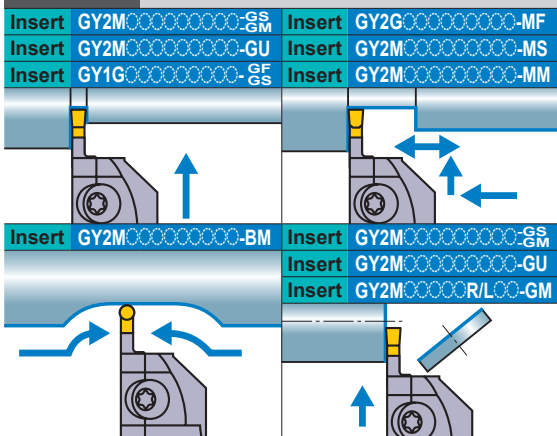
GROOVING

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING)

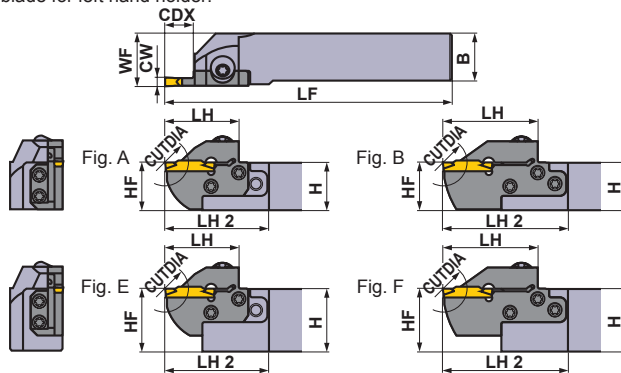
1-2

00° type holder (Metric)



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

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



Right hand tool holder shown.

GROOVING

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

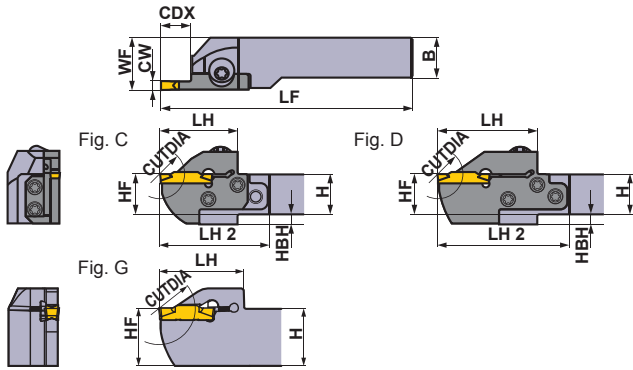
*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

*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 F013 to F016.

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

*4 The maximum groove depth is limited by the workpiece diameter. For details, please refer to page F189.

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



Right hand tool holder shown.

SPARE PARTS

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

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

Select an Insert

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

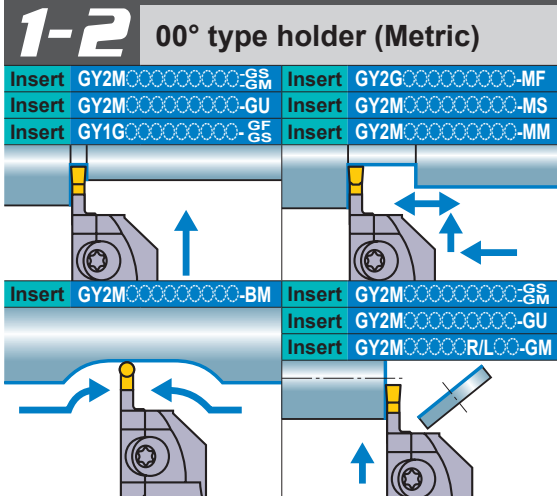
For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
F	.118", 3.00mm	●	●	●	●	●
	.125", 3.18mm	●	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
F	.118", 3.00mm				●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm			●	
	.125", 3.18mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	.128", 3.24mm	●			

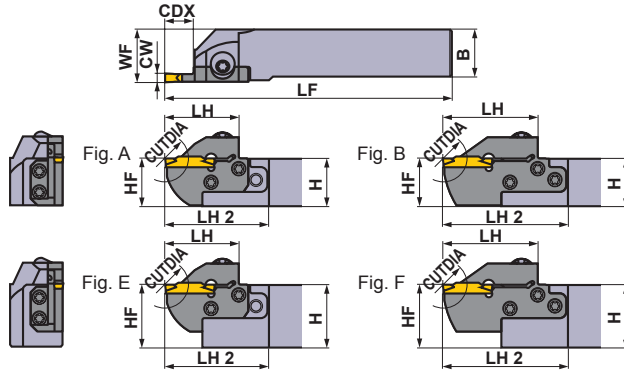
● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING)



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

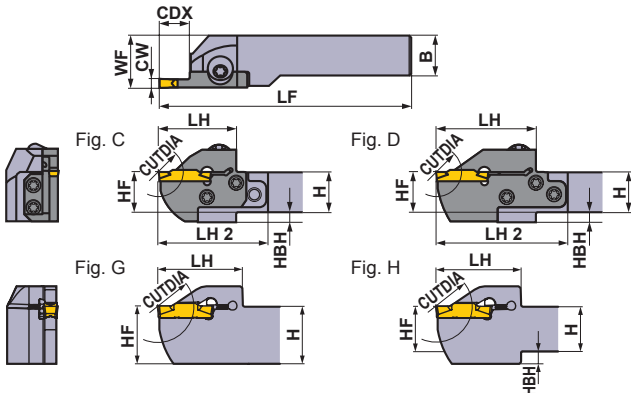


Right hand tool holder shown.

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

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

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



Right hand tool holder shown.

SPARE PARTS

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

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

Select an Insert

Seat Size	Insert Number
G	GY0400/0424G-Breaker

For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		CW	Neutral	Neutral	Neutral	Hand
G	.157", 4.00mm	●	●	●	●	●

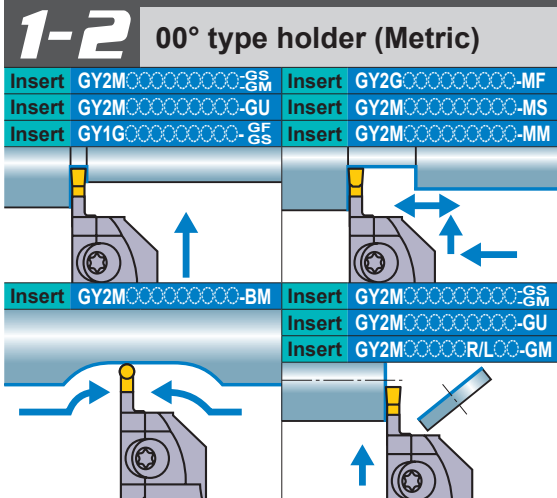
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
		CW			
G	.157", 4.00mm	●	●	●	●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm	●		●	
G	.167", 4.24mm	●			

● : Gauge insert shown dimensions

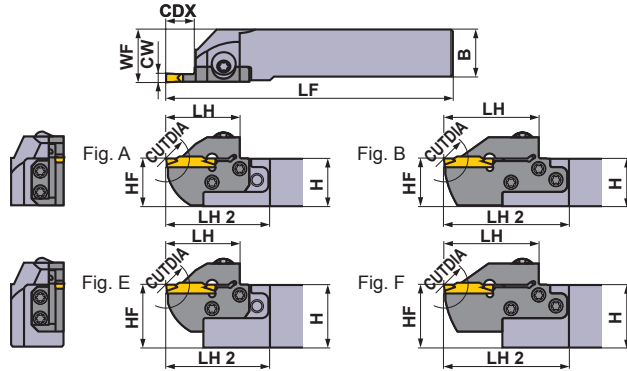
GROOVING

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING)



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

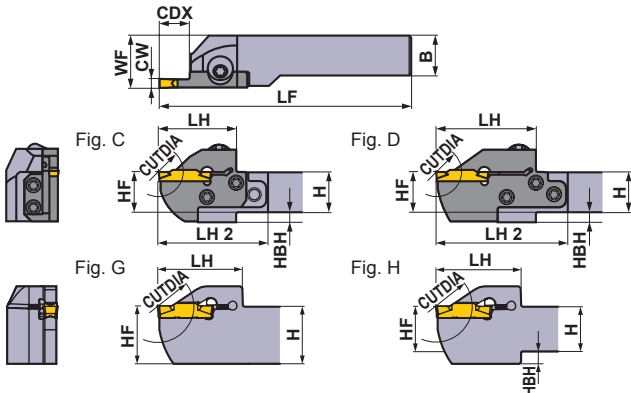


Right hand tool holder shown.

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

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.

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



Right hand tool holder shown.

SPARE PARTS

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

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

Select an Insert

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

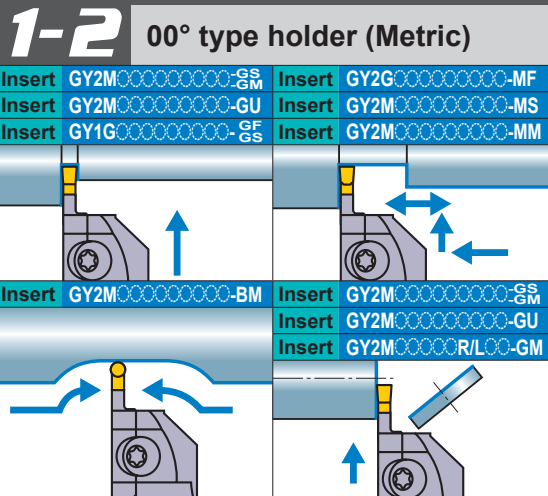
For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
H	.187", 4.75mm	●	●	●	●	●
	.197", 5.00mm	●	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
H	.187", 4.75mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	RE 0.8mm	●			
H	RE 0.2mm	●			●
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	206", 5.24mm	●			

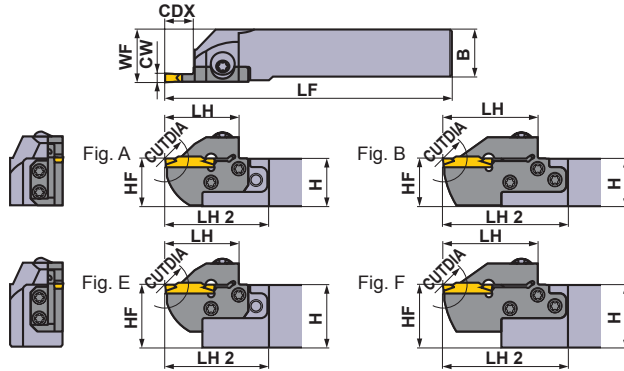
● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING)



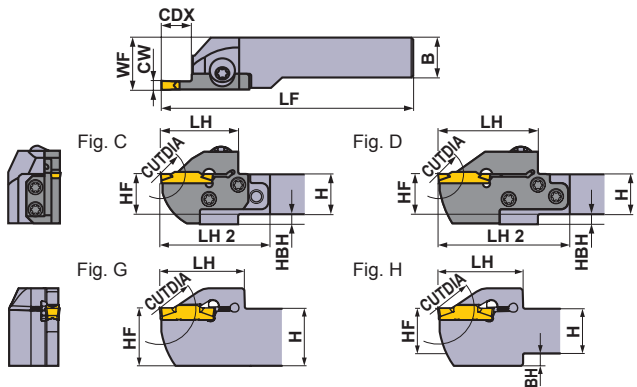
(Note 1) For modular blades and holders, please order separately.
 (Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

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

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.



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

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

Right hand tool holder shown.

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

Select an Insert

Seat Size	Insert Number
J	GY000600/0631/0635J0000-Breaker

For Grooving/Cutting off > F013						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
J	236°, 6.00mm	●	●	●		
	250°, 6.35mm	●	●	●		

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
J	236°, 6.00mm				●
	RE 0.2mm	●			
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	248°, 6.31mm	●			
	250°, 6.35mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	RE 0.8mm	●			

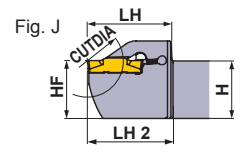
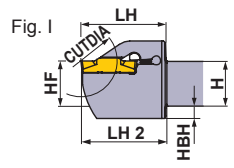
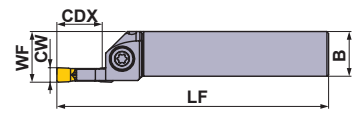
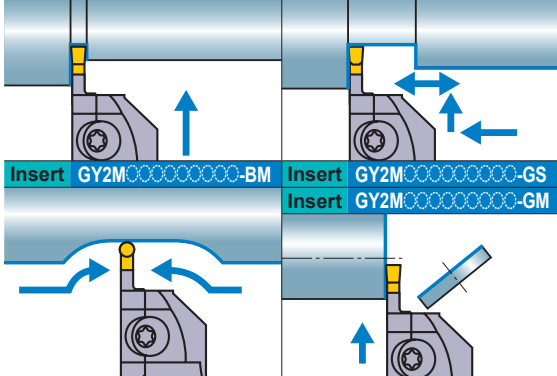
● : Gauge insert shown dimensions

GROOVING

GY SERIES (EXTERNAL GROOVING)

1-2 00° type holder (Metric)

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

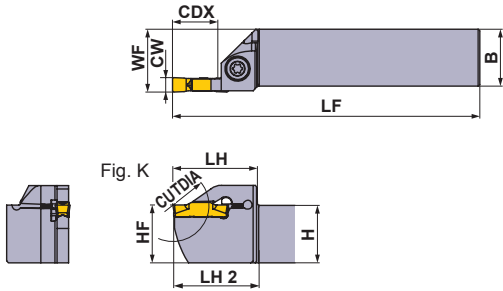


Right hand tool holder shown.

GROOVING

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

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, LH 2 and WF values may vary.



Right hand tool holder shown.

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

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

Select an Insert

Seat Size	Insert Number
K	GY0800K-Breaker

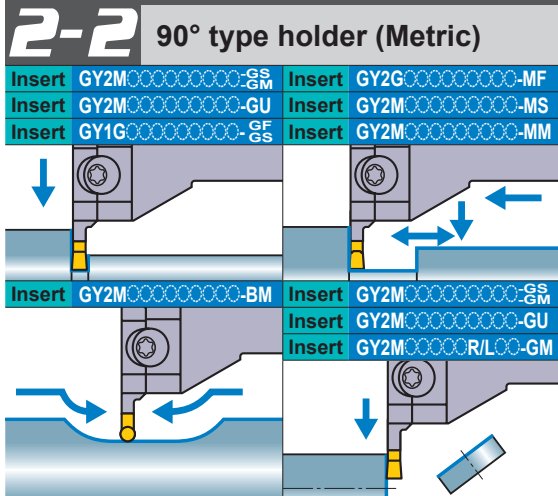
For Grooving/Cutting off > F013						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
	CW	Neutral	Neutral	Neutral	Hand	Neutral
K	.315", 8.00mm		●	●		

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				
K	.315", 8.00mm RE 0.8mm RE 1.2mm		●	●	●

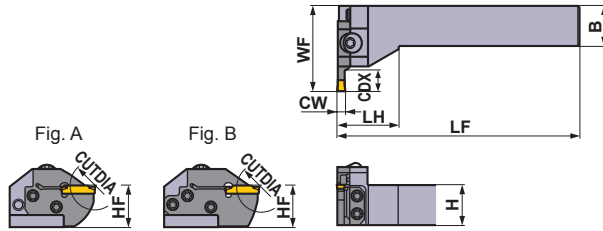
● : Gauge insert shown dimensions

GROOVING

GY SERIES (EXTERNAL GROOVING)



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






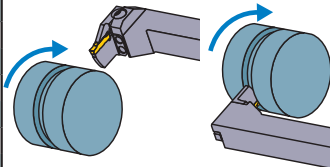
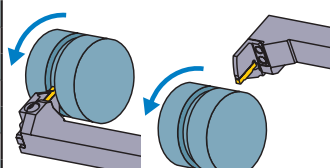
Right hand tool holder shown.

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

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

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

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

Select an Insert

Seat Size	Insert Number
D	GY000200/0224D000000-Breaker
E	GY000239/0250/0274E000000-Breaker

For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
D	.079", 2.00mm	●	●	●	●	●
E	.094", 2.39mm	●	●	●	●	●
	.098", 2.50mm	●	●	●	●	●

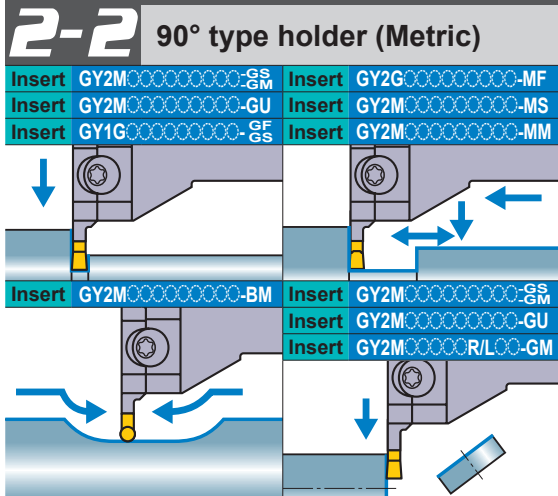
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●			
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			

● : Gauge insert shown dimensions

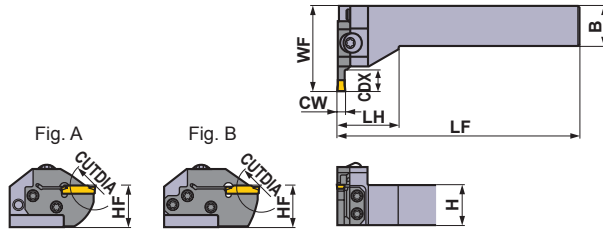
GROOVING

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING)



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






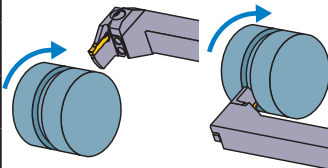
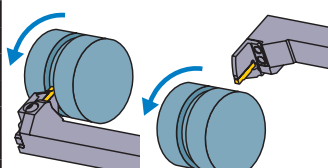
Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	6	12	Modular	R	GYHR2020K90-M20L	●	GYM20LA-F06	●	A
					L	GYHL2020K90-M20R	●	GYM20RA-F06	●	A
				Modular	R	GYHR2525M90-M25L	●	GYM25LA-F06	●	A
					L	GYHL2525M90-M25R	●	GYM25RA-F06	●	A
		10	20	Modular	R	GYHR2020K90-M20L	●	GYM20LA-F10	●	A
					L	GYHL2020K90-M20R	●	GYM20RA-F10	●	A
		12	24	Modular	R	GYHR2525M90-M25L	●	GYM25LA-F12	●	A
					L	GYHL2525M90-M25R	●	GYM25RA-F12	●	A
		18 *4	36	Modular	R	GYHR2020K90-M20L	●	GYM20LB-F18	●	B
					L	GYHL2020K90-M20R	●	GYM20RB-F18	●	B
20 *1	40 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-F20	●	B		
			L	GYHL2525M90-M25R	●	GYM25RA-F20	●	B		
G	4.00 4.24	8	16	Modular	R	GYHR2525M90-M25L	●	GYM25LA-G08	●	A
					L	GYHL2525M90-M25R	●	GYM25RA-G08	●	A
		12	24	Modular	R	GYHR2020K90-M20L	●	GYM20LA-G12	●	A
					L	GYHL2020K90-M20R	●	GYM20RA-G12	●	A
		14	28	Modular	R	GYHR2525M90-M25L	●	GYM25LA-G14	●	A
					L	GYHL2525M90-M25R	●	GYM25RA-G14	●	A
		25 *1	50 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LA-G25	●	B
					L	GYHL2525M90-M25R	●	GYM25RA-G25	●	B

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

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

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

Select an Insert

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

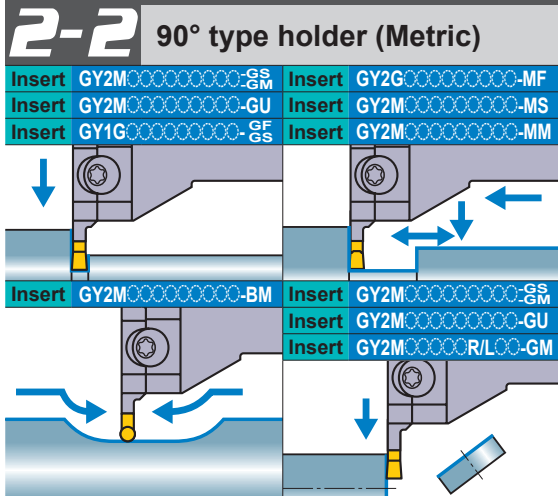
		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
F	.118", 3.00mm	●	●	●	●	●
	.125", 3.18mm	●	●	●	●	●
G	.157", 4.00mm	●	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
F	.118", 3.00mm				●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm			●	
	.125", 3.18mm				●
G	.128", 3.24mm	●			
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm	●		●	
	.157", 4.00mm				●

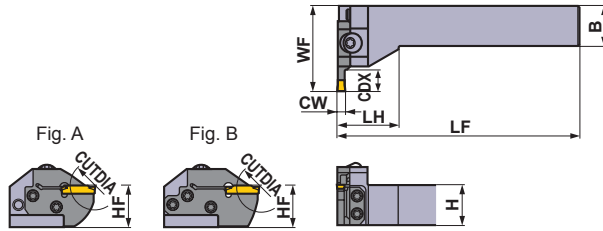
● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING)



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






Right hand tool holder shown.

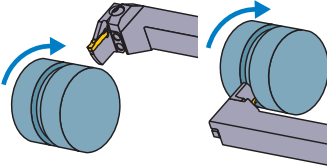
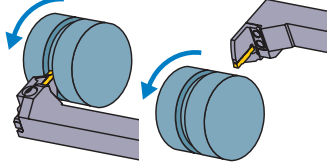
Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	4.75 5.00 5.24	8	16	Modular	R	GYHR2525M90-M25L	●	GYM25LA-H08	●	A
					L	GYHL2525M90-M25R	●	GYM25RA-H08	●	A
		12	24	Modular	R	GYHR2020K90-M20L	●	GYM20LA-H12	●	A
					L	GYHL2020K90-M20R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

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *3 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH and WF values may vary.

GROOVING

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

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

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

Select an Insert

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

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
H	.187", 4.75mm	●	●	●		●
	.197", 5.00mm	●	●	●	●	●
J	.236", 6.00mm	●	●	●		
	.250", 6.35mm	●	●	●		

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
H	.187", 4.75mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	RE 0.8mm	●			
	.197", 5.00mm				●
J	RE 0.2mm	●			
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	.206", 5.24mm	●			
	.236", 6.00mm				●
J	RE 0.2mm	●			
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	.248", 6.31mm	●			
	.250", 6.35mm				●
J	RE 0.2mm	●			
	RE 0.4mm	●			
	RE 0.8mm	●			

● : Gauge insert shown dimensions

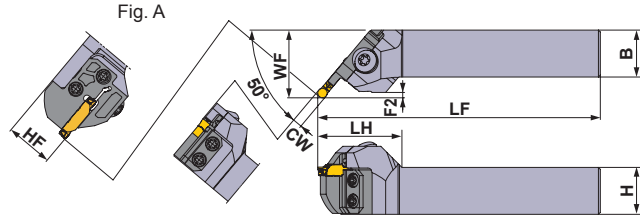
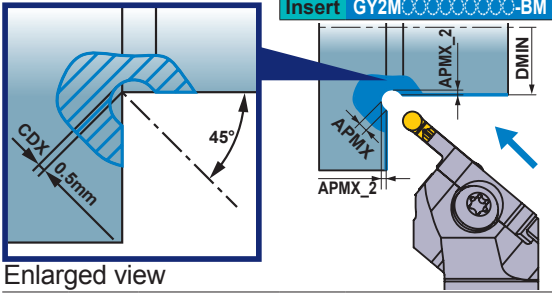
IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL RECESSING)

3-2 50° type holder (Metric)

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

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






Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm)	DMIN (mm)	APMX (mm)	APMX_2 (mm)	Type	Hand (R/L)	Order Number				Fig.
								Holder	Stock	Modular Blade	Stock	
D	2.00	0.5	30	1.5	0.646	Modular	R	GYHR2020K50-M20L	●	GYM20LC-D005	●	A
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-D005	●	A
E	2.50			1.75	0.72	Modular	R	GYHR2525M50-M25L	●	GYM25LC-D005	●	A
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-D005	●	A
F	3.00 3.18			2	0.793	Modular	R	GYHR2020K50-M20L	●	GYM20LC-E005	●	A
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-E005	●	A
G	4.00			2.5	0.939	Modular	R	GYHR2525M50-M25L	●	GYM25LC-E005	●	A
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-E005	●	A
H	4.75 5.00			2.88	1.049	Modular	R	GYHR2020K50-M20L	●	GYM20LC-F005	●	A
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-F005	●	A
J	6.00 6.35	3.5	1.232	Modular	R	GYHR2525M50-M25L	●	GYM25LC-F005	●	A		
				Modular	L	GYHL2525M50-M25R	●	GYM25RC-F005	●	A		
						Modular	R	GYHR2020K50-M20L	●	GYM20LC-G005	●	A
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-G005	●	A
						Modular	R	GYHR2525M50-M25L	●	GYM25LC-G005	●	A
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-G005	●	A
						Modular	R	GYHR2020K50-M20L	●	GYM20LC-H005	●	A
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-H005	●	A
						Modular	R	GYHR2525M50-M25L	●	GYM25LC-H005	●	A
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-H005	●	A
						Modular	R	GYHR2020K50-M20L	●	GYM20LC-J005	●	A
						Modular	L	GYHL2020K50-M20R	●	GYM20RC-J005	●	A
						Modular	R	GYHR2525M50-M25L	●	GYM25LC-J005	●	A
						Modular	L	GYHL2525M50-M25R	●	GYM25RC-J005	●	A

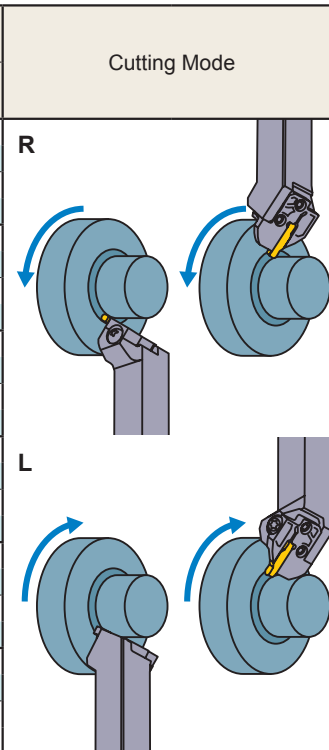
*1 Blades for external and face grooving cannot be used since it interferes with work materials.

*2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LH, WF and F2 values may vary.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
GYHR/L2020K50-M20R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY25D
GYHR/L2525M50-M25R/L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *2						
	H	B	LF	LH	HF	WF	F2
	20	20	125	40	20	32	1.6
	20	20	125	40	20	32	1.6
	25	25	150	45	25	35	1.6
	25	25	150	45	25	35	1.6
	20	20	125	40	20	32	1.8
	20	20	125	40	20	32	1.8
	25	25	150	45	25	35	1.8
	25	25	150	45	25	35	1.8
	20	20	125	40	20	32	2.0
	20	20	125	40	20	32	2.0
	25	25	150	45	25	35	2.0
	25	25	150	45	25	35	2.0
	20	20	125	40	20	32	2.4
	20	20	125	40	20	32	2.4
	25	25	150	45	25	35	2.4
	25	25	150	45	25	35	2.4
	20	20	125	40	20	33	2.8
	20	20	125	40	20	33	2.8
	25	25	150	45	25	36	2.8
	25	25	150	45	25	36	2.8
	25	25	150	44	25	36	3.4
	25	25	150	44	25	36	3.4



Select an Insert

Insert Number
GY2M○○○○○○○○N-BM

For Multifunctional Grooving > F016		
Seat Size	Breaker	BM
	CW	Ball nose
D	.079", 2.00mm	●
E	.098", 2.50mm	●
F	.118", 3.00mm	●
	.125", 3.18mm	●
G	.157", 4.00mm	●
H	.187", 4.75mm	●
	.197", 5.00mm	●
J	.236", 6.00mm	●
	.250", 6.35mm	●

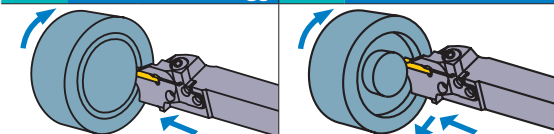
● : Gauge insert shown dimensions

GROOVING

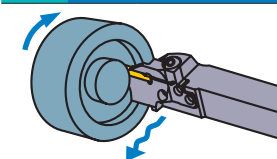
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

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



Insert GY2M^{BM}



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

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

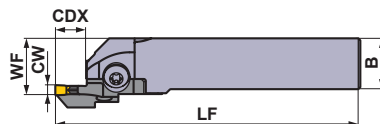


Fig. A

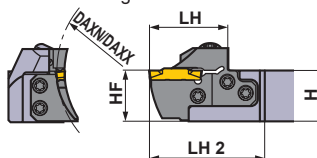
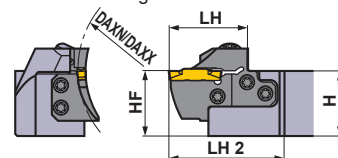


Fig. E



Right hand tool holder shown.

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

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

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

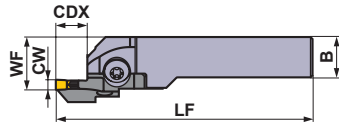
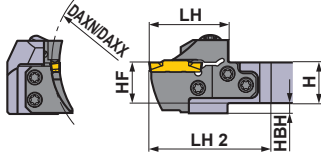


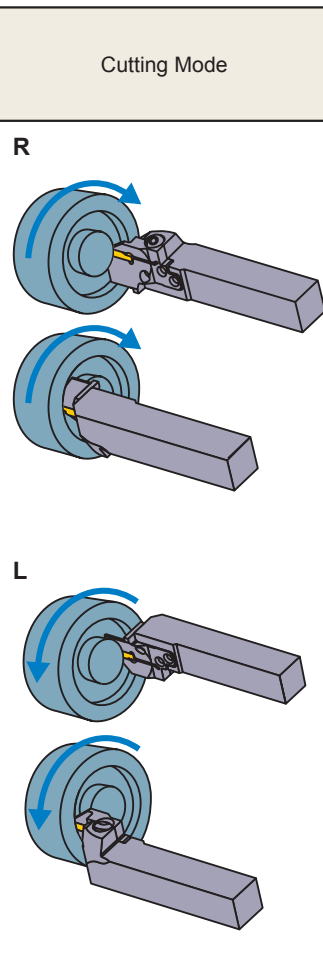
Fig. C



Right hand tool holder shown.

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

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



Select an Insert

Seat Size	Insert Number				
D	GY000200/0224D000000-Breaker				

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW		●	●	●
D	.079", 2.00mm	●	●	●	●

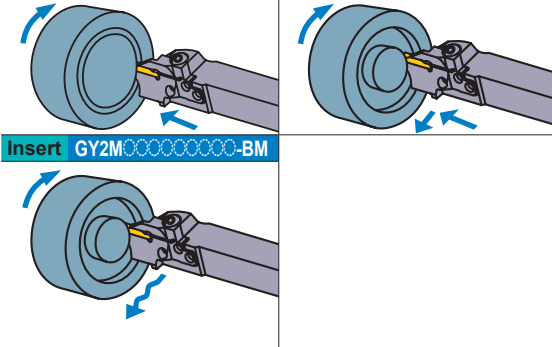
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●	●	●	●

● : Gauge insert shown dimensions

GY SERIES (FACE GROOVING)

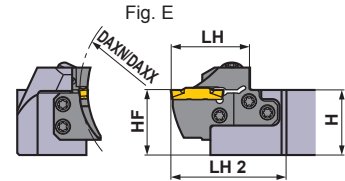
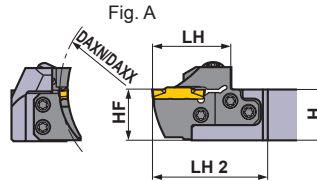
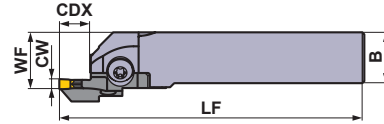
4-1 00° type holder (Inch)

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



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

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



Right hand tool holder shown.

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

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

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

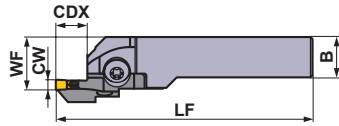
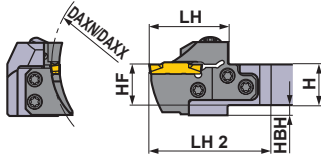


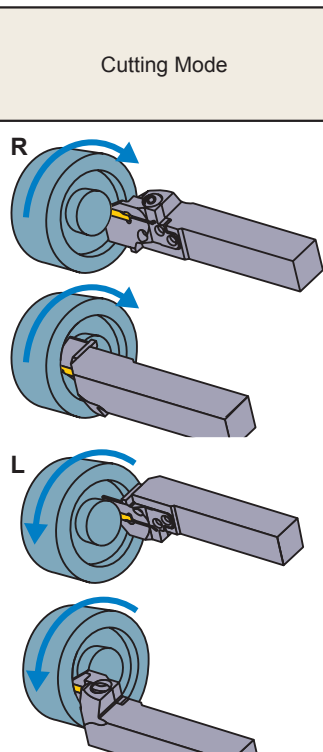
Fig. C



Right hand tool holder shown.

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

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



Select an Insert

Seat Size	Insert Number				
D	GY000200/0224D000000-Breaker				

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	D	CW .079", 2.00mm	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	D	CW .079", 2.00mm .088", 2.24mm	●	●	●

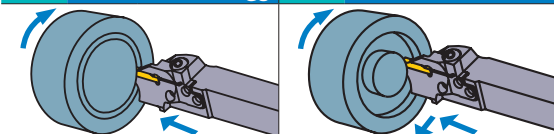
● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
CUTTING CONDITIONS > F196
INSTRUCTION MANUAL > F198

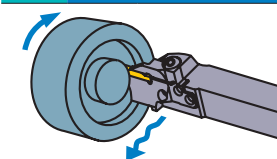
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

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



Insert GY2M^{BM}



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

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

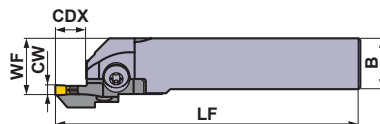


Fig. A

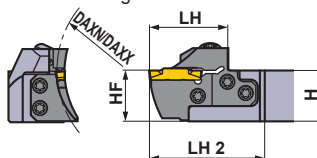
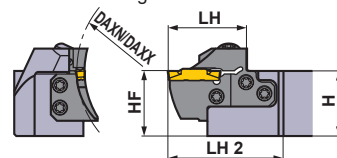


Fig. E



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
E	.094 .098 .108	1.575	1.969	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-040	●	C
					L	GYHLUS12C00-M25L	●	GYM25LD-E12-040	●	C	
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-040	●	A
					L	GYHLUS16D00-M25L	●	GYM25LD-E12-040	●	A	
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-040	●	E
					L	GYHLUS20D00-M25L	●	GYM25LD-E12-040	●	E	
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-040	●	E
					L	GYHLUS24E00-M25L	●	GYM25LD-E12-040	●	E	
		1.969	2.362	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-050	●	C
					L	GYHLUS12C00-M25L	●	GYM25LD-E12-050	●	C	
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-050	●	A
					L	GYHLUS16D00-M25L	●	GYM25LD-E12-050	●	A	
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-050	●	E
					L	GYHLUS20D00-M25L	●	GYM25LD-E12-050	●	E	
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-050	●	E
					L	GYHLUS24E00-M25L	●	GYM25LD-E12-050	●	E	
		2.362	2.953	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-060	●	C
					L	GYHLUS12C00-M25L	●	GYM25LD-E12-060	●	C	
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-060	●	A
					L	GYHLUS16D00-M25L	●	GYM25LD-E12-060	●	A	
Modular	R				GYHRUS20D00-M25R	●	GYM25RD-E12-060	●	E		
L	GYHLUS20D00-M25L				●	GYM25LD-E12-060	●	E			
Modular	R				GYHRUS24E00-M25R	●	GYM25RD-E12-060	●	E		
L	GYHLUS24E00-M25L				●	GYM25LD-E12-060	●	E			
2.953	3.937	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-E12-075	●	C		
			L	GYHLUS12C00-M25L	●	GYM25LD-E12-075	●	C			
			Modular	R	GYHRUS16D00-M25R	●	GYM25RD-E12-075	●	A		
			L	GYHLUS16D00-M25L	●	GYM25LD-E12-075	●	A			
			Modular	R	GYHRUS20D00-M25R	●	GYM25RD-E12-075	●	E		
			L	GYHLUS20D00-M25L	●	GYM25LD-E12-075	●	E			
			Modular	R	GYHRUS24E00-M25R	●	GYM25RD-E12-075	●	E		
			L	GYHLUS24E00-M25L	●	GYM25LD-E12-075	●	E			

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

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

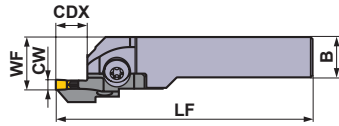
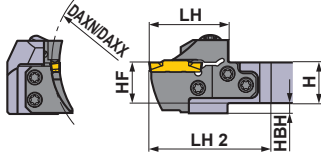


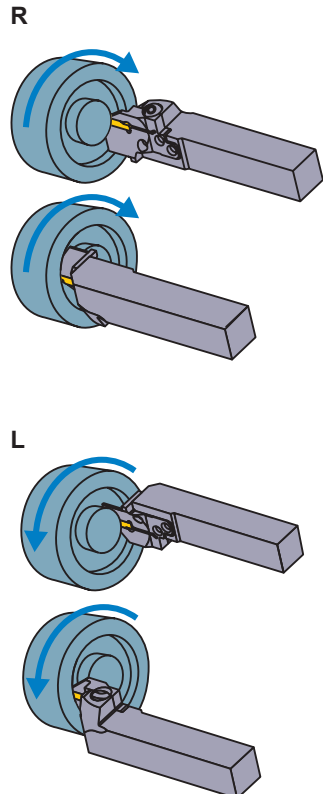
Fig. C



Right hand tool holder shown.

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

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



Select an Insert

Seat Size	Insert Number
E	GY000239/0250/0274E00000-Breaker

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
E	.094", 2.39mm	●	●	●	●
	.098", 2.50mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			

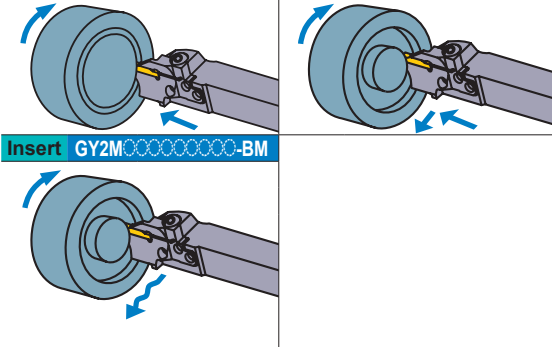
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} -GM	Insert	GY2G ^{GS} -MF
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



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

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

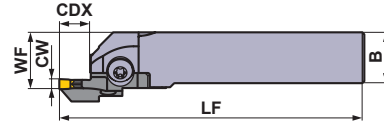


Fig. A

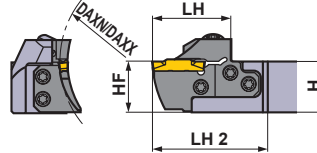
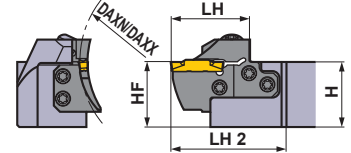


Fig. E



Right hand tool holder shown.

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

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

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

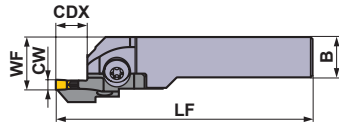
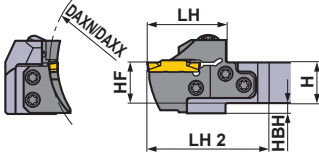





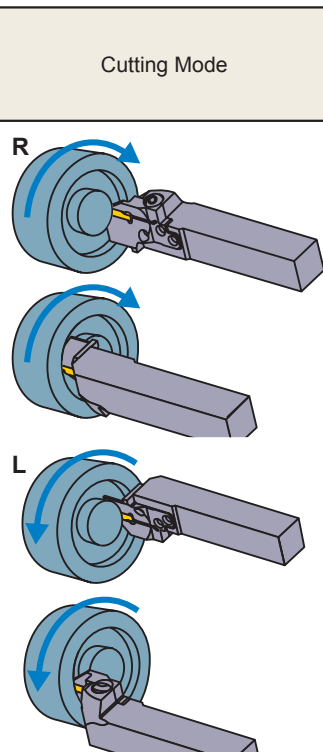
Fig. C



Right hand tool holder shown.

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

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



Select an Insert

Seat Size	Insert Number
E	GY000239/0250/0274E0000-Breaker

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	E	.094", 2.39mm .098", 2.50mm	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	E	.094", 2.39mm .098", 2.50mm .108", 2.74mm	●	●	●

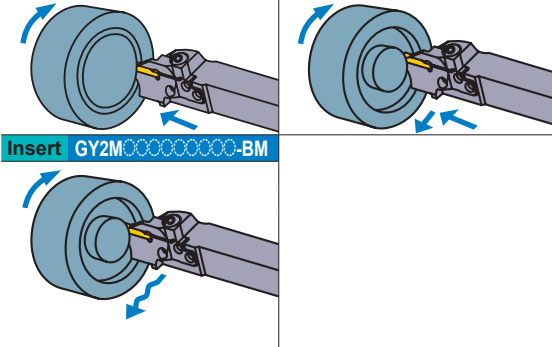
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

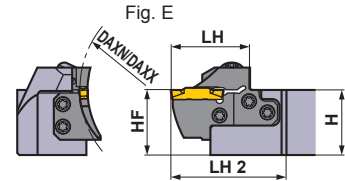
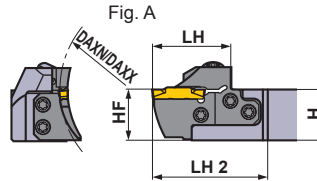
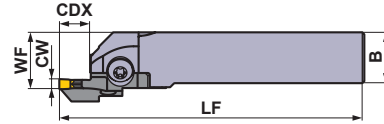
4-1 00° type holder (Inch)

Insert	GY2M ^{GS} -GM	Insert	GY2G ^{GS} -MF
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	1.378	1.575	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-035	●	C
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-035	●	C
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-035	●	A
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-035	●	A
		Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-035	●	E			
		Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-035	●	E			
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-035	●	E			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-035	●	E			
	1.575	1.969	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-040	●	C	
				Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-040	●	C	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-040	●	A	
				Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-040	●	A	
	1.969	2.362	.472	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-040	●	E	
				Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-040	●	E	
				Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-040	●	E	
				Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-040	●	E	
				Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-050	●	C	
				Modular	L	GYHLUS12C00-M25L	●	GYM25LD-F12-050	●	C	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-050	●	A	
				Modular	L	GYHLUS16D00-M25L	●	GYM25LD-F12-050	●	A	
				Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-050	●	E	
				Modular	L	GYHLUS20D00-M25L	●	GYM25LD-F12-050	●	E	
				Modular	R	GYHRUS24E00-M25R	●	GYM25RD-F12-050	●	E	
				Modular	L	GYHLUS24E00-M25L	●	GYM25LD-F12-050	●	E	

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

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

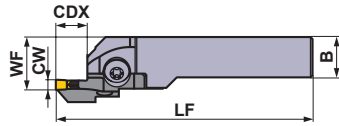
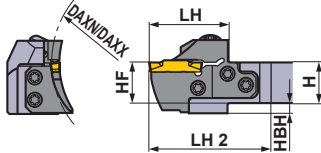


Fig. C

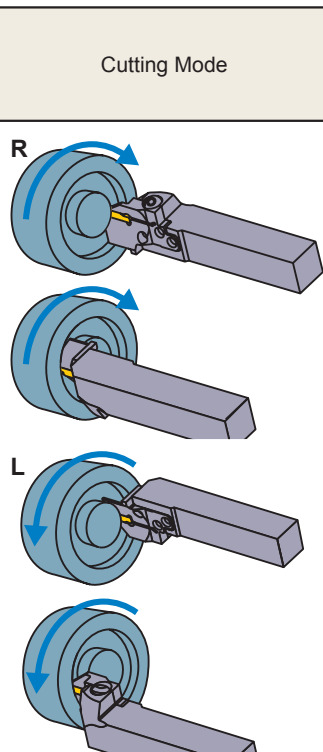


Right hand tool holder shown.

SPARE PARTS

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

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



Select an Insert

Seat Size	Insert Number
F	GY0000300/0318/0324F00000-Breaker

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
		CW			
F	.118", 3.00mm	●	●	●	●
	.125", 3.18mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
		CW			Ball nose
F	.118", 3.00mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.125", 3.18mm	●	●	●	●
	RE .008"	●	●	●	●
F	RE .016"	●	●	●	●
	.128", 3.24mm	●	●	●	●

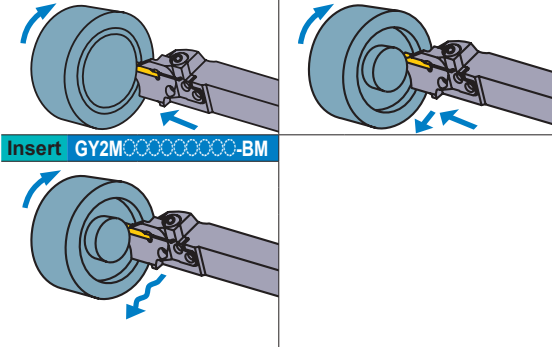
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

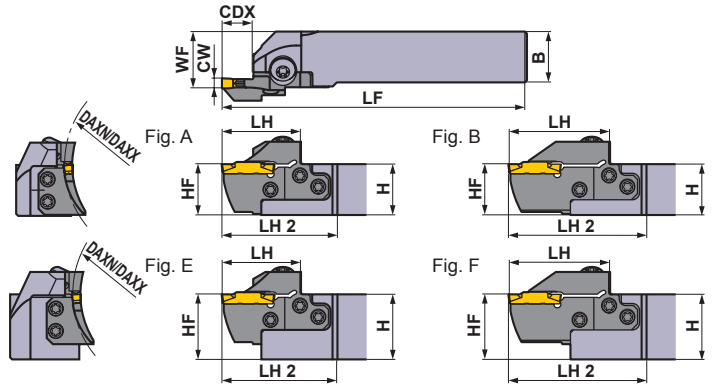
4-1 00° type holder (Inch)

Insert	GY2M ^{GS} -GM	Insert	GY2G ^{GS} -MF
Insert	GY2M ^{GS} -GU	Insert	GY2M ^{GS} -MS
Insert	GY1G ^{GS} -GS	Insert	GY2M ^{GS} -MM



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

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

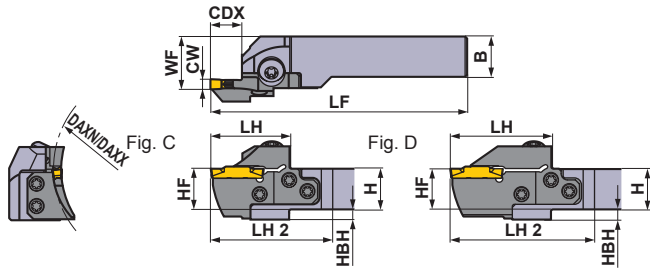


Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	2.362	2.953	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-060	●	C
						L	GYHLUS12C00-M25L	●	GYM25LD-F12-060	●	C
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-060	●	A
						L	GYHLUS16D00-M25L	●	GYM25LD-F12-060	●	A
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-060	●	E
						L	GYHLUS20D00-M25L	●	GYM25LD-F12-060	●	E
					R	GYHRUS24E00-M25R	●	GYM25RD-F12-060	●	E	
					L	GYHLUS24E00-M25L	●	GYM25LD-F12-060	●	E	
					R	GYHRUS12C00-M25R	●	GYM25RD-F20-060	●	D	
					L	GYHLUS12C00-M25L	●	GYM25LD-F20-060	●	D	
					R	GYHRUS16D00-M25R	●	GYM25RD-F20-060	●	B	
					L	GYHLUS16D00-M25L	●	GYM25LD-F20-060	●	B	
		R	GYHRUS20D00-M25R	●	GYM25RD-F20-060	●	F				
		L	GYHLUS20D00-M25L	●	GYM25LD-F20-060	●	F				
		R	GYHRUS24E00-M25R	●	GYM25RD-F20-060	●	F				
		L	GYHLUS24E00-M25L	●	GYM25LD-F20-060	●	F				
		2.953	3.937	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-075	●	C
					L	GYHLUS12C00-M25L	●	GYM25LD-F12-075	●	C	
	Modular				R	GYHRUS16D00-M25R	●	GYM25RD-F12-075	●	A	
					L	GYHLUS16D00-M25L	●	GYM25LD-F12-075	●	A	
	Modular				R	GYHRUS20D00-M25R	●	GYM25RD-F12-075	●	E	
					L	GYHLUS20D00-M25L	●	GYM25LD-F12-075	●	E	
		R	GYHRUS24E00-M25R	●	GYM25RD-F12-075	●	E				
		L	GYHLUS24E00-M25L	●	GYM25LD-F12-075	●	E				
	.787*2			Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-075	●	D	
				L	GYHLUS12C00-M25L	●	GYM25LD-F20-075	●	D		
Modular				R	GYHRUS16D00-M25R	●	GYM25RD-F20-075	●	B		
				L	GYHLUS16D00-M25L	●	GYM25LD-F20-075	●	B		
Modular				R	GYHRUS20D00-M25R	●	GYM25RD-F20-075	●	F		
				L	GYHLUS20D00-M25L	●	GYM25LD-F20-075	●	F		
	R	GYHRUS24E00-M25R	●	GYM25RD-F20-075	●	F					
	L	GYHLUS24E00-M25L	●	GYM25LD-F20-075	●	F					

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

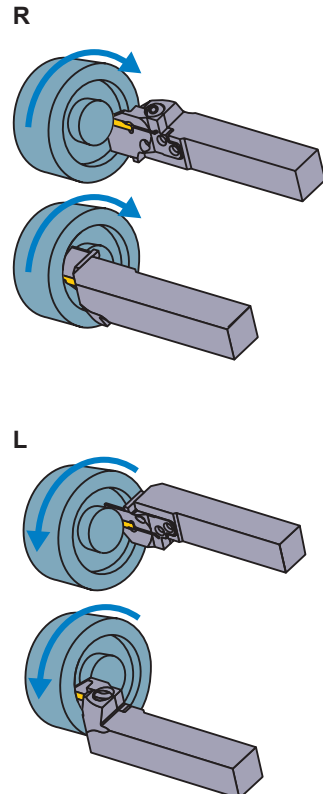


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
		CW	CW	CW	CW
F	.118", 3.00mm	●	●	●	●
	.125", 3.18mm	●	●	●	●

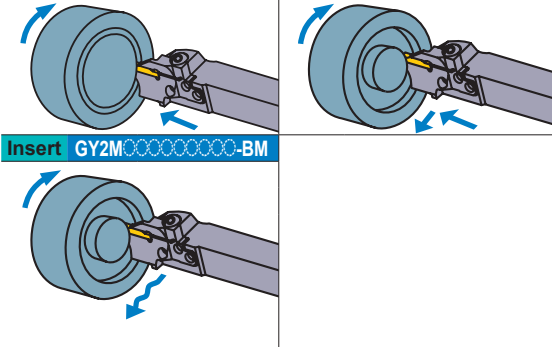
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
		CW	CW	CW	Ball nose
F	.118", 3.00mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.125", 3.18mm	●	●	●	●
	RE .008"	●	●	●	●
F	RE .016"	●	●	●	●
	.128", 3.24mm	●	●	●	●

● : Gauge insert shown dimensions

GY SERIES (FACE GROOVING)

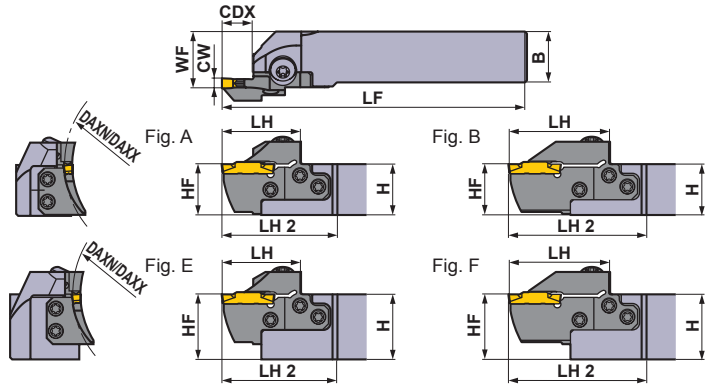
4-1 00° type holder (Inch)

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



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

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

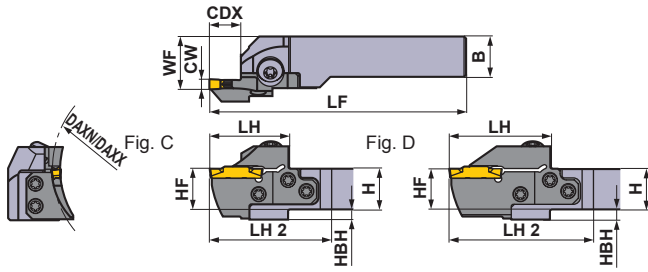


Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	3.937	5.906	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-100	●	C
						L	GYHLUS12C00-M25L	●	GYM25LD-F12-100	●	C
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-F12-100	●	A
						L	GYHLUS16D00-M25L	●	GYM25LD-F12-100	●	A
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-F12-100	●	E
						L	GYHLUS20D00-M25L	●	GYM25LD-F12-100	●	E
					R	GYHRUS24E00-M25R	●	GYM25RD-F12-100	●	E	
					L	GYHLUS24E00-M25L	●	GYM25LD-F12-100	●	E	
					R	GYHRUS12C00-M25R	●	GYM25RD-F20-100	●	D	
					L	GYHLUS12C00-M25L	●	GYM25LD-F20-100	●	D	
					R	GYHRUS16D00-M25R	●	GYM25RD-F20-100	●	B	
					L	GYHLUS16D00-M25L	●	GYM25LD-F20-100	●	B	
		R	GYHRUS20D00-M25R	●	GYM25RD-F20-100	●	F				
		L	GYHLUS20D00-M25L	●	GYM25LD-F20-100	●	F				
		R	GYHRUS24E00-M25R	●	GYM25RD-F20-100	●	F				
		L	GYHLUS24E00-M25L	●	GYM25LD-F20-100	●	F				
		5.315	7.874	.472	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F12-135	●	C
					L	GYHLUS12C00-M25L	●	GYM25LD-F12-135	●	C	
					R	GYHRUS16D00-M25R	●	GYM25RD-F12-135	●	A	
					L	GYHLUS16D00-M25L	●	GYM25LD-F12-135	●	A	
					R	GYHRUS20D00-M25R	●	GYM25RD-F12-135	●	E	
					L	GYHLUS20D00-M25L	●	GYM25LD-F12-135	●	E	
		R	GYHRUS24E00-M25R	●	GYM25RD-F12-135	●	E				
		L	GYHLUS24E00-M25L	●	GYM25LD-F12-135	●	E				
	.787*2			Modular	R	GYHRUS12C00-M25R	●	GYM25RD-F20-135	●	D	
				L	GYHLUS12C00-M25L	●	GYM25LD-F20-135	●	D		
				R	GYHRUS16D00-M25R	●	GYM25RD-F20-135	●	B		
				L	GYHLUS16D00-M25L	●	GYM25LD-F20-135	●	B		
				R	GYHRUS20D00-M25R	●	GYM25RD-F20-135	●	F		
				L	GYHLUS20D00-M25L	●	GYM25LD-F20-135	●	F		
	R	GYHRUS24E00-M25R	●	GYM25RD-F20-135	●	F					
	L	GYHLUS24E00-M25L	●	GYM25LD-F20-135	●	F					

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

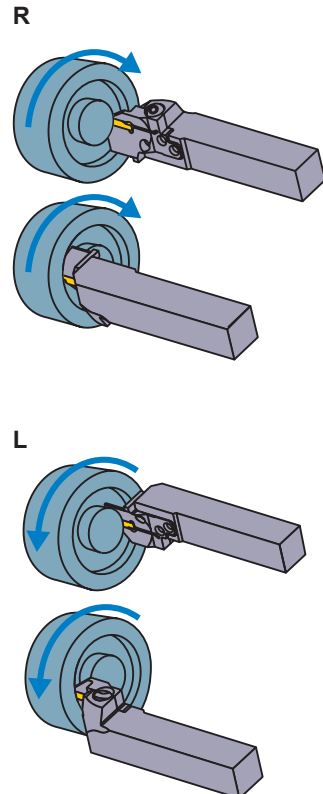


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

Seat Size	Insert Number
F	GY0000300/0318/0324F00000-Breaker

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
		CW			
F	.118", 3.00mm	●	●	●	●
	.125", 3.18mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
F	.118", 3.00mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.125", 3.18mm	●	●	●	●
	RE .008"	●	●	●	●
F	RE .016"	●	●	●	●
	.128", 3.24mm	●	●	●	●

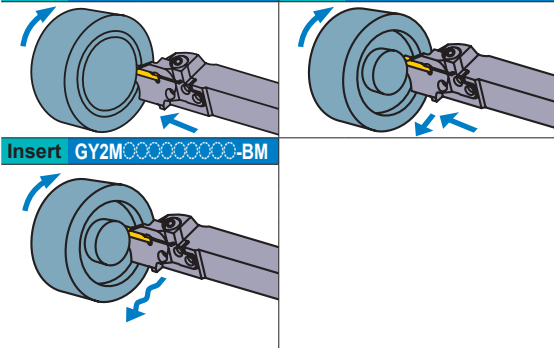
● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F196
 INSTRUCTION MANUAL > F198

GY SERIES (FACE GROOVING)

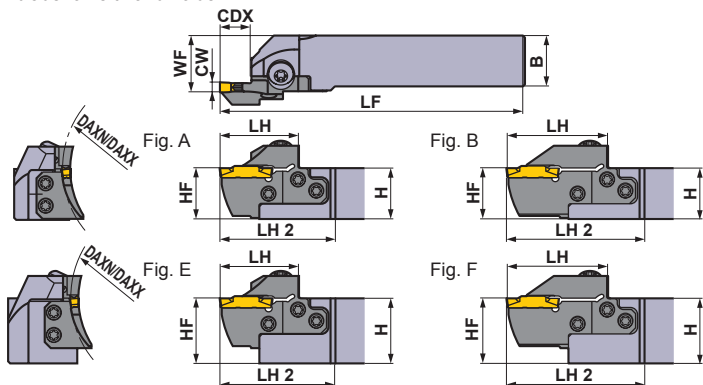
4-1 00° type holder (Inch)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



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

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

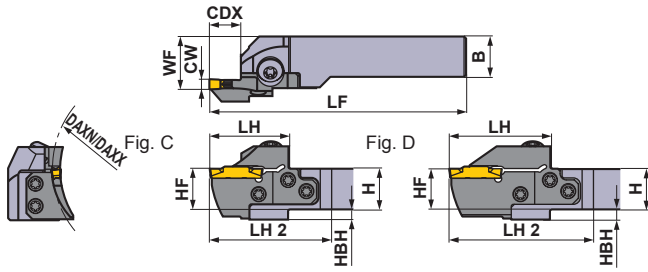


Right hand tool holder shown.

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

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

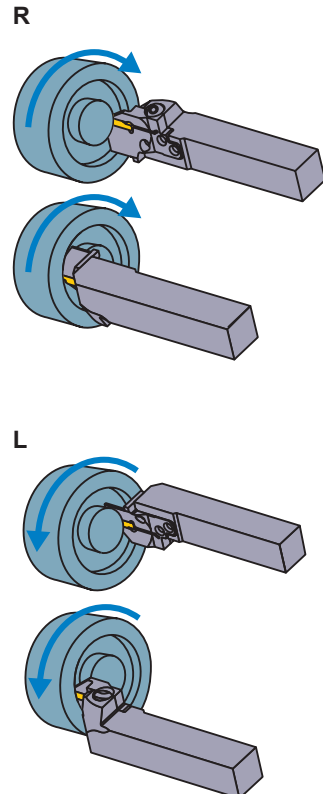


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
		CW			
F	.118", 3.00mm	●	●	●	●
	.125", 3.18mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
		CW			
F	.118", 3.00mm	●	●	●	●
	RE .008"	●	●	●	●
	RE .016"	●	●	●	●
	RE .031"	●	●	●	●
	.125", 3.18mm	●	●	●	●
	RE .008"	●	●	●	●
RE .016"	●	●	●	●	
.128", 3.24mm	●	●	●	●	

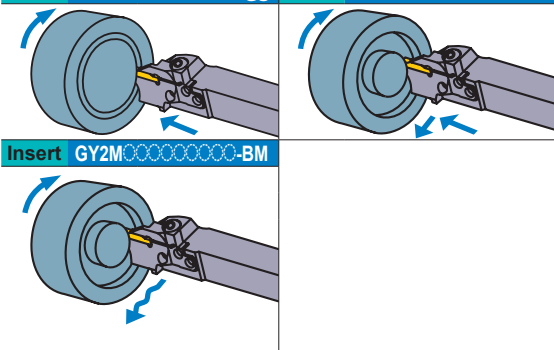
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

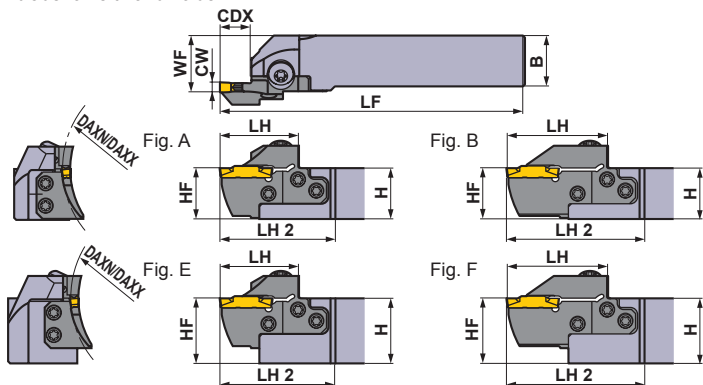
4-1 00° type holder (Inch)

Insert	GY2M ^{GS} -GM	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



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

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

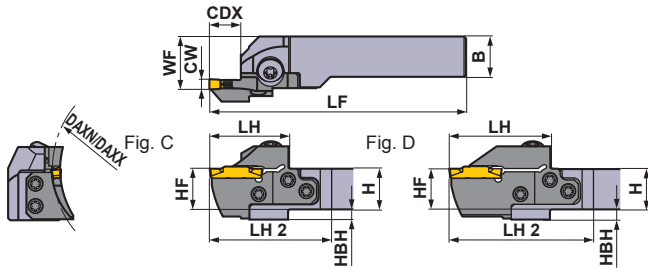


Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	.157 .167	1.575	1.969	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-040	●	C
					Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-040	●	C
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-040	●	A
					Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-040	●	A
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-040	●	E
					Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-040	●	E
					Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-040	●	E
					Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-040	●	E
		Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-050	●	C			
		Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-050	●	C			
		Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-050	●	A			
		Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-050	●	A			
		Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-050	●	E			
		Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-050	●	E			
		Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-050	●	E			
		Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-050	●	E			
	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-060	●	C				
	Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G14-060	●	C				
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-060	●	A				
	Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G14-060	●	A				
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-060	●	E					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G14-060	●	E					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-060	●	E					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G14-060	●	E					
Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G25-060	●	D					
Modular	L	GYHLUS12C00-M25L	●	GYM25LD-G25-060	●	D					
Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G25-060	●	B					
Modular	L	GYHLUS16D00-M25L	●	GYM25LD-G25-060	●	B					
Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G25-060	●	F					
Modular	L	GYHLUS20D00-M25L	●	GYM25LD-G25-060	●	F					
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G25-060	●	F					
Modular	L	GYHLUS24E00-M25L	●	GYM25LD-G25-060	●	F					

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

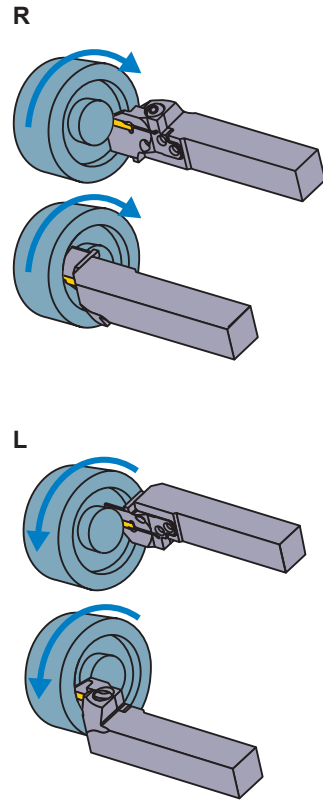


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

		For Grooving/Cutting off > F013, F014			
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
G	.157", 4.00mm	●	●	●	●

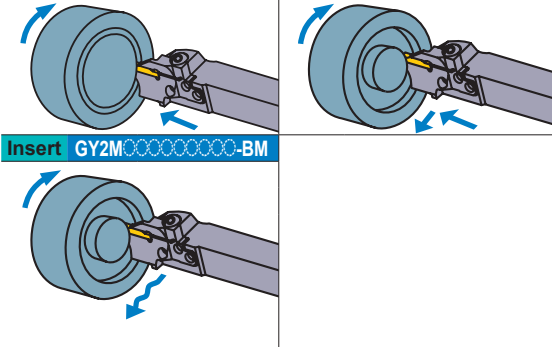
		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	Ball nose
	CW				
G	.157", 4.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.167", 4.24mm	●			

● : Gauge insert shown dimensions

GY SERIES (FACE GROOVING)

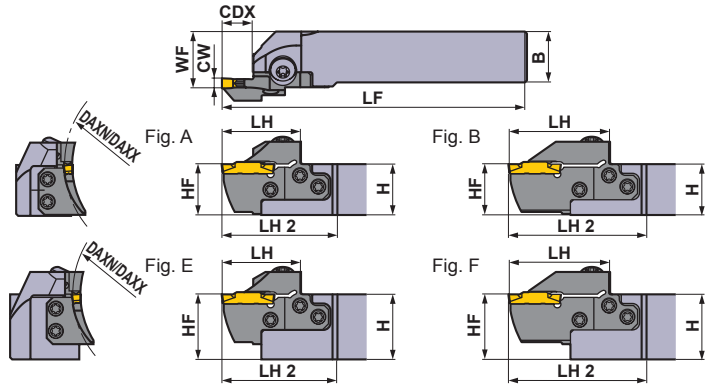
4-1 00° type holder (Inch)

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



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

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

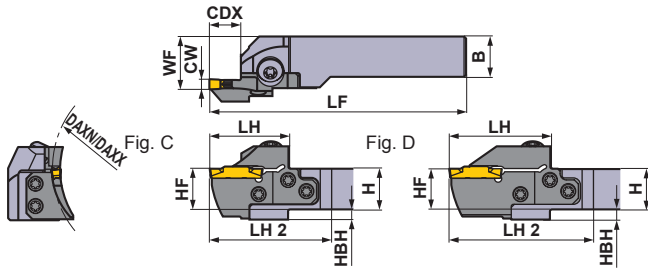


Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	.157 .167	3.346	4.921	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-085	●	C
						L	GYHLUS12C00-M25L	●	GYM25LD-G14-085	●	C
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-085	●	A
						L	GYHLUS16D00-M25L	●	GYM25LD-G14-085	●	A
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-085	●	E
						L	GYHLUS20D00-M25L	●	GYM25LD-G14-085	●	E
				Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-085	●	E	
					L	GYHLUS24E00-M25L	●	GYM25LD-G14-085	●	E	
				.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G25-085	●	D
						L	GYHLUS12C00-M25L	●	GYM25LD-G25-085	●	D
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G25-085	●	B
						L	GYHLUS16D00-M25L	●	GYM25LD-G25-085	●	B
	Modular	R	GYHRUS20D00-M25R		●	GYM25RD-G25-085	●	F			
		L	GYHLUS20D00-M25L		●	GYM25LD-G25-085	●	F			
	4.921	7.874	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G14-125	●	C	
					L	GYHLUS12C00-M25L	●	GYM25LD-G14-125	●	C	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RD-G14-125	●	A	
					L	GYHLUS16D00-M25L	●	GYM25LD-G14-125	●	A	
				Modular	R	GYHRUS20D00-M25R	●	GYM25RD-G14-125	●	E	
					L	GYHLUS20D00-M25L	●	GYM25LD-G14-125	●	E	
			Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G14-125	●	E		
				L	GYHLUS24E00-M25L	●	GYM25LD-G14-125	●	E		
			.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-G25-125	●	D	
					L	GYHLUS12C00-M25L	●	GYM25LD-G25-125	●	D	
Modular				R	GYHRUS16D00-M25R	●	GYM25RD-G25-125	●	B		
				L	GYHLUS16D00-M25L	●	GYM25LD-G25-125	●	B		
Modular	R	GYHRUS20D00-M25R		●	GYM25RD-G25-125	●	F				
	L	GYHLUS20D00-M25L		●	GYM25LD-G25-125	●	F				
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-G25-125	●	F					
	L	GYHLUS24E00-M25L	●	GYM25LD-G25-125	●	F					

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

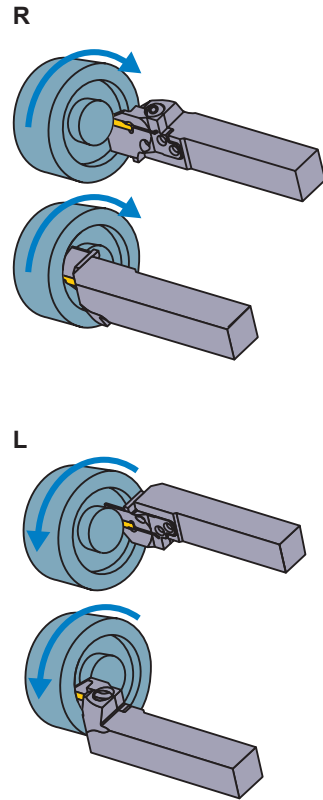


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
G	.157", 4.00mm	●	●	●	●

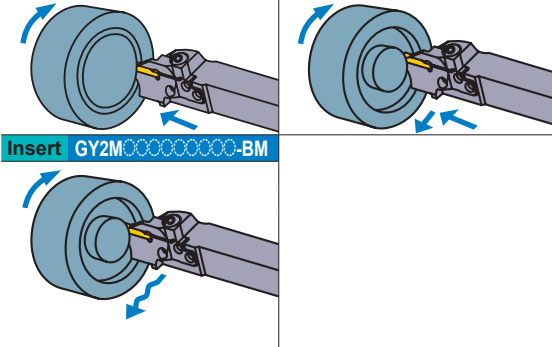
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
G	.157", 4.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●		●	
	.167", 4.24mm	●			

● : Gauge insert shown dimensions

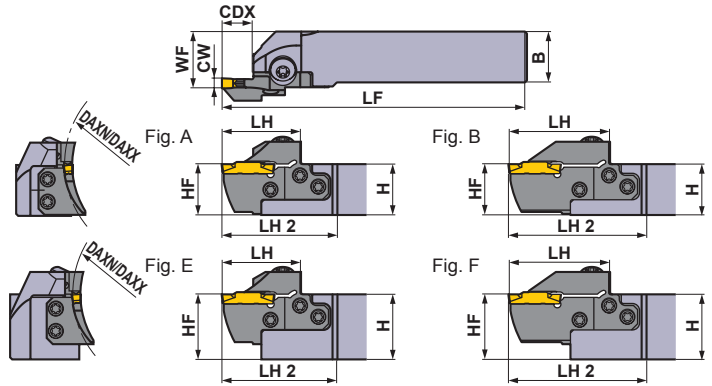
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} -GM	Insert	GY2G ^{GS} -MF
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



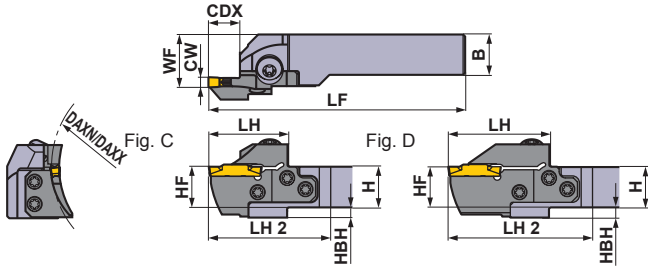
(Note 1) For modular blades and holders, please order separately.
 (Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

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

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.
 *2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

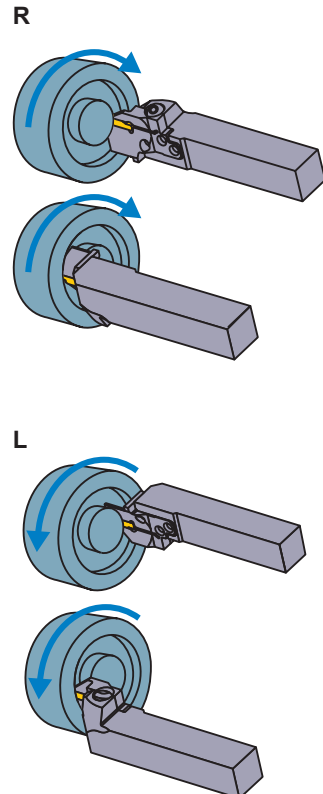


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
G	.157", 4.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
G	.157", 4.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●		●	
	.167", 4.24mm	●			

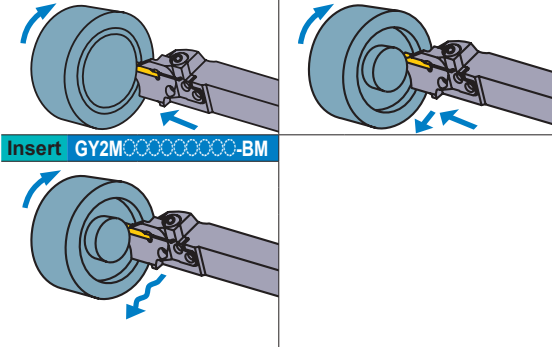
● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F196
 INSTRUCTION MANUAL > F198

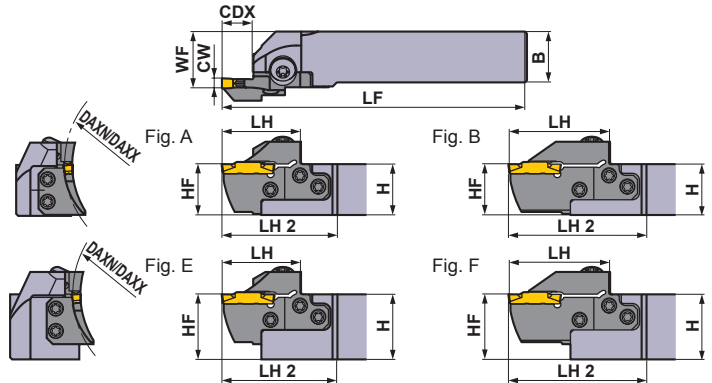
GY SERIES (FACE GROOVING)

4-1 00° type holder (Inch)

Insert	GY2M ^{GS} -GM	Insert	GY2G ^{GS} -MF
Insert	GY2M ^{GS} -GU	Insert	GY2M ^{GS} -MS
Insert	GY1G ^{GS} -GS	Insert	GY2M ^{GS} -MM



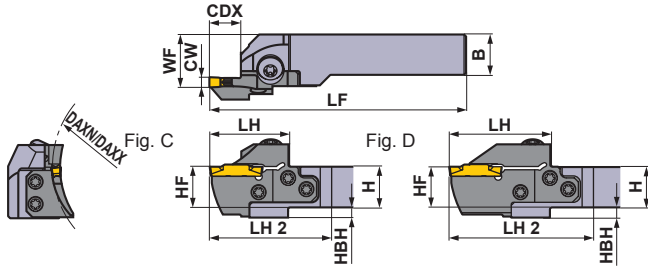
(Note 1) For modular blades and holders, please order separately.
 (Note 2) Please use right hand modular blade for right hand holder and left hand modular blade for left hand holder.



Right hand tool holder shown.

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

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, LH 2, and WF values may vary.
 *2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.



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

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

Right hand tool holder shown.

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

Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	H	CW .187", 4.75mm .197", 5.00mm	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	H	CW .187", 4.75mm RE .008" RE .016" RE .031"	●		
.197", 5.00mm RE .008"		●			●
RE .016"		●	●	●	
RE .031"		●	●	●	
.206", 5.24mm		●			
					Ball nose

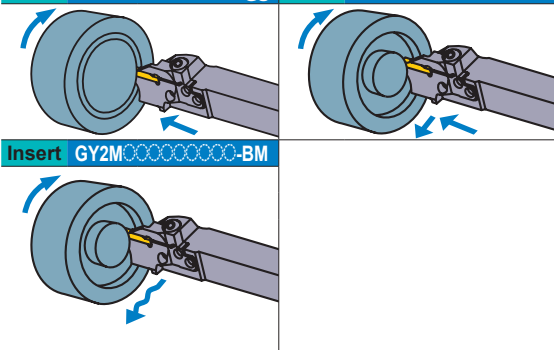
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

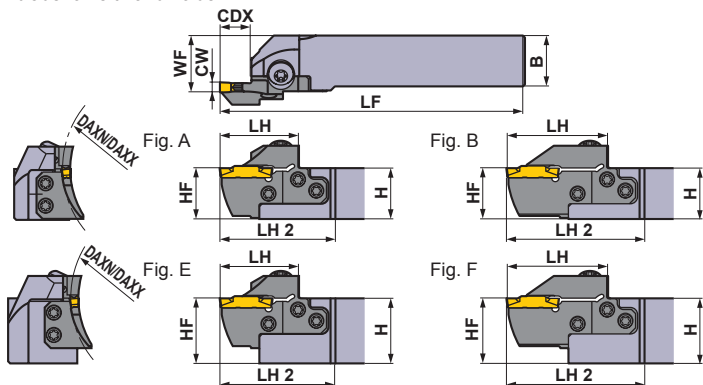
4-1 00° type holder (Inch)

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



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

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

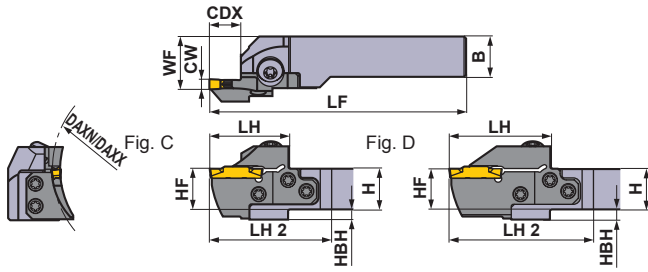


Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	3.346	4.921	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-085	●	C
						L	GYHLUS12C00-M25L	●	GYM25LD-H14-085	●	C
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-085	●	A
						L	GYHLUS16D00-M25L	●	GYM25LD-H14-085	●	A
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-085	●	E
						L	GYHLUS20D00-M25L	●	GYM25LD-H14-085	●	E
				Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-085	●	E	
					L	GYHLUS24E00-M25L	●	GYM25LD-H14-085	●	E	
				.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-085	●	D
						L	GYHLUS12C00-M25L	●	GYM25LD-H25-085	●	D
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H25-085	●	B
						L	GYHLUS16D00-M25L	●	GYM25LD-H25-085	●	B
	Modular	R	GYHRUS20D00-M25R		●	GYM25RD-H25-085	●	F			
		L	GYHLUS20D00-M25L		●	GYM25LD-H25-085	●	F			
	4.921	7.874	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-125	●	C	
					L	GYHLUS12C00-M25L	●	GYM25LD-H14-125	●	C	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-125	●	A	
					L	GYHLUS16D00-M25L	●	GYM25LD-H14-125	●	A	
				Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-125	●	E	
					L	GYHLUS20D00-M25L	●	GYM25LD-H14-125	●	E	
			Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-125	●	E		
				L	GYHLUS24E00-M25L	●	GYM25LD-H14-125	●	E		
			.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-125	●	D	
					L	GYHLUS12C00-M25L	●	GYM25LD-H25-125	●	D	
Modular				R	GYHRUS16D00-M25R	●	GYM25RD-H25-125	●	B		
				L	GYHLUS16D00-M25L	●	GYM25LD-H25-125	●	B		
Modular	R	GYHRUS20D00-M25R		●	GYM25RD-H25-125	●	F				
	L	GYHLUS20D00-M25L		●	GYM25LD-H25-125	●	F				
Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H25-125	●	F					
	L	GYHLUS24E00-M25L	●	GYM25LD-H25-125	●	F					

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

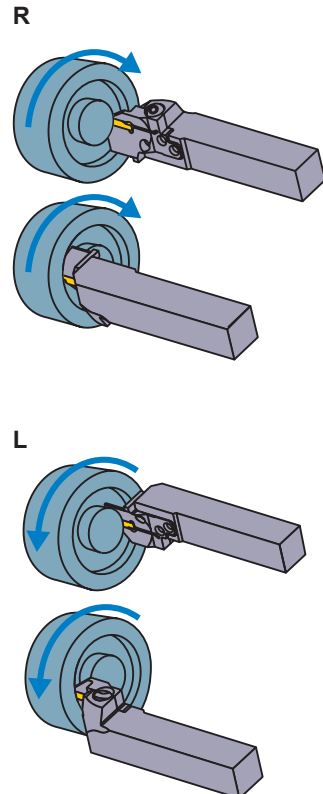


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
H	.187", 4.75mm	●	●	●	●
	.197", 5.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				
H	.187", 4.75mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00mm				●
	RE .008"	●			
RE .016"	●	●	●		
RE .031"	●	●	●		
.206", 5.24mm	●				

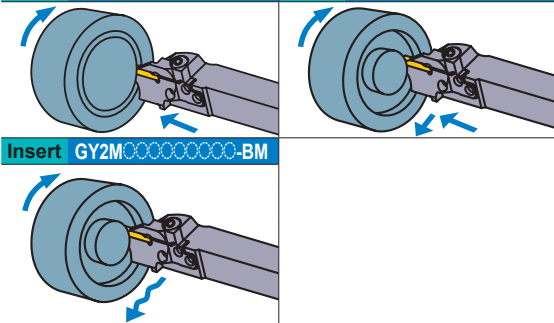
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

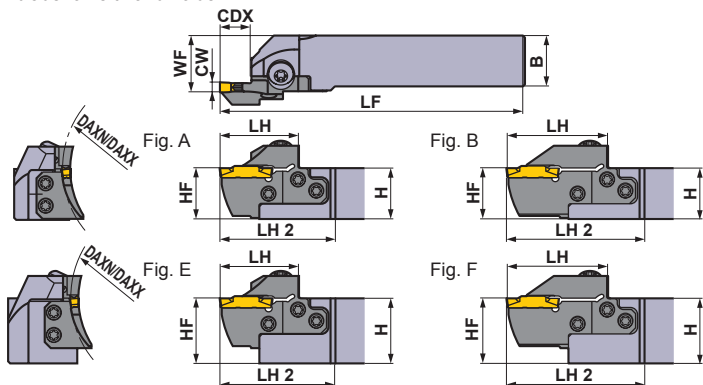
4-1 00° type holder (Inch)

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



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

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

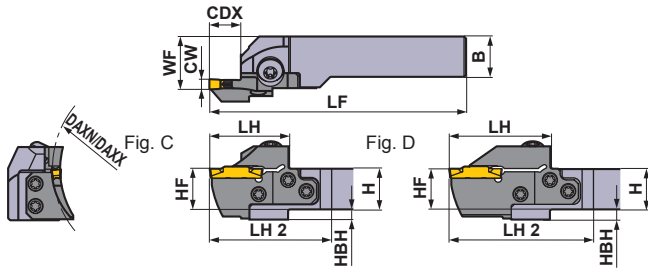


Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	7.087	11.024	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-180	●	C
						L	GYHLUS12C00-M25L	●	GYM25LD-H14-180	●	C
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-180	●	A
						L	GYHLUS16D00-M25L	●	GYM25LD-H14-180	●	A
				Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-180	●	E	
					L	GYHLUS20D00-M25L	●	GYM25LD-H14-180	●	E	
				Modular	R	GYHRUS24E00-M25R	●	GYM25RD-H14-180	●	E	
					L	GYHLUS24E00-M25L	●	GYM25LD-H14-180	●	E	
				.984*2	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-180	●	D
						L	GYHLUS12C00-M25L	●	GYM25LD-H25-180	●	D
	Modular	R	GYHRUS16D00-M25R		●	GYM25RD-H25-180	●	B			
		L	GYHLUS16D00-M25L		●	GYM25LD-H25-180	●	B			
	Modular	R	GYHRUS20D00-M25R		●	GYM25RD-H25-180	●	F			
		L	GYHLUS20D00-M25L		●	GYM25LD-H25-180	●	F			
	9.843	39.331	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H14-250	●	C	
					L	GYHLUS12C00-M25L	●	GYM25LD-H14-250	●	C	
				Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H14-250	●	A	
					L	GYHLUS16D00-M25L	●	GYM25LD-H14-250	●	A	
			Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H14-250	●	E		
				L	GYHLUS20D00-M25L	●	GYM25LD-H14-250	●	E		
Modular			R	GYHRUS24E00-M25R	●	GYM25RD-H14-250	●	E			
			L	GYHLUS24E00-M25L	●	GYM25LD-H14-250	●	E			
.984*2			Modular	R	GYHRUS12C00-M25R	●	GYM25RD-H25-250	●	D		
				L	GYHLUS12C00-M25L	●	GYM25LD-H25-250	●	D		
	Modular	R	GYHRUS16D00-M25R	●	GYM25RD-H25-250	●	B				
		L	GYHLUS16D00-M25L	●	GYM25LD-H25-250	●	B				
	Modular	R	GYHRUS20D00-M25R	●	GYM25RD-H25-250	●	F				
		L	GYHLUS20D00-M25L	●	GYM25LD-H25-250	●	F				
					R	GYHRUS24E00-M25R	●	GYM25RD-H25-250	●	F	
					L	GYHLUS24E00-M25L	●	GYM25LD-H25-250	●	F	

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

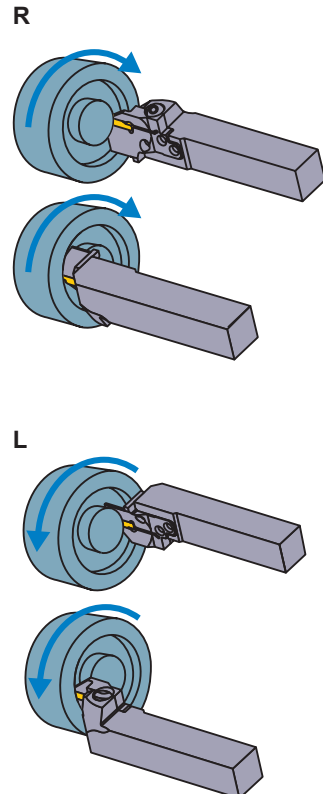


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
H	.187", 4.75mm	●	●	●	●
	.197", 5.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
H	.187", 4.75mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00mm				●
	RE .008"	●			
RE .016"	●	●	●		
RE .031"	●	●	●		
.206", 5.24mm	●				

● : Gauge insert shown dimensions

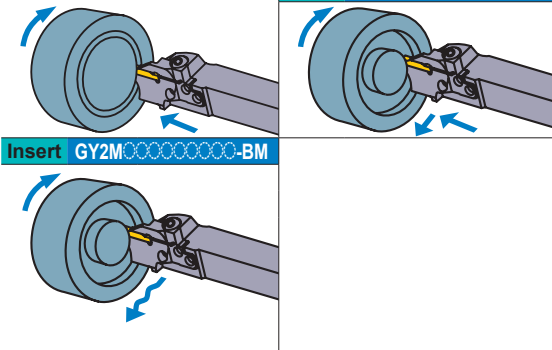
IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F196
 INSTRUCTION MANUAL > F198

GROOVING

GY SERIES (FACE GROOVING)

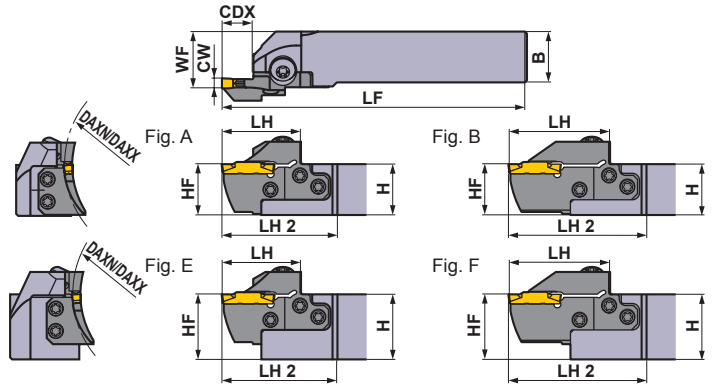
4-1 00° type holder (Inch)

Insert	GY2M ^{GS}	Insert	GY2G-MF
Insert	GY2M ^{GU}	Insert	GY2M-MS
		Insert	GY2M-MM



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

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

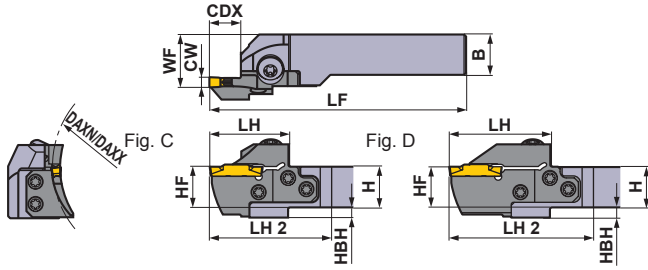


Right hand tool holder shown.

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

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

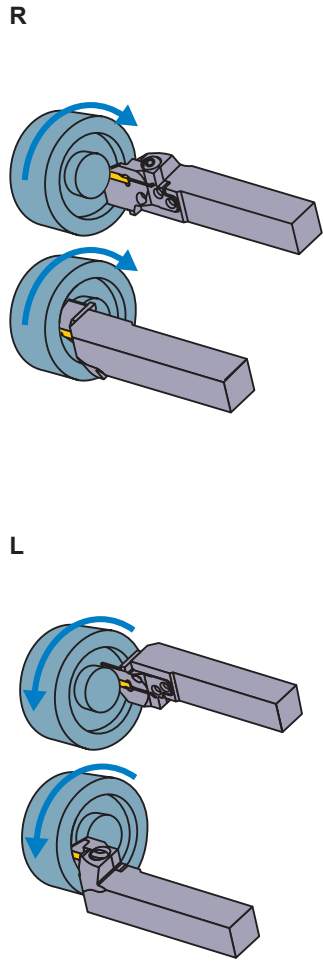


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013					
Seat Size	Breaker	GU	GS	GM	GFGS
		CW			
J	236", 6.00mm	●	●	●	
	250", 6.35mm	●	●	●	

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
		CW			Ball nose
J	236", 6.00mm	●			●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●	●	●	
J	248", 6.31mm	●			
	250", 6.35mm	●			●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			

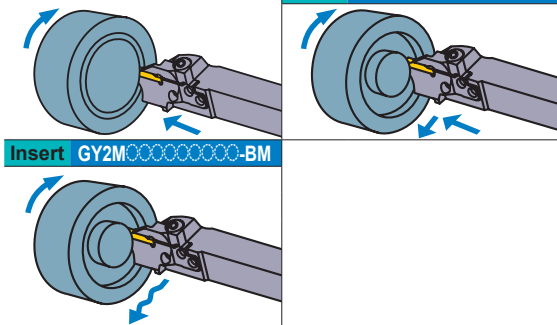
● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F196
 INSTRUCTION MANUAL > F198

GY SERIES (FACE GROOVING)

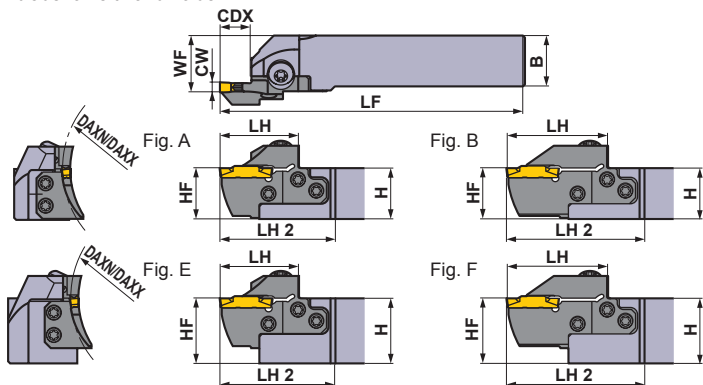
4-1 00° type holder (Inch)

Insert	GY2M ^{GS}	Insert	GY2G-MF
Insert	GY2M ^{GM}	Insert	GY2M-MS
		Insert	GY2M-MM



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

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

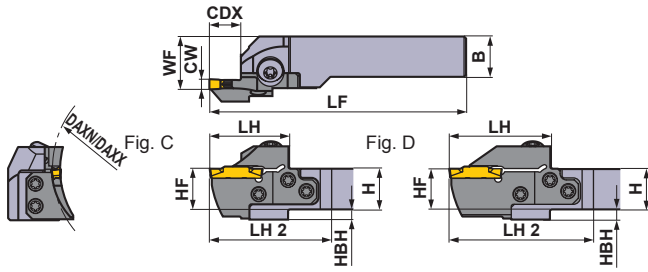


Right hand tool holder shown.

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	.236 .248 .250	6.693	11.024	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-170	●	C
						L	GYHLUS12C00-M25L	●	GYM25LD-J14-170	●	C
					Modular	R	GYHRUS16D00-M25R	●	GYM25RD-J14-170	●	A
						L	GYHLUS16D00-M25L	●	GYM25LD-J14-170	●	A
					Modular	R	GYHRUS20D00-M25R	●	GYM25RD-J14-170	●	E
						L	GYHLUS20D00-M25L	●	GYM25LD-J14-170	●	E
			R	GYHRUS24E00-M25R	●	GYM25RD-J14-170	●	E			
			L	GYHLUS24E00-M25L	●	GYM25LD-J14-170	●	E			
			R	GYHRUS12C00-M25R	●	GYM25RD-J25-170	●	D			
			L	GYHLUS12C00-M25L	●	GYM25LD-J25-170	●	D			
			R	GYHRUS16D00-M25R	●	GYM25RD-J25-170	●	B			
			L	GYHLUS16D00-M25L	●	GYM25LD-J25-170	●	B			
		R	GYHRUS20D00-M25R	●	GYM25RD-J25-170	●	F				
		L	GYHLUS20D00-M25L	●	GYM25LD-J25-170	●	F				
		R	GYHRUS24E00-M25R	●	GYM25RD-J25-170	●	F				
		L	GYHLUS24E00-M25L	●	GYM25LD-J25-170	●	F				
		9.843	39.331	.551	Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J14-250	●	C
					L	GYHLUS12C00-M25L	●	GYM25LD-J14-250	●	C	
	Modular				R	GYHRUS16D00-M25R	●	GYM25RD-J14-250	●	A	
					L	GYHLUS16D00-M25L	●	GYM25LD-J14-250	●	A	
	Modular				R	GYHRUS20D00-M25R	●	GYM25RD-J14-250	●	E	
					L	GYHLUS20D00-M25L	●	GYM25LD-J14-250	●	E	
		R	GYHRUS24E00-M25R	●	GYM25RD-J14-250	●	E				
		L	GYHLUS24E00-M25L	●	GYM25LD-J14-250	●	E				
	.984*2			Modular	R	GYHRUS12C00-M25R	●	GYM25RD-J25-250	●	D	
				L	GYHLUS12C00-M25L	●	GYM25LD-J25-250	●	D		
Modular				R	GYHRUS16D00-M25R	●	GYM25RD-J25-250	●	B		
				L	GYHLUS16D00-M25L	●	GYM25LD-J25-250	●	B		
Modular				R	GYHRUS20D00-M25R	●	GYM25RD-J25-250	●	F		
				L	GYHLUS20D00-M25L	●	GYM25LD-J25-250	●	F		
	R	GYHRUS24E00-M25R	●	GYM25RD-J25-250	●	F					
	L	GYHLUS24E00-M25L	●	GYM25LD-J25-250	●	F					

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

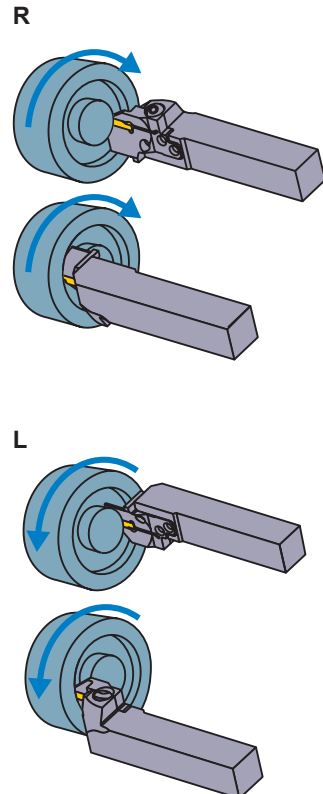


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
J	236", 6.00mm	●	●	●	
	250", 6.35mm	●	●	●	

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	J	236", 6.00mm			
RE .008"		●			
J	248", 6.31mm	●	●	●	
	RE .016"	●	●	●	
J	250", 6.35mm	●			●
	RE .031"	●			
J	RE .008"	●			
	RE .016"	●			
J	RE .031"	●			
	RE .031"	●			

● : Gauge insert shown dimensions

GROOVING

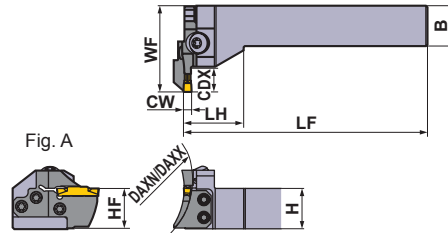
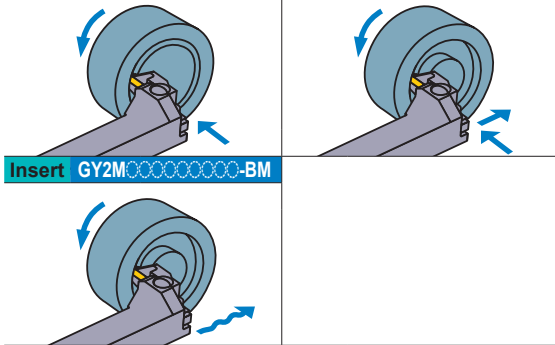
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}

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

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



Right hand tool holder shown.




GROOVING

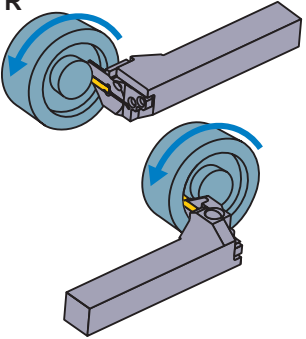
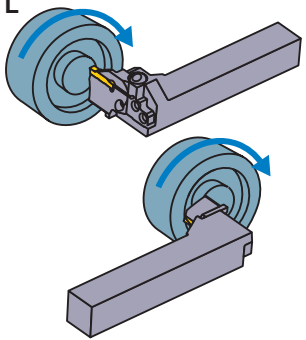
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
D	.079 .088	1.575	1.969	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-D12-040	●	A
						L	GYHLUS16D90-M25R	●	GYM25RD-D12-040	●	A
		1.969	2.362	.472	Modular	R	GYHRUS16D90-M25L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

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

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

SPARE PARTS

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

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

Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
D	.079", 2.00mm	●	●	●	●
E	.094", 2.39mm	●	●	●	●
	.098", 2.50mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●			●
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			

● : Gauge insert shown dimensions

GROOVING

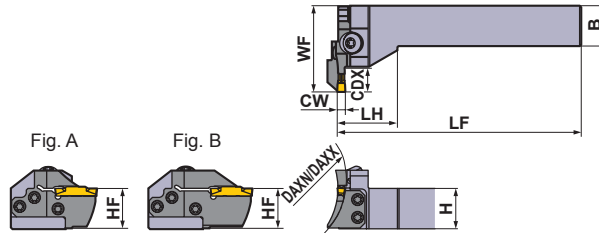
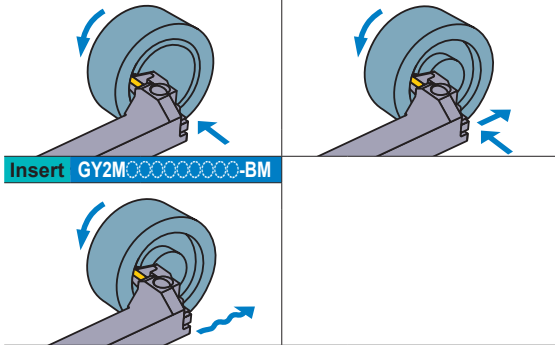
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

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

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

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



Right hand tool holder shown.




GROOVING

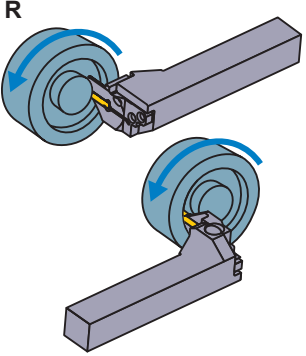
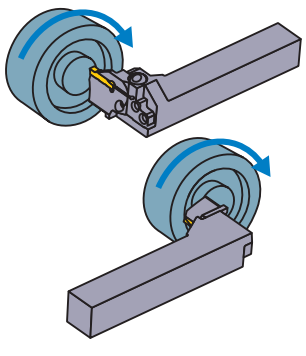
Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	1.378	1.575	.472	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-F12-035	●	A
						L	GYHLUS16D90-M25R	●	GYM25RD-F12-035	●	A
		1.575	1.969	.472	Modular	R	GYHRUS16D90-M25L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

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

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

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

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

Select an Insert

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

For Grooving/Cutting off > F013, F014						
Seat Size	CW	Breaker	GU	GS	GM	GFGS
		F	.118", 3.00mm .125", 3.18mm	●	●	●

For Multifunctional Grooving > F015, F016						
Seat Size	CW	Breaker	MF	MS	MM	BM
		F	.118", 3.00mm RE .008" RE .016" RE .031" .125", 3.18mm RE .008" RE .016" .128", 3.24mm		●	●

● : Gauge insert shown dimensions

GROOVING

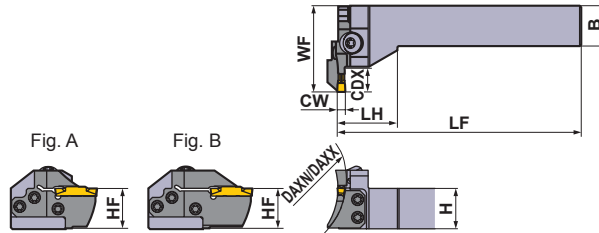
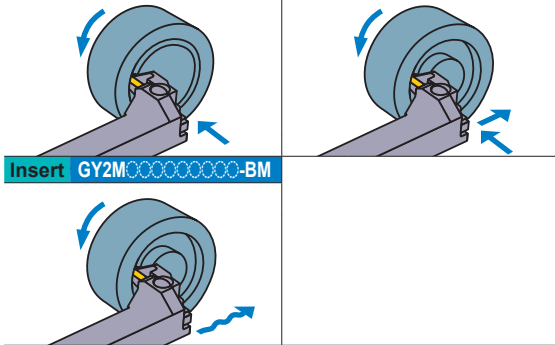
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}

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

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






Right hand tool holder shown.

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

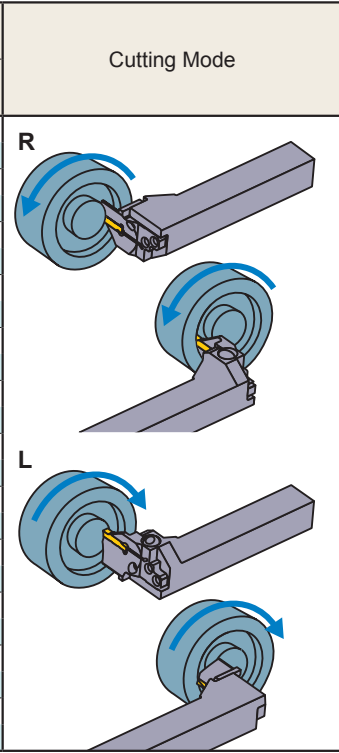
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

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

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

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



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
G	.157", 4.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
G	.157", 4.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.167", 4.24mm	●			

● : Gauge insert shown dimensions

GROOVING

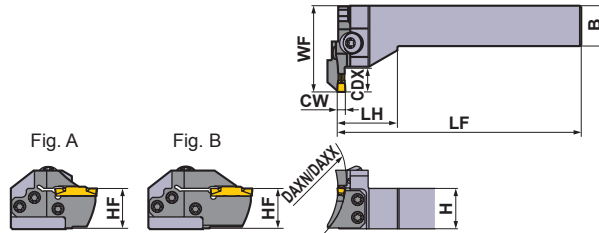
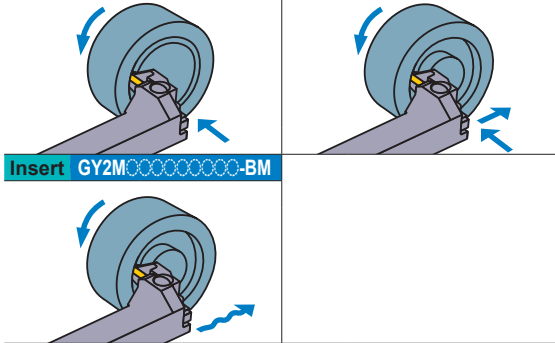
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

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

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

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



Right hand tool holder shown.




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

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

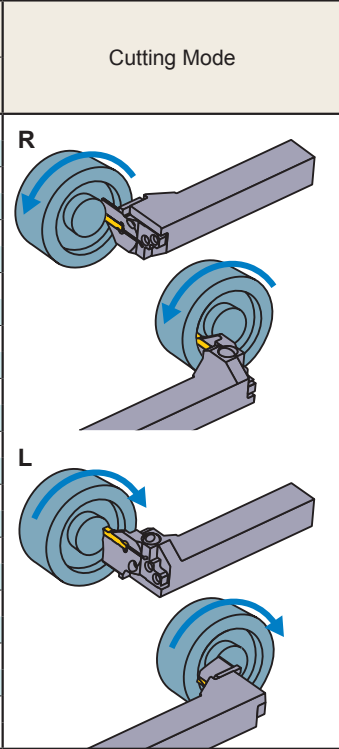
*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

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

SPARE PARTS

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

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



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
		CW			
H	.187", 4.75mm	●	●	●	●
	.197", 5.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
		CW			
H	.187", 4.75mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
.206", 5.24mm	●				

● : Gauge insert shown dimensions

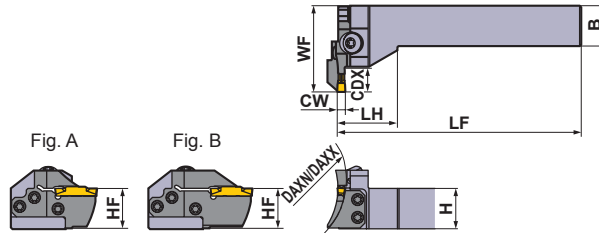
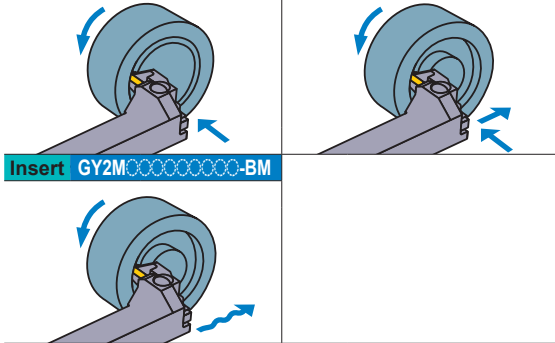
GY SERIES (FACE GROOVING)

5-1 90° type holder (inch)

Insert	GY2M ^{GS}	Insert	GY2G ^{GM} -MF
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}

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

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



Right hand tool holder shown.




GROOVING

Seat Size	CW (inch)	DAXN (inch)	DAXX (inch)	CDX (inch)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
J	.236 .248 .250	1.969	2.756	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-050	●	A
					Modular	L	GYHLUS16D90-M25R	●	GYM25RD-J14-050	●	A
		2.756	4.331	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-070	●	A
					Modular	L	GYHLUS16D90-M25R	●	GYM25RD-J14-070	●	A
		.984*2	.984*2	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J25-070	●	B
					Modular	L	GYHLUS16D90-M25R	●	GYM25RD-J25-070	●	B
		4.331	7.874	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-110	●	A
					Modular	L	GYHLUS16D90-M25R	●	GYM25RD-J14-110	●	A
		.984*2	.984*2	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J25-110	●	B
					Modular	L	GYHLUS16D90-M25R	●	GYM25RD-J25-110	●	B
		6.693	11.024	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-170	●	A
					Modular	L	GYHLUS16D90-M25R	●	GYM25RD-J14-170	●	A
		.984*2	.984*2	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J25-170	●	B
					Modular	L	GYHLUS16D90-M25R	●	GYM25RD-J25-170	●	B
		9.843	39.331	.551	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J14-250	●	A
					Modular	L	GYHLUS16D90-M25R	●	GYM25RD-J14-250	●	A
.984*2	.984*2	.984*2	Modular	R	GYHRUS16D90-M25L	●	GYM25LD-J25-250	●	B		
			Modular	L	GYHLUS16D90-M25R	●	GYM25RD-J25-250	●	B		

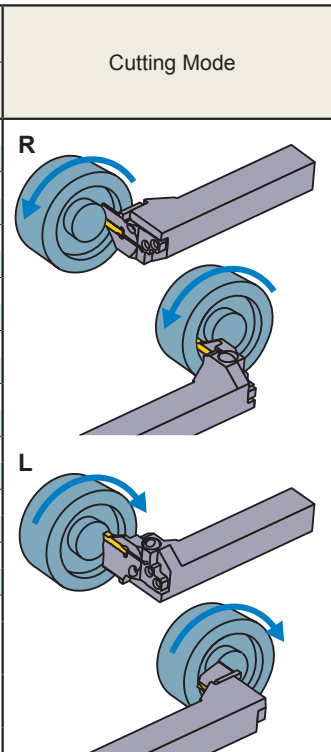
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

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

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

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



Select an Insert

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

For Grooving/Cutting off > F013					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
J	236", 6.00mm	●	●	●	
	250", 6.35mm	●	●	●	

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
J	236", 6.00mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
J	248", 6.31mm	●			
	250", 6.35mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			

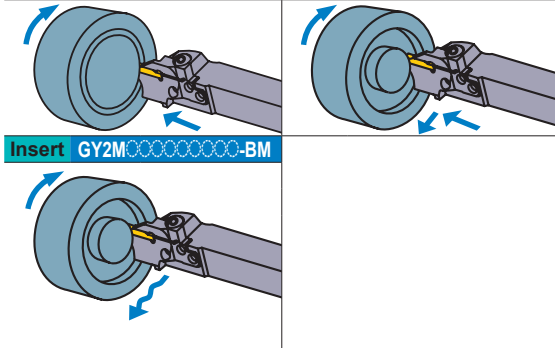
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

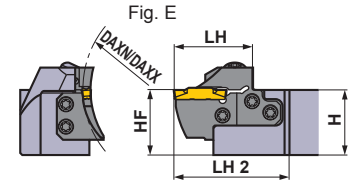
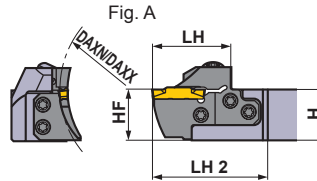
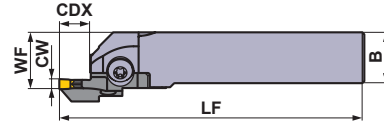
4-2 00° type holder (Metric)

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



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

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



Right hand tool holder shown.

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

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

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

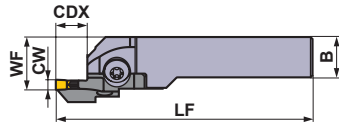
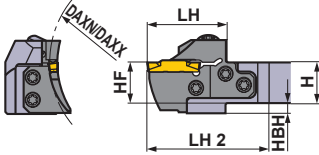


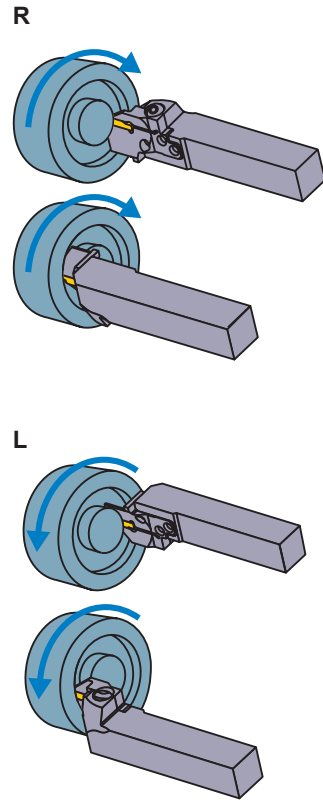
Fig. C



Right hand tool holder shown.

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

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



Select an Insert

Seat Size	Insert Number
D	GY000200/0224D000000-Breaker

For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
	CW	Neutral	Neutral	Neutral	Hand	Neutral
D	.079", 2.00mm	●	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●	●	●	●

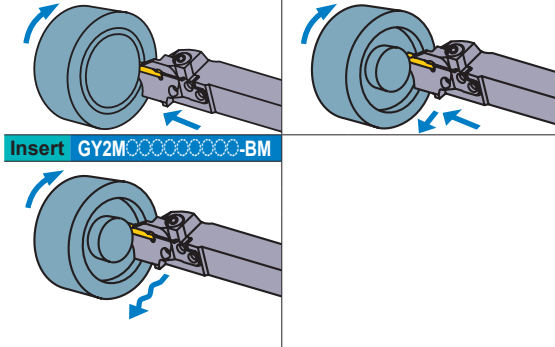
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

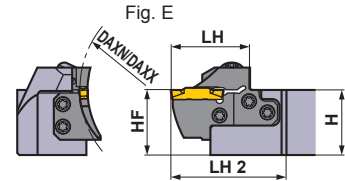
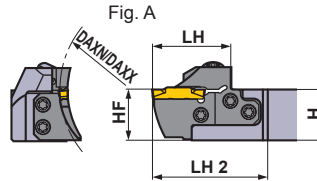
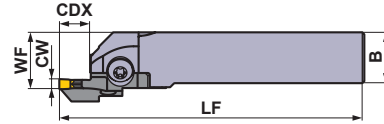
4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GF} _{GS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

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

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

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

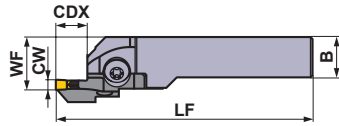
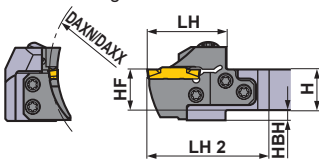


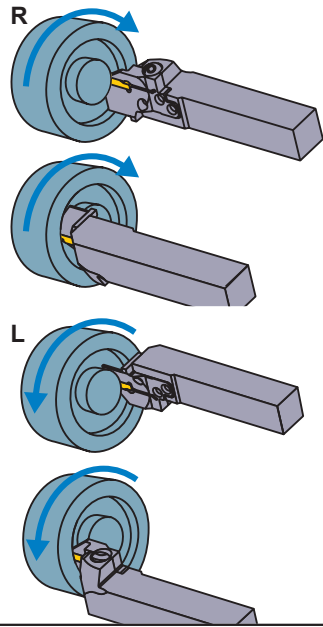
Fig. C



Right hand tool holder shown.

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

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



Select an Insert

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

For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		CW	Neutral	Neutral	Neutral	Hand
D	.079", 2.00mm	●	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
		CW			
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●	●		

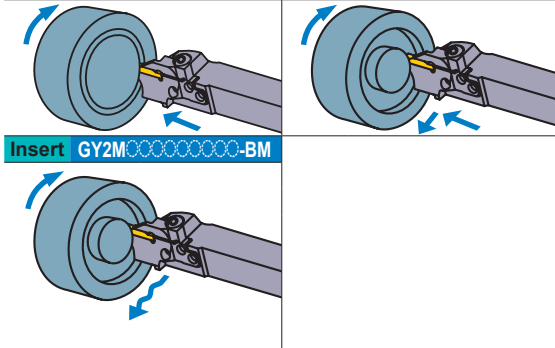
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

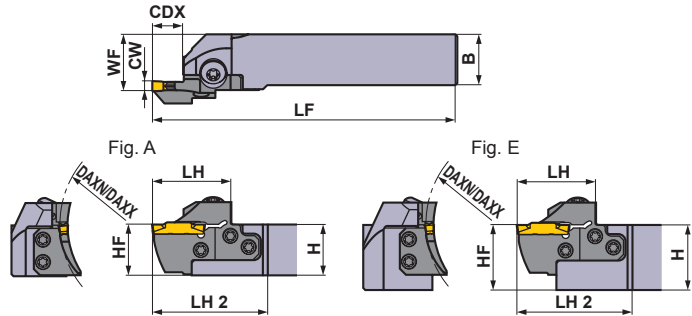
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

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

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

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

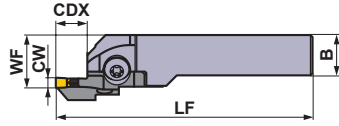
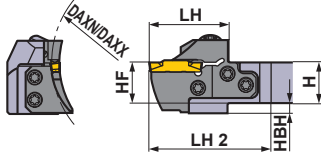


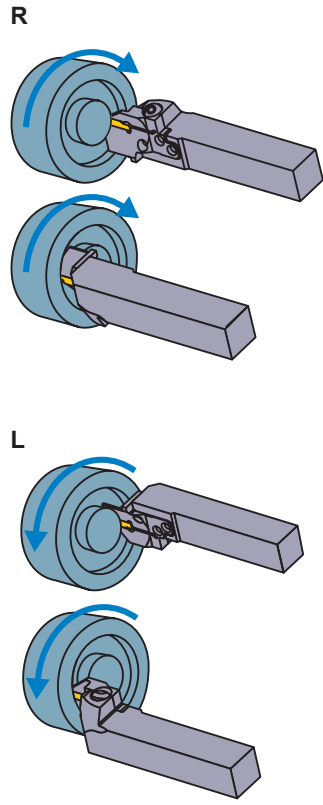
Fig. C



Right hand tool holder shown.

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

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



Select an Insert

Seat Size	Insert Number
E	GY000239/0250/0274E0000-Breaker

For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
E	.094", 2.39mm	●	●	●	●	●
	.098", 2.50mm	●	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			

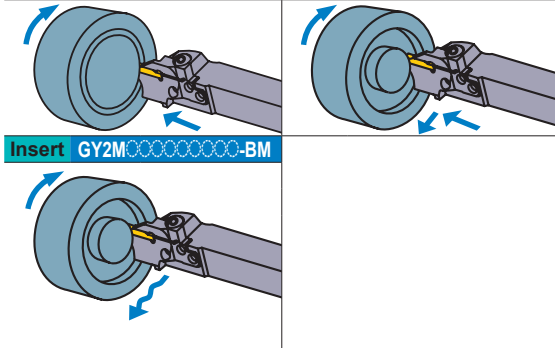
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

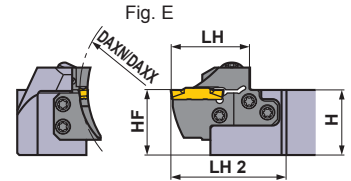
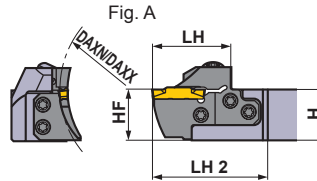
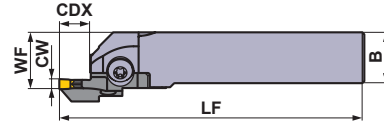
4-2 00° type holder (Metric)

Insert	GY2M ^{GS} _{GM}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GF} _{GS}	Insert	GY2M ^{MM}



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

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



Right hand tool holder shown.

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

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

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

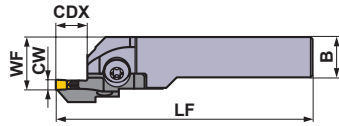
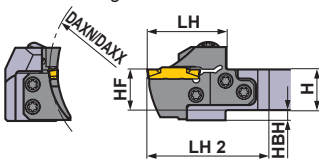


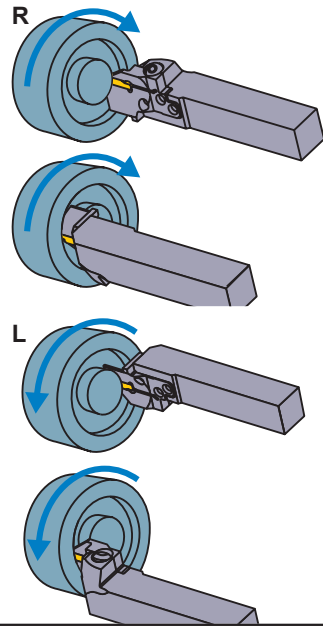
Fig. C



Right hand tool holder shown.

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

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



Select an Insert

Seat Size	Insert Number
E	GY000239/0250/0274E0000-Breaker

For Grooving/Cutting off > F013, F014						
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
E	.094", 2.39mm	●	●	●	●	●
	.098", 2.50mm	●	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			

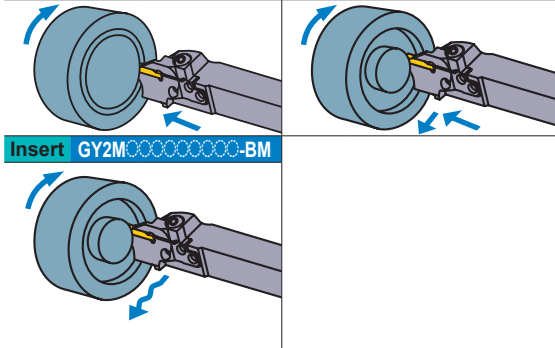
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

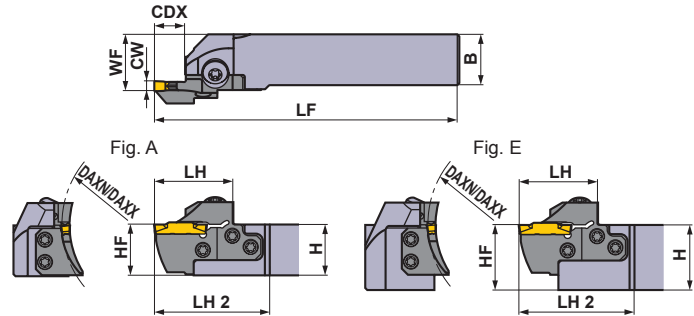
4-2 00° type holder (Metric)

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



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

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



Right hand tool holder shown.

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

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

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

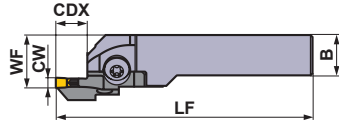
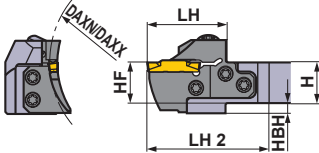


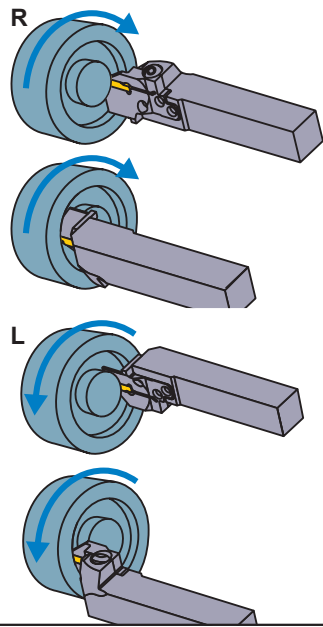
Fig. C



Right hand tool holder shown.

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

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



Select an Insert

Seat Size	Insert Number
F	GY000300/0318/0324F00000-Breaker

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
		F	.118", 3.00mm	●	●
	.125", 3.18mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
		F	.118", 3.00mm		
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm			●	
	.125", 3.18mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	.128", 3.24mm	●			

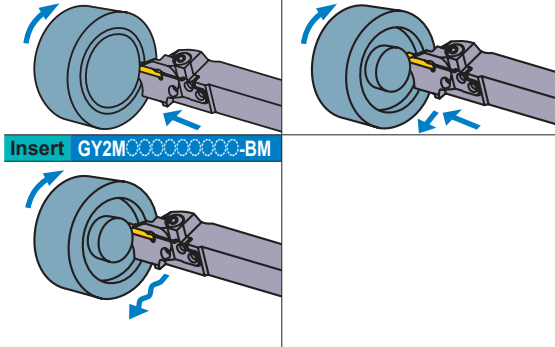
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

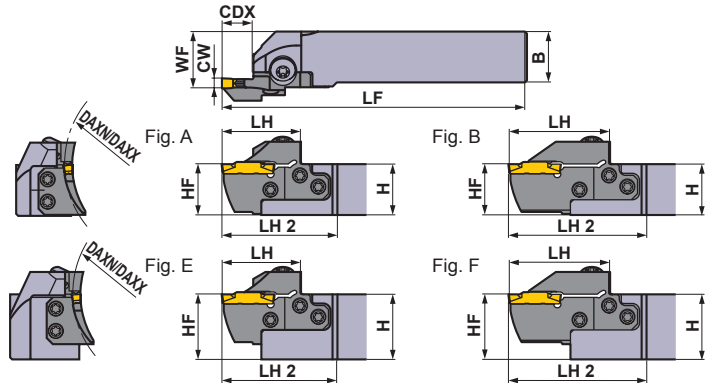
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



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

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

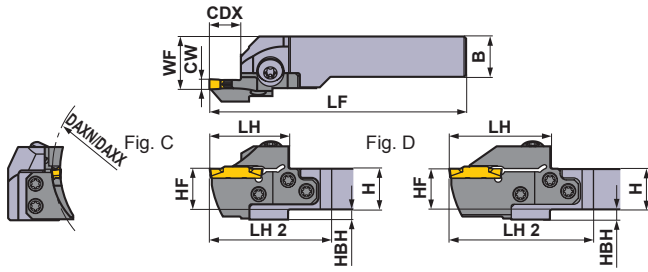


Right hand tool holder shown.

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

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

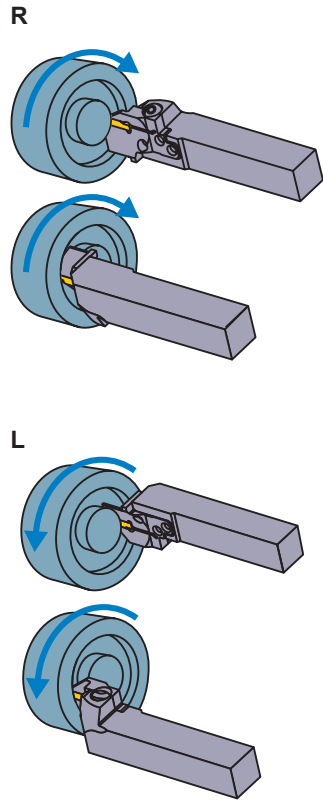


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

Seat Size	Insert Number
F	GY000300/0318/0324F00000-Breaker

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
F	.118", 3.00mm	●	●	●	●
	.125", 3.18mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
F	.118", 3.00mm				●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm			●	
	.125", 3.18mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	.128", 3.24mm	●			

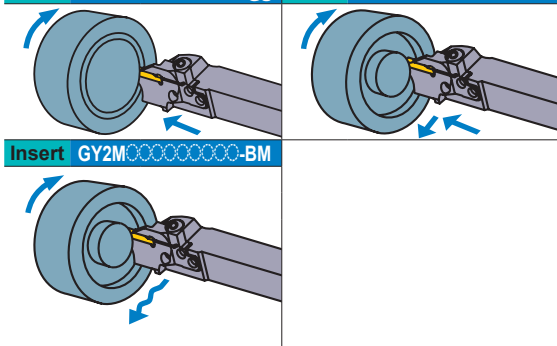
● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F196
 INSTRUCTION MANUAL > F198

GY SERIES (FACE GROOVING)

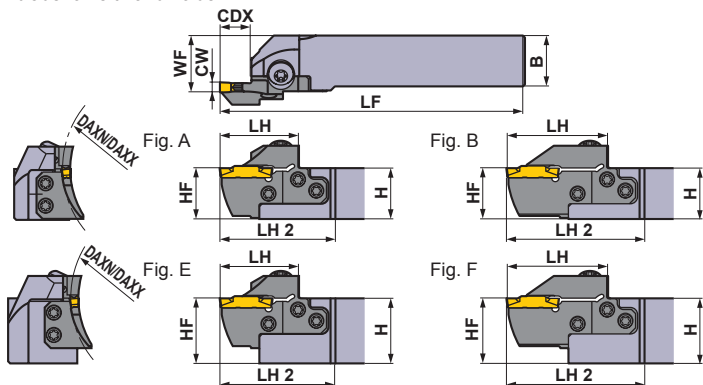
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



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

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

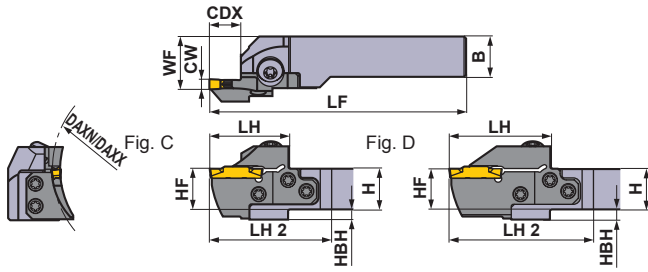


Right hand tool holder shown.

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

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

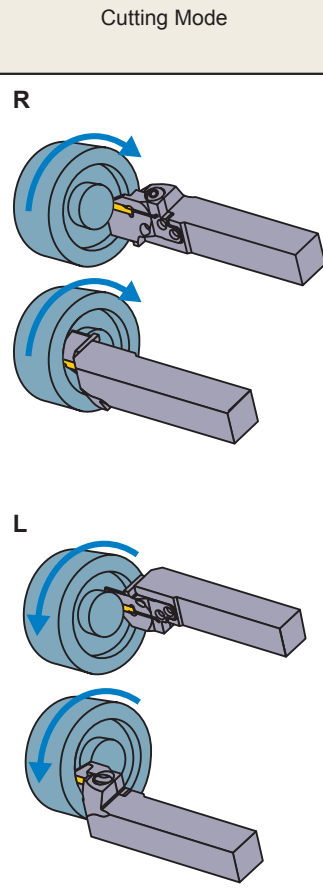


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

Seat Size	Insert Number
F	GY000300/0318/0324F00000-Breaker

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
F	.118", 3.00mm	●	●	●	●
	.125", 3.18mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
F	.118", 3.00mm				●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm			●	
	.125", 3.18mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	.128", 3.24mm	●			

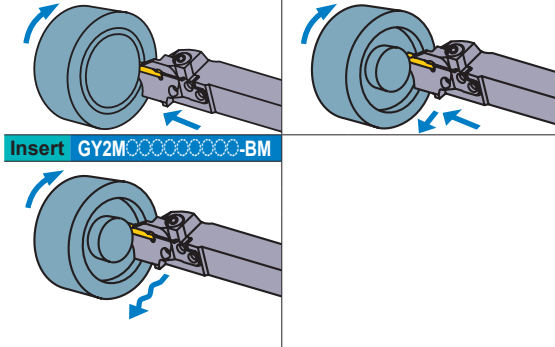
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

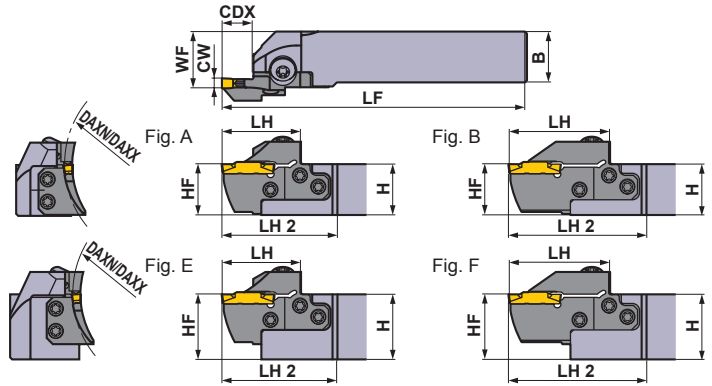
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



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

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

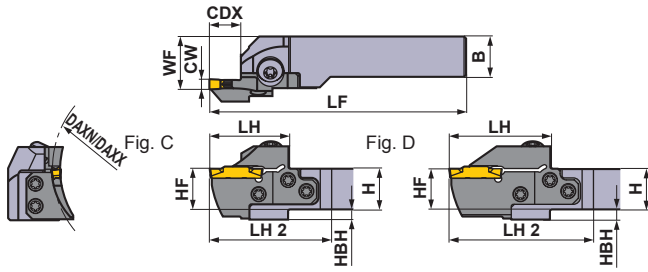


Right hand tool holder shown.

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

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

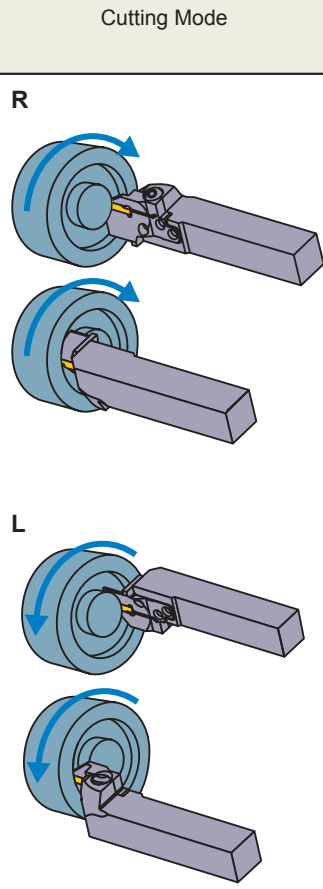


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

Seat Size	Insert Number
F	GY000300/0318/0324F00000-Breaker

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
F	.118", 3.00mm	●	●	●	●
	.125", 3.18mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
F	.118", 3.00mm				●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm			●	
	.125", 3.18mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	.128", 3.24mm	●			

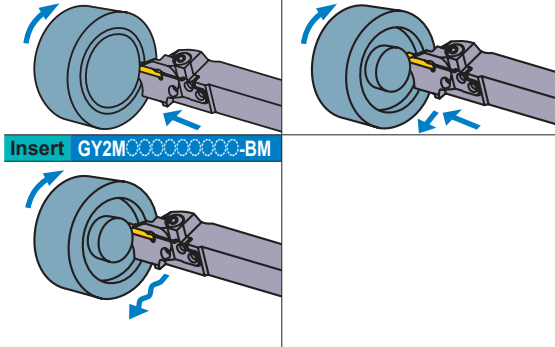
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

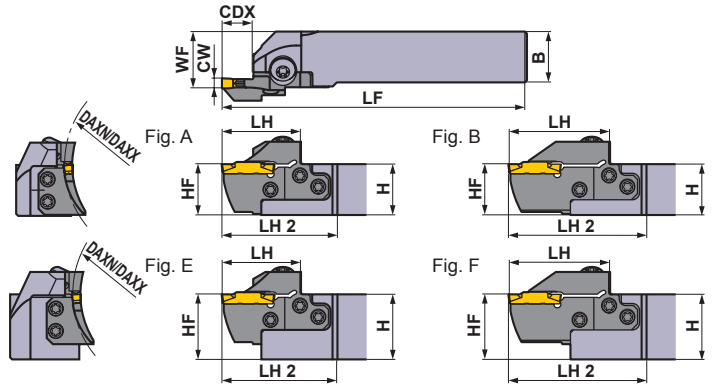
4-2 00° type holder (Metric)

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



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

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

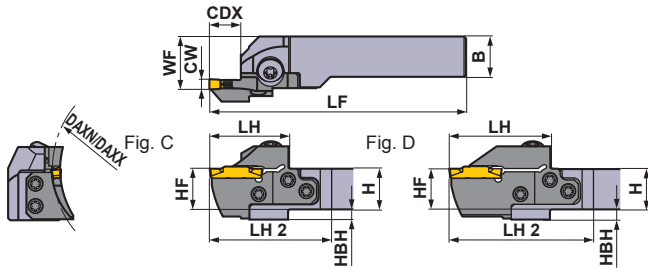


Right hand tool holder shown.

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

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

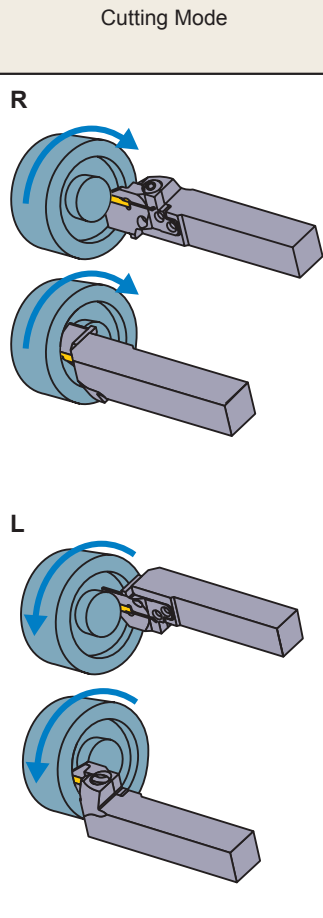


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

		For Grooving/Cutting off > F013, F014			
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
G	.157", 4.00mm	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	Ball nose
	CW				
G	.157", 4.00mm				●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	.167", 4.24mm	●			

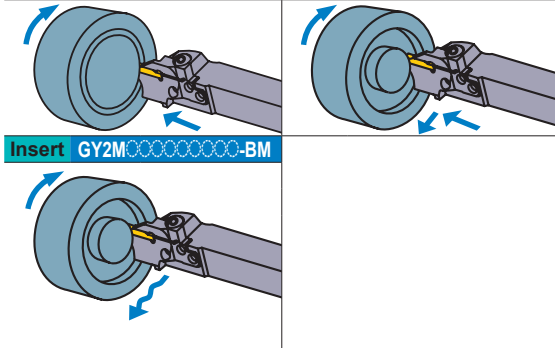
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

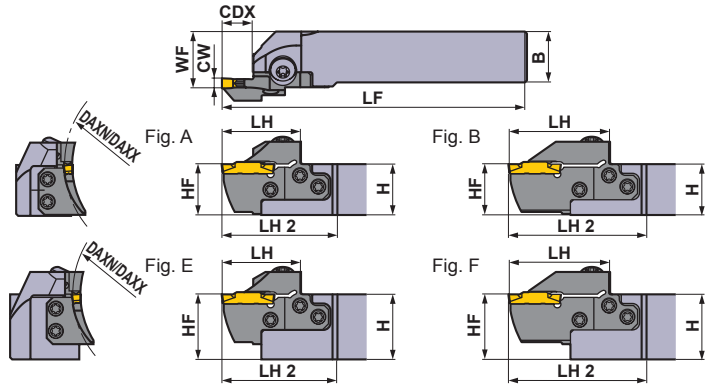
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



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

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

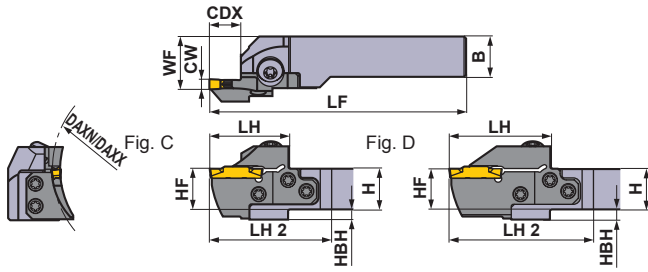


Right hand tool holder shown.

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	4.00	85	125	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-085	●	C
						L	GYHL2020K00-M25L	●	GYM25LD-G14-085	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-085	●	A
						L	GYHL2525M00-M25L	●	GYM25LD-G14-085	●	A
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-085	●	E
						L	GYHL3225P00-M25L	★	GYM25LD-G14-085	●	E
				Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-085	●	E	
					L	GYHL3232P00-M25L	★	GYM25LD-G14-085	●	E	
				Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-085	●	D	
					L	GYHL2020K00-M25L	●	GYM25LD-G25-085	●	D	
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-085	●	B				
		L	GYHL2525M00-M25L	●	GYM25LD-G25-085	●	B				
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-085	●	F				
		L	GYHL3225P00-M25L	★	GYM25LD-G25-085	●	F				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-085	●	F				
		L	GYHL3232P00-M25L	★	GYM25LD-G25-085	●	F				
	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-125	●	C				
		L	GYHL2020K00-M25L	●	GYM25LD-G14-125	●	C				
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-125	●	A				
		L	GYHL2525M00-M25L	●	GYM25LD-G14-125	●	A				
Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-125	●	E					
	L	GYHL3225P00-M25L	★	GYM25LD-G14-125	●	E					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-125	●	E					
	L	GYHL3232P00-M25L	★	GYM25LD-G14-125	●	E					
Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-125	●	D					
	L	GYHL2020K00-M25L	●	GYM25LD-G25-125	●	D					
Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-125	●	B					
	L	GYHL2525M00-M25L	●	GYM25LD-G25-125	●	B					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-125	●	F					
	L	GYHL3225P00-M25L	★	GYM25LD-G25-125	●	F					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-125	●	F					
	L	GYHL3232P00-M25L	★	GYM25LD-G25-125	●	F					

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

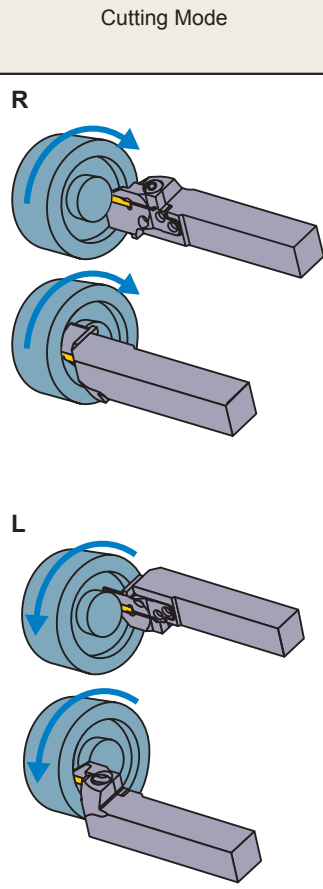


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
G	.157", 4.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
G	.157", 4.00mm				●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	.167", 4.24mm	●			

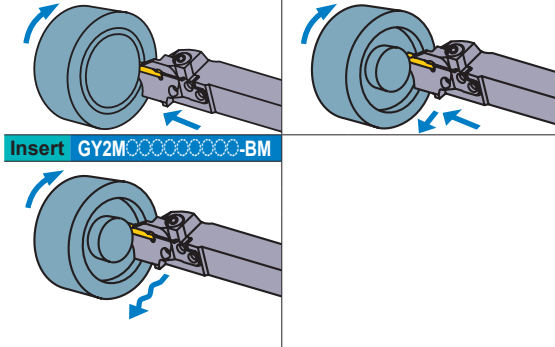
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

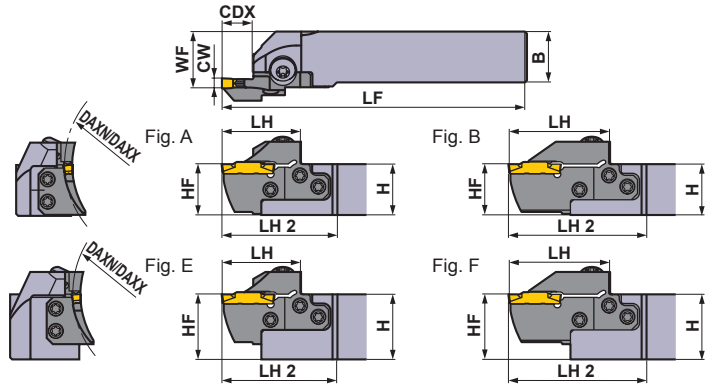
4-2 00° type holder (Metric)

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



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

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



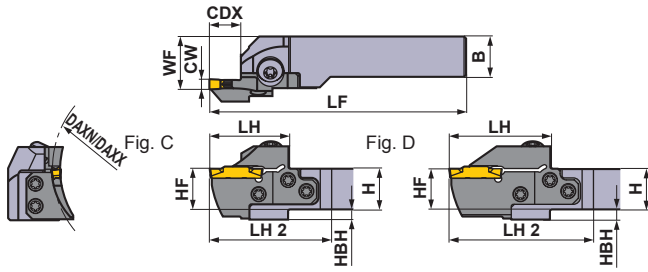
Right hand tool holder shown.

GROOVING

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
G	4.00	180	280	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-180	●	C
						L	GYHL2020K00-M25L	●	GYM25LD-G14-180	●	C
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-G14-180	●	A
						L	GYHL2525M00-M25L	●	GYM25LD-G14-180	●	A
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-G14-180	●	E
						L	GYHL3225P00-M25L	★	GYM25LD-G14-180	●	E
				Modular	R	GYHR3232P00-M25R	★	GYM25RD-G14-180	●	E	
					L	GYHL3232P00-M25L	★	GYM25LD-G14-180	●	E	
				Modular	R	GYHR2020K00-M25R	●	GYM25RD-G25-180	●	D	
					L	GYHL2020K00-M25L	●	GYM25LD-G25-180	●	D	
	Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-180	●	B				
		L	GYHL2525M00-M25L	●	GYM25LD-G25-180	●	B				
	Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-180	●	F				
		L	GYHL3225P00-M25L	★	GYM25LD-G25-180	●	F				
	Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-180	●	F				
		L	GYHL3232P00-M25L	★	GYM25LD-G25-180	●	F				
	4.24	250	999	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-G14-250	●	C
					L	GYHL2020K00-M25L	●	GYM25LD-G14-250	●	C	
	Modular				R	GYHR2525M00-M25R	●	GYM25RD-G14-250	●	A	
					L	GYHL2525M00-M25L	●	GYM25LD-G14-250	●	A	
Modular	R				GYHR3225P00-M25R	★	GYM25RD-G14-250	●	E		
	L				GYHL3225P00-M25L	★	GYM25LD-G14-250	●	E		
Modular	R			GYHR3232P00-M25R	★	GYM25RD-G14-250	●	E			
	L			GYHL3232P00-M25L	★	GYM25LD-G14-250	●	E			
Modular	R			GYHR2020K00-M25R	●	GYM25RD-G25-250	●	D			
	L			GYHL2020K00-M25L	●	GYM25LD-G25-250	●	D			
Modular	R	GYHR2525M00-M25R	●	GYM25RD-G25-250	●	B					
	L	GYHL2525M00-M25L	●	GYM25LD-G25-250	●	B					
Modular	R	GYHR3225P00-M25R	★	GYM25RD-G25-250	●	F					
	L	GYHL3225P00-M25L	★	GYM25LD-G25-250	●	F					
Modular	R	GYHR3232P00-M25R	★	GYM25RD-G25-250	●	F					
	L	GYHL3232P00-M25L	★	GYM25LD-G25-250	●	F					

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.



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

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

Right hand tool holder shown.

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

Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
G	.157", 4.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
G	.157", 4.00mm				●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	.167", 4.24mm	●			

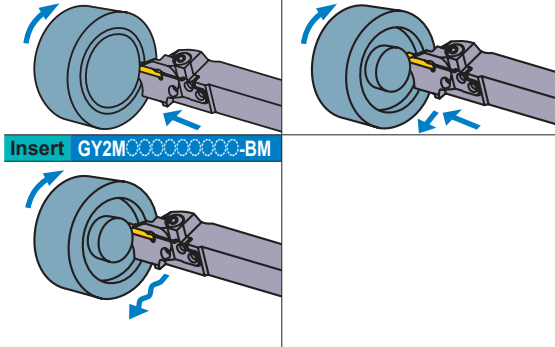
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

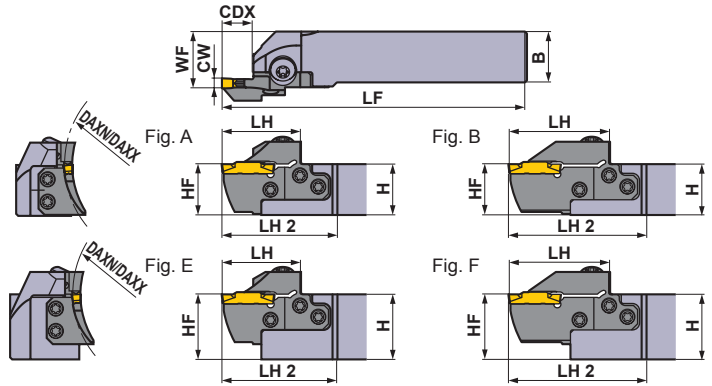
4-2 00° type holder (Metric)

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



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

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

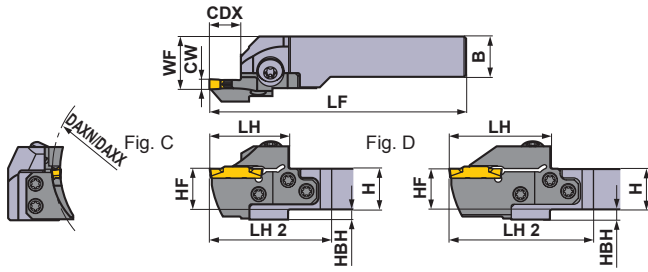


Right hand tool holder shown.

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

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

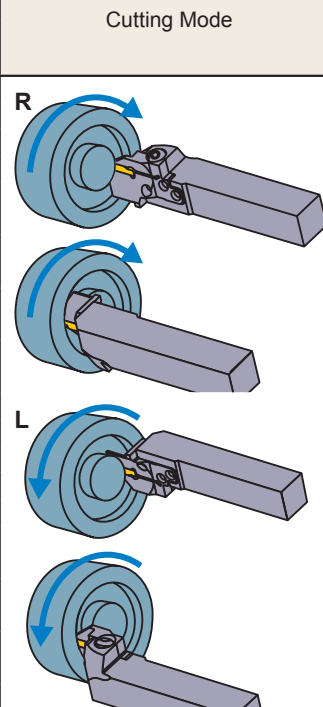


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
		CW			
H	.187", 4.75mm	●	●	●	●
	.197", 5.00mm	●	●	●	●

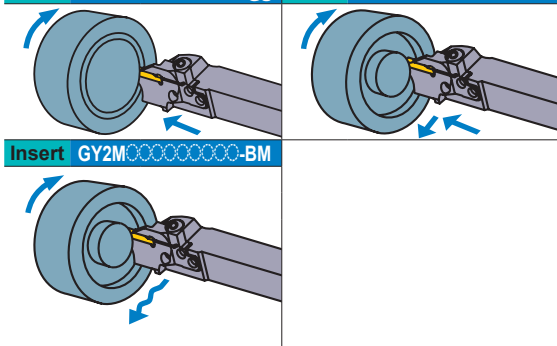
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
		CW			
H	.187", 4.75mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	RE 0.8mm	●			
	.197", 5.00mm				●
	RE 0.2mm	●			
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	.206", 5.24mm	●			

● : Gauge insert shown dimensions

GY SERIES (FACE GROOVING)

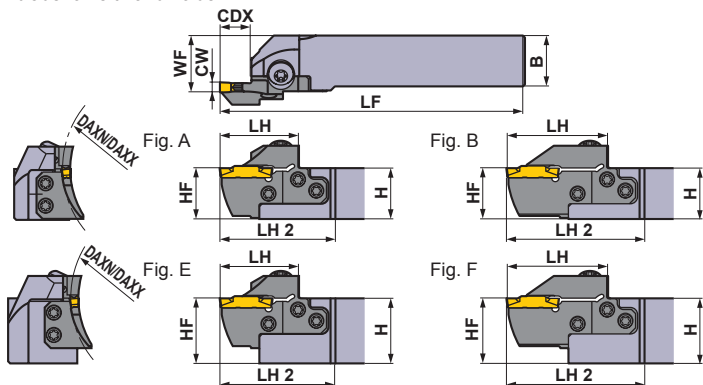
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



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

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

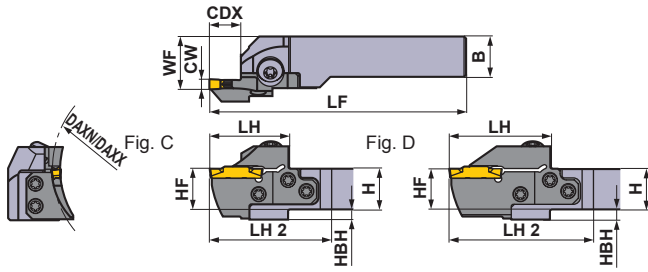


Right hand tool holder shown.

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

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

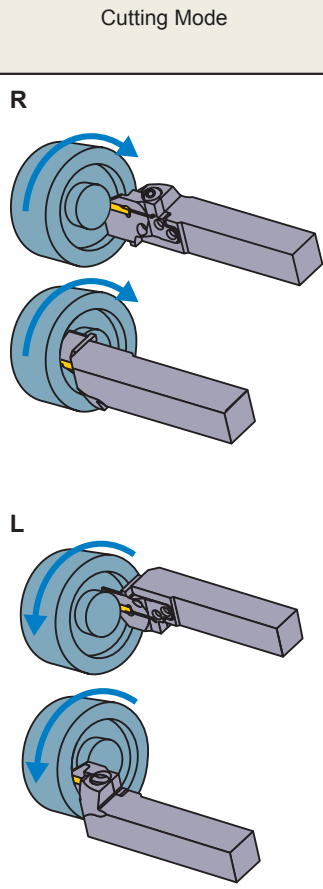


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

Seat Size	Insert Number
H	GY000475/0500/0524H00000-Breaker

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
H	.187", 4.75mm	●	●	●	●
	.197", 5.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
H	.187", 4.75mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	RE 0.8mm	●			
	.197", 5.00mm				●
	RE 0.2mm	●			
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	.206", 5.24mm	●			

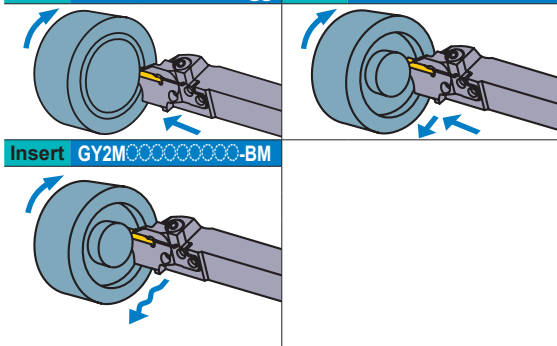
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

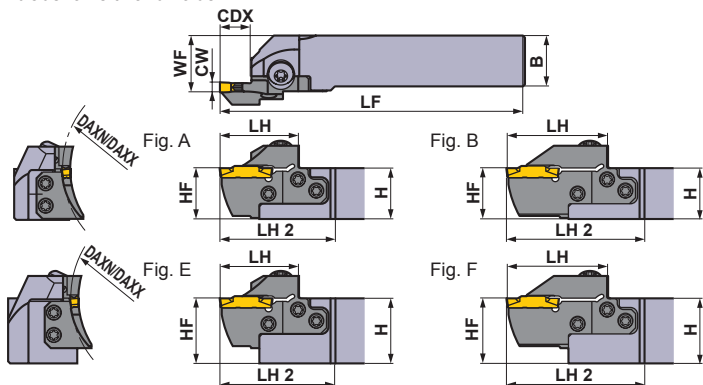
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}



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

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

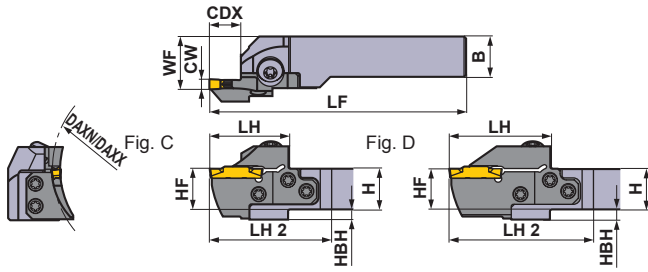


Right hand tool holder shown.

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

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

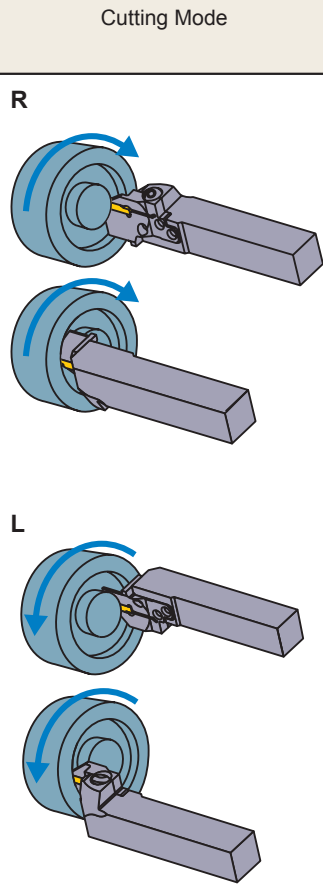


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
H	.187", 4.75mm	●	●	●	●
	.197", 5.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				
H	.187", 4.75mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	RE 0.8mm	●			
	.197", 5.00mm				●
	RE 0.2mm	●			
	RE 0.4mm	●	●	●	
RE 0.8mm	●	●	●		
.206", 5.24mm	●				

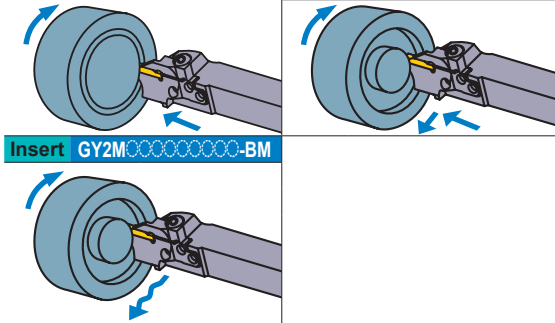
● : Gauge insert shown dimensions

GROOVING

GY SERIES (FACE GROOVING)

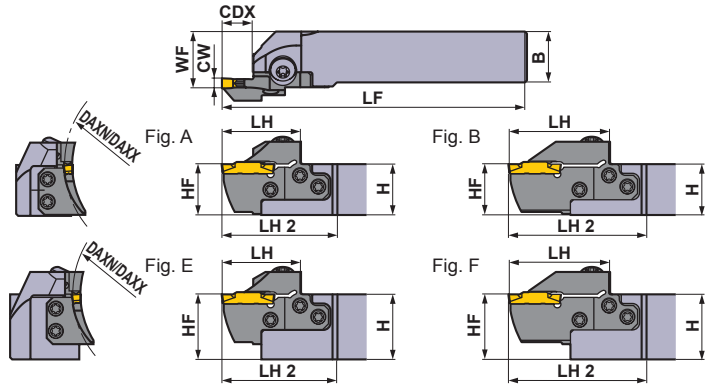
4-2 00° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G
Insert	GY2M	Insert	GY2M
		Insert	GY2M



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

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



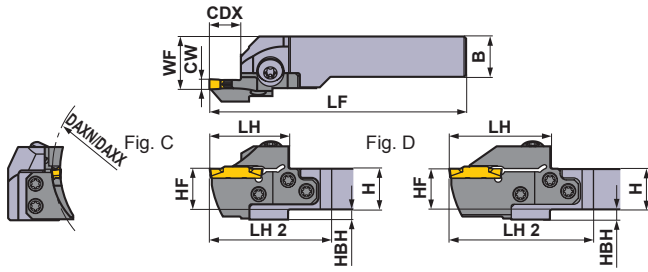
Right hand tool holder shown.

GROOVING

Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.			
							Holder	Stock	Modular Blade	Stock				
J	6.00 6.31 6.35	50	70	14	Modular	R	GYHR2020K00-M25R	●	GYM25RD-J14-050	●	C			
						L	GYHL2020K00-M25L	●	GYM25LD-J14-050	●	C			
					Modular	R	GYHR2525M00-M25R	●	GYM25RD-J14-050	●	A			
						L	GYHL2525M00-M25L	●	GYM25LD-J14-050	●	A			
					Modular	R	GYHR3225P00-M25R	★	GYM25RD-J14-050	●	E			
						L	GYHL3225P00-M25L	★	GYM25LD-J14-050	●	E			
									R	GYHR3232P00-M25R	★	GYM25RD-J14-050	●	E
									L	GYHL3232P00-M25L	★	GYM25LD-J14-050	●	E
									R	GYHR2020K00-M25R	●	GYM25RD-J14-070	●	C
									L	GYHL2020K00-M25L	●	GYM25LD-J14-070	●	C
									R	GYHR2525M00-M25R	●	GYM25RD-J14-070	●	A
									L	GYHL2525M00-M25L	●	GYM25LD-J14-070	●	A
							R	GYHR3225P00-M25R	★	GYM25RD-J14-070	●	E		
							L	GYHL3225P00-M25L	★	GYM25LD-J14-070	●	E		
							R	GYHR3232P00-M25R	★	GYM25RD-J14-070	●	E		
							L	GYHL3232P00-M25L	★	GYM25LD-J14-070	●	E		
							R	GYHR2020K00-M25R	●	GYM25RD-J25-070	●	D		
							L	GYHL2020K00-M25L	●	GYM25LD-J25-070	●	D		
							R	GYHR2525M00-M25R	●	GYM25RD-J25-070	●	B		
							L	GYHL2525M00-M25L	●	GYM25LD-J25-070	●	B		
							R	GYHR3225P00-M25R	★	GYM25RD-J25-070	●	F		
							L	GYHL3225P00-M25L	★	GYM25LD-J25-070	●	F		
							R	GYHR3232P00-M25R	★	GYM25RD-J25-070	●	F		
							L	GYHL3232P00-M25L	★	GYM25LD-J25-070	●	F		
					R	GYHR2020K00-M25R	●	GYM25RD-J14-110	●	C				
					L	GYHL2020K00-M25L	●	GYM25LD-J14-110	●	C				
					R	GYHR2525M00-M25R	●	GYM25RD-J14-110	●	A				
					L	GYHL2525M00-M25L	●	GYM25LD-J14-110	●	A				
					R	GYHR3225P00-M25R	★	GYM25RD-J14-110	●	E				
					L	GYHL3225P00-M25L	★	GYM25LD-J14-110	●	E				
					R	GYHR3232P00-M25R	★	GYM25RD-J14-110	●	E				
					L	GYHL3232P00-M25L	★	GYM25LD-J14-110	●	E				
					R	GYHR2020K00-M25R	●	GYM25RD-J25-110	●	D				
					L	GYHL2020K00-M25L	●	GYM25LD-J25-110	●	D				
					R	GYHR2525M00-M25R	●	GYM25RD-J25-110	●	B				
					L	GYHL2525M00-M25L	●	GYM25LD-J25-110	●	B				
					R	GYHR3225P00-M25R	★	GYM25RD-J25-110	●	F				
					L	GYHL3225P00-M25L	★	GYM25LD-J25-110	●	F				
					R	GYHR3232P00-M25R	★	GYM25RD-J25-110	●	F				
					L	GYHL3232P00-M25L	★	GYM25LD-J25-110	●	F				

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

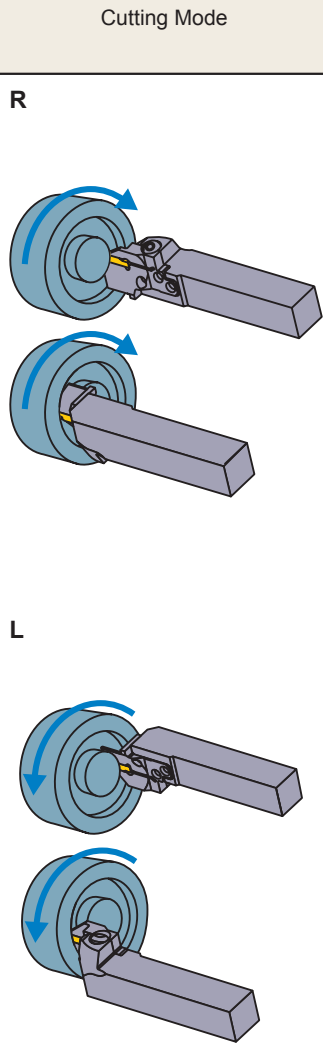


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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



For Grooving/Cutting off > F013					
Seat Size	Breaker	GU	GS	GM	GFGS
		CW			
J	236°, 6.00mm	●	●	●	
	250°, 6.35mm	●	●	●	

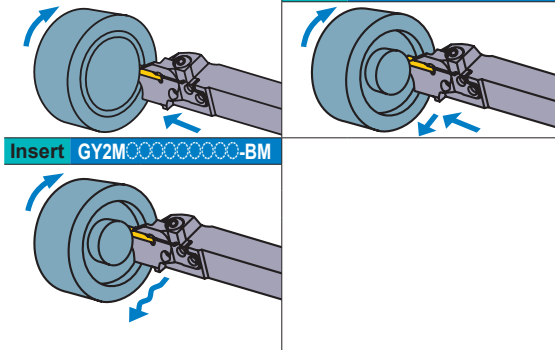
For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
		CW			
J	236°, 6.00mm				●
	RE 0.2mm	●		●	
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	248°, 6.31mm	●			
	250°, 6.35mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
RE 0.8mm	●				

● : Gauge insert shown dimensions

GY SERIES (FACE GROOVING)

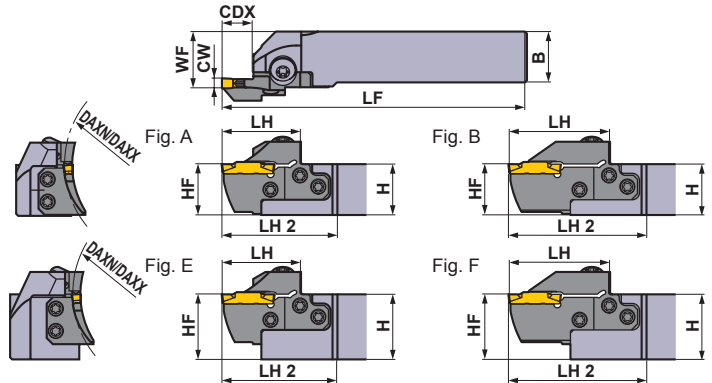
4-2 00° type holder (Metric)

Insert	GY2M ^{GS} 	Insert	GY2G 
Insert	GY2M ^{GU} 	Insert	GY2M 
		Insert	GY2M 



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

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

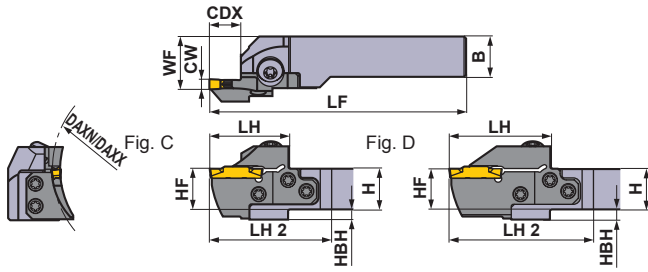


Right hand tool holder shown.

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

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

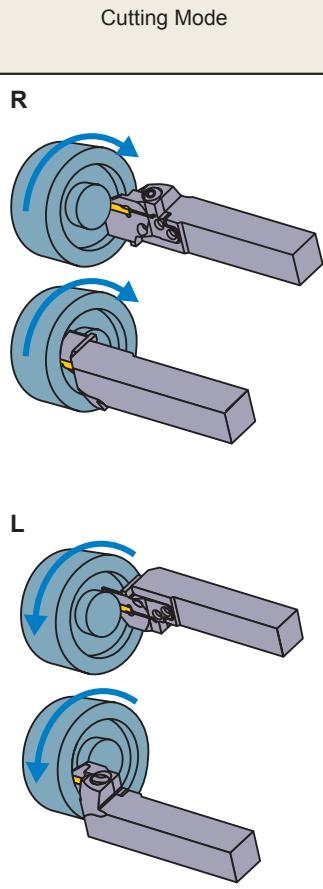


* Wrench : ① : Clamp Screw, ② : Blade Screw

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

Right hand tool holder shown.

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



Select an Insert

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

For Grooving/Cutting off > F013					
Seat Size	Breaker	GU	GS	GM	GFGS
	J	CW 236°, 6.00mm 250°, 6.35mm	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	J	CW 236°, 6.00mm RE 0.2mm RE 0.4mm RE 0.8mm 248°, 6.31mm 250°, 6.35mm RE 0.2mm RE 0.4mm RE 0.8mm			

● : Gauge insert shown dimensions

GROOVING

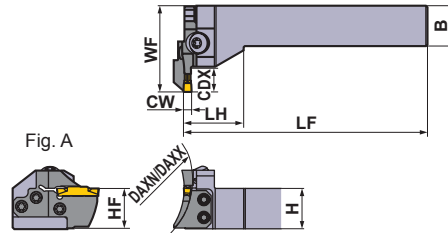
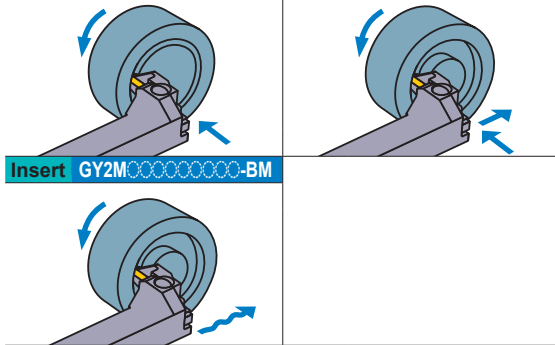
GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}

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

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






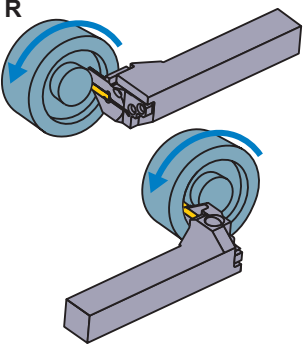
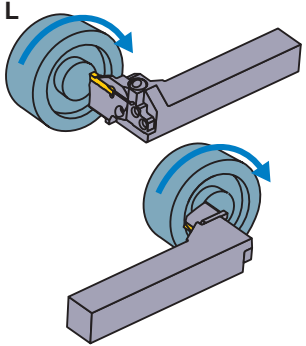
Right hand tool holder shown.

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

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

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

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

	Dimensions (mm) *1						Cutting Mode
	H	B	LF	LH	HF	WF	
	25	25	150	38	25	53	 
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	

Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
D	.079", 2.00mm	●	●	●	●
E	.094", 2.39mm	●	●	●	●
	.098", 2.50mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●			
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			

● : Gauge insert shown dimensions

GROOVING

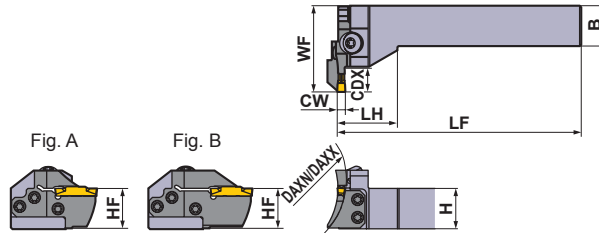
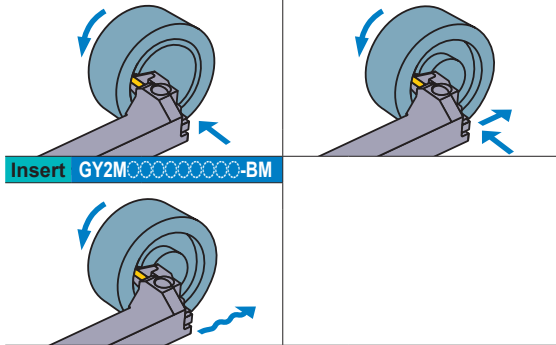
GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}

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

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






Right hand tool holder shown.

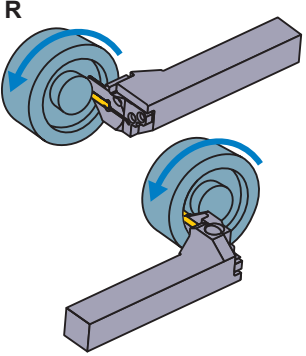
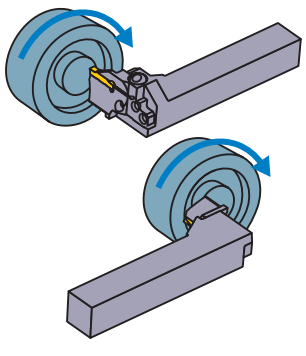
Seat Size	CW (mm)	DAXN (mm)	DAXX (mm)	CDX (mm)	Type	Hand (R/L)	Order Number				Fig.
							Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	100	150	12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-035	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-035	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-040	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-040	●	A
				12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-050	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-050	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-060	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-060	●	A
				12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-075	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-075	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-075	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-075	●	B
				12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-100	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-100	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-100	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-100	●	B
				12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-135	●	A
						L	GYHL2525M90-M25R	●	GYM25RD-F12-135	●	A
				20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-135	●	B
						L	GYHL2525M90-M25R	●	GYM25RD-F20-135	●	B
12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-180	●	A				
		L	GYHL2525M90-M25R	●	GYM25RD-F12-180	●	A				
20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-180	●	B				
		L	GYHL2525M90-M25R	●	GYM25RD-F20-180	●	B				
12	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F12-225	●	A				
		L	GYHL2525M90-M25R	●	GYM25RD-F12-225	●	A				
20 *2	Modular	R	GYHR2525M90-M25L	●	GYM25LD-F20-225	●	B				
		L	GYHL2525M90-M25R	●	GYM25RD-F20-225	●	B				

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

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

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

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

	Dimensions (mm) *1						Cutting Mode
	H	B	LF	LH	HF	WF	
	25	25	150	38	25	53	 
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	59	
	25	25	150	38	25	59	
	25	25	150	38	25	53	
	25	25	150	38	25	53	

Select an Insert

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

		For Grooving/Cutting off > F013, F014				
Seat Size	CW	Breaker	GU	GS	GM	GFGS
		F	.118", 3.00mm	●	●	●
		.125", 3.18mm	●	●	●	●

		For Multifunctional Grooving > F015, F016				
Seat Size	CW	Breaker	MF	MS	MM	BM
		F	.118", 3.00mm			
		RE 0.2mm	●	●	●	
		RE 0.4mm	●	●	●	
		RE 0.8mm			●	
	.125", 3.18mm					●
		RE 0.2mm	●			
		RE 0.4mm	●			
	.128", 3.24mm	●				

● : Gauge insert shown dimensions

GROOVING

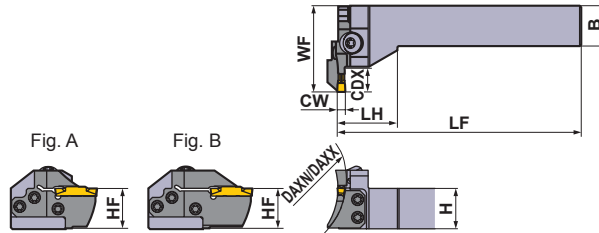
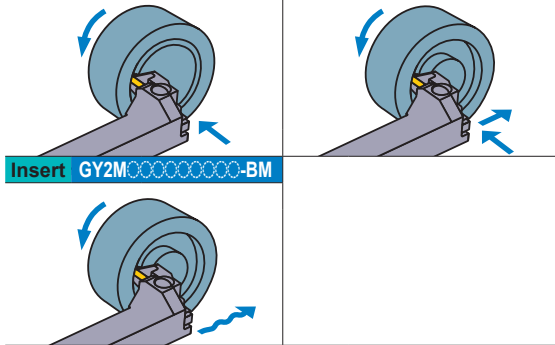
GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}

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

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






Right hand tool holder shown.

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

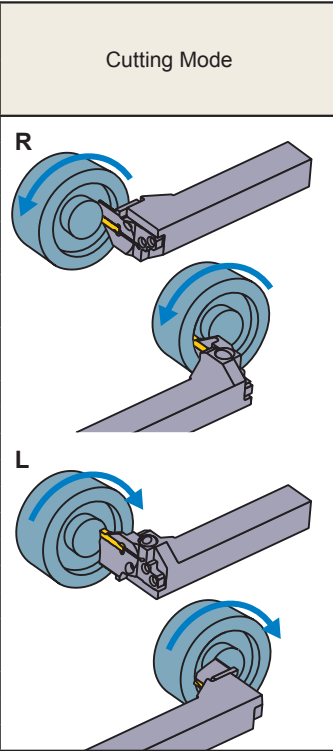
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

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

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

	Dimensions (mm) *1					
	H	B	LF	LH	HF	WF
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64
	25	25	150	38	25	53
	25	25	150	38	25	53
	25	25	150	38	25	64
	25	25	150	38	25	64



Select an Insert

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

For Grooving/Cutting off		> F013, F014			
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
G	.157", 4.00mm	●	●	●	●

For Multifunctional Grooving		> F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
G	.157", 4.00mm				●
	RE 0.2mm	●	●	●	
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	.167", 4.24mm	●			

● : Gauge insert shown dimensions

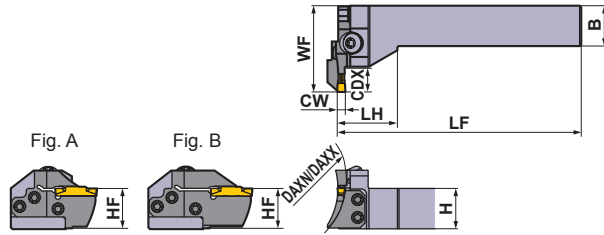
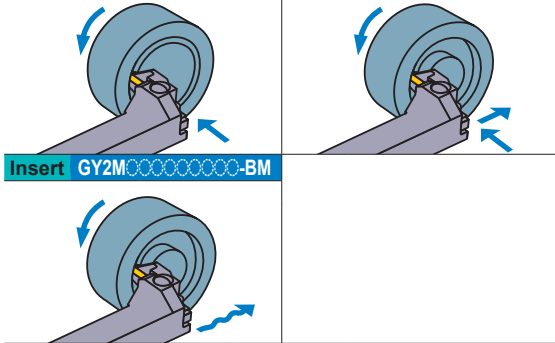
GROOVING

GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}

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






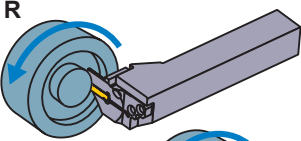
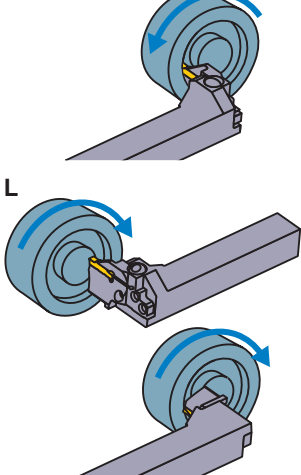
Right hand tool holder shown.

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

*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.
 *2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

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

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

	Dimensions (mm) *1						Cutting Mode
	H	B	LF	LH	HF	WF	
	25	25	150	38	25	53	 
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	
	25	25	150	38	25	64	
	25	25	150	38	25	64	
	25	25	150	38	25	53	
	25	25	150	38	25	53	

Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
		CW			
H	.187", 4.75mm	●	●	●	●
	.197", 5.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
H	.187", 4.75mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	RE 0.8mm	●			
	.197", 5.00mm				●
	RE 0.2mm	●			
H	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
	.206", 5.24mm	●			

● : Gauge insert shown dimensions

GROOVING

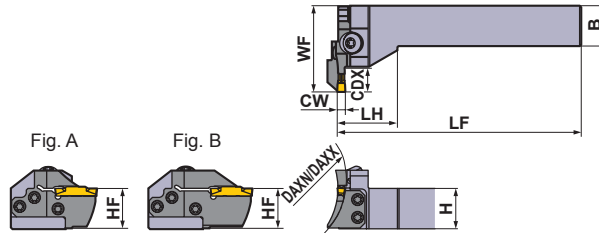
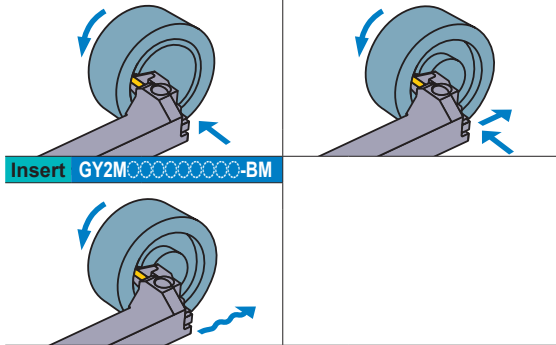
GY SERIES (FACE GROOVING)

5-2 90° type holder (Metric)

Insert	GY2M ^{GS}	Insert	GY2G ^{MF}
Insert	GY2M ^{GU}	Insert	GY2M ^{MS}
Insert	GY1G ^{GS}	Insert	GY2M ^{MM}

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

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






Right hand tool holder shown.

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

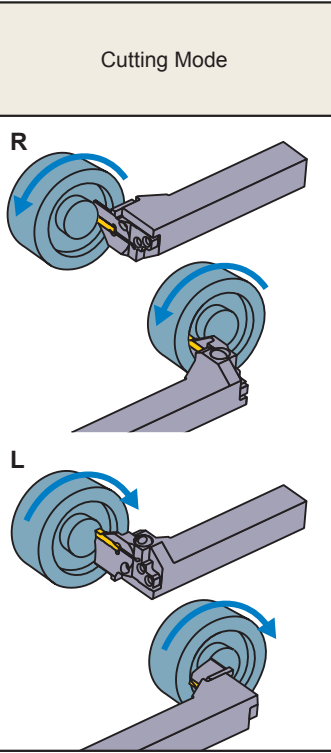
*1 Dimensions shown are when gauge insert is used. If other insert geometries are used then LF, LH, and WF values may vary.

*2 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

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

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

Dimensions (mm) *1							Cutting Mode
H	B	LF	LH	HF	WF		
25	25	150	38	25	53	R	
25	25	150	38	25	53		
25	25	150	38	25	53	R	
25	25	150	38	25	53		
25	25	150	38	25	64	R	
25	25	150	38	25	64		
25	25	150	38	25	53	L	
25	25	150	38	25	53		
25	25	150	38	25	64	L	
25	25	150	38	25	64		
25	25	150	38	25	53	L	
25	25	150	38	25	53		
25	25	150	38	25	64	L	
25	25	150	38	25	64		
25	25	150	38	25	53	L	
25	25	150	38	25	53		
25	25	150	38	25	64	L	
25	25	150	38	25	64		



Select an Insert

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

For Grooving/Cutting off > F013					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
J	236", 6.00mm	●	●	●	
	250", 6.35mm	●	●	●	

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
J	236", 6.00mm				●
	RE 0.2mm	●			
	RE 0.4mm	●	●	●	
	RE 0.8mm	●	●	●	
J	248", 6.31mm	●			
	250", 6.35mm				●
	RE 0.2mm	●			
	RE 0.4mm	●			
	RE 0.8mm	●			

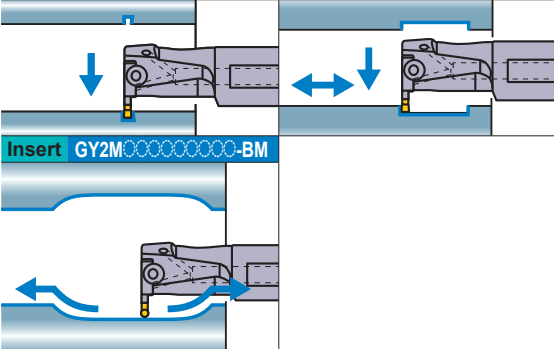
● : Gauge insert shown dimensions

GROOVING

GY SERIES (INTERNAL GROOVING)

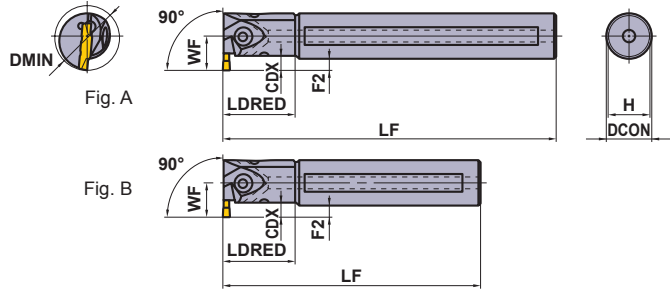
6-1 90° type holder (Inch)

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



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

● Mono block type (Air / coolant through)



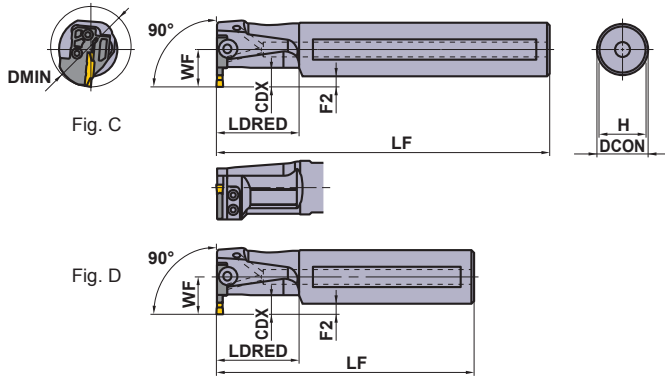
Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch) *3	DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	.079 .088	.236	1.000	Mono Block	R	GYARUS12K90A-D06	●	—	—	A
				Mono Block	L	GYALUS12K90A-D06	●	—	—	A
			Mono Block	R	GYARUS12Q90A-D06	●	—	—	B	
			Mono Block	L	GYALUS12Q90A-D06	●	—	—	B	
			Mono Block	R	GYARUS16K90B-D06	●	—	—	A	
			Mono Block	L	GYALUS16K90B-D06	●	—	—	A	
		.157— .374 *1	1.625	Mono Block	R	GYARUS16R90B-D06	●	—	—	B
				Mono Block	L	GYALUS16R90B-D06	●	—	—	B
			Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-D10	●	C	
			Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-D10	●	C	
		.217— .374 *1	2.000	Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-D10	●	D
				Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-D10	●	D
			Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-D10	●	C	
			Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-D10	●	C	
		.276— .453 *1	2.500	Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-D10	●	D
				Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-D10	●	D
			Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-D12	●	C	
			Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-D12	●	C	
			Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-D12	●	D	
			Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-D12	●	D	
2.750	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-D12	●	C			
	Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-D12	●	C			
				Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-D12	●	D
				Modular	L	GYDLUS32T90F-M25R	●	GYM25RA-D12	●	D

*1 The maximum groove depth varies according to the cutting diameter (DMIN). For details, please refer to page F204.
 *2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and F2 values may vary.
 *3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

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

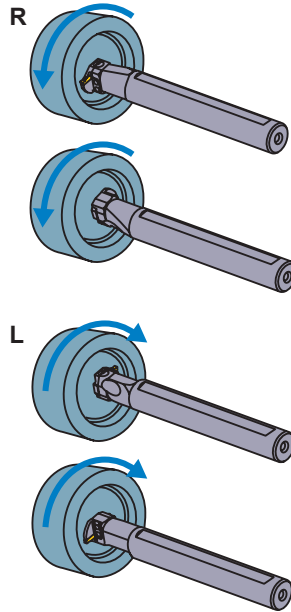


Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/LUS12[○]90A[○]06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/LUS16[○]90B[○]06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYDR/LUS20[○]90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24[○]90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24[○]90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32[○]90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) *2						Cutting Mode
	DCON	LF	LDRED	WF	F2	H	
	.750	5.000	1.250	.605	.230	.671	R
	.750	5.000	1.250	.605	.230	.671	
	.750	7.000	1.250	.605	.230	.671	R
	.750	7.000	1.250	.605	.230	.671	
	1.000	5.000	1.500	.730	.230	.921	R
	1.000	5.000	1.500	.730	.230	.921	
	1.000	8.000	1.500	.730	.230	.921	R
	1.000	8.000	1.500	.730	.230	.921	
	1.250	5.500	2.000	.875	.250	1.171	R
	1.250	5.500	2.000	.875	.250	1.171	
	1.250	10.000	2.000	.875	.250	1.171	R
	1.250	10.000	2.000	.875	.250	1.171	
	1.500	6.000	2.500	1.125	.375	1.382	L
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	
	2.000	6.750	3.250	1.250	.250	1.882	L
	2.000	6.750	3.250	1.250	.250	1.882	
	2.000	12.000	3.250	1.250	.250	1.882	L
	2.000	12.000	3.250	1.250	.250	1.882	



Select an Insert

Seat Size	Insert Number
D	GY [○] 0200/0224D [○] —Breaker

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
D	.079", 2.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
D	.079", 2.00mm	●	●	●	●
D	.088", 2.24mm	●	●	●	●

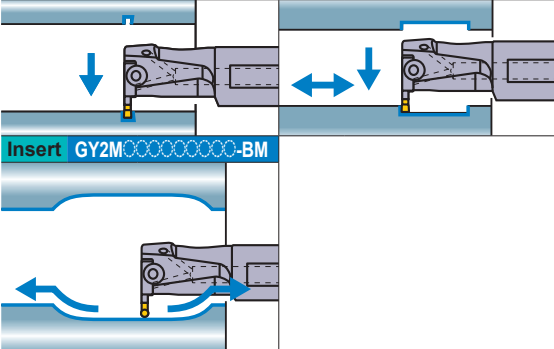
● : Gauge insert shown dimensions

GROOVING

GY SERIES (INTERNAL GROOVING)

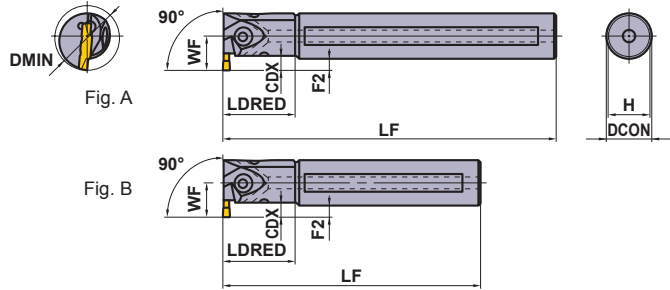
6-1 90° type holder (Inch)

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



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

● Mono block type (Air / coolant through)



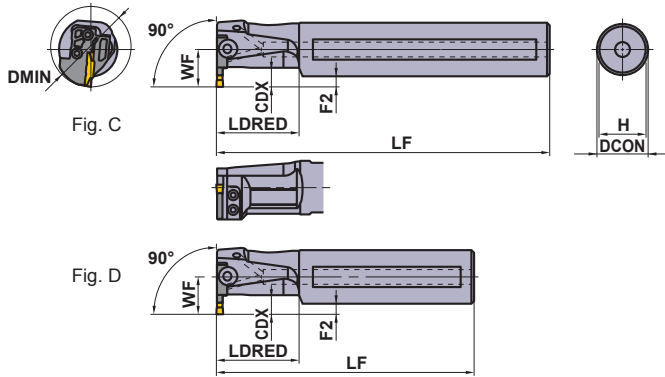
Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch) *3	DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.		
						Holder	Stock	Modular Blade	Stock			
E	.094 .098 .108	.236	1.000	Mono Block	R	GYARUS12K90A-E06	●	—	—	A		
				Mono Block	L	GYALUS12K90A-E06	●	—	—	A		
			Mono Block	R	GYARUS12Q90A-E06	●	—	—	B			
			Mono Block	L	GYALUS12Q90A-E06	●	—	—	B			
			Mono Block	R	GYARUS16K90B-E06	●	—	—	A			
			Mono Block	L	GYALUS16K90B-E06	●	—	—	A			
		.157— .374 *1	1.625	Mono Block	R	GYARUS16R90B-E06	●	—	—	B		
				Mono Block	L	GYALUS16R90B-E06	●	—	—	B		
					2.000	Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-E10	●	C
						Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-E10	●	C
					2.000	Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-E10	●	D
						Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-E10	●	D
		.276— .453 *1			2.500	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-E10	●	C
						Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-E10	●	C
					Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-E10	●	D	
					Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-E10	●	D	
					Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-E12	●	C	
					Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-E12	●	C	
2.750	Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-E12	●	D					
	Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-E12	●	D					
			2.750	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-E12	●	C		
				Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-E12	●	C		
			2.750	Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-E12	●	D		
				Modular	L	GYDLUS32T90F-M25R	●	GYM25RA-E12	●	D		

*1 The maximum groove depth varies according to the cutting diameter (DMIN). For details, please refer to page F204.
 *2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and F2 values may vary.
 *3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

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

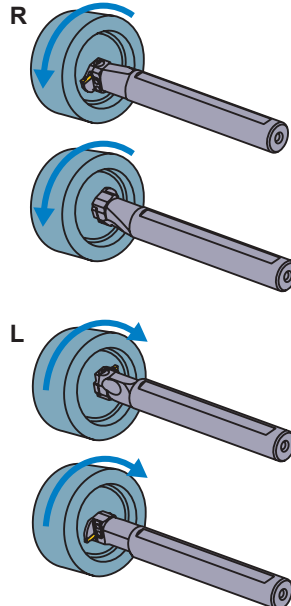


Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/LUS12[○]90A[○]06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/LUS16[○]90B[○]06	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS20[○]90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS24[○]90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS24[○]90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32[○]90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) *2						Cutting Mode
	DCON	LF	LDRED	WF	F2	H	
	.750	5.000	1.250	.605	.230	.671	R
	.750	5.000	1.250	.605	.230	.671	
	.750	7.000	1.250	.605	.230	.671	R
	.750	7.000	1.250	.605	.230	.671	
	1.000	5.000	1.500	.730	.230	.921	R
	1.000	5.000	1.500	.730	.230	.921	
	1.000	8.000	1.500	.730	.230	.921	R
	1.000	8.000	1.500	.730	.230	.921	
	1.250	5.500	2.000	.875	.250	1.171	R
	1.250	5.500	2.000	.875	.250	1.171	
	1.250	10.000	2.000	.875	.250	1.171	R
	1.250	10.000	2.000	.875	.250	1.171	
	1.500	6.000	2.500	1.125	.375	1.382	L
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	
	1.500	6.000	2.500	1.125	.375	1.382	L
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	
	2.000	6.750	3.250	1.250	.250	1.882	L
	2.000	6.750	3.250	1.250	.250	1.882	
	2.000	12.000	3.250	1.250	.250	1.882	L
	2.000	12.000	3.250	1.250	.250	1.882	



Select an Insert

Seat Size	Insert Number
E	GY [○] 0239/0250/0274E [○] 0000-Breaker

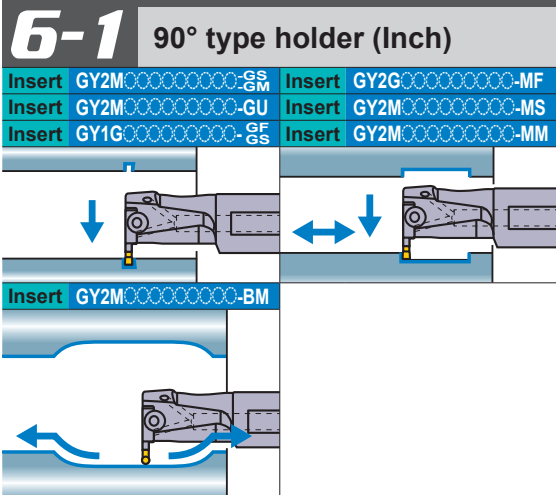
		For Grooving/Cutting off > F013, F014				
Seat Size	CW	Breaker	GU	GS	GM	GFGS
		E	.094", 2.39mm	●	●	●
	.098", 2.50mm	●	●	●	●	

		For Multifunctional Grooving > F015, F016				
Seat Size	CW	Breaker	MF	MS	MM	BM
		E	.094", 2.39mm	●		
	.098", 2.50mm	●	●	●	●	
	.108", 2.74mm	●				

● : Gauge insert shown dimensions

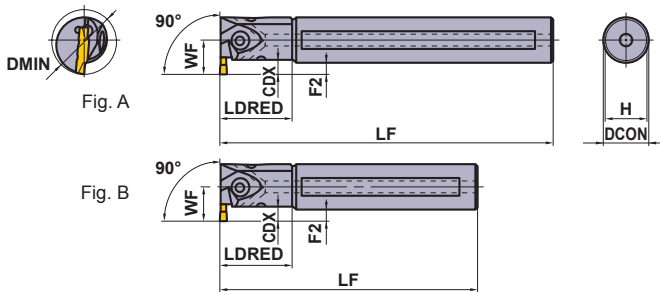
GROOVING

GY SERIES (INTERNAL GROOVING)



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

● Mono block type (Air / coolant through)



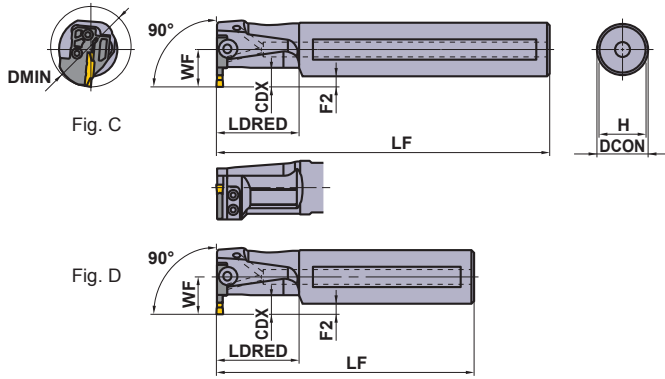
Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch) *3	DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	.118 .125 .128	.236	1.000	Mono Block	R	GYARUS12K90A-F06	●	—	—	A
				Mono Block	L	GYALUS12K90A-F06	●	—	—	A
			Mono Block	R	GYARUS12Q90A-F06	●	—	—	B	
			Mono Block	L	GYALUS12Q90A-F06	●	—	—	B	
		1.250	Mono Block	R	GYARUS16K90B-F06	●	—	—	A	
			Mono Block	L	GYALUS16K90B-F06	●	—	—	A	
		1.625	Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-F10	●	C	
			Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-F10	●	C	
	.157 - .374 *1	2.000	Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-F10	●	D	
			Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-F10	●	D	
		2.500	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-F10	●	C	
			Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-F10	●	C	
	.217 - .374 *1	2.000	Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-F10	●	D	
			Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-F10	●	D	
		2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-F12	●	C	
			Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-F12	●	C	
.276 - .453 *1	2.500	Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-F12	●	D		
		Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-F12	●	D		
	2.750	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-F12	●	C		
		Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-F12	●	C		
G	.157 .167	.276	1.250	Mono Block	R	GYARUS16K90B-G07	●	—	—	A
				Mono Block	L	GYALUS16K90B-G07	●	—	—	A
		.197 - .453 *1	1.625	Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-G12	●	C
				Modular	L	GYDLUS20L90C-M20R	●	GYM20RA-G12	●	C
		.236 - .453 *1	2.000	Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-G12	●	D
				Modular	L	GYDLUS20S90C-M20R	●	GYM20RA-G12	●	D
			2.000	Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-G12	●	C
				Modular	L	GYDLUS24M90D-M20R	●	GYM20RA-G12	●	C
	.295 - .512 *1	2.750	Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-G12	●	D	
			Modular	L	GYDLUS24T90D-M20R	●	GYM20RA-G12	●	D	
		2.750	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-G14	●	C	
			Modular	L	GYDLUS32P90F-M25R	●	GYM25RA-G14	●	C	
	.315 - .512 *1	2.500	Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-G14	●	D	
			Modular	L	GYDLUS32T90F-M25R	●	GYM25RA-G14	●	D	
		2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-G14	●	C	
			Modular	L	GYDLUS24M90D-M25R	●	GYM25RA-G14	●	C	
2.500	2.500	Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-G14	●	D		
		Modular	L	GYDLUS24T90D-M25R	●	GYM25RA-G14	●	D		

*1 The maximum groove depth varies according to the cutting diameter (DMIN). For details, please refer to page F204.
 *2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and F2 values may vary.
 *3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

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



Right hand tool holder shown.

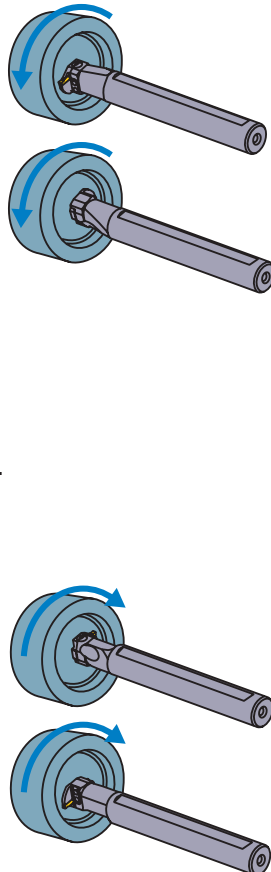
SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/LUS12○90A-F06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/LUS16○90B-○○○	—	—	—
GYDR/LUS20○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS24○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (inch) *2						Cutting Mode
	DCON	LF	LDRED	WF	F2	H	
	.750	5.000	1.250	.605	.230	.671	R
	.750	5.000	1.250	.605	.230	.671	
	.750	7.000	1.250	.605	.230	.671	R
	.750	7.000	1.250	.605	.230	.671	
	1.000	5.000	1.500	.730	.230	.921	R
	1.000	5.000	1.500	.730	.230	.921	
	1.000	8.000	1.500	.730	.230	.921	R
	1.000	8.000	1.500	.730	.230	.921	
	1.250	5.500	2.000	.875	.250	1.171	R
	1.250	5.500	2.000	.875	.250	1.171	
	1.250	10.000	2.000	.875	.250	1.171	R
	1.250	10.000	2.000	.875	.250	1.171	
	1.500	6.000	2.500	1.125	.375	1.382	R
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	R
	1.500	12.000	2.500	1.125	.375	1.382	
	1.500	6.000	2.500	1.125	.375	1.382	R
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	R
	1.500	12.000	2.500	1.125	.375	1.382	
	2.000	6.750	3.250	1.250	.250	1.882	L
	2.000	6.750	3.250	1.250	.250	1.882	
	2.000	12.000	3.250	1.250	.250	1.882	L
	2.000	12.000	3.250	1.250	.250	1.882	
	1.000	5.000	1.500	.730	.230	.921	L
	1.000	5.000	1.500	.730	.230	.921	
	1.000	8.000	1.500	.730	.230	.921	L
	1.000	8.000	1.500	.730	.230	.921	
	1.250	5.500	2.000	.875	.250	1.171	L
	1.250	5.500	2.000	.875	.250	1.171	
	1.250	10.000	2.000	.875	.250	1.171	L
	1.250	10.000	2.000	.875	.250	1.171	
	1.500	6.000	2.500	1.125	.375	1.382	L
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	
	2.000	6.750	3.250	1.250	.250	1.882	L
	2.000	6.750	3.250	1.250	.250	1.882	
	2.000	12.000	3.250	1.250	.250	1.882	L
	2.000	12.000	3.250	1.250	.250	1.882	
	1.500	6.000	2.500	1.125	.375	1.382	L
	1.500	6.000	2.500	1.125	.375	1.382	
	1.500	12.000	2.500	1.125	.375	1.382	L
	1.500	12.000	2.500	1.125	.375	1.382	

R

L



Select an Insert

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

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker CW	GU	GS	GM	GFGS	
		F	.118", 3.00mm .125", 3.18mm	●	●	●

		For Multifunctional Grooving > F015, F016				
Seat Size	Breaker CW	MF	MS	MM	BM	
		F	.118", 3.00mm RE .008" RE .016" RE .031" .125", 3.18mm RE .008" RE .016" .128", 3.24mm	●	●	●

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

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker CW	GU	GS	GM	GFGS	
		G	.157", 4.00mm	●	●	●

		For Multifunctional Grooving > F015, F016				
Seat Size	Breaker CW	MF	MS	MM	BM	
		G	.157", 4.00mm RE .008" RE .016" RE .031" .167", 4.24mm	●	●	●

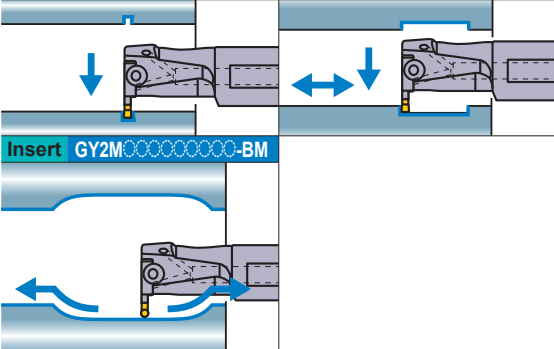
● : Gauge insert shown dimensions

IDENTIFICATION > F010, F011
CUTTING CONDITIONS > F204
INSTRUCTION MANUAL > F206

GY SERIES (INTERNAL GROOVING)

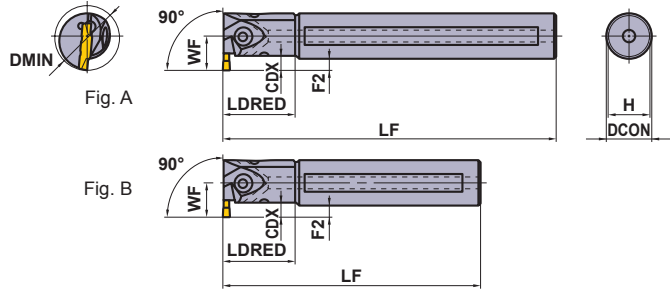
6-1 90° type holder (Inch)

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



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

● Mono block type (Air / coolant through)



Right hand tool holder shown.

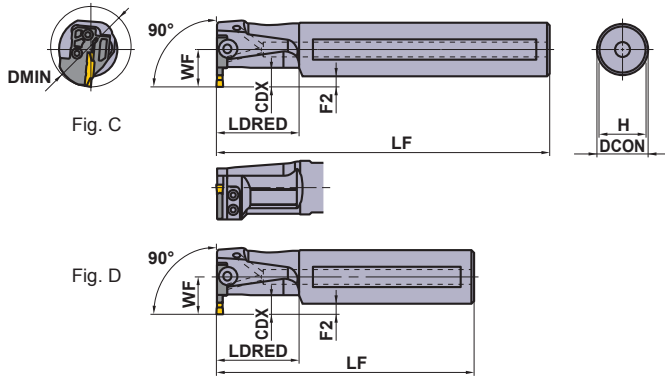
GROOVING

Seat Size	CW (inch)	CDX (inch) *3	DMIN (inch)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
H	.187 .197 .206	.276	1.250	Mono Block	R	GYARUS16K90B-H07	●	—	—	A
				Mono Block	L	GYALUS16K90B-H07	●	—	—	A
				Mono Block	R	GYARUS16R90B-H07	●	—	—	B
				Mono Block	L	GYALUS16R90B-H07	●	—	—	B
		.197 - .453 *1	1.625	Modular	R	GYDRUS20L90C-M20L	●	GYM20LA-H12	●	C
					L	GYDLUS20L90C-M20R	●	GYM20RA-H12	●	C
				Modular	R	GYDRUS20S90C-M20L	●	GYM20LA-H12	●	D
					L	GYDLUS20S90C-M20R	●	GYM20RA-H12	●	D
				Modular	R	GYDRUS24M90D-M20L	●	GYM20LA-H12	●	C
					L	GYDLUS24M90D-M20R	●	GYM20RA-H12	●	C
				Modular	R	GYDRUS24T90D-M20L	●	GYM20LA-H12	●	D
					L	GYDLUS24T90D-M20R	●	GYM20RA-H12	●	D
		.295 - .512 *1	2.750	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-H14	●	C
					L	GYDLUS32P90F-M25R	●	GYM25RA-H14	●	C
Modular	R			GYDRUS32T90F-M25L	●	GYM25LA-H14	●	D		
	L			GYDLUS32T90F-M25R	●	GYM25RA-H14	●	D		
.315 - .512 *1	2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-H14	●	C		
			L	GYDLUS24M90D-M25R	●	GYM25RA-H14	●	C		
		Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-H14	●	D		
			L	GYDLUS24T90D-M25R	●	GYM25RA-H14	●	D		
J	.236 .248 .250	.295 - .512 *1	2.750	Modular	R	GYDRUS32P90F-M25L	●	GYM25LA-J14	●	C
					L	GYDLUS32P90F-M25R	●	GYM25RA-J14	●	C
				Modular	R	GYDRUS32T90F-M25L	●	GYM25LA-J14	●	D
					L	GYDLUS32T90F-M25R	●	GYM25RA-J14	●	D
		.315 - .512 *1	2.500	Modular	R	GYDRUS24M90D-M25L	●	GYM25LA-J14	●	C
					L	GYDLUS24M90D-M25R	●	GYM25RA-J14	●	C
				Modular	R	GYDRUS24T90D-M25L	●	GYM25LA-J14	●	D
					L	GYDLUS24T90D-M25R	●	GYM25RA-J14	●	D

*1 The maximum groove depth varies according to the cutting diameter (DMIN). For details, please refer to page F204.
 *2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and F2 values may vary.
 *3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

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

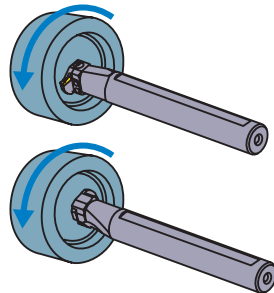


Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/LUS16○90B○07	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYDR/LUS20○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/LUS24○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/LUS32○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

Dimensions (inch) *2						Cutting Mode
DCON	LF	LDRED	WF	F2	H	
1.000	5.000	1.500	.730	.230	.921	R
1.000	5.000	1.500	.730	.230	.921	
1.000	8.000	1.500	.730	.230	.921	
1.000	8.000	1.500	.730	.230	.921	
1.250	5.500	2.000	.875	.250	1.171	L
1.250	5.500	2.000	.875	.250	1.171	
1.250	10.000	2.000	.875	.250	1.171	
1.250	10.000	2.000	.875	.250	1.171	
1.500	6.000	2.500	1.125	.375	1.382	
1.500	6.000	2.500	1.125	.375	1.382	
1.500	12.000	2.500	1.125	.375	1.382	
1.500	12.000	2.500	1.125	.375	1.382	
2.000	6.750	3.250	1.250	.250	1.882	
2.000	6.750	3.250	1.250	.250	1.882	
2.000	12.000	3.250	1.250	.250	1.882	
2.000	12.000	3.250	1.250	.250	1.882	
1.500	6.000	2.500	1.125	.375	1.382	R
1.500	6.000	2.500	1.125	.375	1.382	
1.500	12.000	2.500	1.125	.375	1.382	
1.500	12.000	2.500	1.125	.375	1.382	
2.000	6.750	3.250	1.250	.250	1.882	
2.000	6.750	3.250	1.250	.250	1.882	
2.000	12.000	3.250	1.250	.250	1.882	
2.000	12.000	3.250	1.250	.250	1.882	
1.500	6.000	2.500	1.125	.375	1.382	
1.500	6.000	2.500	1.125	.375	1.382	
1.500	12.000	2.500	1.125	.375	1.382	
1.500	12.000	2.500	1.125	.375	1.382	



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		H	.187", 4.75mm .197", 5.00mm	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker CW	MF	MS	MM	BM
		H	.187", 4.75mm RE .008" RE .016" RE .031" .197", 5.00mm RE .008" RE .016" RE .031" .206", 5.24mm	●	●

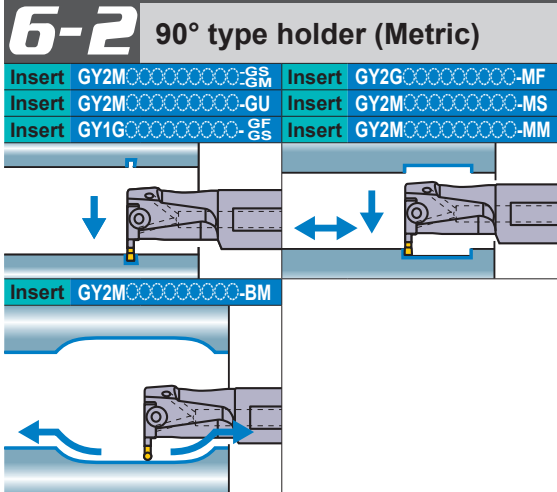
Seat Size	Insert Number
J	GY○○0600/0631/0635J○○○○-Breaker

For Grooving/Cutting off > F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		J	.236", 6.00mm .250", 6.35mm	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker CW	MF	MS	MM	BM
		J	.236", 6.00mm RE .008" RE .016" RE .031" .248", 6.31mm .250", 6.35mm RE .008" RE .016" RE .031"	●	●

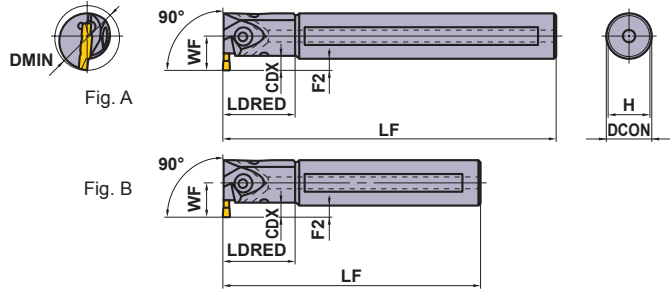
● : Gauge insert shown dimensions

GY SERIES (INTERNAL GROOVING)



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

● Mono block type (Air / coolant through)



Right hand tool holder shown.

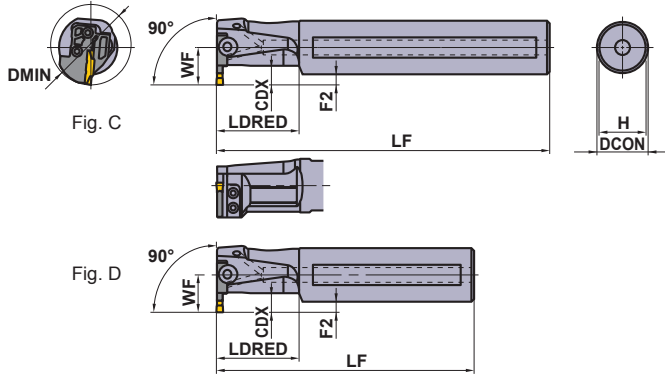
GROOVING

Seat Size	CW (mm)	CDX (mm) *3	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
D	2.00 2.24	6	25	Mono Block	R	GYAR20K90A-D06	●	—	—	B
				Mono Block	L	GYAL20K90A-D06	●	—	—	B
			Mono Block	R	GYAR20Q90A-D06	●	—	—	A	
			Mono Block	L	GYAL20Q90A-D06	●	—	—	A	
			Mono Block	R	GYAR25K90B-D06	●	—	—	B	
			Mono Block	L	GYAL25K90B-D06	●	—	—	B	
		4—9.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-D10	●	D
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-D10	●	D
			Modular	R	GYDR32S90C-M20L	●	GYM20LA-D10	●	C	
			Modular	L	GYDL32S90C-M20R	●	GYM20RA-D10	●	C	
			50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-D10	●	D
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-D10	●	D
		7—11.5 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-D12	●	D
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-D12	●	D
			Modular	R	GYDR40T90D-M25L	●	GYM25LA-D12	●	C	
			Modular	L	GYDL40T90D-M25R	●	GYM25RA-D12	●	C	
			70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-D12	●	D
				Modular	L	GYDL50P90F-M25R	●	GYM25RA-D12	●	D
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-D12	●	C
				Modular	L	GYDL50T90F-M25R	●	GYM25RA-D12	●	C

*1 The maximum groove depth varies according to the cutting diameter (DMIN). For details, please refer to page F204.
 *2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and F2 values may vary.
 *3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

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

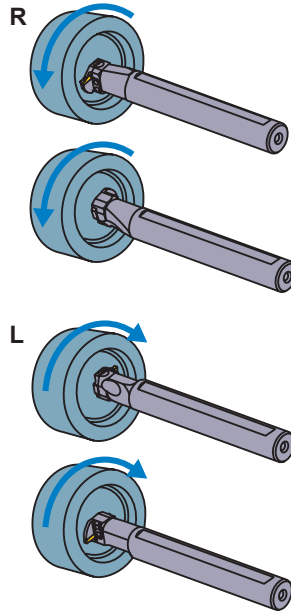


Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/L20 ○90A-○06	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/L25 ○90B-○06	—	—	—
GYDR/L32 ○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40 ○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L40 ○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L50 ○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *2						Cutting Mode
	DCON	LF	LDRED	WF	F2	H	
	20	125	30	14.5	4.5	18	R
	20	125	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	R
	20	180	30	14.5	4.5	18	
	25	125	40	19.0	6.5	23	R
	25	125	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	R
	25	200	40	19.0	6.5	23	
	32	140	50	22.0	6.0	30	R
	32	140	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	R
	32	250	50	22.0	6.0	30	
	40	150	60	28.0	8.0	37	L
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	L
	40	300	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	L
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	L
	40	300	60	28.0	8.0	37	
	50	170	80	34.0	9.0	47	L
	50	170	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	L
	50	300	80	34.0	9.0	47	



Select an Insert

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

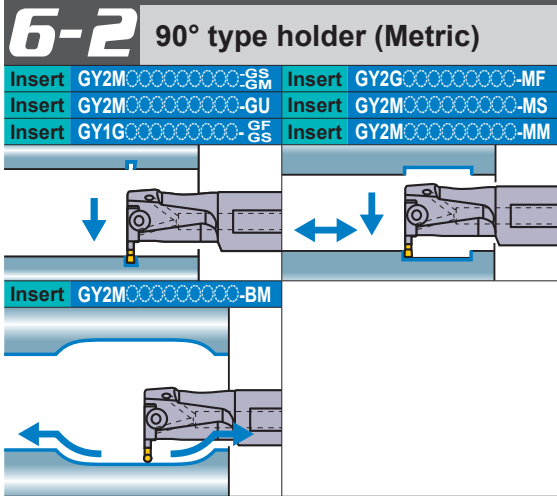
For Grooving/Cutting off > F013, F014					
Seat Size	Breaker	GU	GS	GM	GFGS
	CW				
D	.079", 2.00mm	●	●	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker	MF	MS	MM	BM
	CW				Ball nose
D	.079", 2.00mm	●	●	●	●
D	.088", 2.24mm	●	●	●	●

● : Gauge insert shown dimensions

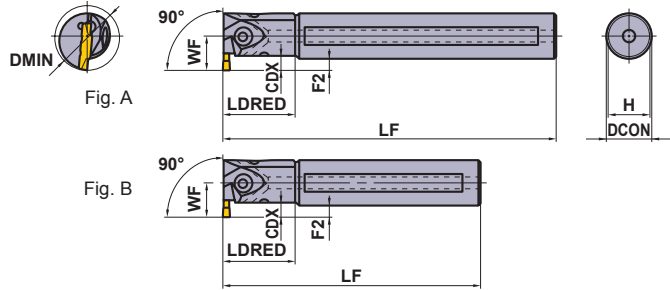
GROOVING

GY SERIES (INTERNAL GROOVING)



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

● Mono block type (Air / coolant through)



Right hand tool holder shown.

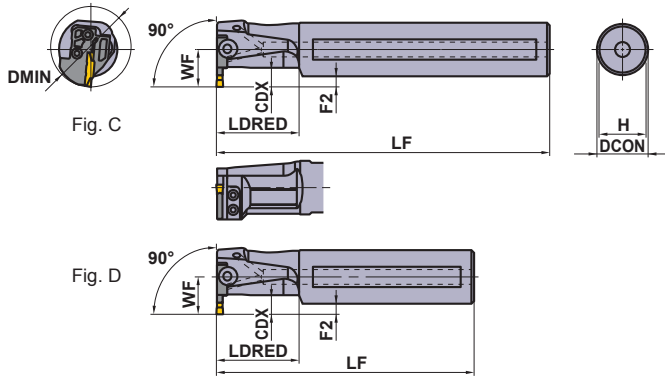
GROOVING

Seat Size	CW (mm)	CDX (mm) *3	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
E	2.39 2.50 2.74	6	25	Mono Block	R	GYAR20K90A-E06	●	—	—	B
				Mono Block	L	GYAL20K90A-E06	●	—	—	B
			Mono Block	R	GYAR20Q90A-E06	●	—	—	A	
			Mono Block	L	GYAL20Q90A-E06	●	—	—	A	
			Mono Block	R	GYAR25K90B-E06	●	—	—	B	
			Mono Block	L	GYAL25K90B-E06	●	—	—	B	
		4—9.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-E10	●	D
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-E10	●	D
			Modular	R	GYDR32S90C-M20L	●	GYM20LA-E10	●	C	
			Modular	L	GYDL32S90C-M20R	●	GYM20RA-E10	●	C	
			50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-E10	●	D
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-E10	●	D
	7—11.5 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-E12	●	D	
			Modular	L	GYDL40M90D-M25R	●	GYM25RA-E12	●	D	
		Modular	R	GYDR40T90D-M25L	●	GYM25LA-E12	●	C		
		Modular	L	GYDL40T90D-M25R	●	GYM25RA-E12	●	C		
		70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-E12	●	D	
			Modular	L	GYDL50P90F-M25R	●	GYM25RA-E12	●	D	
				Modular	R	GYDR50T90F-M25L	●	GYM25LA-E12	●	C
				Modular	L	GYDL50T90F-M25R	●	GYM25RA-E12	●	C

*1 The maximum groove depth varies according to the cutting diameter (DMIN). For details, please refer to page F204.
 *2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and F2 values may vary.
 *3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

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

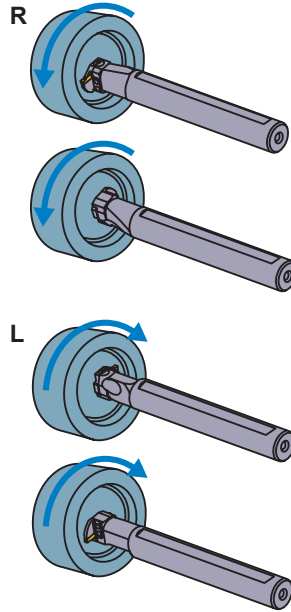


Right hand tool holder shown.

SPARE PARTS

Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/L20-90A-006	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYAR/L25-90B-006	—	—	—
GYDR/L32-90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40-90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L40-90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L50-90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *2						Cutting Mode
	DCON	LF	LDRED	WF	F2	H	
	20	125	30	14.5	4.5	18	R
	20	125	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	R
	20	180	30	14.5	4.5	18	
	25	125	40	19.0	6.5	23	R
	25	125	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	R
	25	200	40	19.0	6.5	23	
	32	140	50	22.0	6.0	30	R
	32	140	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	R
	32	250	50	22.0	6.0	30	
	40	150	60	28.0	8.0	37	L
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	L
	40	300	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	L
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	L
	40	300	60	28.0	8.0	37	
	50	170	80	34.0	9.0	47	L
	50	170	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	L
	50	300	80	34.0	9.0	47	



Select an Insert

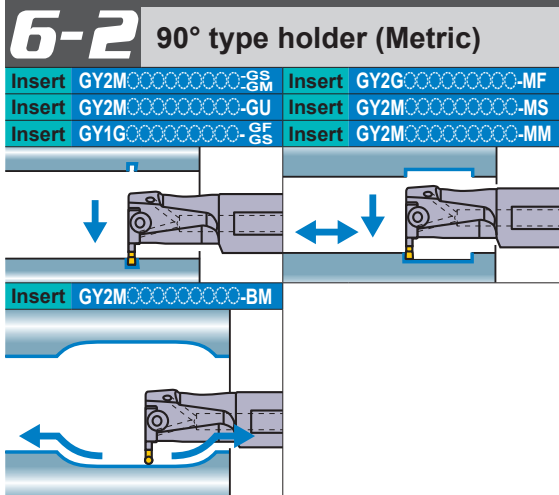
Seat Size	Insert Number
E	GY-0239/0250/0274E-0000-Breaker

		For Grooving/Cutting off > F013, F014				
Seat Size	CW	Breaker	GU	GS	GM	GFGS
		E	.094", 2.39mm	●	●	●
	.098", 2.50mm	●	●	●	●	

		For Multifunctional Grooving > F015, F016				
Seat Size	CW	Breaker	MF	MS	MM	BM
		E	.094", 2.39mm	●		
	.098", 2.50mm	●	●	●	●	
	.108", 2.74mm	●				

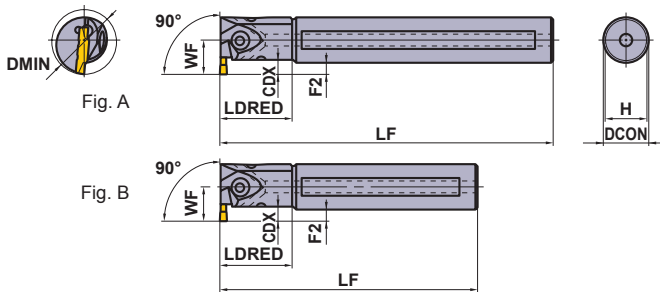
● : Gauge insert shown dimensions

GY SERIES (INTERNAL GROOVING)



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

● Mono block type (Air / coolant through)



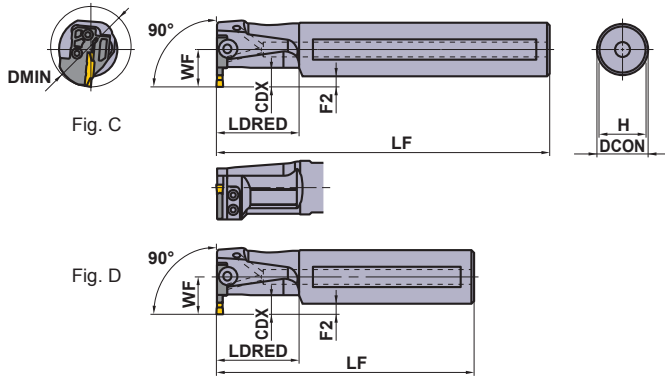
Right hand tool holder shown.

Seat Size	CW (mm)	CDX (mm) *3	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.
						Holder	Stock	Modular Blade	Stock	
F	3.00 3.18 3.24	6	25	Mono Block	R	GYAR20K90A-F06	●	—	—	B
				Mono Block	L	GYAL20K90A-F06	●	—	—	B
			Mono Block	R	GYAR20Q90A-F06	●	—	—	A	
			Mono Block	L	GYAL20Q90A-F06	●	—	—	A	
		32	Mono Block	R	GYAR25K90B-F06	●	—	—	B	
			Mono Block	L	GYAL25K90B-F06	●	—	—	B	
			Mono Block	R	GYAR25R90B-F06	●	—	—	A	
			Mono Block	L	GYAL25R90B-F06	●	—	—	A	
		4-9.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-F10	●	D
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-F10	●	D
			Modular	R	GYDR32S90C-M20L	●	GYM20LA-F10	●	C	
			Modular	L	GYDL32S90C-M20R	●	GYM20RA-F10	●	C	
	5.5-9.5 *1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-F10	●	D	
			Modular	L	GYDL40M90D-M20R	●	GYM20RA-F10	●	D	
		Modular	R	GYDR40T90D-M20L	●	GYM20LA-F10	●	C		
		Modular	L	GYDL40T90D-M20R	●	GYM20RA-F10	●	C		
7-11.5 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-F12	●	D		
		Modular	L	GYDL40M90D-M25R	●	GYM25RA-F12	●	D		
	Modular	R	GYDR40T90D-M25L	●	GYM25LA-F12	●	C			
	Modular	L	GYDL40T90D-M25R	●	GYM25RA-F12	●	C			
70	70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-F12	●	D		
		Modular	L	GYDL50P90F-M25R	●	GYM25RA-F12	●	D		
	Modular	R	GYDR50T90F-M25L	●	GYM25LA-F12	●	C			
	Modular	L	GYDL50T90F-M25R	●	GYM25RA-F12	●	C			
G	4.00 4.24	7	32	Mono Block	R	GYAR25K90B-G07	●	—	—	B
				Mono Block	L	GYAL25K90B-G07	●	—	—	B
			Mono Block	R	GYAR25R90B-G07	●	—	—	A	
			Mono Block	L	GYAL25R90B-G07	●	—	—	A	
		4.5-11.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-G12	●	D
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-G12	●	D
			Modular	R	GYDR32S90C-M20L	●	GYM20LA-G12	●	C	
			Modular	L	GYDL32S90C-M20R	●	GYM20RA-G12	●	C	
		6-11.5 *1	50	Modular	R	GYDR40M90D-M20L	●	GYM20LA-G12	●	D
				Modular	L	GYDL40M90D-M20R	●	GYM20RA-G12	●	D
			Modular	R	GYDR40T90D-M20L	●	GYM20LA-G12	●	C	
			Modular	L	GYDL40T90D-M20R	●	GYM20RA-G12	●	C	
	7.5-13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-G14	●	D	
			Modular	L	GYDL40M90D-M25R	●	GYM25RA-G14	●	D	
		Modular	R	GYDR40T90D-M25L	●	GYM25LA-G14	●	C		
		Modular	L	GYDL40T90D-M25R	●	GYM25RA-G14	●	C		
70	70	Modular	R	GYDR50P90F-M25L	●	GYM25LA-G14	●	D		
		Modular	L	GYDL50P90F-M25R	●	GYM25RA-G14	●	D		
	Modular	R	GYDR50T90F-M25L	●	GYM25LA-G14	●	C			
	Modular	L	GYDL50T90F-M25R	●	GYM25RA-G14	●	C			

*1 The maximum groove depth varies according to the cutting diameter (DMIN). For details, please refer to page F204.
 *2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and F2 values may vary.
 *3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

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



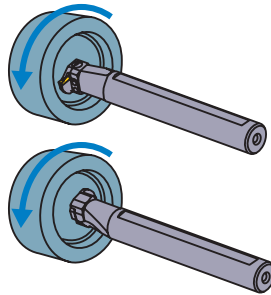
Right hand tool holder shown.

SPARE PARTS

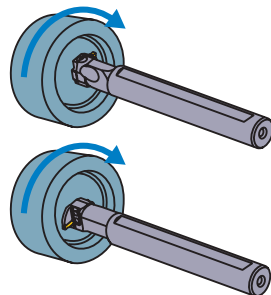
Holder Number	①	②	①	②
	Clamp Screw	Blade Screw	4 pcs.	Wrench *
GYAR/L20○90A-F06	①GY05016S (Clamp Torque : 44 lbf-in)	—	—	①TKY20R
GYAR/L25○90B-○○○	—	—	—	—
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	—	①TKY30R ②TKY15D
GYDR/L40○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	—	①TKY30R ②TKY25D
GYDR/L40○90D-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	—	①TKY30R ②TKY25D
GYDR/L50○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	—	①TKY30R ②TKY25D

	Dimensions (mm) *2						Cutting Mode
	DCON	LF	LDRED	WF	F2	H	
	20	125	30	14.5	4.5	18	R
	20	125	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	20	180	30	14.5	4.5	18	
	25	125	40	19.0	6.5	23	
	25	125	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	
	32	140	50	22.0	6.0	30	
	32	140	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	40	150	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	50	170	80	34.0	9.0	47	
	50	170	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	
	25	125	40	19.0	6.5	23	L
	25	125	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	
	25	200	40	19.0	6.5	23	
	32	140	50	22.0	6.0	30	
	32	140	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	32	250	50	22.0	6.0	30	
	40	150	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	150	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	40	300	60	28.0	8.0	37	
	50	170	80	34.0	9.0	47	
	50	170	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	
	50	300	80	34.0	9.0	47	

R



L



Select an Insert

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

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	GFGS	
		CW				
F	.118", 3.00mm	●	●	●	●	
	.125", 3.18mm	●	●	●	●	

		For Multifunctional Grooving > F015, F016				
Seat Size	Breaker	MF	MS	MM	BM	
		CW			Ball nose	
F	.118", 3.00mm	●	●	●	●	
	RE 0.2mm	●	●	●		
	RE 0.4mm	●	●	●		
	RE 0.8mm	●	●	●		
F	.125", 3.18mm	●			●	
	RE 0.2mm	●				
	RE 0.4mm	●				
	.128", 3.24mm	●				

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

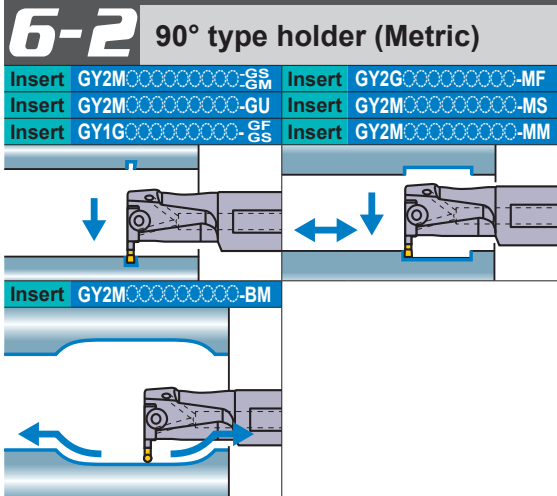
		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	GFGS	
		CW				
G	.157", 4.00mm	●	●	●	●	

		For Multifunctional Grooving > F015, F016				
Seat Size	Breaker	MF	MS	MM	BM	
		CW			Ball nose	
G	.157", 4.00mm	●	●	●	●	
	RE 0.2mm	●	●	●		
	RE 0.4mm	●	●	●		
	RE 0.8mm	●	●	●		
	.167", 4.24mm	●				

● : Gauge insert shown dimensions

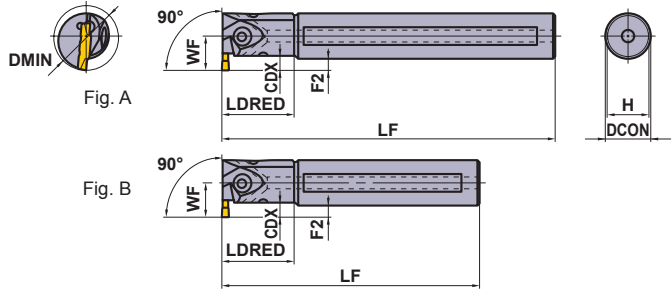
IDENTIFICATION > F010, F011
 CUTTING CONDITIONS > F204
 INSTRUCTION MANUAL > F206

GY SERIES (INTERNAL GROOVING)



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

● Mono block type (Air / coolant through)



Right hand tool holder shown.

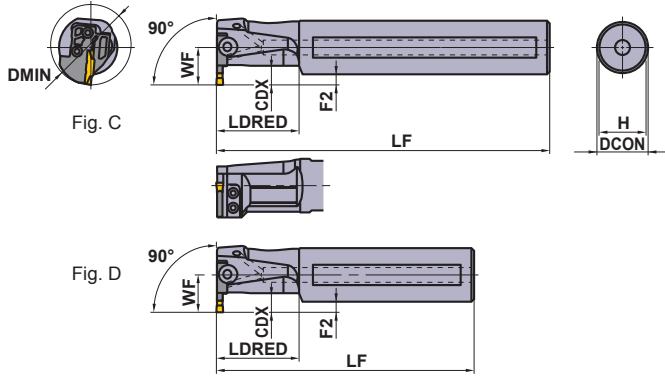
GROOVING

Seat Size	CW (mm)	CDX (mm) *3	DMIN (mm)	Type	Hand (R/L)	Order Number				Fig.	
						Holder	Stock	Modular Blade	Stock		
H	4.75 5.00 5.24	7	32	Mono Block	R	GYAR25K90B-H07	●	—	—	B	
				Mono Block	L	GYAL25K90B-H07	●	—	—	B	
		4.5—11.5 *1	40	Modular	R	GYDR32L90C-M20L	●	GYM20LA-H12	●	D	
				Modular	L	GYDL32L90C-M20R	●	GYM20RA-H12	●	D	
			6—11.5 *1	50	Modular	R	GYDR32S90C-M20L	●	GYM20LA-H12	●	C
					Modular	L	GYDL32S90C-M20R	●	GYM20RA-H12	●	C
	7.5—13 *1	60	Modular	R	GYDR40M90D-M20L	●	GYM20LA-H12	●	D		
			Modular	L	GYDL40M90D-M20R	●	GYM20RA-H12	●	D		
		70	Modular	R	GYDR40T90D-M20L	●	GYM20LA-H12	●	C		
			Modular	L	GYDL40T90D-M20R	●	GYM20RA-H12	●	C		
			Modular	R	GYDR50P90F-M25L	●	GYM25LA-H14	●	D		
			Modular	L	GYDL50P90F-M25R	●	GYM25RA-H14	●	D		
J	6.00 6.31 6.35	7.5—13 *1	60	Modular	R	GYDR40M90D-M25L	●	GYM25LA-J14	●	D	
				Modular	L	GYDL40M90D-M25R	●	GYM25RA-J14	●	D	
			70	Modular	R	GYDR40T90D-M25L	●	GYM25LA-J14	●	C	
				Modular	L	GYDL40T90D-M25R	●	GYM25RA-J14	●	C	
		7.5—13 *1	60	Modular	R	GYDR50P90F-M25L	●	GYM25LA-J14	●	D	
				Modular	L	GYDL50P90F-M25R	●	GYM25RA-J14	●	D	
			70	Modular	R	GYDR50T90F-M25L	●	GYM25LA-J14	●	C	
				Modular	L	GYDL50T90F-M25R	●	GYM25RA-J14	●	C	

*1 The maximum groove depth varies according to the cutting diameter (DMIN). For details, please refer to page F204.
 *2 Dimensions shown are when the gauge insert is used. If other insert geometries are used then LF, LDRED, WF and F2 values may vary.
 *3 The maximum groove depth (CDX) is a value within the dimension (LDRED).

●Modular blade type (Air / coolant through)

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



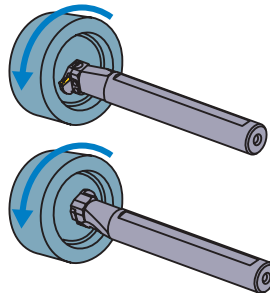
Right hand tool holder shown.

SPARE PARTS

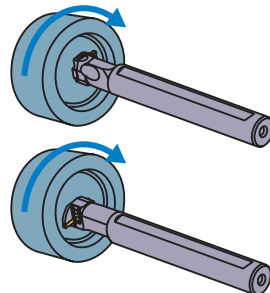
Holder Number	① Clamp Screw	② Blade Screw 4 pcs.	① Wrench *
GYAR/L25○90B-○07	①GY05016S (Clamp Torque : 44 lbf-in)	—	①TKY20R
GYDR/L32○90C-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
GYDR/L40○90D-M20L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
GYDR/L50○90F-M25L/R	②GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D

	Dimensions (mm) *2					
	DCON	LF	LDRED	WF	F2	H
	25	125	40	19	6.5	23
	25	125	40	19	6.5	23
	25	200	40	19	6.5	23
	25	200	40	19	6.5	23
	32	140	50	22	6.0	30
	32	140	50	22	6.0	30
	32	250	50	22	6.0	30
	32	250	50	22	6.0	30
	40	150	60	28	8.0	37
	40	150	60	28	8.0	37
	40	300	60	28	8.0	37
	40	300	60	28	8.0	37
	40	150	60	28	8.0	37
	40	150	60	28	8.0	37
	40	300	60	28	8.0	37
	40	300	60	28	8.0	37
	50	170	80	34	9.0	47
	50	170	80	34	9.0	47
	50	300	80	34	9.0	47
	50	300	80	34	9.0	47
	40	150	60	28	8.0	37
	40	150	60	28	8.0	37
	40	300	60	28	8.0	37
	40	300	60	28	8.0	37
	50	170	80	34	9.0	47
	50	170	80	34	9.0	47
	50	300	80	34	9.0	47
	50	300	80	34	9.0	47

R



L



Select an Insert

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

For Grooving/Cutting off > F013, F014					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		H	.187", 4.75mm .197", 5.00mm	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker CW	MF	MS	MM	BM
		H	.187", 4.75mm RE 0.2mm RE 0.4mm RE 0.8mm .197", 5.00mm RE 0.2mm RE 0.4mm RE 0.8mm 206", 5.24mm	●	●

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

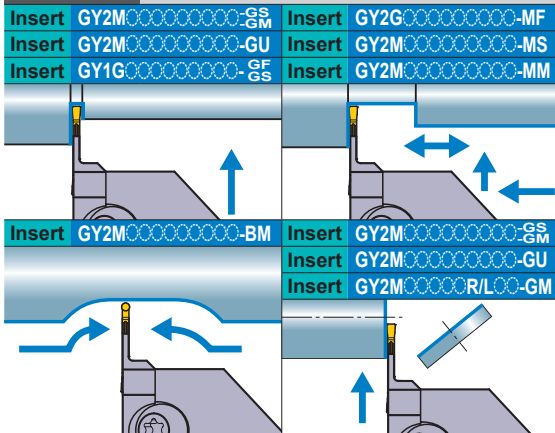
For Grooving/Cutting off > F013					
Seat Size	Breaker CW	GU	GS	GM	GFGS
		J	.236", 6.00mm .250", 6.35mm	●	●

For Multifunctional Grooving > F015, F016					
Seat Size	Breaker CW	MF	MS	MM	BM
		J	.236", 6.00mm RE 0.2mm RE 0.4mm RE 0.8mm .248", 6.31mm .250", 6.35mm RE 0.2mm RE 0.4mm RE 0.8mm	●	●

● : Gauge insert shown dimensions

GY SERIES (EXTERNAL GROOVING PSC TYPE)

7-1 00° type holder (Inch)



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

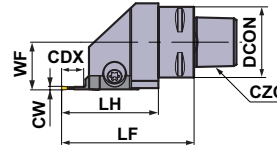
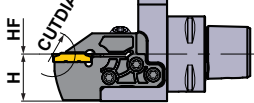
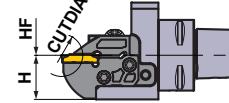
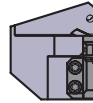


Fig. A

Fig. B






Right hand tool holder shown.

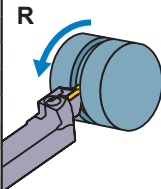
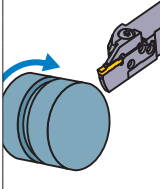
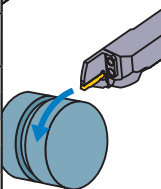
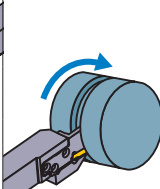
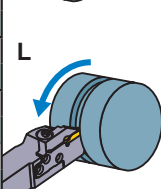
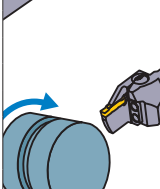
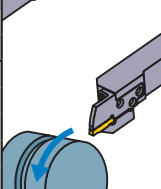
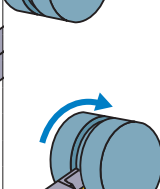
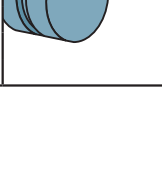
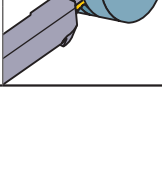




GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
D	.079 .088	.236	.472	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-D06	●	A	C3
				L	C3-GYHLDX00-M20L	●	GYM20LA-D06	●	A		
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-D06	●	A	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-D06	●	A		
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-D06	●	A	C5
				L	C5-GYHLEX00-M25L	●	GYM25LA-D06	●	A		
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-D06	●	A	C6
				L	C6-GYHLF00-M25L	●	GYM25LA-D06	●	A		
		.394	.787	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-D10	●	A	C3
		L	C3-GYHLDX00-M20L	●	GYM20LA-D10	●	A				
		.472	.945	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-D12	●	A	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-D12	●	A		
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-D12	●	A	C5
				L	C5-GYHLEX00-M25L	●	GYM25LA-D12	●	A		
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-D12	●	A	C6		
		L	C6-GYHLF00-M25L	●	GYM25LA-D12	●	A				
		.709*4	1.417	Modular	R	C3-GYHRDX00-M20R	●	GYM20RB-D18	●	B	C3
				L	C3-GYHLDX00-M20L	●	GYM20LB-D18	●	B		
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-D20	●	B	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-D20	●	B		
.787*1	1.575*2	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-D20	●	B	C5		
		L	C5-GYHLEX00-M25L	●	GYM25LA-D20	●	B				
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-D20	●	B	C6		
		L	C6-GYHLF00-M25L	●	GYM25LA-D20	●	B				

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.260	2.323	1.724	.866	0	.787		
	1.260	2.323	1.724	.866	0	.787		
	1.575	2.638	1.843	1.063	0	.984		
	1.575	2.638	1.843	1.063	0	.984		
	1.969	2.638	1.843	1.378	0	1.063		
	1.969	2.638	1.843	1.378	0	1.063		
	2.480	2.835	1.961	1.772	0	1.378		
	2.480	2.835	1.961	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.260	2.795	2.197	.866	0	.787		
	1.260	2.795	2.197	.866	0	.787		
	1.575	3.189	2.394	1.063	0	.984		
	1.575	3.189	2.394	1.063	0	.984		
	1.969	3.189	2.394	1.378	0	1.063		
	1.969	3.189	2.394	1.378	0	1.063		
	2.480	3.386	2.512	1.772	0	1.378		
	2.480	3.386	2.512	1.772	0	1.378		

Select an Insert

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

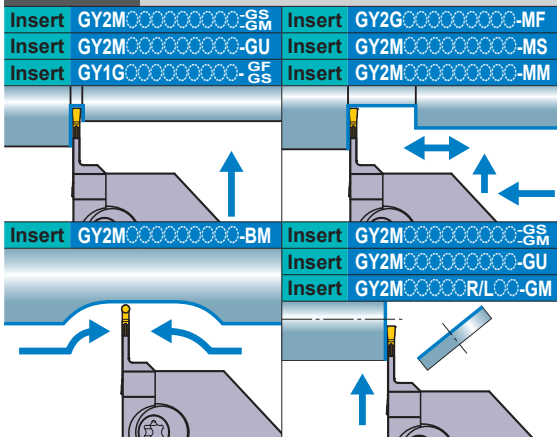
		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		CW	Neutral	Neutral	Neutral	Hand
D	.079", 2.00mm	●	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
		CW			
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●			

● : Gauge insert shown dimensions

GY SERIES (EXTERNAL GROOVING PSC TYPE)

7-1 00° type holder (Inch)



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

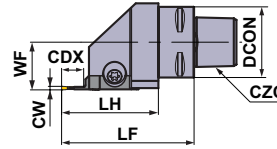
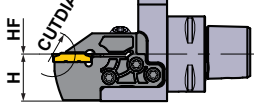
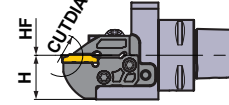
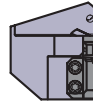


Fig. A

Fig. B






Right hand tool holder shown.

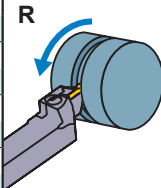
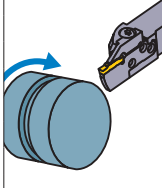
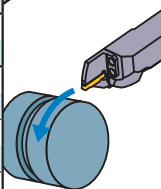
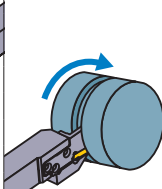
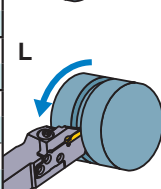
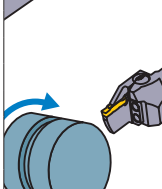
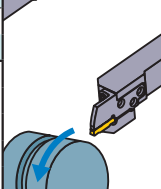
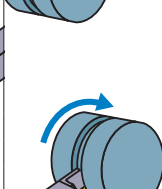
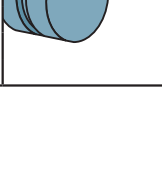
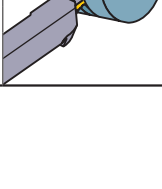




GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
E	.094 .098 .108	.236	.472	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-E06	●	A	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-E06	●	A	
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-E06	●	A	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-E06	●	A	
		Modular	R	C5-GYHREX00-M25R	●	GYM25RA-E06	●	A	C5		
		Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-E06	●	A			
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-E06	●	A	C6		
		Modular	L	C6-GYHLF00-M25L	●	GYM25LA-E06	●	A			
		.394	.787	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-E10	●	A	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-E10	●	A	
		.472	.945	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-E12	●	A	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-E12	●	A	
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-E12	●	A	C5
				Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-E12	●	A	
		.709 ^{*4}	1.417	Modular	R	C3-GYHRDX00-M20R	●	GYM20RB-E18	●	B	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LB-E18	●	B	
.787 ^{*1}	1.575 ^{*2}	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-E20	●	B	C4		
		Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-E20	●	B			
		Modular	R	C5-GYHREX00-M25R	●	GYM25RA-E20	●	B	C5		
		Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-E20	●	B			
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-E20	●	B	C6		
		Modular	L	C6-GYHLF00-M25L	●	GYM25LA-E20	●	B			

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.260	2.323	1.724	.866	0	.787		
	1.260	2.323	1.724	.866	0	.787		
	1.575	2.638	1.843	1.063	0	.984		
	1.575	2.638	1.843	1.063	0	.984		
	1.969	2.638	1.843	1.378	0	1.063		
	1.969	2.638	1.843	1.378	0	1.063		
	2.480	2.835	1.961	1.772	0	1.378		
	2.480	2.835	1.961	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.260	2.795	2.197	.866	0	.787		
	1.260	2.795	2.197	.866	0	.787		
	1.575	3.189	2.394	1.063	0	.984		
	1.575	3.189	2.394	1.063	0	.984		
	1.969	3.189	2.394	1.378	0	1.063		
	1.969	3.189	2.394	1.378	0	1.063		
	2.480	3.386	2.512	1.772	0	1.378		
	2.480	3.386	2.512	1.772	0	1.378		

Select an Insert

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

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
E	.094", 2.39mm	●	●	●		●
	.098", 2.50mm	●	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			

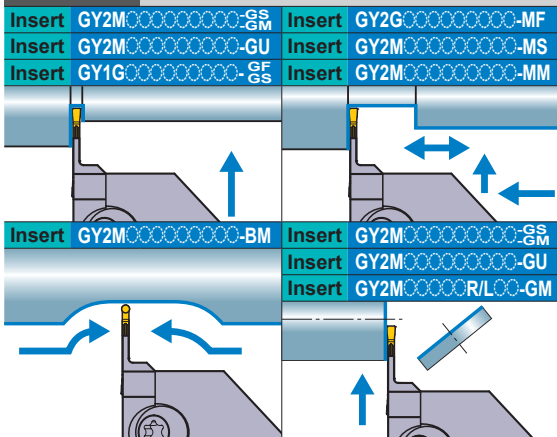
● : Gauge insert shown dimensions

GROOVING

IDENTIFICATION > F012
CUTTING CONDITIONS > F186
INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING PSC TYPE)

7-1 00° type holder (Inch)



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

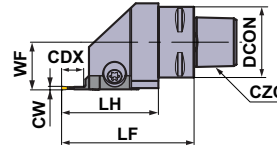
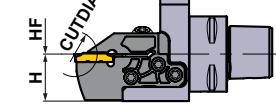
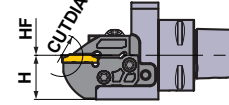
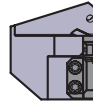


Fig. A

Fig. B






Right hand tool holder shown.

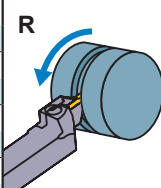
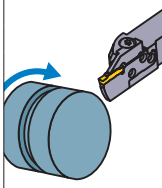
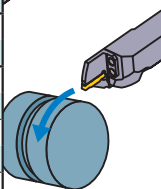
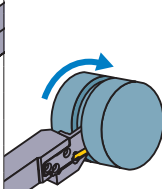
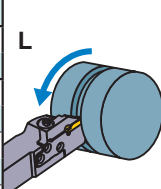
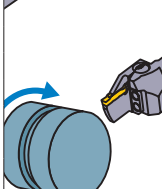
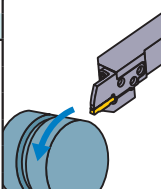
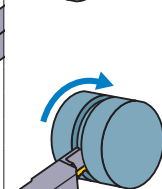
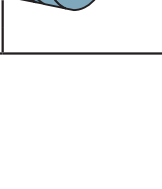
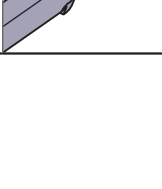




GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
F	.118 .125 .128	.236	.472	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-F06	●	A	C3
				L	C3-GYHLDX00-M20L	●	GYM20LA-F06	●	A		
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-F06	●	A	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-F06	●	A		
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-F06	●	A	C5
				L	C5-GYHLEX00-M25L	●	GYM25LA-F06	●	A		
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-F06	●	A	C6
				L	C6-GYHLF00-M25L	●	GYM25LA-F06	●	A		
		.394	.787	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-F10	●	A	C3
				L	C3-GYHLDX00-M20L	●	GYM20LA-F10	●	A		
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-F12	●	A	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-F12	●	A		
		.472	.945	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-F12	●	A	C5
				L	C5-GYHLEX00-M25L	●	GYM25LA-F12	●	A		
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-F12	●	A	C6
				L	C6-GYHLF00-M25L	●	GYM25LA-F12	●	A		
		.709*4	1.417	Modular	R	C3-GYHRDX00-M20R	●	GYM20RB-F18	●	B	C3
				L	C3-GYHLDX00-M20L	●	GYM20LB-F18	●	B		
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-F20	●	B	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-F20	●	B		
.787*1	1.575*2	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-F20	●	B	C5		
		L	C5-GYHLEX00-M25L	●	GYM25LA-F20	●	B				
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-F20	●	B	C6		
		L	C6-GYHLF00-M25L	●	GYM25LA-F20	●	B				

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.260	2.323	1.724	.866	0	.787		
	1.260	2.323	1.724	.866	0	.787		
	1.575	2.638	1.843	1.063	0	.984		
	1.575	2.638	1.843	1.063	0	.984		
	1.969	2.638	1.843	1.378	0	1.063		
	1.969	2.638	1.843	1.378	0	1.063		
	2.480	2.835	1.961	1.772	0	1.378		
	2.480	2.835	1.961	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.260	2.795	2.197	.866	0	.787		
	1.260	2.795	2.197	.866	0	.787		
	1.575	3.189	2.394	1.063	0	.984		
	1.575	3.189	2.394	1.063	0	.984		
	1.969	3.189	2.394	1.378	0	1.063		
	1.969	3.189	2.394	1.378	0	1.063		
	2.480	3.386	2.512	1.772	0	1.378		
	2.480	3.386	2.512	1.772	0	1.378		

Select an Insert

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

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
F	.118", 3.00mm	●	●	●	●	●
	.125", 3.18mm	●	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
F	.118", 3.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24mm	●			

● : Gauge insert shown dimensions

GY SERIES (EXTERNAL GROOVING PSC TYPE)

7-1 00° type holder (Inch)

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

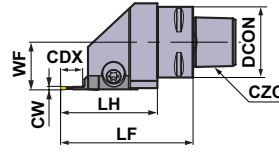
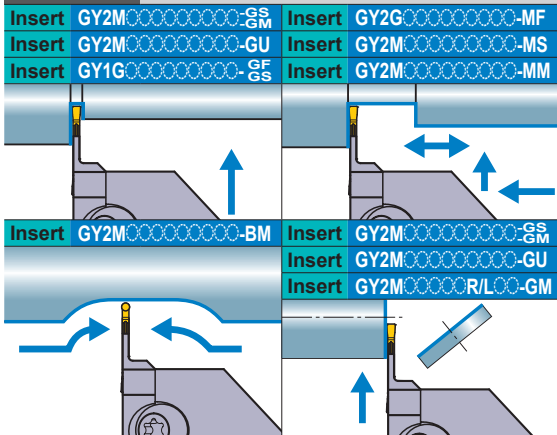
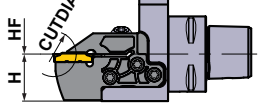
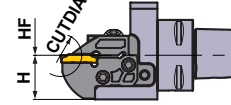
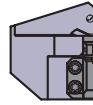


Fig. A

Fig. B






Right hand tool holder shown.

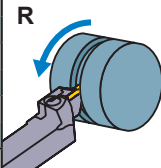
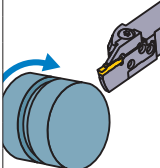
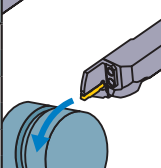
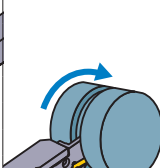
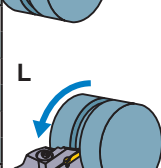
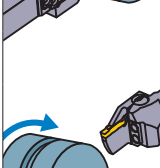
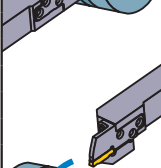
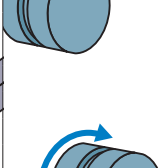
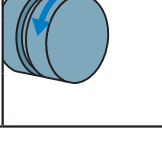
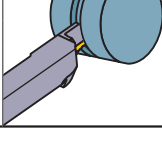






GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
G	.157 .167	.315	.630	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-G08	●	A	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-G08	●	A		
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-G08	●	A	C5
				L	C5-GYHLEX00-M25L	●	GYM25LA-G08	●	A		
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-G08	●	A	C6
				L	C6-GYHLF00-M25L	●	GYM25LA-G08	●	A		
		.472	.945	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-G12	●	A	C3
				L	C3-GYHLDX00-M20L	●	GYM20LA-G12	●	A		
				Modular	R	C4-GYHREX00-M25R	●	GYM25RA-G14	●	A	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-G14	●	A		
		.551	1.102	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-G14	●	A	C5
				L	C5-GYHLEX00-M25L	●	GYM25LA-G14	●	A		
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-G14	●	A	C6
				L	C6-GYHLF00-M25L	●	GYM25LA-G14	●	A		
		.984*1	1.969*2	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-G25	●	B	C4
				L	C4-GYHLEX00-M25L	●	GYM25LA-G25	●	B		
Modular	R			C5-GYHREX00-M25R	●	GYM25RA-G25	●	B	C5		
L	C5-GYHLEX00-M25L			●	GYM25LA-G25	●	B				
				Modular	R	C6-GYHRF00-M25R	●	GYM25RA-G25	●	B	C6
				L	C6-GYHLF00-M25L	●	GYM25LA-G25	●	B		

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LDX00-M20R/L		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.575	2.717	1.921	1.063	0	.984		
	1.575	2.717	1.921	1.063	0	.984		
	1.969	2.717	1.921	1.378	0	1.063		
	1.969	2.717	1.921	1.378	0	1.063		
	2.480	2.913	2.039	1.772	0	1.378		
	2.480	2.913	2.039	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.575	3.386	2.591	1.063	0	.984		
	1.575	3.386	2.591	1.063	0	.984		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	2.480	3.583	2.709	1.772	0	1.378		
	2.480	3.583	2.709	1.772	0	1.378		

Select an Insert

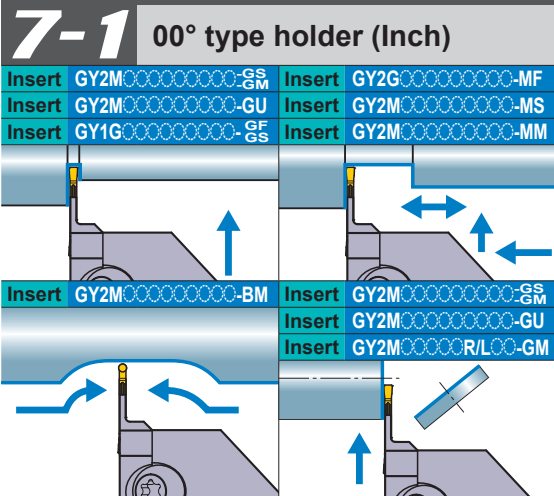
Seat Size	Insert Number
G	GY○○○0400/0424G○○○○○-Breaker

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		CW	Neutral	Neutral	Neutral	Hand
G	.157", 4.00mm	●	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
		CW			
G	.157", 4.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●		●	
	.167", 4.24mm	●			

● : Gauge insert shown dimensions

GY SERIES (EXTERNAL GROOVING PSC TYPE)



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

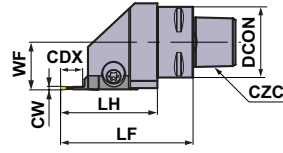
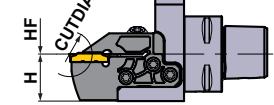
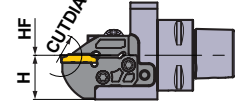
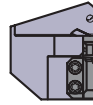


Fig. A

Fig. B






Right hand tool holder shown.

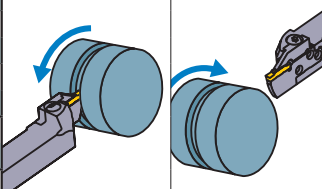
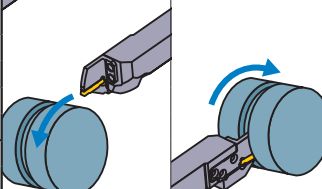
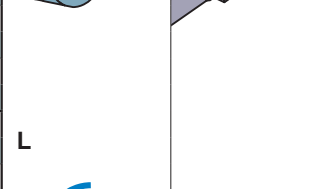
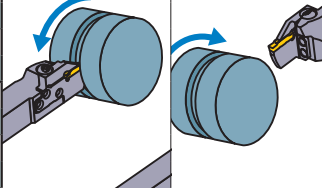
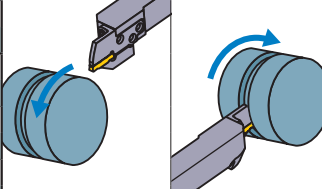
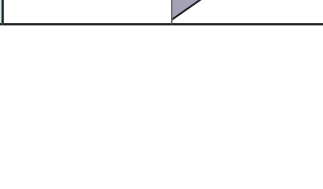

GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
H	.187 .197 .206	.315	.630	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-H08	●	A	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-H08	●	A	
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-H08	●	A	C5
		Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-H08	●	A			
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-H08	●	A	C6		
		Modular	L	C6-GYHLF00-M25L	●	GYM25LA-H08	●	A			
	.551	.472	.945	Modular	R	C3-GYHRDX00-M20R	●	GYM20RA-H12	●	A	C3
				Modular	L	C3-GYHLDX00-M20L	●	GYM20LA-H12	●	A	
		Modular	R	C4-GYHREX00-M25R	●	GYM25RA-H14	●	A	C4		
		Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-H14	●	A			
		Modular	R	C5-GYHREX00-M25R	●	GYM25RA-H14	●	A	C5		
		Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-H14	●	A			
.984*1	1.969*2	Modular	R	C6-GYHRF00-M25R	●	GYM25RA-H14	●	A	C6		
		Modular	L	C6-GYHLF00-M25L	●	GYM25LA-H14	●	A			
	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-H25	●	B	C4			
	Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-H25	●	B				
	Modular	R	C5-GYHREX00-M25R	●	GYM25RA-H25	●	B	C5			
	Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-H25	●	B				
J	.236 .248 .250	.315	.630	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-J08	●	A	C4
				Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-J08	●	A	
				Modular	R	C5-GYHREX00-M25R	●	GYM25RA-J08	●	A	C5
		Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-J08	●	A			
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-J08	●	A	C6		
		Modular	L	C6-GYHLF00-M25L	●	GYM25LA-J08	●	A			
	.984*1	1.969*2	Modular	R	C4-GYHREX00-M25R	●	GYM25RA-J14	●	A	C4	
			Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-J14	●	A		
		Modular	R	C5-GYHREX00-M25R	●	GYM25RA-J14	●	A	C5		
		Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-J14	●	A			
		Modular	R	C6-GYHRF00-M25R	●	GYM25RA-J14	●	A	C6		
		Modular	L	C6-GYHLF00-M25L	●	GYM25LA-J14	●	A			
Modular	R	C4-GYHREX00-M25R	●	GYM25RA-J25	●	B	C4				
Modular	L	C4-GYHLEX00-M25L	●	GYM25LA-J25	●	B					
Modular	R	C5-GYHREX00-M25R	●	GYM25RA-J25	●	B	C5				
Modular	L	C5-GYHLEX00-M25L	●	GYM25LA-J25	●	B					
Modular	R	C6-GYHRF00-M25R	●	GYM25RA-J25	●	B	C6				
Modular	L	C6-GYHLF00-M25L	●	GYM25LA-J25	●	B					

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LDX00-M20R/L	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LEX00-M25R/L		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LEX00-M25R/L			
C6-GYHR/LF00-M25R/L			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	H	Clockwise	Anticlockwise
	1.575	2.717	1.921	1.063	0	.984	R	
	1.575	2.717	1.921	1.063	0	.984		
	1.969	2.717	1.921	1.378	0	1.063		
	1.969	2.717	1.921	1.378	0	1.063		
	2.480	2.913	2.039	1.772	0	1.378		
	2.480	2.913	2.039	1.772	0	1.378		
	1.260	2.559	1.961	.866	0	.787		
	1.260	2.559	1.961	.866	0	.787		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.575	3.386	2.591	1.063	0	.984		
	1.575	3.386	2.591	1.063	0	.984		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	2.480	3.583	2.709	1.772	0	1.378		
	2.480	3.583	2.709	1.772	0	1.378		
	1.575	2.717	1.921	1.063	0	.984		
	1.575	2.717	1.921	1.063	0	.984		
	1.969	2.717	1.921	1.378	0	1.063		
	1.969	2.717	1.921	1.378	0	1.063		
	1.969	2.717	1.921	1.378	0	1.063		
	1.969	2.717	1.921	1.378	0	1.063		
	2.480	2.913	2.039	1.772	0	1.378		
	2.480	2.913	2.039	1.772	0	1.378		
	2.480	2.913	2.039	1.772	0	1.378		
	2.480	2.913	2.039	1.772	0	1.378		
	1.575	2.953	2.157	1.063	0	.984		
	1.575	2.953	2.157	1.063	0	.984		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	1.969	2.953	2.157	1.378	0	1.063		
	2.480	3.150	2.276	1.772	0	1.378		
	2.480	3.150	2.276	1.772	0	1.378		
	1.575	3.386	2.591	1.063	0	.984		
	1.575	3.386	2.591	1.063	0	.984		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	1.969	3.386	2.591	1.378	0	1.063		
	2.480	3.583	2.709	1.772	0	1.378		
	2.480	3.583	2.709	1.772	0	1.378		
	2.480	3.583	2.709	1.772	0	1.378		
	2.480	3.583	2.709	1.772	0	1.378		

Select an Insert

Seat Size	Insert Number
H	GY00475/0500/0524H-Breaker
J	GY00600/0631/0635J-Breaker

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
H	.187", 4.75mm	●	●	●	●	●
	.197", 5.00mm	●	●	●	●	●
J	.236", 6.00mm	●	●	●	●	●
	.250", 6.35mm	●	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
H	.187", 4.75mm	●			●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
H	.197", 5.00mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
J	.206", 5.24mm	●			
	.236", 6.00mm	●			●
	RE .008"	●			
	RE .016"	●	●	●	
J	.248", 6.31mm	●			
	.250", 6.35mm	●			●
	RE .008"	●			
	RE .016"	●			
J	RE .031"	●			

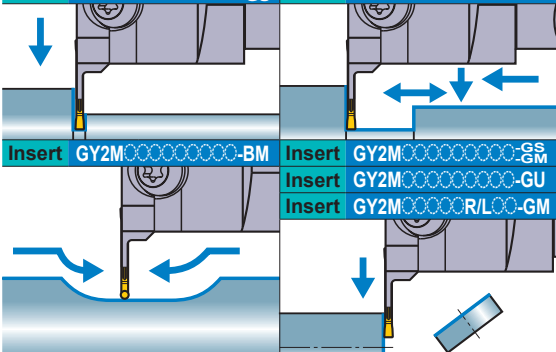
● : Gauge insert shown dimensions

IDENTIFICATION > F012
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING PSC TYPE)

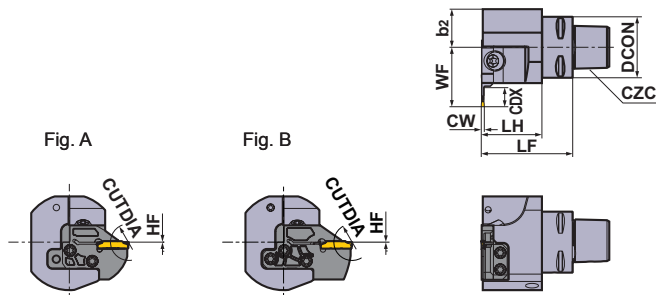
8-1 90° type holder (Inch)

Insert	GY2M ^{GS} -GM	Insert	GY2G ^{GS} -MF
Insert	GY2M ^{GS} -GU	Insert	GY2M ^{GS} -MS
Insert	GY1G ^{GS} -GF	Insert	GY2M ^{GS} -MM



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

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



Right hand tool holder shown.

GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
D	.079 .088	.236	.472	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-D06	●	A	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-D06	●	A		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-D06	●	A	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-D06	●	A		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-D06	●	A	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-D06	●	A		
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-D06	●	A	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-D06	●	A		
		.394	.787	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-D10	●	A	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-D10	●	A		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-D12	●	A	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-D12	●	A		
		.472	.945	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-D12	●	A	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-D12	●	A		
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-D12	●	A	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-D12	●	A		
		.709 ^{*4}	1.417	Modular	R	C3-GYHRCX90-M20L	●	GYM20LB-D18	●	B	C3
				L	C3-GYHLCX90-M20R	●	GYM20RB-D18	●	B		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-D20	●	B	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-D20	●	B		
.787 ^{*1}	1.575 ^{*2}	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-D20	●	B	C5		
		L	C5-GYHLD90-M25R	●	GYM25RA-D20	●	B				
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-D20	●	B	C6		
		L	C6-GYHLE90-M25R	●	GYM25RA-D20	●	B				




*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.

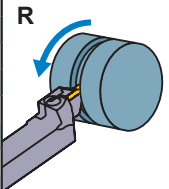
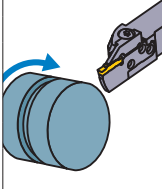
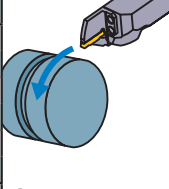
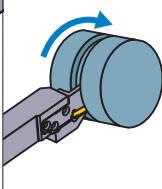
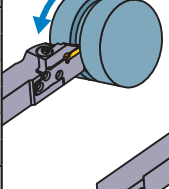
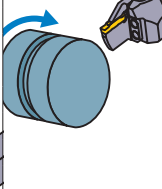
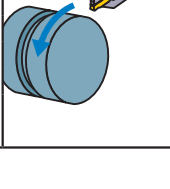
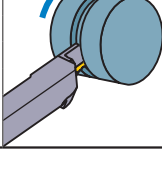
*2 The maximum cut off diameter (CUTDIA) varies according to the insert used. The cut off diameter is double the maximum groove depth (CDX) of inserts on pages F013 to F016.

*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 F189.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LCX90-M20L/R		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	b2	Clockwise	Anticlockwise
	1.260	2.165	1.567	1.024	0	.787		
	1.260	2.165	1.567	1.024	0	.787		
	1.575	2.362	1.567	1.220	0	.984		
	1.575	2.362	1.567	1.220	0	.984		
	1.969	2.362	1.567	1.299	0	1.024		
	1.969	2.362	1.567	1.299	0	1.024		
	2.480	2.756	1.882	1.575	0	1.319		
	2.480	2.756	1.882	1.575	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.260	2.165	1.567	1.496	0	.787		
	1.260	2.165	1.567	1.496	0	.787		
	1.575	2.362	1.567	1.772	0	.984		
	1.575	2.362	1.567	1.772	0	.984		
	1.969	2.362	1.567	1.850	0	1.024		
	1.969	2.362	1.567	1.850	0	1.024		
	2.480	2.756	1.882	2.126	0	1.319		
	2.480	2.756	1.882	2.126	0	1.319		

Select an Insert

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

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		CW	Neutral	Neutral	Neutral	Hand
D	.079", 2.00mm	●	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
		CW			
D	.079", 2.00mm	●	●	●	●
	.088", 2.24mm	●			

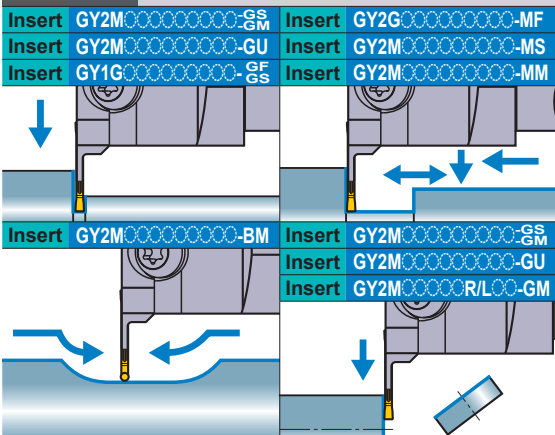
● : Gauge insert shown dimensions

GROOVING

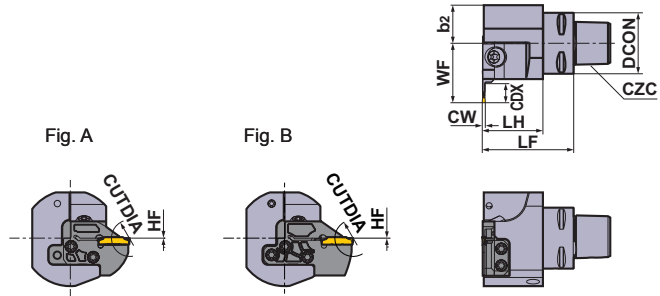
IDENTIFICATION > F012
 CUTTING CONDITIONS > F186
 INSTRUCTION MANUAL > F191

GY SERIES (EXTERNAL GROOVING PSC TYPE)

8-1 90° type holder (Inch)



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






Right hand tool holder shown.

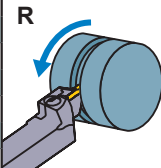
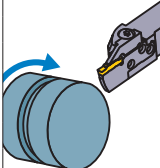
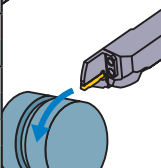
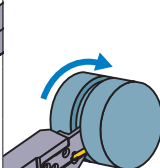
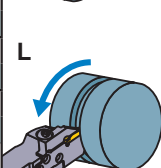
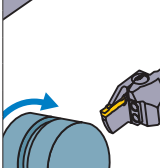
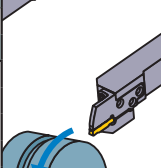
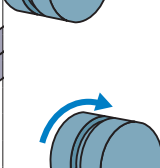
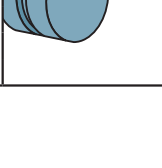
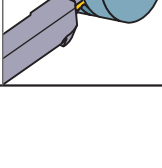




GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
E	.094 .098 .108	.236	.472	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-E06	●	A	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-E06	●	A		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-E06	●	A	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-E06	●	A		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-E06	●	A	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-E06	●	A		
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-E06	●	A	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-E06	●	A		
		.394	.787	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-E10	●	A	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-E10	●	A		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-E12	●	A	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-E12	●	A		
		.472	.945	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-E12	●	A	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-E12	●	A		
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-E12	●	A	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-E12	●	A		
		.709 ^{*4}	1.417	Modular	R	C3-GYHRCX90-M20L	●	GYM20LB-E18	●	B	C3
				L	C3-GYHLCX90-M20R	●	GYM20RB-E18	●	B		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-E20	●	B	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-E20	●	B		
.787 ^{*1}	1.575 ^{*2}	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-E20	●	B	C5		
		L	C5-GYHLD90-M25R	●	GYM25RA-E20	●	B				
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-E20	●	B	C6		
		L	C6-GYHLE90-M25R	●	GYM25RA-E20	●	B				

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LCX90-M20L/R		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	b2	Clockwise	Anticlockwise
	1.260	2.165	1.567	1.024	0	.787		
	1.260	2.165	1.567	1.024	0	.787		
	1.575	2.362	1.567	1.220	0	.984		
	1.575	2.362	1.567	1.220	0	.984		
	1.969	2.362	1.567	1.299	0	1.024		
	1.969	2.362	1.567	1.299	0	1.024		
	2.480	2.756	1.882	1.575	0	1.319		
	2.480	2.756	1.882	1.575	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.260	2.165	1.567	1.496	0	.787		
	1.260	2.165	1.567	1.496	0	.787		
	1.575	2.362	1.567	1.772	0	.984		
	1.575	2.362	1.567	1.772	0	.984		
	1.969	2.362	1.567	1.850	0	1.024		
	1.969	2.362	1.567	1.850	0	1.024		
	2.480	2.756	1.882	2.126	0	1.319		
	2.480	2.756	1.882	2.126	0	1.319		

Select an Insert

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

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
E	.094", 2.39mm	●	●	●	●	●
	.098", 2.50mm	●	●	●	●	●

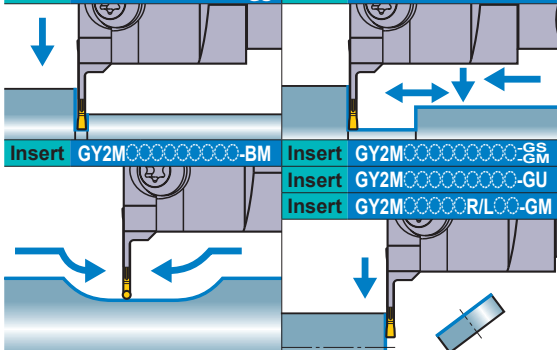
		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
E	.094", 2.39mm	●			
	.098", 2.50mm	●	●	●	●
	.108", 2.74mm	●			

● : Gauge insert shown dimensions

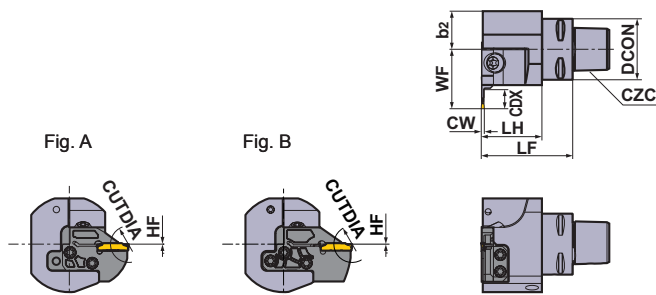
GY SERIES (EXTERNAL GROOVING PSC TYPE)

8-1 90° type holder (Inch)

Insert	GY2M ^{GS} -GM	Insert	GY2G ^{GS} -MF
Insert	GY2M ^{GS} -GU	Insert	GY2M ^{GS} -MS
Insert	GY1G ^{GS} -GF	Insert	GY2M ^{GS} -MM



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






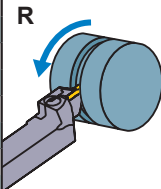
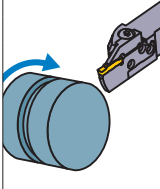
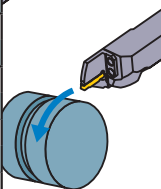
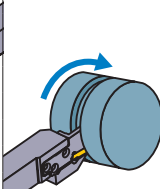
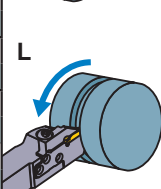
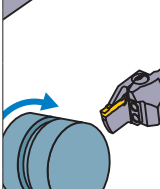
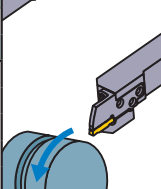
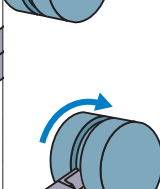
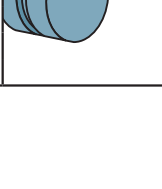
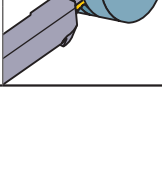




Right hand tool holder shown.

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
F	.118 .125 .128	.236	.472	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-F06	●	A	C3
				Modular	L	C3-GYHLCX90-M20R	●	GYM20RA-F06	●	A	
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-F06	●	A	C4
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-F06	●	A	
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-F06	●	A	C5
				Modular	L	C5-GYHLD90-M25R	●	GYM25RA-F06	●	A	
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-F06	●	A	C6
				Modular	L	C6-GYHLE90-M25R	●	GYM25RA-F06	●	A	
		.394	.787	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-F10	●	A	C3
				Modular	L	C3-GYHLCX90-M20R	●	GYM20RA-F10	●	A	
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-F12	●	A	C4
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-F12	●	A	
		.472	.945	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-F12	●	A	C5
				Modular	L	C5-GYHLD90-M25R	●	GYM25RA-F12	●	A	
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-F12	●	A	C6
				Modular	L	C6-GYHLE90-M25R	●	GYM25RA-F12	●	A	
		.709 ^{*4}	1.417	Modular	R	C3-GYHRCX90-M20L	●	GYM20LB-F18	●	B	C3
				Modular	L	C3-GYHLCX90-M20R	●	GYM20RB-F18	●	B	
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-F20	●	B	C4
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-F20	●	B	
.787 ^{*1}	1.575 ^{*2}	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-F20	●	B	C5		
		Modular	L	C5-GYHLD90-M25R	●	GYM25RA-F20	●	B			
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-F20	●	B	C6		
		Modular	L	C6-GYHLE90-M25R	●	GYM25RA-F20	●	B			

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LCX90-M20L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	b2	Clockwise	Anticlockwise
	1.260	2.165	1.567	1.024	0	.787		
	1.260	2.165	1.567	1.024	0	.787		
	1.575	2.362	1.567	1.220	0	.984		
	1.575	2.362	1.567	1.220	0	.984		
	1.969	2.362	1.567	1.299	0	1.024		
	1.969	2.362	1.567	1.299	0	1.024		
	2.480	2.756	1.882	1.575	0	1.319		
	2.480	2.756	1.882	1.575	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.260	2.165	1.567	1.496	0	.787		
	1.260	2.165	1.567	1.496	0	.787		
	1.575	2.362	1.567	1.772	0	.984		
	1.575	2.362	1.567	1.772	0	.984		
	1.969	2.362	1.567	1.850	0	1.024		
	1.969	2.362	1.567	1.850	0	1.024		
	2.480	2.756	1.882	2.126	0	1.319		
	2.480	2.756	1.882	2.126	0	1.319		

Select an Insert

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

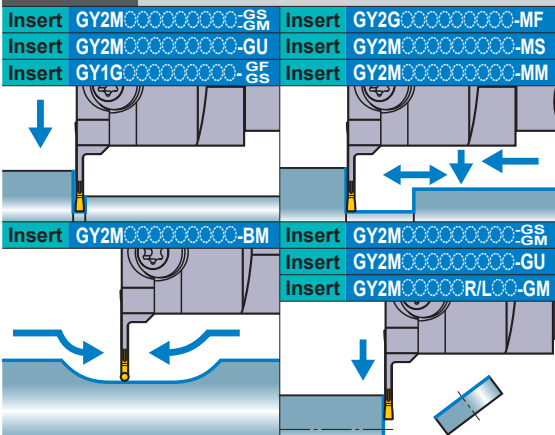
		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
F	.118", 3.00mm	●	●	●	●	●
	.125", 3.18mm	●	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
F	.118", 3.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"			●	
	.125", 3.18mm				●
	RE .008"	●			
	RE .016"	●			
	.128", 3.24mm	●			

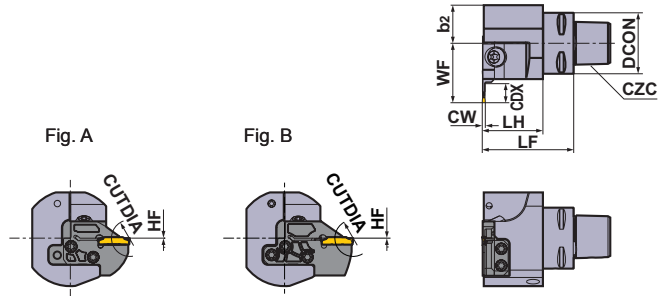
● : Gauge insert shown dimensions

GY SERIES (EXTERNAL GROOVING PSC TYPE)

8-1 90° type holder (Inch)



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






Right hand tool holder shown.

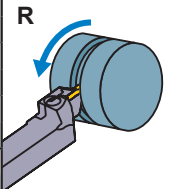
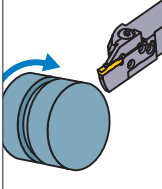
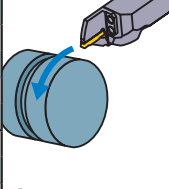
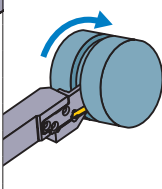
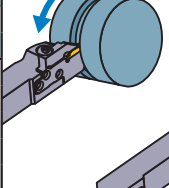
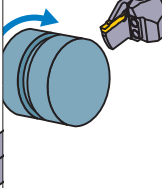
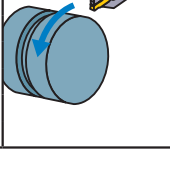
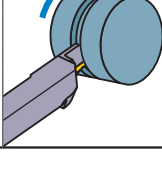
GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC
						Holder	Stock	Modular Blade	Stock		
G	.157 .167	.315	.630	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-G08	●	A	C4
				L	C4-GYHLD90-M25R	●	GYM25RA-G08	●	A		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-G08	●	A	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-G08	●	A		
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-G08	●	A	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-G08	●	A		
		.472	.945	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-G12	●	A	C3
				L	C3-GYHLCX90-M20R	●	GYM20RA-G12	●	A		
				Modular	R	C4-GYHRD90-M25L	●	GYM25LA-G14	●	A	C4
		L	C4-GYHLD90-M25R	●	GYM25RA-G14	●	A				
		.551	1.102	Modular	R	C5-GYHRD90-M25L	●	GYM25LA-G14	●	A	C5
				L	C5-GYHLD90-M25R	●	GYM25RA-G14	●	A		
	Modular			R	C6-GYHRE90-M25L	●	GYM25LA-G14	●	A	C6	
	L			C6-GYHLE90-M25R	●	GYM25RA-G14	●	A			
	.984*1	1.969*2	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-G25	●	B	C4	
			L	C4-GYHLD90-M25R	●	GYM25RA-G25	●	B			
Modular			R	C5-GYHRD90-M25L	●	GYM25LA-G25	●	B	C5		
L			C5-GYHLD90-M25R	●	GYM25RA-G25	●	B				
				Modular	R	C6-GYHRE90-M25L	●	GYM25LA-G25	●	B	C6
				L	C6-GYHLE90-M25R	●	GYM25RA-G25	●	B		

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LCX90-M20L/R		TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	b2	Clockwise	Anticlockwise
	1.575	2.362	1.567	1.299	0	.984		
	1.575	2.362	1.567	1.299	0	.984		
	1.969	2.362	1.567	1.378	0	1.024		
	1.969	2.362	1.567	1.378	0	1.024		
	2.480	2.756	1.882	1.654	0	1.319		
	2.480	2.756	1.882	1.654	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.575	2.362	1.567	1.969	0	.984		
	1.575	2.362	1.567	1.969	0	.984		
	1.969	2.362	1.567	2.047	0	1.024		
	1.969	2.362	1.567	2.047	0	1.024		
	2.480	2.756	1.882	2.323	0	1.319		
	2.480	2.756	1.882	2.323	0	1.319		

Select an Insert

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

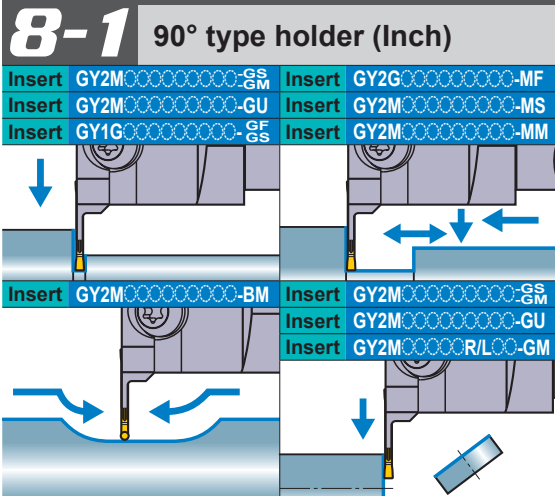
		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		CW	Neutral	Neutral	Neutral	Hand
G	.157", 4.00mm	●	●	●	●	●

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
		CW			
G	.157", 4.00mm				●
	RE .008"	●	●	●	
	RE .016"	●	●	●	
	RE .031"	●		●	
G	.167", 4.24mm	●			

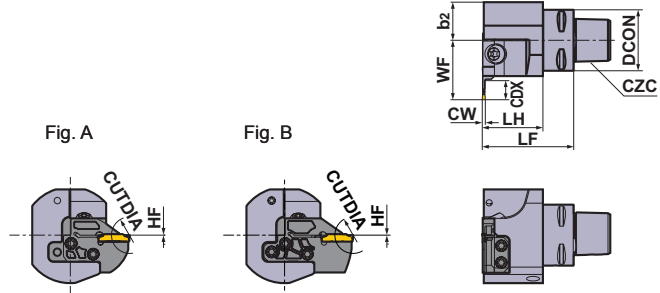
● : Gauge insert shown dimensions

GROOVING

GY SERIES (EXTERNAL GROOVING PSC TYPE)



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






Right hand tool holder shown.

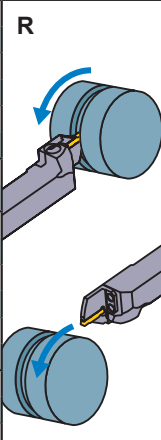
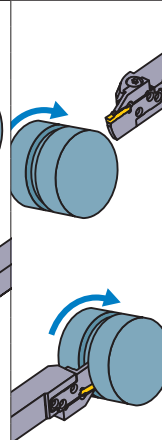
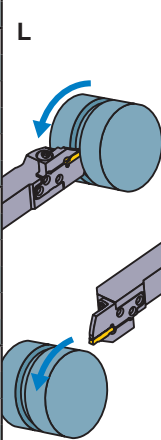
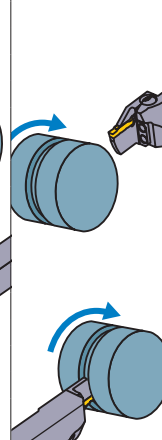
GROOVING

Seat Size	CW (inch)	CDX (inch)	CUTDIA (inch)	Type	Hand (R/L)	Order Number				Fig.	CZC	
						Holder	Stock	Modular Blade	Stock			
H	.187 .197 .206	.315	.630	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-H08	●	A	C4	
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-H08	●	A		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-H08	●	A	C5	
		Modular	L	C5-GYHLD90-M25R	●	GYM25RA-H08	●	A				
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-H08	●	A	C6			
		Modular	L	C6-GYHLE90-M25R	●	GYM25RA-H08	●	A				
	.472	.551	.945	.945	Modular	R	C3-GYHRCX90-M20L	●	GYM20LA-H12	●	A	C3
					Modular	L	C3-GYHLCX90-M20R	●	GYM20RA-H12	●	A	
			Modular	R	C4-GYHRD90-M25L	●	GYM25LA-H14	●	A	C4		
			Modular	L	C4-GYHLD90-M25R	●	GYM25RA-H14	●	A			
			Modular	R	C5-GYHRD90-M25L	●	GYM25LA-H14	●	A	C5		
			Modular	L	C5-GYHLD90-M25R	●	GYM25RA-H14	●	A			
.984*1	1.969*2	1.969*2	1.969*2	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-H25	●	B	C4	
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-H25	●	B		
		Modular	R	C5-GYHRD90-M25L	●	GYM25LA-H25	●	B	C5			
		Modular	L	C5-GYHLD90-M25R	●	GYM25RA-H25	●	B				
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-H25	●	B	C6			
		Modular	L	C6-GYHLE90-M25R	●	GYM25RA-H25	●	B				
J	.236 .248 .250	.315	.630	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-J08	●	A	C4	
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-J08	●	A		
				Modular	R	C5-GYHRD90-M25L	●	GYM25LA-J08	●	A	C5	
		Modular	L	C5-GYHLD90-M25R	●	GYM25RA-J08	●	A				
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-J08	●	A	C6			
		Modular	L	C6-GYHLE90-M25R	●	GYM25RA-J08	●	A				
	.984*1	1.969*2	1.969*2	1.969*2	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-J14	●	A	C4
					Modular	L	C4-GYHLD90-M25R	●	GYM25RA-J14	●	A	
			Modular	R	C5-GYHRD90-M25L	●	GYM25LA-J14	●	A	C5		
			Modular	L	C5-GYHLD90-M25R	●	GYM25RA-J14	●	A			
			Modular	R	C6-GYHRE90-M25L	●	GYM25LA-J14	●	A	C6		
			Modular	L	C6-GYHLE90-M25R	●	GYM25RA-J14	●	A			
.984*1	1.969*2	1.969*2	1.969*2	Modular	R	C4-GYHRD90-M25L	●	GYM25LA-J25	●	B	C4	
				Modular	L	C4-GYHLD90-M25R	●	GYM25RA-J25	●	B		
		Modular	R	C5-GYHRD90-M25L	●	GYM25LA-J25	●	B	C5			
		Modular	L	C5-GYHLD90-M25R	●	GYM25RA-J25	●	B				
		Modular	R	C6-GYHRE90-M25L	●	GYM25LA-J25	●	B	C6			
		Modular	L	C6-GYHLE90-M25R	●	GYM25RA-J25	●	B				

*1 The maximum groove depth varies according to the insert used. Please refer to the maximum groove depth of inserts on pages F013 to F016.
 *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 F013 to F016.
 *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 F189.

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

SPARE PARTS			
Holder Number		 5 pcs.	
	Clamp Screw	Blade Screw	Wrench *
C3-GYHR/LCX90-M20L/R	GY06013M (Clamp Torque : 53 lbf-in)	TS407 (Clamp Torque : 31 lbf-in)	①TKY30R ②TKY15D
C4-GYHR/LD90-M25L/R		TS55 (Clamp Torque : 44 lbf-in)	①TKY30R ②TKY25D
C5-GYHR/LD90-M25L/R			
C6-GYHR/LE90-M25L/R			

	Dimensions (inch) *3						Cutting Mode	
	DCON	LF	LH	WF	HF	b2	Clockwise	Anticlockwise
	1.575	2.362	1.567	1.299	0	.984		
	1.575	2.362	1.567	1.299	0	.984		
	1.969	2.362	1.567	1.378	0	1.024		
	1.969	2.362	1.567	1.378	0	1.024		
	2.480	2.756	1.882	1.654	0	1.319		
	2.480	2.756	1.882	1.654	0	1.319		
	1.260	2.165	1.567	1.260	0	.787		
	1.260	2.165	1.567	1.260	0	.787		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.575	2.362	1.567	1.969	0	.984		
	1.575	2.362	1.567	1.969	0	.984		
	1.969	2.362	1.567	2.047	0	1.024		
	1.969	2.362	1.567	2.047	0	1.024		
	2.480	2.756	1.882	2.323	0	1.319		
	2.480	2.756	1.882	2.323	0	1.319		
	1.575	2.362	1.567	1.299	0	.984		
	1.575	2.362	1.567	1.299	0	.984		
	1.969	2.362	1.567	1.378	0	1.024		
	1.969	2.362	1.567	1.378	0	1.024		
	2.480	2.756	1.882	1.654	0	1.319		
	2.480	2.756	1.882	1.654	0	1.319		
	1.575	2.362	1.567	1.535	0	.984		
	1.575	2.362	1.567	1.535	0	.984		
	1.969	2.362	1.567	1.614	0	1.024		
	1.969	2.362	1.567	1.614	0	1.024		
	2.480	2.756	1.882	1.890	0	1.319		
	2.480	2.756	1.882	1.890	0	1.319		
	1.575	2.362	1.567	1.969	0	.984		
	1.575	2.362	1.567	1.969	0	.984		
	1.969	2.362	1.567	2.047	0	1.024		
	1.969	2.362	1.567	2.047	0	1.024		
	2.480	2.756	1.882	2.323	0	1.319		
	2.480	2.756	1.882	2.323	0	1.319		

Select an Insert

Seat Size	Insert Number
H	GY00475/0500/0524H-Breaker
J	GY00600/0631/0635J-Breaker

		For Grooving/Cutting off > F013, F014				
Seat Size	Breaker	GU	GS	GM	05-GM	GFGS
		Neutral	Neutral	Neutral	Hand	Neutral
H	.187", 4.75mm	●	●	●		●
	.197", 5.00mm	●	●	●	●	●
J	.236", 6.00mm	●	●	●		
	.250", 6.35mm	●	●	●		

		For Multifunctional Grooving > F015, F016			
Seat Size	Breaker	MF	MS	MM	BM
					Ball nose
H	.187", 4.75mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.197", 5.00mm				●
J	.206", 5.24mm				●
	RE .008"	●			
	RE .016"	●	●	●	
	RE .031"	●	●	●	
	.236", 6.00mm				●
J	.248", 6.31mm				●
	RE .008"	●			
	RE .016"	●			
	RE .031"	●			
	.250", 6.35mm				●

● : Gauge insert shown dimensions

GROOVING

GROOVING SYSTEM

RECOMMENDED CUTTING SPEED (SFM) [For External Grooving]

Work Material	Hardness	Grade	Cutting Speed (SFM)						
			165	330	490	655	820	985	
P Mild Steel	≤160HB	VP20RT		330	720				
		VP10RT		360	755				
		NX2525		295	690				
	Carbon Steel Alloy Steel	160-280HB	VP20RT		260	590			
			VP10RT		295	620			
			MY5015		360	820			
			NX2525		230	560			
		280HB≤	VP20RT		195	460			
			VP10RT		230	490			
			MY5015		295	690			
NX2525		180	440						
	M Stainless Steel	≤270HB	VP20RT	195	460				
VP10RT			230	490					
K Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT		260	590				
		VP10RT		295	620				
		MY5015		460	985				
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT		195	460			
			VP10RT		230	490			
			MY5015		295	690			
S Heat Resistant Alloy Titanium Alloy	-	VP20RT	100	195					
		VP10RT	130	230					
		RT9010	130	230					
H Hardened steel	50HRC≤	MB8025		260	395				

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

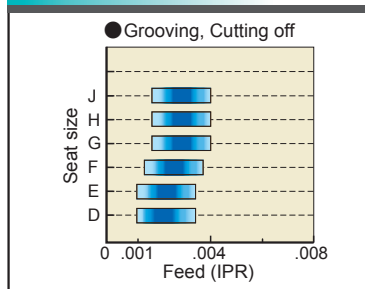
(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For External Grooving]

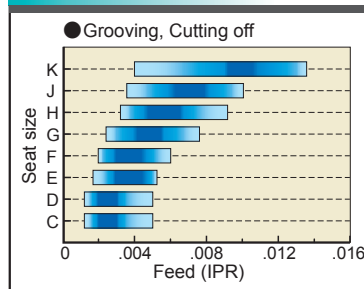
*Below are the recommended cutting conditions when using the modular type holder GYHR/L2525M00/90-M25R/L with the modular blade GYM25R/LA-○○○○.

Recommended feed rate and depth of cut

GU BREAKER

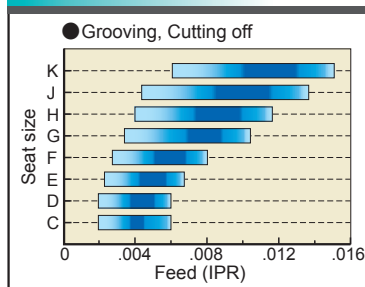


GS BREAKER

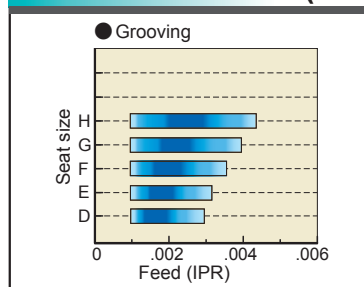


■ : 1st recommended area

GM BREAKER

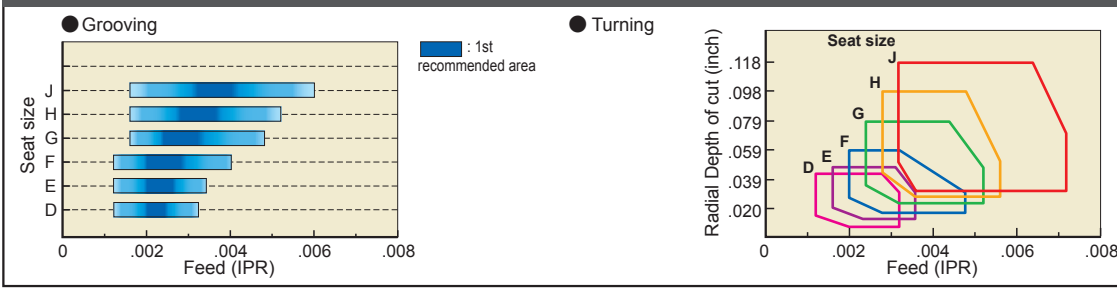


FLAT TOP GFGS (CBN)



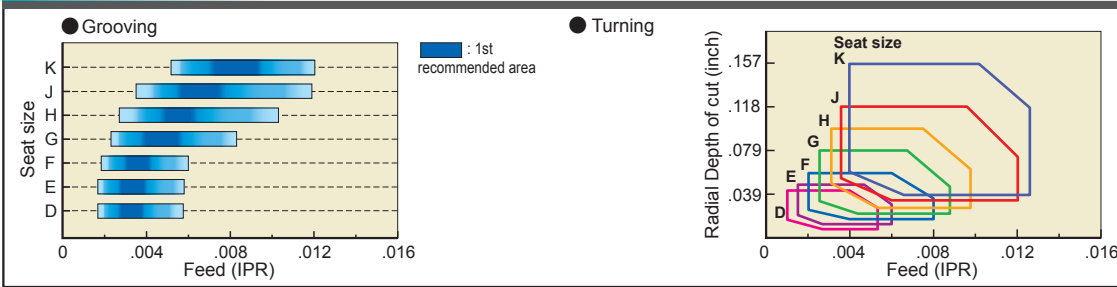
Seat Size	Insert Width
C	.059", 1.50mm
D	.079", 2.00mm
	.088", 2.24mm
E	.094", 2.39mm
	.098", 2.50mm
	.108", 2.74mm
F	.118", 3.00mm
	.125", 3.18mm
G	.128", 3.24mm
	.157", 4.00mm
H	.167", 4.24mm
	.187", 4.75mm
J	.197", 5.00mm
	.206", 5.24mm
K	.236", 6.00mm
	.248", 6.31mm
	.250", 6.35mm
	.315", 8.00mm

MF BREAKER

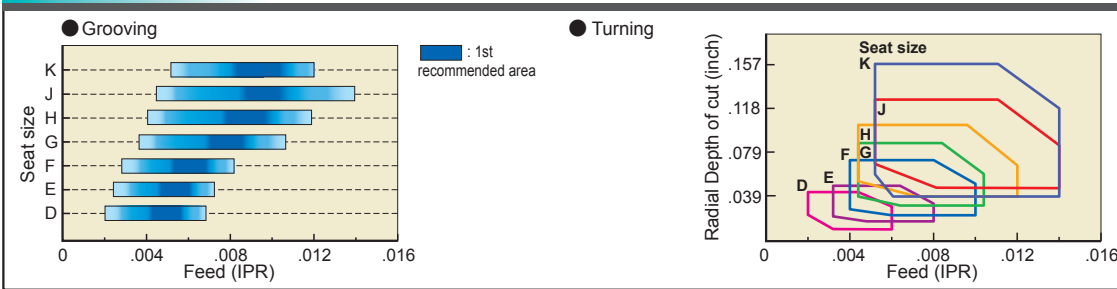


Seat Size	
Insert Width	
C	.059", 1.50mm
D	.079", 2.00mm .088", 2.24mm
E	.094", 2.39mm .098", 2.50mm .108", 2.74mm
F	.118", 3.00mm .125", 3.18mm .128", 3.24mm
G	.157", 4.00mm .167", 4.24mm
H	.187", 4.75mm .197", 5.00mm .206", 5.24mm
J	.236", 6.00mm .248", 6.31mm .250", 6.35mm
K	.315", 8.00mm

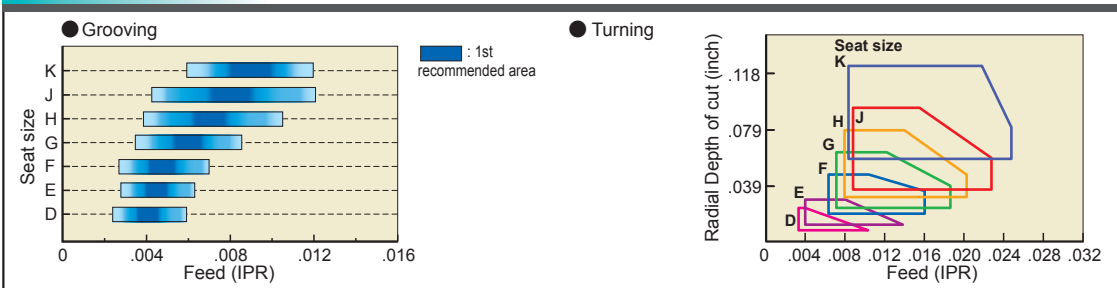
MS BREAKER



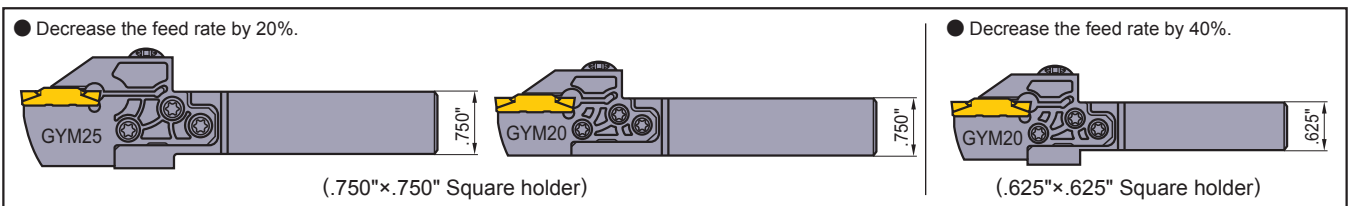
MM BREAKER



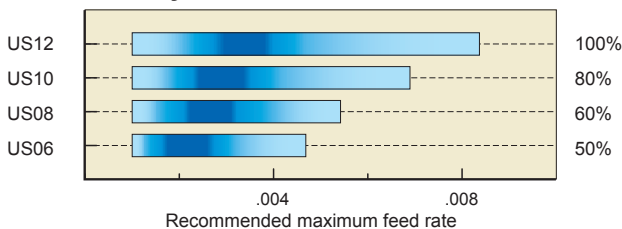
BM BREAKER



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



For Swiss style lathes mono block holder



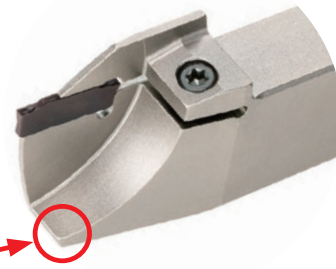
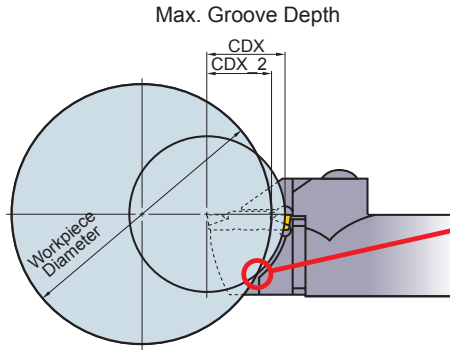
Please refer to the tables above of recommended cutting conditions for external grooving. Apply the percentage ratio shown of each shank size to the values in those tables.

GROOVING SYSTEM

LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

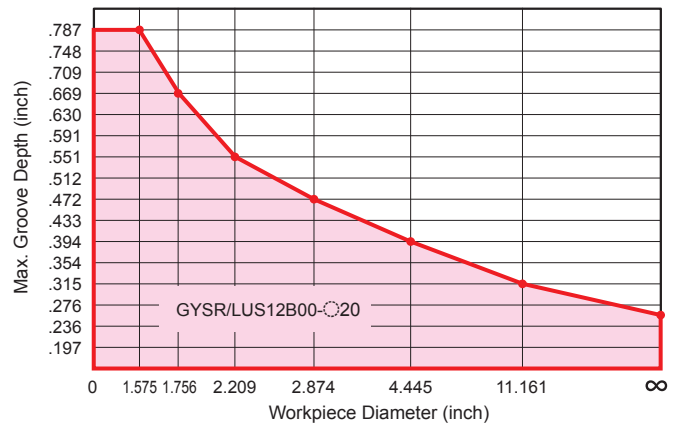
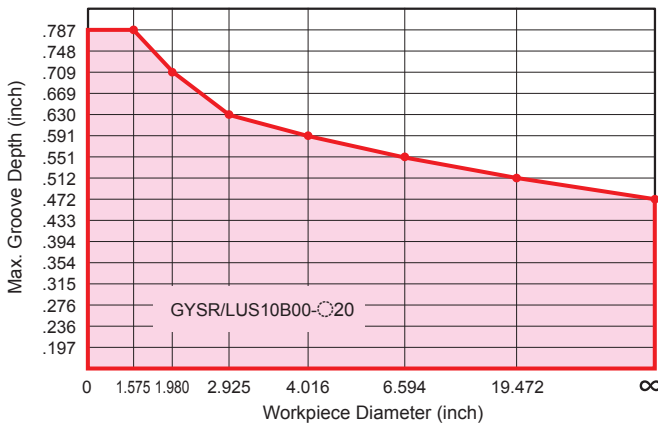
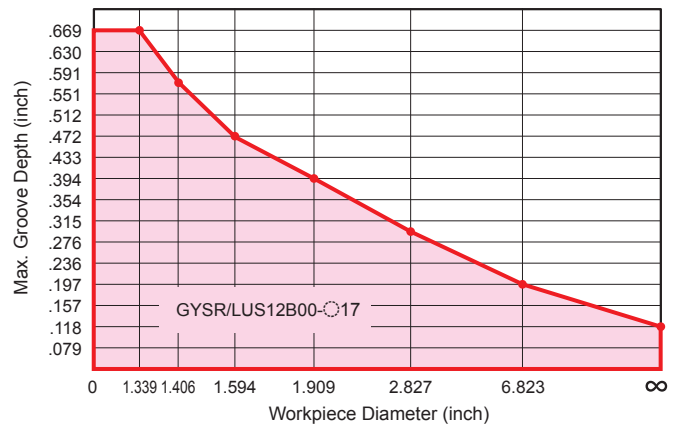
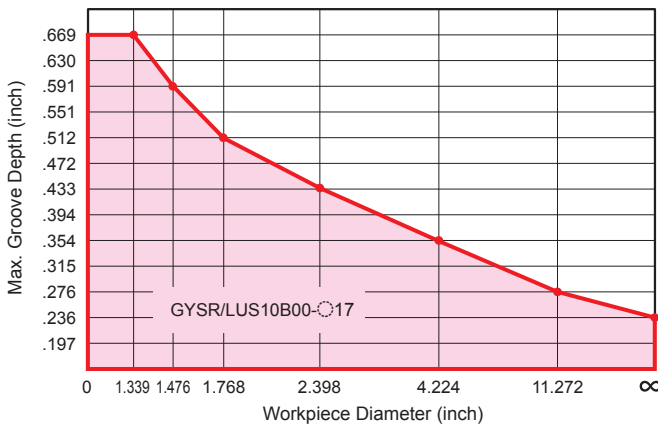
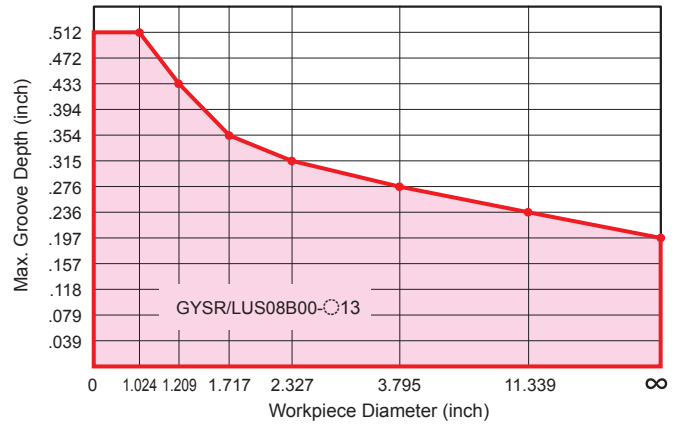
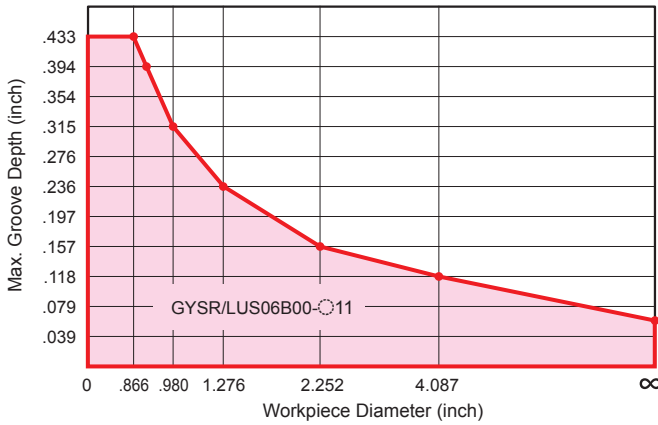
•For Swiss style lathes mono block holder

The maximum groove depth is limited by the workpiece diameter.



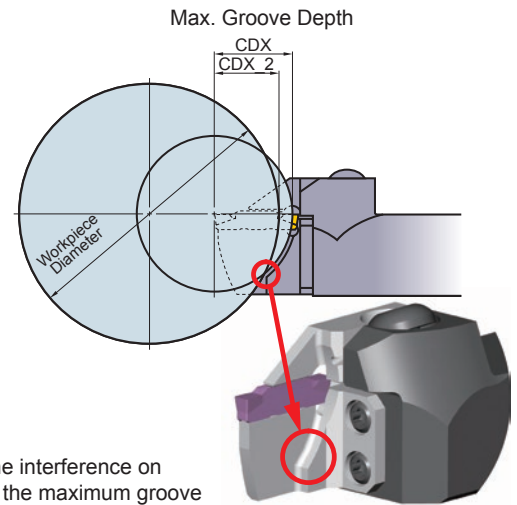
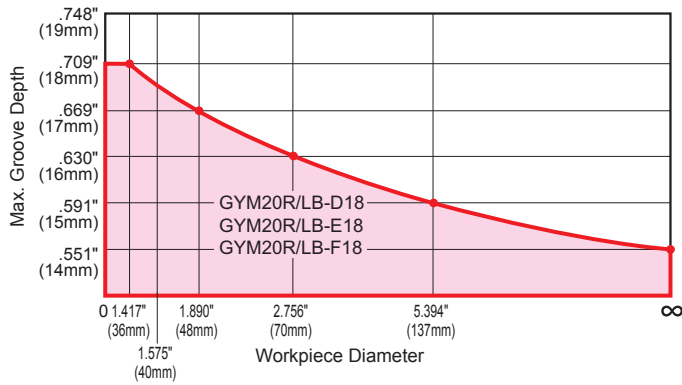
Due to the interference on this part, the maximum groove depth is limited by the workpiece diameter.

GROOVING



LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

- **When using the modular blade GYM[®]OR/LA-[®]○○○**
The maximum groove depth is not limited by the workpiece diameter.
- **When using the modular blade GYM[®]OR/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.

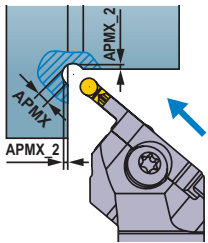
GROOVING SYSTEM

RECOMMENDED CUTTING SPEED (SFM) [For External Recessing]

Work Material	Hardness	Grade	Cutting Speed (SFM)					
			165	330	490	655	820	
P Mild Steel Carbon Steel Alloy Steel	≤180HB	VP20RT		260	590			
		VP10RT		295	620			
	180–280HB	VP20RT	195	460				
		VP10RT	230	490				
		MY5015	295	690				
		NX2525	180	440				
		280–350HB	VP20RT	165	360			
			VP10RT	195	395			
		MY5015	260	525				
		NX2525	150	345				
M Stainless Steel	≤350HB	VP20RT	165	360				
		VP10RT	195	395				
K Gray Cast Iron Ductile Cast Iron	Tensile Strength ≤350MPa	VP20RT	195	460				
		VP10RT	230	490				
		MY5015	295	690				
	Tensile Strength ≤800MPa	VP20RT	165	360				
		VP10RT	195	395				
		MY5015	260	525				
S Titanium Alloy Heat Resistant Alloy	—	VP20RT	100	195				
		VP10RT	130	230				
	—	VP20RT	100	195				
		VP10RT	130	230				

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.
 (Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

DISTANCE FROM THE WORKPIECE TO THE RECESS DEPTH

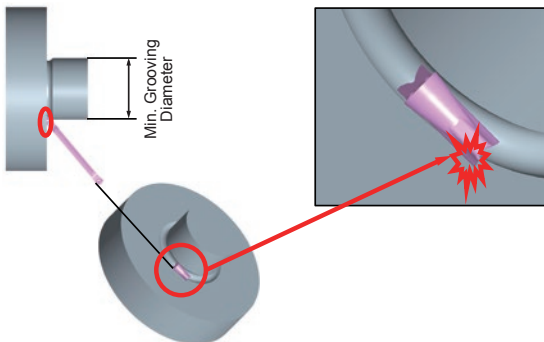


Grooving Width CW	Recessing Depth APMX	Distance workpiece to the recess depth APMX_2
.079", 2.00mm	.059", 1.50mm	.025", 0.646mm
.098", 2.50mm	.069", 1.75mm	.028", 0.720mm
.118", 3.00mm	.079", 2.00mm	.031", 0.793mm
.125", 3.18mm	.082", 2.09mm	.032", 0.819mm
.157", 4.00mm	.098", 2.50mm	.037", 0.939mm
.187", 4.75mm	.113", 2.88mm	.041", 1.049mm
.197", 5.00mm	.118", 3.00mm	.043", 1.086mm
.236", 6.00mm	.138", 3.50mm	.049", 1.232mm
.250", 6.35mm	.145", 3.68mm	.051", 1.283mm

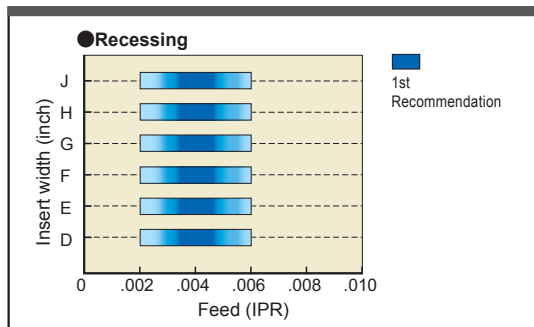
BM BREAKER

Minimum grooving diameter

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



Recommended feed rate and depth of cut



Tool Selection

Notes when selecting the tool body

Modular holder

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

Modular blade (1)

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

Modular blade (2)

● Select the shortest possible blade suitable for the application.

Modular blade (3)

● Select the shortest possible blade suitable for the application.

✓: Recommended.

Notes when setting the tool

Setting of cutting edge height

<Grooving/Cross-feed machining>
Set the cutting edge height to ± 0.004 " parallel to the central axis.
<Cutting off>
Set the cutting edge height to $0 - +0.008$ " parallel to the central axis.

Tool body setting angle

● Set the insert perpendicular to the central axis.

Overhang

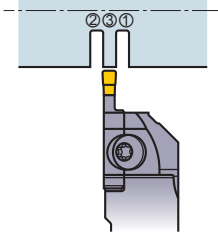
● When setting the tool, ensure that the overhang is as short as possible.

GROOVING SYSTEM

Machining Recommendations

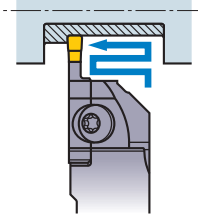
Notes on multi-functional machining (MF-MS and MM breakers)

Machining narrow grooves



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

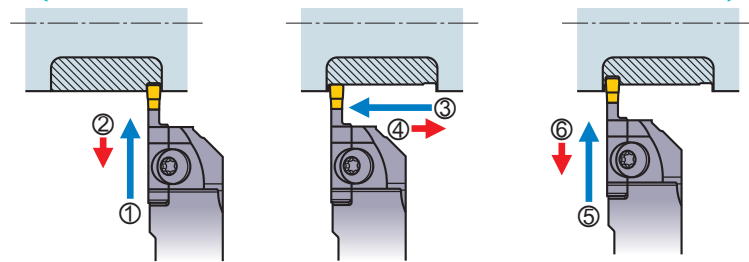
Machining wide grooves



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

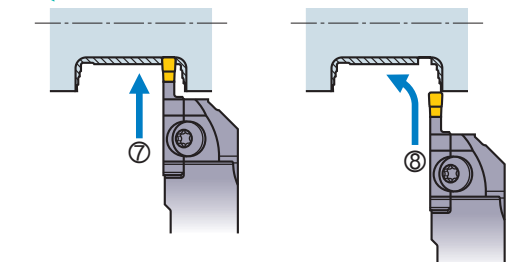
Machining wide grooves

Roughing



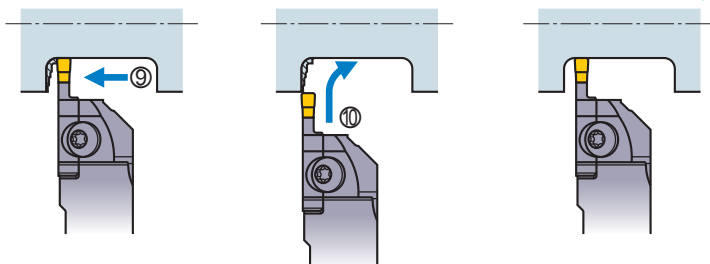
- Carry out grooving.
 - Retract the tool approx .004".
 - Carry out cross feed machining.
 - Retract the tool approx .004".
 - Carry out grooving.
 - Retract the tool approx .004".
- * Repeat the steps ①-⑥.

Finishing



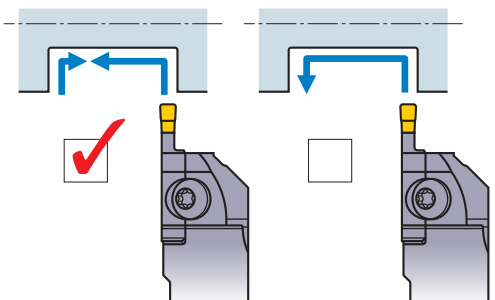
- Carry out grooving to the end point of the corner radius.
- Machining of the wall surface, corner radius and bottom face should be carried out in one process.

Finishing



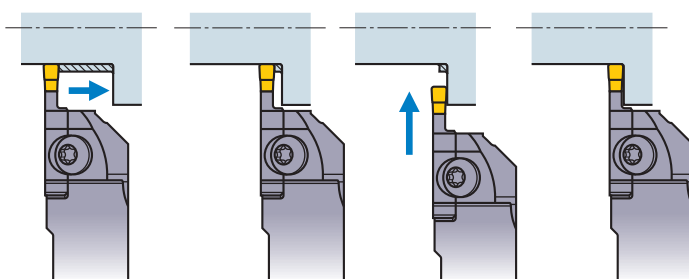
- Stop at the bottom of the corner radius.
- Machine the counter wall to the corner radius in one process.
- Finish machining.

Precautions when finishing walls



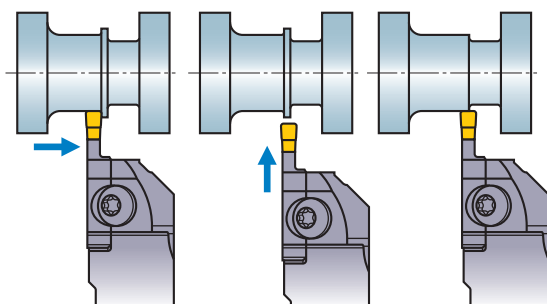
- To produce high accuracy walls using MS or MM breaker insert, do not carry out back turning. Plunging is recommended.

Wall machining



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

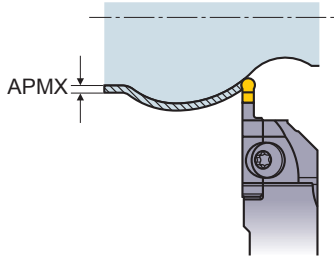
Machining of a ring section



- When a ring remains in a cross feed end process, finish cross feed machining .040"-.059" short of the end point, then remove the ring by plunging.

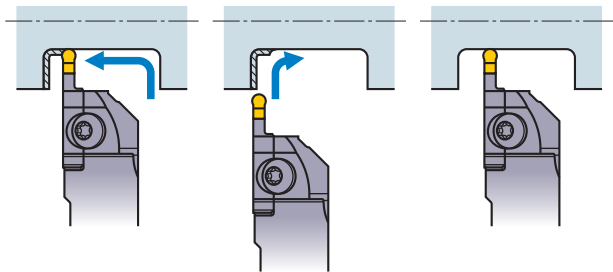
Machining Recommendations

Notes on multi-functional machining (BM breaker)



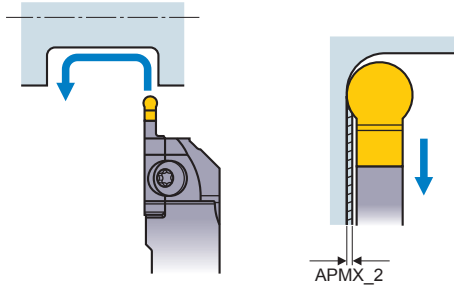
- With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (APMX) to 40% less than the insert width.

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.

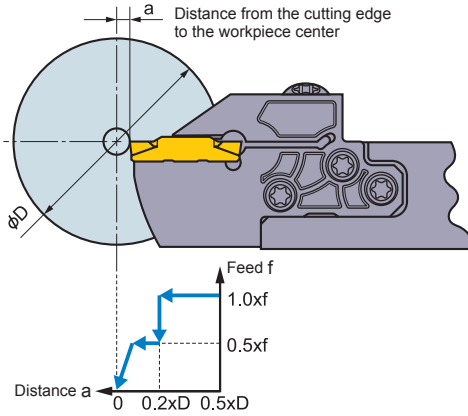
Insert	APMX_2 (inch)
GY2M0200D100N-BM	.002
GY2M0250E125N-BM	.004
GY2M0300F150N-BM	.006
GY2M0318F159N-BM	.006
GY2M0400G200N-BM	.008
GY2M0475H238N-BM	.009
GY2M0500H250N-BM	.009
GY2M0600J150N-BM	.012
GY2M0635J318N-BM	.012
GY2M0800K400N-BM	.016

Machining Recommendations

Notes for cutting off

feed

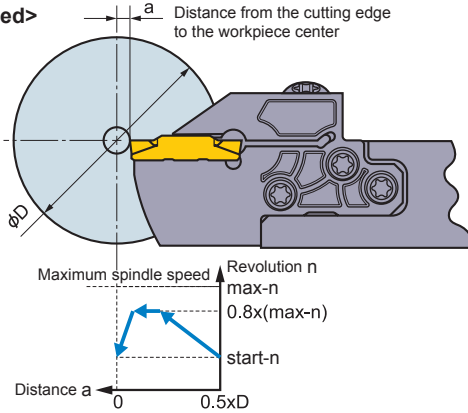
<Feed>



- When the cutting edge approaches the center, reduce the feed by 50%.
- If necessary, stop the feed prior to reaching the center of the workpiece. The part will fall off because of its own weight.

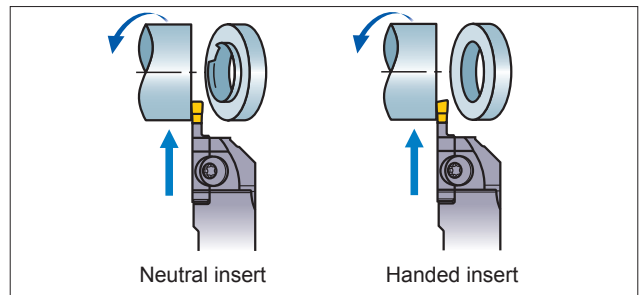
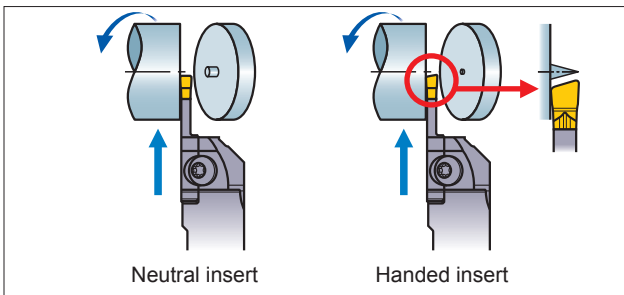
Revolution

<Spindle speed>



- When using constant cutting speed during a cutting off cycle, it is recommended to limit the spindle speed to 80% of maximum to ensure stability.
- To prevent the workpiece from being expelled, lower the spindle speed before finishing the grooving operation.

insert



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

ASSEMBLY INSTRUCTION

Assembly Procedures

A (b) Wrench

(d) Wrench

(a) Insert clamp screw x 1pc.

(c) Modular blade set screw x 5pcs.

(Ex.) GYHRUS16D00 - **M25R**
GYHR2525M00 - **M25R**

Holder

Modular Blade
(Ex.) **GY M25R A - F 20**
GY M25R A - F 12

Long (5 holes) Short, Medium (4 holes)

Insert
(Ex.) GY2M0300 **F 040N-MS**
GY2M0318 **F 030N-GM**

Note 1) ③ and ④ are changed by the insert size.

B

Side Screws (3 screws)

Long Modular Blade (5 holes)

B'

Side Screws (2 screws)

Short, Medium Modular Blade (4 holes)

Note 2) ① and ② should be matched. (See caption A)

C

Front Screws (2 screws)

Note 3) Please tighten the modular blade set screws in order of [Side screws] → [Front screws].

D

Note 4) Please clean the insert-seat before installing the insert.

Note 5) ③ and ④ should be matched. (See caption A)

E

Note 6) Don't tighten the insert clamp screw without installing the insert. This will prevent modular blade damage.

Note 7) The insert clamp screw is inclined. Ensure that the wrench is perpendicular to the screw tightening.

Good **NG**

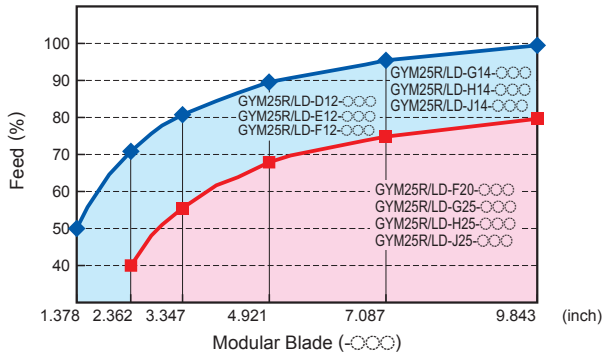
F

Assembled

GROOVING

GROOVING SYSTEM

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



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

RECOMMENDED CUTTING SPEED (SFM) [For Face Grooving]

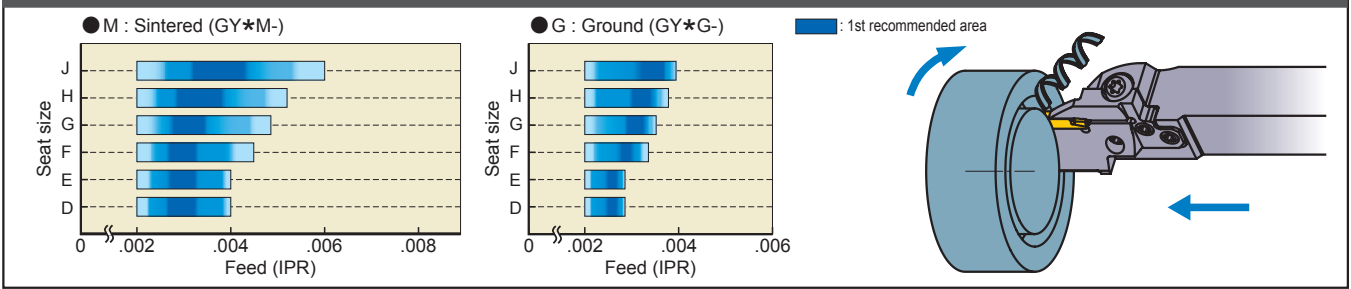
Work Material	Hardness	Grade	Cutting Speed (SFM)							
			165	330	490	655	820	985		
P Mild Steel Carbon Steel Alloy Steel	≤160HB	VP20RT		260	590					
		VP10RT		295	620					
		NX2525	230		560					
	160–280HB	VP20RT	195		460					
		VP10RT	230		490					
		MY5015		295		690				
		NX2525	180		440					
		280HB≤	VP20RT	165		360				
			VP10RT	195		395				
			MY5015		260		525			
NX2525	150			345						
M Stainless Steel	≤270HB	VP20RT	165		360					
	VP10RT	195		395						
K Gray Cast Iron Ductile Cast Iron	Tensile Strength ≤300MPa	VP20RT	195		460					
		VP10RT	230		490					
		MY5015		295		690				
	Tensile Strength ≤800MPa	VP20RT	165		360					
		VP10RT	195		395					
		MY5015		260		525				
S Heat Resistant Alloy Titanium Alloy	—	VP20RT	100	195						
		VP10RT	130	230						
		RT9010	130	230						
H Hardened steel	50HRC≤	MB8025	195	330						

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

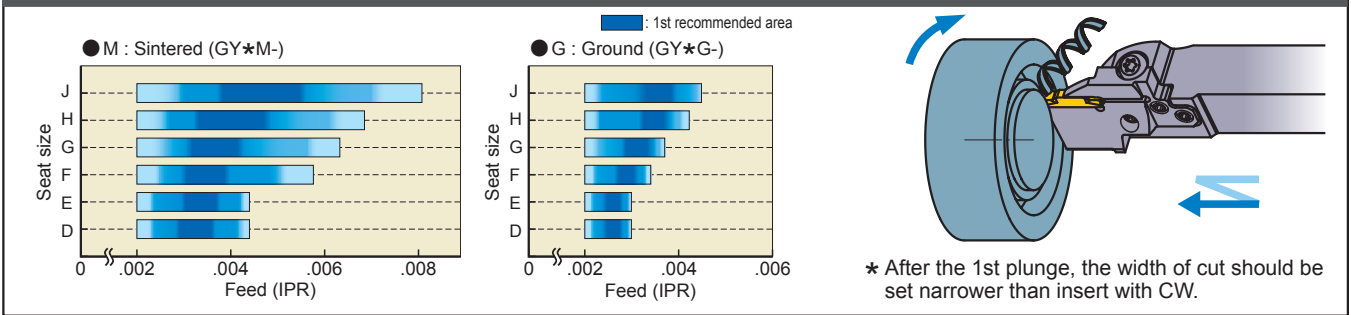
(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For Face Grooving]

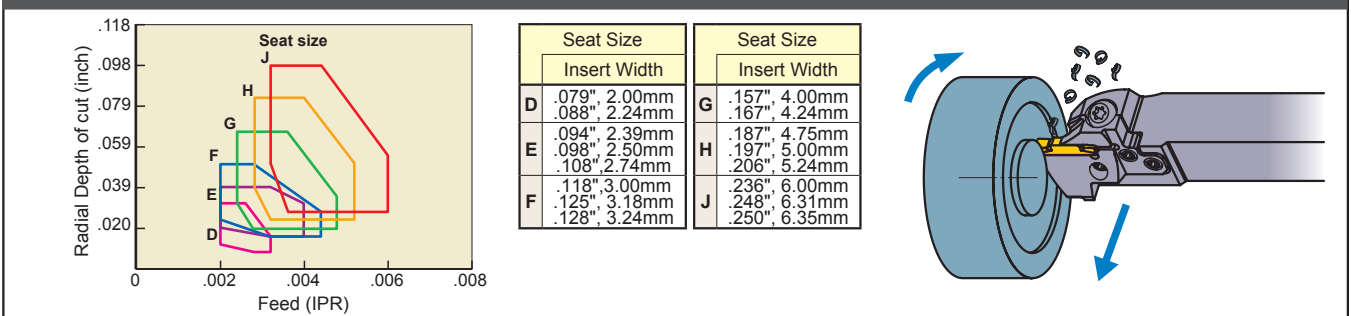
GROOVING



PLUNGING



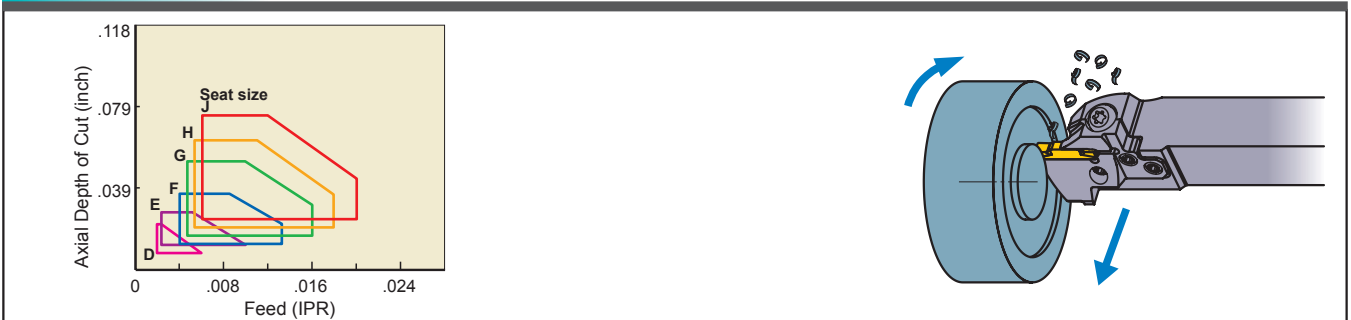
TRAVERSE MACHINING (MF BREAKER)



TRAVERSE MACHINING (MM/MS BREAKER)



TRAVERSE MACHINING (BM BREAKER)

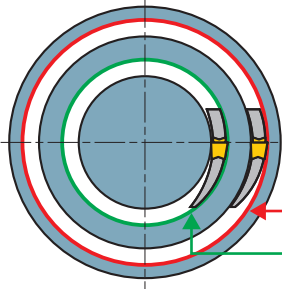


GROOVING SYSTEM

TOOL SELECTION

Notes when selecting the tool body

Modular blade (1)

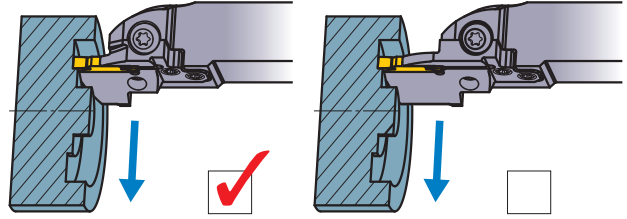


● Select a modular blade for face grooving, so that the cutting diameter at the first pass is within the range of DAXN and DAXX that are described in the table of dimensions.

DAXX (Max.)

DAXN (Min.)

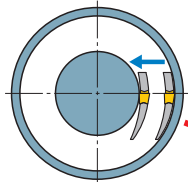
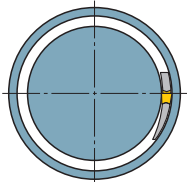
Modular blade (2)



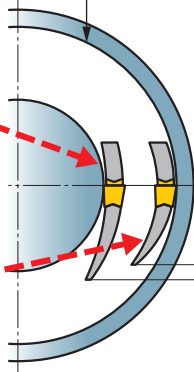
● Select the shortest possible blade suitable for the application.

Modular blade (3)

Good



The maximum cutting diameter

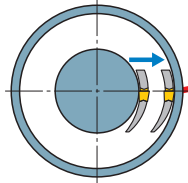
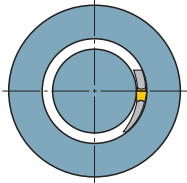


● Select the largest size blade within the maximum cutting diameter of the workpiece.

● Machine from the outer diameter towards the center.



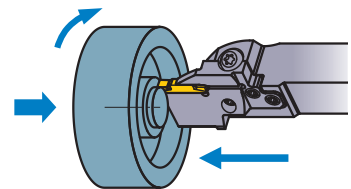
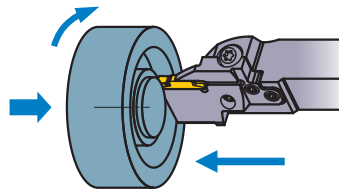
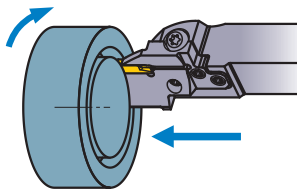
NG



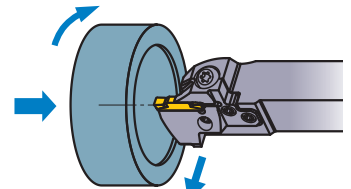
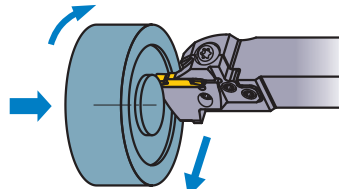
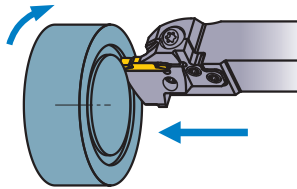
● Increased machining stability and rigidity is possible if a modular blade with the largest possible back metal is used.

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

● When plunging in several passes.



● When combining plunging and infeed machining.



Modular holder



Modular holder



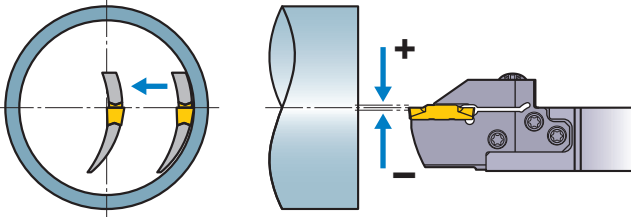
Modular holder

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

GROOVING

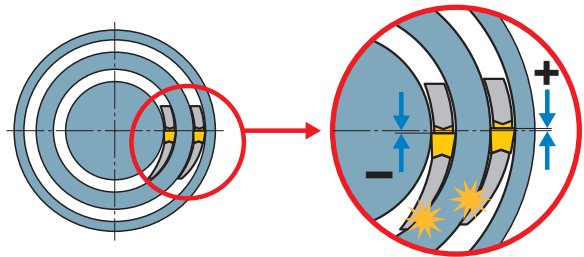
Notes when setting the tool

Setting the cutting edge height



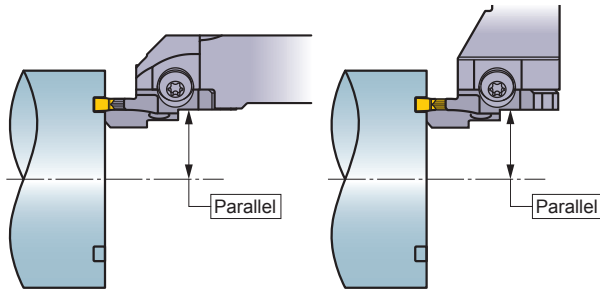
- Set the cutting edge height to $\pm .004$ " parallel to the central axis.
- Cutting edge center height check should be done by traverse machining towards the center with a very small depth of cut and ensure that an even surface and no material remains at the center point afterwards.

When interfering the wall of groove and the Modular blade



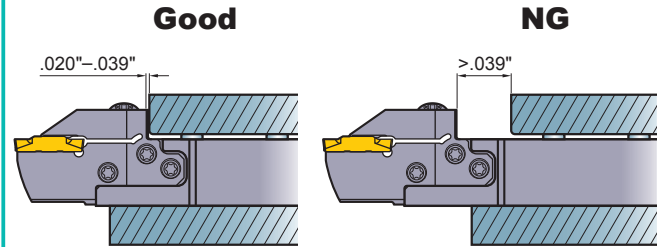
- If interference occurs even when the correct blade is used, the cutting edge height could be incorrect.
 - When interference occurs on the inner side of the blade, the cutting edge height is set too high.
 - When interference occurs on the outer side of the blade, the cutting edge height is set too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

Setting the tool



- Set the insert parallel to the central axis.

Tool overhang



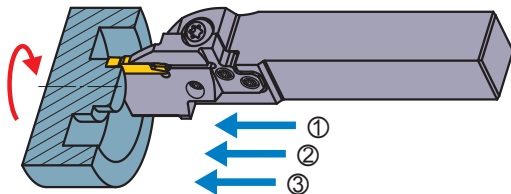
- When setting the tool, ensure that the overhang is as short as possible.

MACHINING RECOMMENDATIONS

Notes when face grooving (1)

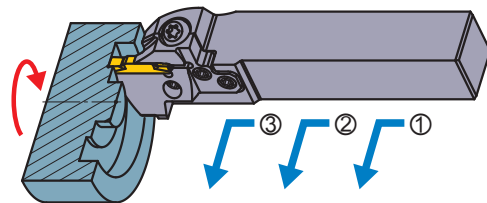
- Always machine from the outer diameter towards the center.

Machining narrow grooves



- Plunging in several passes is recommended.

Machining wide grooves



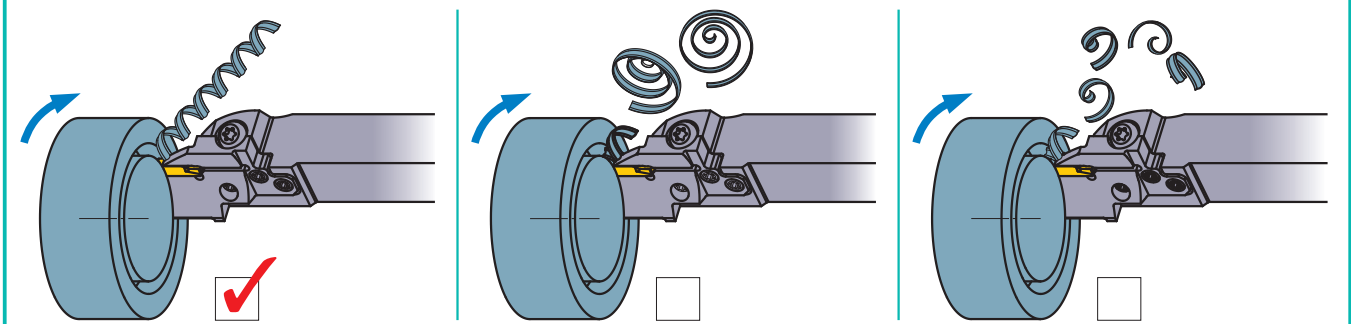
- Cross feed machining is recommended.

GROOVING SYSTEM

MACHINING RECOMMENDATIONS

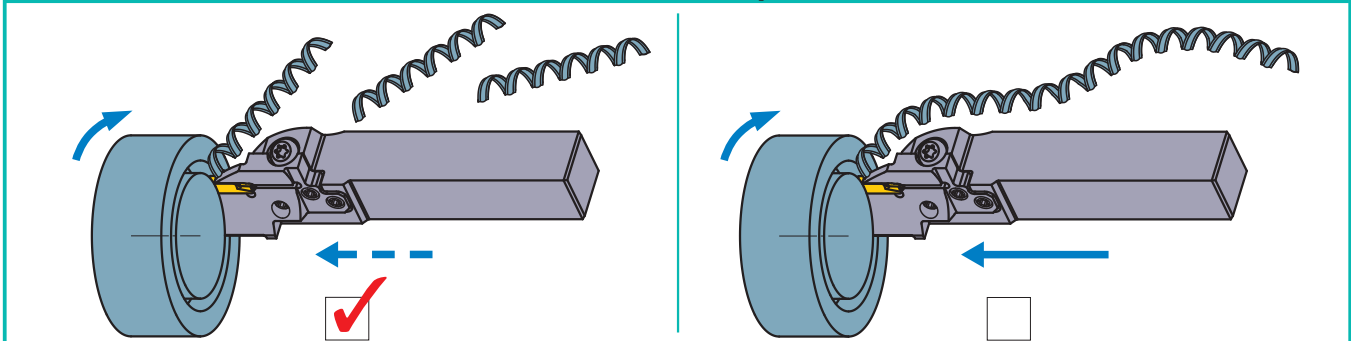
● Notes when face grooving (2)

Notes on the first pass (1)



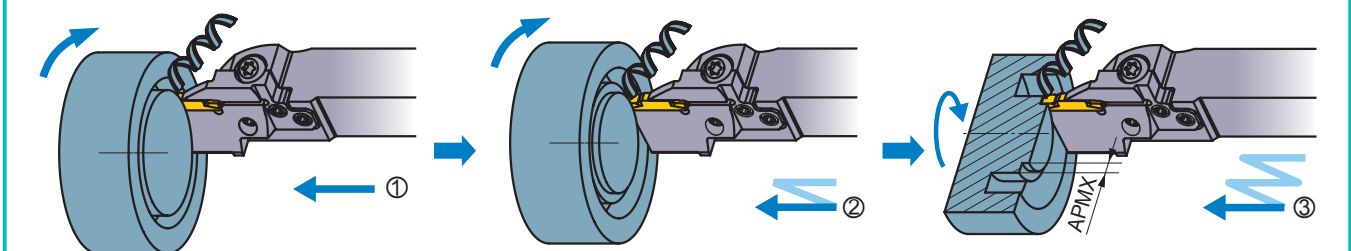
- During the first face grooving pass it is difficult to disperse broken chips and can lead to problems such as a chipped insert. Maintain longer chips that disperse easily by decreasing the feed per rotation.

Notes on the first pass (2)



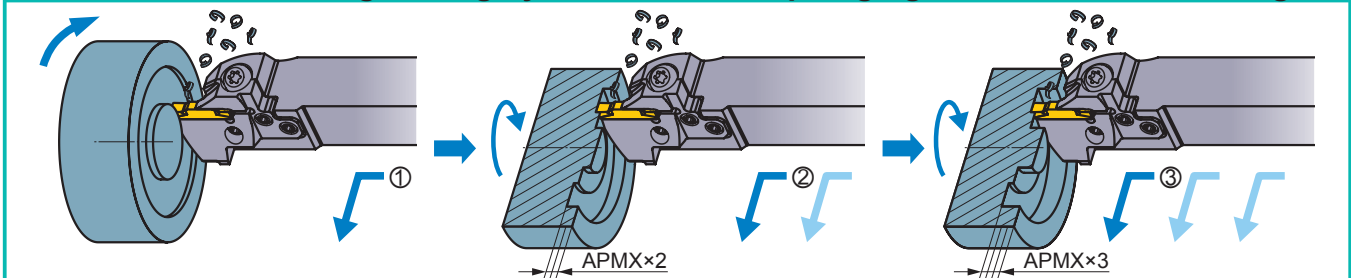
- When chips become too long, use peck feed to break them into a suitable length.

Notes when wide face grooving by plunging in several passes.



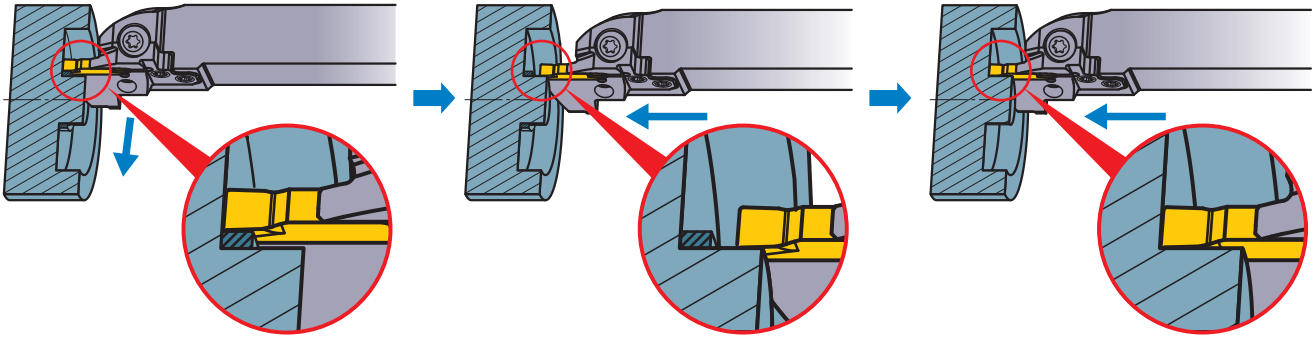
- When machining a face groove in several passes, machine from the outer diameter towards the center so that space for discharging chips is created to prevent insert damage caused by chip jamming.
- Plunging width of cut is recommended to be set at 60 - 80% of the insert width. This enhances the effect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

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



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

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



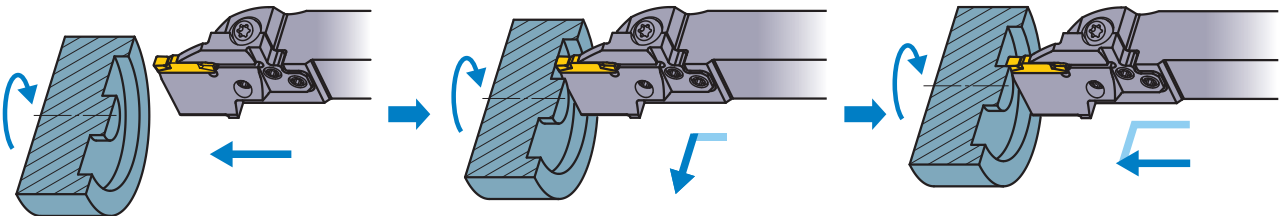
- When infeed machining at the bottom of deep groove, chips may interfere on the cutting edge near the center wall. In such cases, stop infeed machining just before the center wall (at a point less than the insert width) then remove the remaining material by plunging.

Notes when copying (BM Breaker)



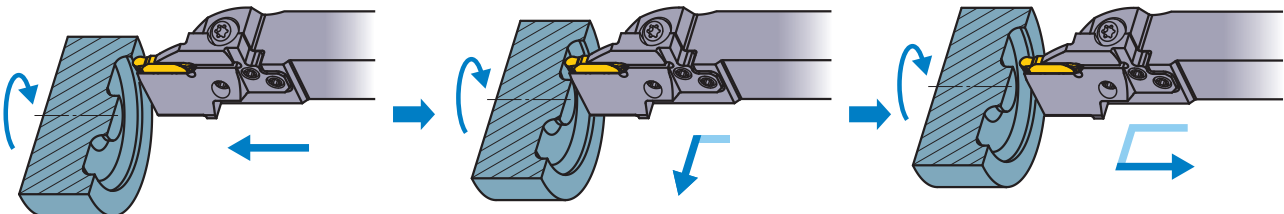
- With the BM breaker insert, 3 dimensional copying is possible. Set the depth of cut (APMX_2) to 30% of the insert width.

Finishing (1)

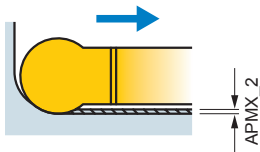


- When finish cutting, machine continuously from the outer wall to the bottom of the groove, then finally plunge cut the center wall.

Finishing (2) (BM Breaker)



- Carry out finishing in one process. For the depth of cut (APMX_2) when back turning, refer to the table on the right.

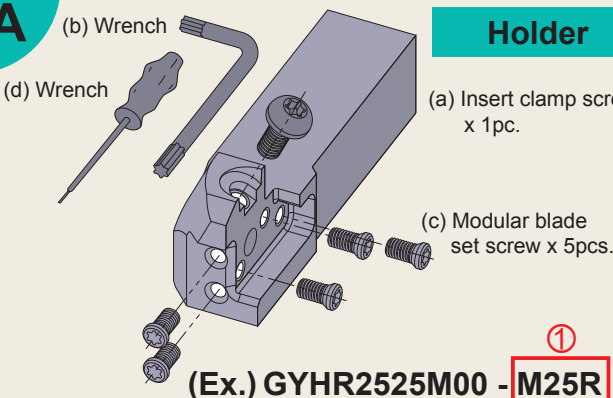


Insert	APMX_2 (inch)
GY2M0200D100N-BM	.004
GY2M0250E125N-BM	
GY2M0300F150N-BM	
GY2M0318F159N-BM	.006
GY2M0400G200N-BM	
GY2M0475H238N-BM	.008
GY2M0500H250N-BM	
GY2M0600J150N-BM	.010
GY2M0635J318N-BM	

ASSEMBLY INSTRUCTION

● Assembly procedure

A



Holder

Modular Blade

(Ex.) ^② GY M25R D - F 20-060
 GY M25R D - F 12-060 ^③

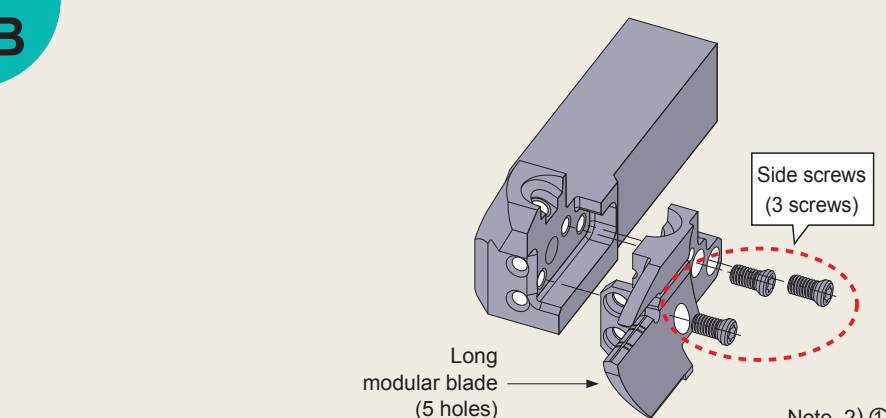
Long Medium

Insert

(Ex.) GY2M0300 F 040N-MS ^④
 GY2M0318 F 030N-GM

Note 1) ③ and ④ are changed by the insert size.

B

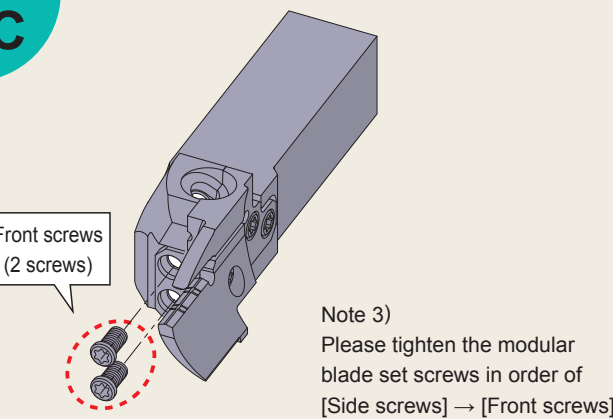


Side screws (3 screws)

Long modular blade (5 holes)

Note 2) ① and ② should be matched. (See caption A)

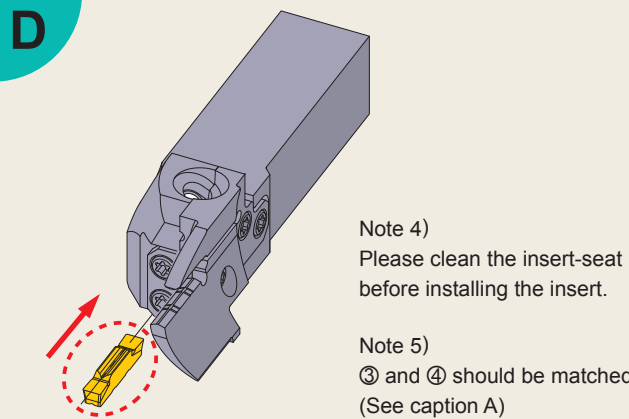
C



Front screws (2 screws)

Note 3) Please tighten the modular blade set screws in order of [Side screws] → [Front screws].

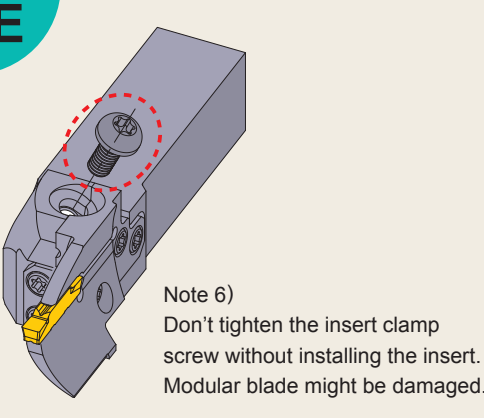
D



Note 4) Please clean the insert-seat before installing the insert.

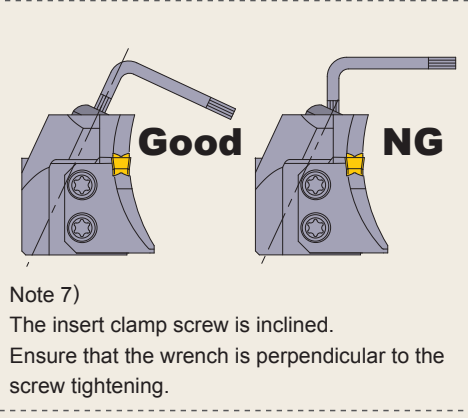
Note 5) ③ and ④ should be matched. (See caption A)

E



Note 6) Don't tighten the insert clamp screw without installing the insert. Modular blade might be damaged.

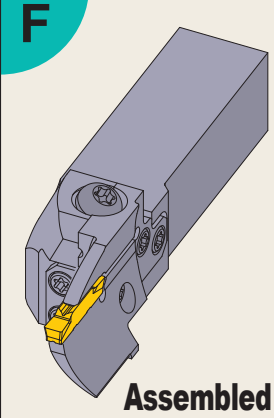
Note 7)



Good **NG**

The insert clamp screw is inclined. Ensure that the wrench is perpendicular to the screw tightening.

F



Assembled

GROOVING

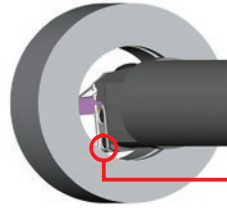
Memo

A series of horizontal dotted lines for writing.

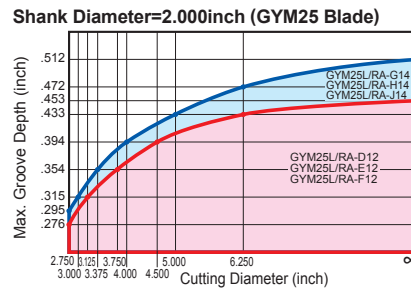
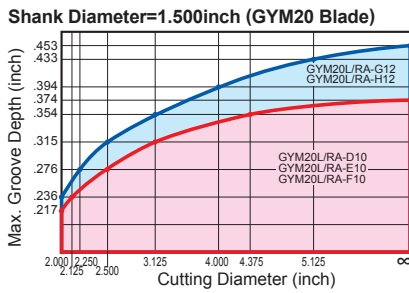
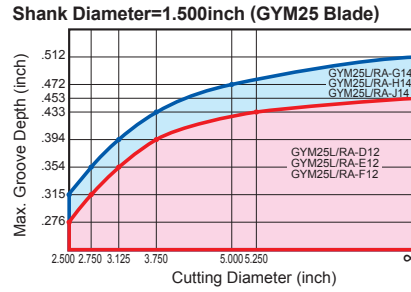
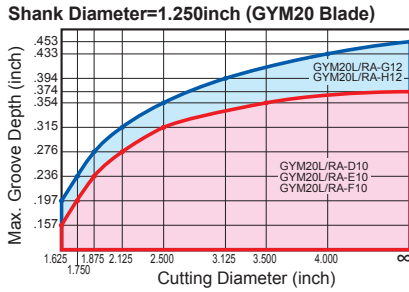
GROOVING SYSTEM

LIMITATION OF THE MAXIMUM GROOVE DEPTH [For Internal Grooving]

- When using the mono block type
The maximum groove depth is not limited by the cutting diameter.
- When using the modular blade type
The maximum groove depth is limited by the cutting diameter.



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



RECOMMENDED CUTTING SPEED (SFM) [For Internal Grooving]

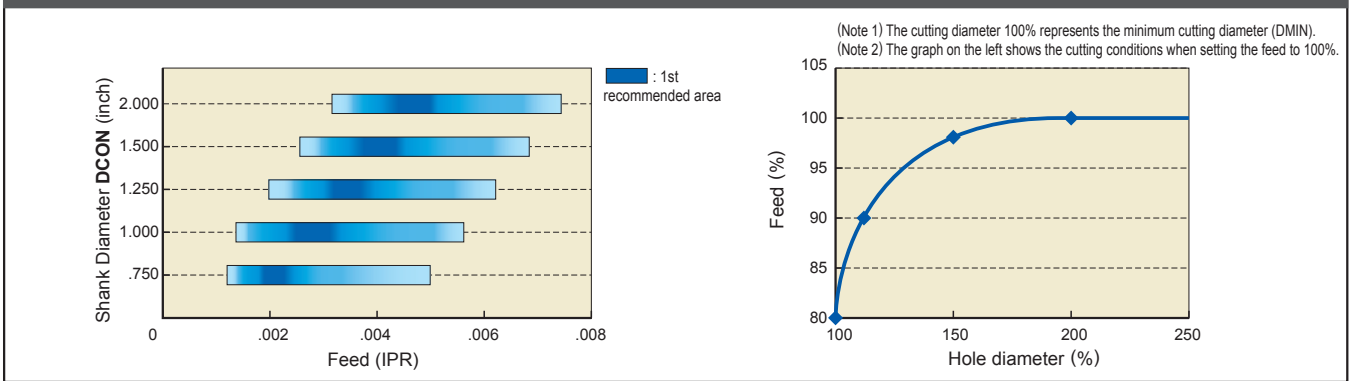
Work Material	Hardness	Grade	Cutting Speed (SFM)						
			165	330	490	655	820	985	
P Mild Steel Carbon Steel Alloy Steel	≤160HB	VP20RT		260	590				
		VP10RT		295	620				
		NX2525	230		560				
	160-280HB	VP20RT	195		460				
		VP10RT	230		490				
		MY5015		295		690			
		NX2525	180		440				
	280HB≤	VP20RT	165		360				
		VP10RT	195		395				
		MY5015		260		525			
	NX2525	150		345					
	M Stainless Steel	≤270HB	VP20RT	165		360			
VP10RT			195		395				
K Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT	195		460				
		VP10RT	230		490				
		MY5015		295		690			
Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	165		360				
		VP10RT	195		395				
		MY5015		260		525			
S Heat Resistant Alloy Titanium Alloy	-	VP20RT	100	195					
		VP10RT	130	230					
		RT9010	130	230					
H Hardened steel	50HRC≤	MB8025	195	330					

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

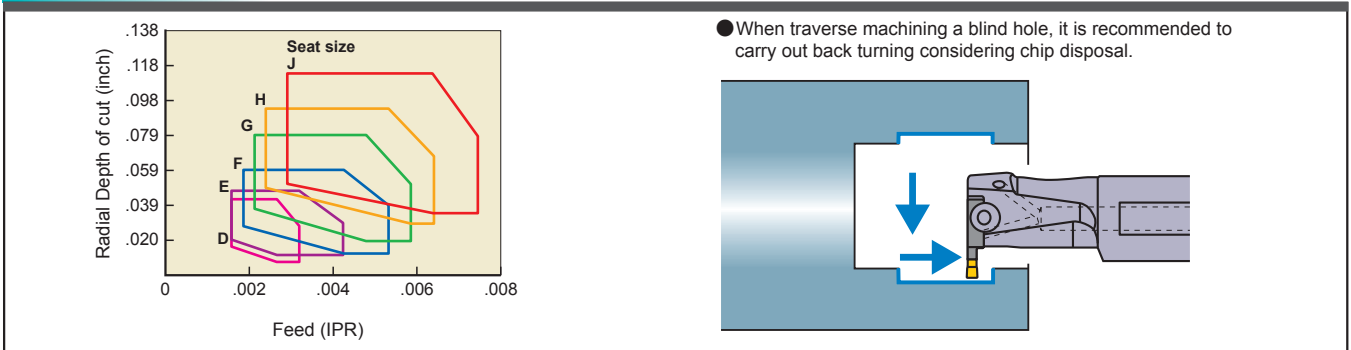
(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

RECOMMENDED CUTTING CONDITIONS [For Internal Grooving]

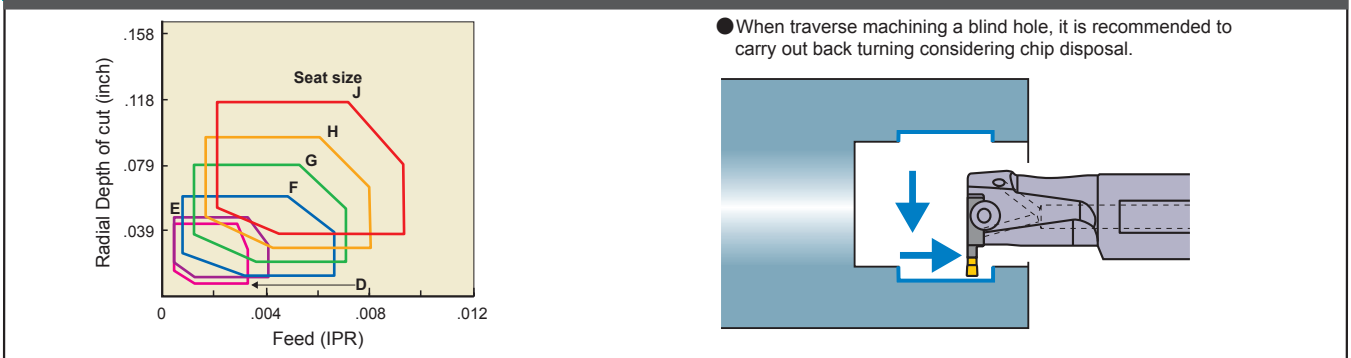
GROOVING



TRAVERSE MACHING (MF BREAKER)

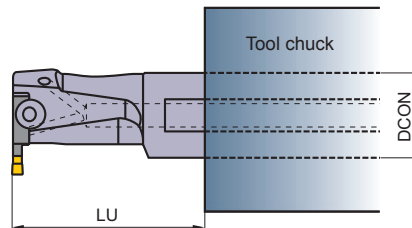


TRAVERSE MACHING (MM/MS BREAKER)



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

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



GROOVING SYSTEM

RECOMMENDATIONS FOR INTERNAL GROOVING

Notes when selecting the tool body



Holder

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

Modular blade (1)

● For a $\phi 1.5"$ & $\phi 40\text{mm}$ shank holder, if there is no restriction for use, select a holder suitable for GYM25 blade.

Modular blade (2)

	
GYM20R/LA-○○○	GYM25R/LA-○○○
GYM20R/LA-D10	GYM25R/LA-D12
GYM20R/LA-E10	GYM25R/LA-E12
GYM20R/LA-F10	GYM25R/LA-F12
GYM20R/LA-G12	GYM25R/LA-G14
GYM20R/LA-H12	GYM25R/LA-H14
	GYM25R/LA-J14

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

Notes when setting the tool

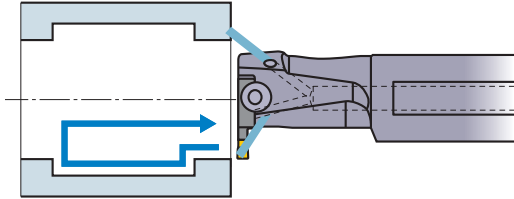
Over hang

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

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

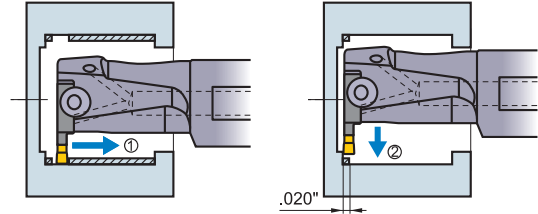
For internal grooving, the machining methods for external grooving (F192 – F193) can be used, but please note the following precautions.

Coolant



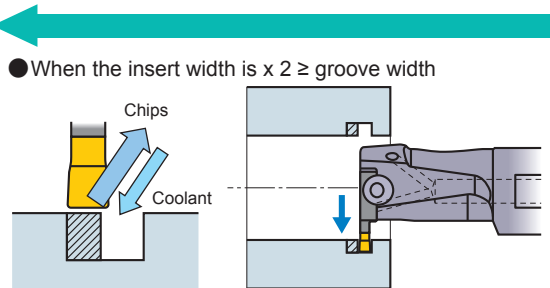
- Supply large amounts of coolant for effective chip disposal during cutting. Maintain supply until the tool has been retracted completely for improved chip disposal.

Machining blind holes



- As continuous chips tend to elongate at the back of the bore, the above operation is recommended. The recommended width of cut for ② is .020 inch.

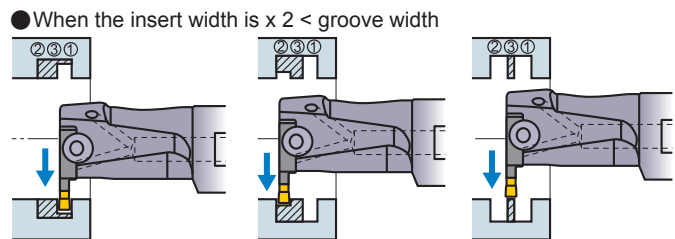
Machining Wide Grooves



- When the insert width is $x 2 \geq$ groove width

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

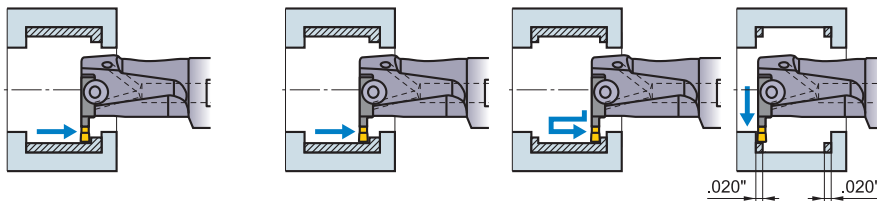
Grooving



- When the insert width is $x 2 <$ groove width

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

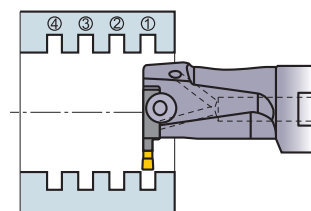
Turning



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

- Wide face grooving when the corner R of the workpiece is equal to the corner R of the insert, machine as shown above. (When corner R of the workpiece is larger than corner R of the insert, refer to the description of external wide grooving.)
- If the groove depth exceeds a given level, chips may elongate at the wall. In such a case, increase the feed and carry out machining as shown above.

Machining instruction



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

ASSEMBLY INSTRUCTION

A (a) Insert clamp screw x 1pc. **Modular Holder**
 (b) Wrench
 (c) Modular blade set screw x 4pcs.
 (d) Wrench

(Ex.) GYDLUS24M90D - **M20R**
 GYDLUS32P90F - **M25R**

Modular Blade

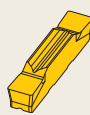
(Ex.) GY **M20R** A - **F** 10
 GY **M25R** A - **F** 12

Short, Medium (4 holes)

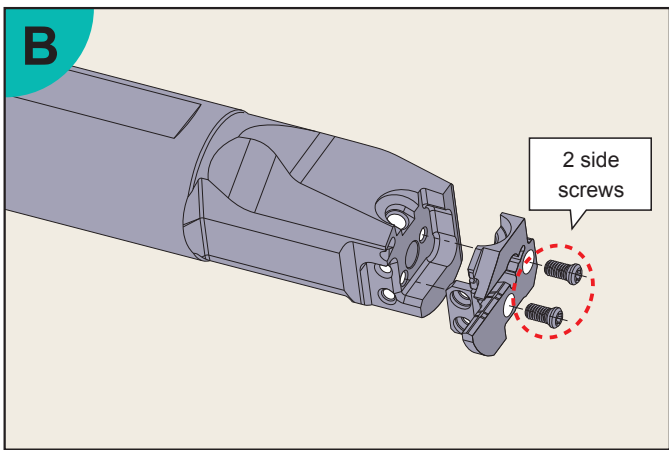
Insert

(Ex.) GY2M0300 **F** 040N-MS
 GY2M0318 **F** 030N-GM

Note 1) ③ and ④ are changed by the insert size.

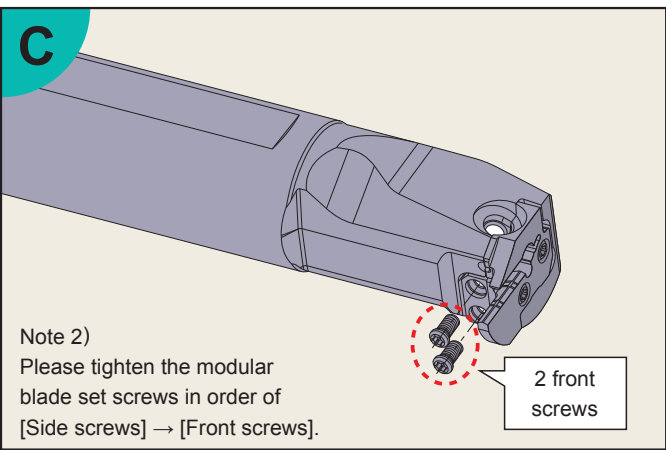


B



2 side screws

C

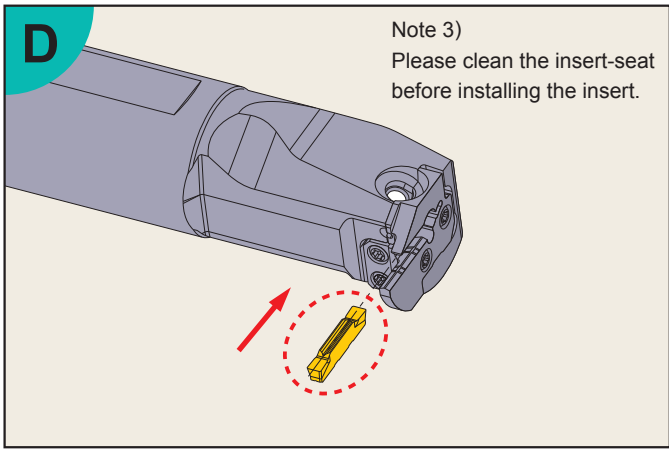


2 front screws

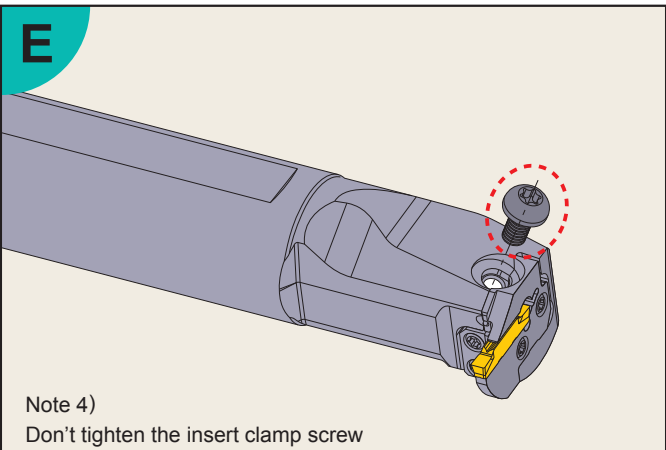
Note 2) Please tighten the modular blade set screws in order of [Side screws] → [Front screws].

D

Note 3) Please clean the insert-seat before installing the insert.

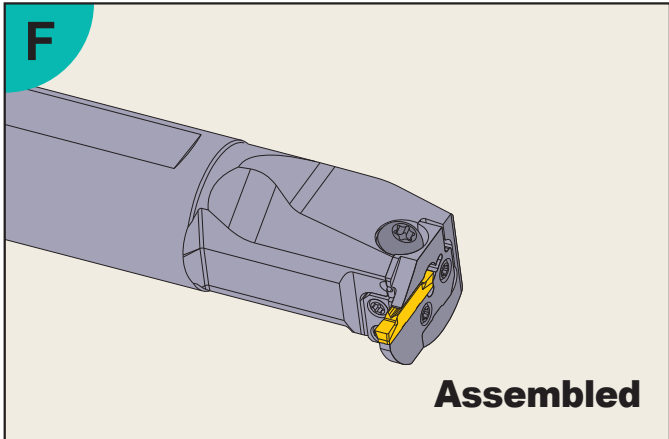


E

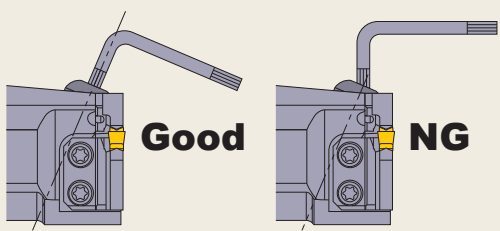


Note 4) Don't tighten the insert clamp screw without installing the insert. This will prevent modular blade damage.

F



Assembled



Good **NG**

Note 5) The insert clamp screw is inclined. Ensure that the wrench is perpendicular to the screw tightening.

GROOVING

INSERT INSTALLATION

A

(a) Insert clamp screw x 1pc.

(b) Wrench

Holder

Insert

(Ex.) GY2M0300 **F**^① 040N - MS
 GY2M0318 **F** 030N - GM

(Ex.) GYAL○○○○90○○ - **F**^② 06

Note 1) ① and ② are changed by the insert size.

B

Note 2)
 Please clean the insert-seat before installing the insert.

C

Note 3)
 Don't tighten the insert clamp screw without installing the insert.
 This will prevent modular blade damage.

D

Assembled

Note 4)
 The insert clamp screw is inclined.
 Ensure that the wrench is perpendicular to the screw tightening.

Good **NG**

GROOVING

EXTERNAL GROOVING

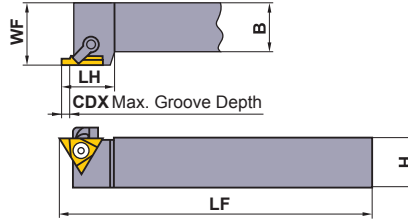
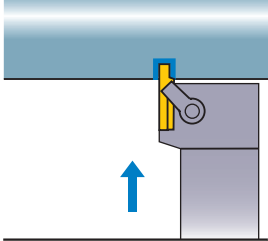
MTVO HOLDER

- Multi-clamp type.
- Precision class insert.
- Positive insert produces a good finished surface.

- Holder is capable of performing both grooving and threading.
- Economical due to the use of 3 cutting edges.

MTVO

External grooving, Threading



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (inch)						Insert Screw	Clamp Screw	Clamp	
	R	L		H	B	LF	LH	WF	CDX *1				
MTVOR/L-8-3B	●	●	TNMC	32	.500	.500	4.50	1.000	.750	.057, .156	GTS1	XNS35	CL6
MTVOR/L-10-3B	●	●		32	.625	.625	4.50	1.000	.875	.057, .156	GTS1	XNS35	CL6
MTVOR/L-12-3B	●	●		32	.750	.750	4.50	1.000	1.000	.057, .156	GTS1	XNS35	CL6
MTVOR/L-12-4B	●	●		43	.750	.750	4.50	1.063	1.000	.156, .234	GTS2	XNS36	CL6
MTVOR/L-16-4D	●	●		43	1.000	1.000	6.00	1.063	1.250	.156, .234	GTS2	XNS36	CL6
MTVOR/L-16-5D	●	●		54	1.000	1.000	6.00	1.250	1.250	.297	GTS3	XNS36	CL6
MTVOR/L-20-4D	●	●		43	1.250	1.250	6.00	1.063	1.500	.156, .234	GTS2	XNS36	CL6

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

*1 Refer to Inserts (PDPT) dimensions for CDX.

INSERTS (GROOVING)

Order Number	Class	Stock		Dimensions (inch)					Geometry
		Coated	Cermet	CW	IC	S	PDPT	RE	
		UP20M	UTi20T						
TNMC32NGR032	E	●	●	.032	.375	.125	.057	≤.003	
TNMC32NGL032	E	●	●	.032	.375	.125	.057	≤.003	
TNMC32NGR063	E	●	●	.063	.375	.125	.156	≤.003	
TNMC32NGL063	E	●	●	.063	.375	.125	.156	≤.003	
TNMC43NGR063	E	●	●	.063	.500	.188	.156	≤.003	
TNMC43NGL063	E	●	●	.063	.500	.188	.156	≤.003	
TNMC43NGR094	E	●	●	.094	.500	.188	.156	≤.003	
TNMC43NGL094	E	●	●	.094	.500	.188	.156	≤.003	
TNMC43NGR125	E	●	●	.125	.500	.188	.234	≤.003	
TNMC43NGL125	E	●	●	.125	.500	.188	.234	≤.003	
TNMC43NGR156	E	●	●	.156	.500	.188	.234	≤.003	
TNMC43NGL156	E	●	●	.156	.500	.188	.234	≤.003	
TNMC54NGR187	E	●	●	.187	.625	.250	.297	≤.003	
TNMC54NGL187	E	●	●	.187	.625	.250	.297	≤.003	

Right hand insert shown.

INSERTS (THREADING)

Order Number	Class	Stock		Min. Pitch (T.P.I.)	Dimensions (inch)			Geometry
		Coated	Carbide		IC	S	RE	
		UP20M	UTi20T					
TNMC32NV	E	●	●	8	.375	.125	.004	
TNMC43NV	E	●	●	6	.500	.187	.004	
TNMC54NV	E	●	●	4	.625	.250	.004	

INTERNAL GROOVING

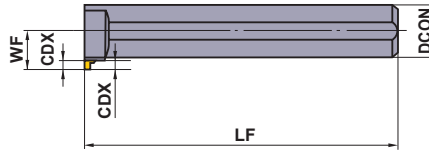
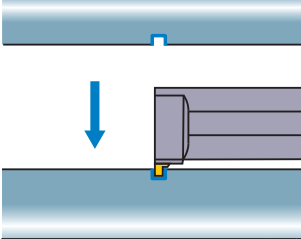
STHN/O TYPE

- Multi-clamp type.
- Precision class insert.
- Positive insert produces a good finished surface.

- Holder is capable of performing both grooving and threading.
- Economical due to the use of 3 cutting edges.

S-STHN/O

Internal grooving, Threading, Boring



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (inch)						CDX *1	Clamp Screw	Wrench
	R	L		DCON	LF	WF	GAMF	DMIN				
S16-STHNR/L-3	●	●	TNMC	32	1.000	10.00	.656	10°	1.250	.057, .156	GTS1	TKY10F
S20-STHNR/L-4	●	●		43	1.250	12.00	.843	10°	1.750	.156, .234	GTS2	TKY20F
S24-STHNR/L-4	●	●		43	1.500	14.00	.968	10°	2.250	.156, .234	GTS2	TKY20F
S32-STHNR/L-4	●	●		43	2.000	14.00	1.218	10°	3.000	.156, .234	GTS2	TKY20F
S32-STHOR/L-5	●	●		54	2.000	14.00	1.250	0	4.000	.297	GTS3	TKY20F

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

*1 Refer to Inserts (PDPT) dimensions for CDX.

INSERTS (GROOVING)

Order Number	Class	Stock		Dimensions (inch)					Geometry
		Coated	Carbide	CW	IC	S	PDPT	RE	
		UP20M	UTi20T						
TNMC32NGR032	E	●	●	.032	.375	.125	.057	≤.003	
TNMC32NGL032	E	●	●	.032	.375	.125	.057	≤.003	
TNMC32NGR063	E	●	●	.063	.375	.125	.156	≤.003	
TNMC32NGL063	E	●	●	.063	.375	.125	.156	≤.003	
TNMC43NGR063	E	●	●	.063	.500	.188	.156	≤.003	
TNMC43NGL063	E	●	●	.063	.500	.188	.156	≤.003	
TNMC43NGR094	E	●	●	.094	.500	.188	.156	≤.003	
TNMC43NGL094	E	●	●	.094	.500	.188	.156	≤.003	
TNMC43NGR125	E	●	●	.125	.500	.188	.234	≤.003	
TNMC43NGL125	E	●	●	.125	.500	.188	.234	≤.003	
TNMC43NGR156	E	●	●	.156	.500	.188	.234	≤.003	
TNMC43NGL156	E	●	●	.156	.500	.188	.234	≤.003	
TNMC54NGR187	E	●	●	.187	.625	.250	.297	≤.003	
TNMC54NGL187	E	●	●	.187	.625	.250	.297	≤.003	

Right hand insert shown.

INSERTS (THREADING)

Order Number	Class	Stock		Min. Pitch (T.P.I.)	Dimensions (inch)			Geometry
		Coated	Carbide		IC	S	RE	
		UP20M	UTi20T					
TNMC32NV	E	●	●	8	.375	.125	.004	
TNMC43NV	E	●	●	6	.500	.187	.004	
TNMC54NV	E	●	●	4	.625	.250	.004	

SPARE PARTS > M001
TECHNICAL DATA > N001

INTERNAL GROOVING

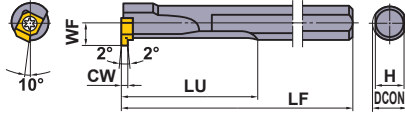
F TYPE

- Min. cutting diameter 10mm.
- Screw-on type.
- Usable for various applications.
- Max. groove depth: 3mm.

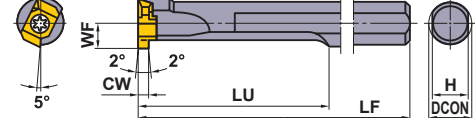
FSL51

Internal grooving, Threading

1 Corner type (FSL5108R,5110R)



2 Corner type (FSL5112R,5114R,5116R)



Metric Standard

Right hand tool holder only.

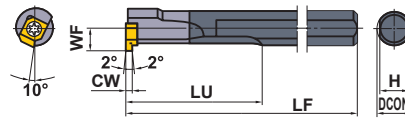
Order Number	Stock	Insert Number		Dimensions (mm)							Max. Groove Depth (mm)	Clamp Screw	Wrench		
		Grooving	Threading	DCON	H	LF	LU	WF	CW	DMIN*					
FSL5108R	★	MLG	10 \odot L	MLT	1001L	8	7	125	30	4.8	1.2	10	1.0	TS25	TKY08F
FSL5110R	★		10 \odot L		1001L	10	9	150	40	5.8	2.0				
FSL5112R	★	MLG	14 \odot L	MLT	1401L	12	10.8	180	50	6.8	1.5	14	2.0	TS32	TKY08F
FSL5114R	★		14 \odot L		1401L	14	12.4	180	60	7.8	3.0				
FSL5116R	★	MLG	20 \odot L	MLT	2001L	16	14	200	70	9.7	2.0	20	3.0	TS43	TKY15F
											4.0				

*DMIN : Min. Cutting Diameter

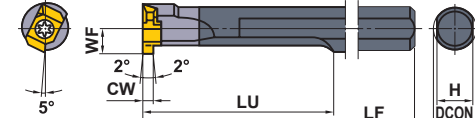
FSL52

Carbide shank

1 Corner type (FSL5208R,5210R)



2 Corner type (FSL5212R,5214R,5216R)



Metric Standard

Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions (mm)							Max. Groove Depth (mm)	Clamp Screw	Wrench		
		Grooving	Threading	DCON	H	LF	LU	WF	CW	DMIN*					
FSL5208R	★	MLG	10 \odot L	MLT	1001L	8	7	125	60	4.8	1.2	10	1.0	TS25	TKY08F
FSL5210R	★		10 \odot L		1001L	10	9	150	70	5.8	2.0				
FSL5212R	★	MLG	14 \odot L	MLT	1401L	12	10.8	180	80	6.8	1.5	14	2.0	TS32	TKY08F
FSL5214R	★		14 \odot L		1401L	14	12.4	180	85	7.8	3.0				
FSL5216R	★	MLG	20 \odot L	MLT	2001L	16	14	200	115	9.7	2.0	20	3.0	TS43	TKY15F
											4.0				

*DMIN : Min. Cutting Diameter

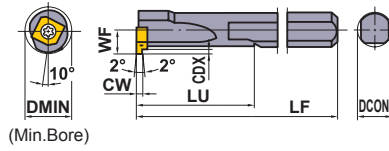
RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (SFM)	Feed (inch/rev)
P Carbon Steel Alloy Steel	180-280HB	UP20M • UTi20T	295 (195-390)	.002 (.0008-.003)
	280-350HB	UP20M • UTi20T	260 (165-330)	.001 (.0008-.0015)

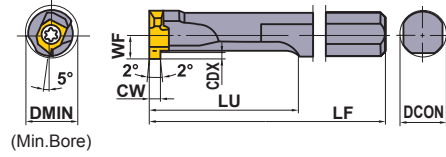
S-SL5N

Internal grooving, Threading, Boring



1 Corner type (S-SL5NR05 / 06)



2 Corner type (S-SL5NR08 / 10 / 12)



Right hand tool holder only.

Order Number	Stock R	Insert Number		Dimensions (inch)								
		Grooving	Threading	DCON	LF	LU	WF	CW	DMIN	CDX		
S-SL5NR05	●	MLG10W○○○L	MLT1001L	.313	5.000	1.250	.188	.062" 1.2mm	.390	.039	TS25	TKY08F
S-SL5NR06	●	MLG10W○○○L	MLT1001L	.375	6.000	1.500	.219	1.5mm 2.0mm	.449	.039	TS25	TKY08F
S-SL5NR08	●	MLG14W○○○L	MLT1401L	.500	7.000	2.000	.281	.062" 1.5mm 2.0mm 3.0mm	.579	.079	TS32	TKY08F
S-SL5NR10	●	MLG20W○○○L	MLT2001L	.625	8.000	3.000	.375	2.0mm 3.0mm	.791	.118	TS43	TKY15F
S-SL5NR12	●	MLG20W○○○L	MLT2001L	.750	10.000	4.000	.438	4.0mm	.902	.118	TS43	TKY15F

GROOVING

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (SFM)	Feed (inch/rev)
P Carbon Steel Alloy Steel	180–280HB	UP20M • UTi20T	295 (195–390)	.002 (.0008–.003)
	280–350HB	UP20M • UTi20T	260 (165–330)	.001 (.0008–.0015)

INSERTS > F214
SPARE PARTS > M001
TECHNICAL DATA > N001

INTERNAL GROOVING

F TYPE

- Min. cutting diameter .390inch.
- Screw-on type.
- Usable for various applications.
- Max. groove depth: .118inch.

INSERTS

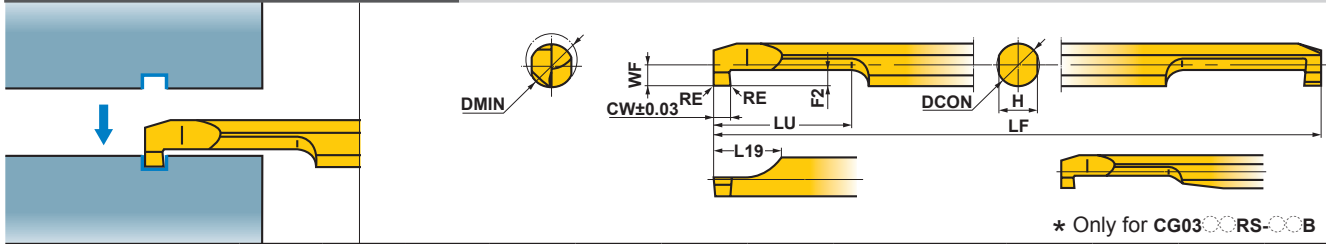
Application	CW (inch)	Order Number	Carbide		Dimensions (inch)					Geometry	
			UTi20T	HTi10	L	W1	PDPT	S	BCH		
Grooving	Inch	.062	MLG10W062L		●	.276	.197	.039	.094	.004	MLG...L (1 Corner type)
	Metric	.047 (1.2mm)	MLG1012L	●		.276	.197	.039	.094	.004	
		.059 (1.5mm)	MLG1015L	●		.276	.197	.039	.094	.004	
		.079 (2.0mm)	MLG1020L	●		.276	.197	.039	.094	.004	
	Metric	.059 (1.5mm)	MLG1415L	●		.465	.256	.079	.187	.004	MLG...L (2 Corner type)
		.079 (2.0mm)	MLG1420L	●		.465	.256	.079	.187	.004	
		.118 (3.0mm)	MLG1430L	●		.465	.256	.079	.187	.004	
		.079 (2.0mm)	MLG2020L	●		.661	.356	.118	.250	.004	
		.118 (3.0mm)	MLG2030L	●		.661	.356	.118	.250	.004	
		.157 (4.0mm)	MLG2040L	●		.661	.356	.118	.250	.004	

Application	Pitch	Order Number	Coated	Carbide	Dimensions (inch)				Geometry
			UP20M	UTi20T	L	W1	S	RE	
Threading	13T.P.I	MLT1001L	●	●	.276	.197	.094	.004	MLT1001L (1 Corner type)
	11T.P.I	MLT1401L	●	●	.465	.256	.187	.004	
	8T.P.I	MLT2001L	●	●	.661	.356	.250	.004	

MICRO-MINI TWIN

CG

Internal grooving



Order Number	Stock		Breaker	Dimensions (mm)									
	Micro Grain Carbide	Coated		DMIN	CW	F2	RE	DCON	LF	LU	L19	WF	H
	TF15	VP15TF											
CG0305RS-10	●	●	Without	3	1	1	0.05	3	50	5	6	1.3	2.7
CG0305RS-10B	●	●	With	3	1	1	0.05	3	50	5	6	1.3	2.7
CG0306RS-20	●	●	Without	3	2	1	0.1	3	50	6	6	1.3	2.7
CG0306RS-20B	●	●	With	3	2	1	0.1	3	50	6	6	1.3	2.7
CG03RS-10	●	●	Without	3	1	1	0.05	3	50	10	6	1.3	2.7
CG03RS-10B	●	●	With	3	1	1	0.05	3	50	10	6	1.3	2.7
CG03RS-20	●	●	Without	3	2	1	0.1	3	50	11	6	1.3	2.7
CG03RS-20B	●	●	With	3	2	1	0.1	3	50	11	6	1.3	2.7
CG0407RS-10	●	●	Without	4	1	1.5	0.05	4	60	7	7	1.8	3.6
CG0407RS-10B	●	●	With	4	1	1.5	0.05	4	60	7	7	1.8	3.6
CG0408RS-20	●	●	Without	4	2	1.5	0.1	4	60	8	7	1.8	3.6
CG0408RS-20B	●	●	With	4	2	1.5	0.1	4	60	8	7	1.8	3.6
CG04RS-10	●	●	Without	4	1	1.5	0.05	4	60	15	7	1.8	3.6
CG04RS-10B	●	●	With	4	1	1.5	0.05	4	60	15	7	1.8	3.6
CG04RS-20	●	●	Without	4	2	1.5	0.1	4	60	16	7	1.8	3.6
CG04RS-20B	●	●	With	4	2	1.5	0.1	4	60	16	7	1.8	3.6
CG0510RS-10	●	●	Without	5	1	2	0.05	5	70	10	8	2.3	4.5
CG0510RS-10B	●	●	With	5	1	2	0.05	5	70	10	8	2.3	4.5
CG0511RS-20	●	●	Without	5	2	2	0.1	5	70	11	8	2.3	4.5
CG0511RS-20B	●	●	With	5	2	2	0.1	5	70	11	8	2.3	4.5
CG05RS-10	●	●	Without	5	1	2	0.05	5	70	20	8	2.3	4.5
CG05RS-10B	●	●	With	5	1	2	0.05	5	70	20	8	2.3	4.5
CG05RS-20	●	●	Without	5	2	2	0.1	5	70	21	8	2.3	4.5
CG05RS-20B	●	●	With	5	2	2	0.1	5	70	21	8	2.3	4.5
CG0610RS-10	●	●	Without	6	1	2	0.05	6	75	10	8	2.8	5.4
CG0610RS-10B	●	●	With	6	1	2	0.05	6	75	10	8	2.8	5.4
CG0611RS-20	●	●	Without	6	2	2	0.1	6	75	11	8	2.8	5.4
CG0611RS-20B	●	●	With	6	2	2	0.1	6	75	11	8	2.8	5.4
CG06RS-10	●	●	Without	6	1	2	0.05	6	75	20	8	2.8	5.4
CG06RS-10B	●	●	With	6	1	2	0.05	6	75	20	8	2.8	5.4
CG06RS-20	●	●	Without	6	2	2	0.1	6	75	21	8	2.8	5.4
CG06RS-20B	●	●	With	6	2	2	0.1	6	75	21	8	2.8	5.4
CG0712RS-10	●	●	Without	7	1	2	0.05	7	85	12	8	3.3	6.4
CG0712RS-10B	●	●	With	7	1	2	0.05	7	85	12	8	3.3	6.4
CG0713RS-20	●	●	Without	7	2	2	0.1	7	85	13	8	3.3	6.4
CG0713RS-20B	●	●	With	7	2	2	0.1	7	85	13	8	3.3	6.4
CG07RS-10	●	●	Without	7	1	2	0.05	7	85	25	8	3.3	6.4
CG07RS-10B	●	●	With	7	1	2	0.05	7	85	25	8	3.3	6.4
CG07RS-20	●	●	Without	7	2	2	0.1	7	85	26	8	3.3	6.4
CG07RS-20B	●	●	With	7	2	2	0.1	7	85	26	8	3.3	6.4

* Only for CG0300RS00B

GROOVING

HOLDER > E034, E036, E037

SPARE PARTS > M001
TECHNICAL DATA > N001

F215

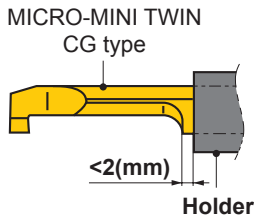
HOLDER

HOLDER CROSS REFERENCE LIST OF INCH SHANK STANDARD

Holder		Stock	MICRO-MINI TWIN	Machine Makers
Type	Order Number *1		CG	
Round Type Holder φ.625inch	ID : Metric Type	●	030RS-○○(B), 03RS-○○(B)	Citizen Precision Machinery Co., Ltd. NC lathes
		●	040RS-○○(B), 04RS-○○(B)	
		●	051RS-○○(B), 05RS-○○(B)	
		●	061RS-○○(B), 06RS-○○(B)	
		●	071RS-○○(B), 07RS-○○(B)	
Round Type Holder φ.750inch	ID : Metric Type	●	030RS-○○(B), 03RS-○○(B)	Citizen Precision Machinery Co., Ltd.
		●	040RS-○○(B), 04RS-○○(B)	
		●	051RS-○○(B), 05RS-○○(B)	
		●	061RS-○○(B), 06RS-○○(B)	
		●	071RS-○○(B), 07RS-○○(B)	
Round Type Holder φ1.000inch	ID : Metric Type	●	030RS-○○(B), 03RS-○○(B)	Citizen Precision Machinery Co., Ltd. NC lathes
		●	040RS-○○(B), 04RS-○○(B)	
		●	051RS-○○(B), 05RS-○○(B)	
		●	061RS-○○(B), 06RS-○○(B)	
		●	071RS-○○(B), 07RS-○○(B)	

* Mitsubishi Materials obtained the makers' approval before entering their names in the list.
*1 For holder details, refer to Boring Bar Section, page E034—E038.

RECOMMENDED TOOL OVERHANG



(Note) For LU, refer to page F215.

RECOMMENDED CUTTING CONDITIONS

Work Material	Cutting Speed (SFM)	Feed (IPR)	
		03RS/04RS	05RS/06RS/07RS
P General Steel	130—395	.0004—.001	.0004—.002
M Stainless Steel	130—395	.0004—.001	.0004—.002
K Cast Iron	130—395	.0004—.002	.0004—.002
N Non Ferrous Materials	260—525	.0004—.002	.0004—.003

(Note) Recommend wet machining.

HOLDER CROSS REFERENCE LIST OF METRIC SHANK STANDARD

Holder		Stock	MICRO-MINI TWIN	Machine Makers
Type	Order Number*1		CG	
Round Type Holder φ16mm	RBH1630N	●	030 \bigcirc RS- $\bigcirc\bigcirc$ (B), 03RS- $\bigcirc\bigcirc$ (B)	MIYANO MACHINERY JAPAN INC. NC lathes
	RBH1640N	●	040 \bigcirc RS- $\bigcirc\bigcirc$ (B), 04RS- $\bigcirc\bigcirc$ (B)	
	RBH1650N	●	051 \bigcirc RS- $\bigcirc\bigcirc$ (B), 05RS- $\bigcirc\bigcirc$ (B)	
	RBH1660N	●	061 \bigcirc RS- $\bigcirc\bigcirc$ (B), 06RS- $\bigcirc\bigcirc$ (B)	
	RBH1670N	●	071 \bigcirc RS- $\bigcirc\bigcirc$ (B), 07RS- $\bigcirc\bigcirc$ (B)	
Round Type Holder φ20mm	RBH2030N	●	030 \bigcirc RS- $\bigcirc\bigcirc$ (B), 03RS- $\bigcirc\bigcirc$ (B)	Citizen Precision Machinery Co., Ltd. Tsugami Corporation MIYANO MACHINERY JAPAN INC. NC lathes
	RBH2040N	●	040 \bigcirc RS- $\bigcirc\bigcirc$ (B), 04RS- $\bigcirc\bigcirc$ (B)	
	RBH2050N	●	051 \bigcirc RS- $\bigcirc\bigcirc$ (B), 05RS- $\bigcirc\bigcirc$ (B)	
	RBH2060N	●	061 \bigcirc RS- $\bigcirc\bigcirc$ (B), 06RS- $\bigcirc\bigcirc$ (B)	
	RBH2070N	●	071 \bigcirc RS- $\bigcirc\bigcirc$ (B), 07RS- $\bigcirc\bigcirc$ (B)	
Round Type Holder φ22mm	RBH2230N	●	030 \bigcirc RS- $\bigcirc\bigcirc$ (B), 03RS- $\bigcirc\bigcirc$ (B)	STAR MICRONICS CO., LTD.
	RBH2240N	●	040 \bigcirc RS- $\bigcirc\bigcirc$ (B), 04RS- $\bigcirc\bigcirc$ (B)	
	RBH2250N	●	051 \bigcirc RS- $\bigcirc\bigcirc$ (B), 05RS- $\bigcirc\bigcirc$ (B)	
	RBH2260N	●	061 \bigcirc RS- $\bigcirc\bigcirc$ (B), 06RS- $\bigcirc\bigcirc$ (B)	
	RBH2270N	●	071 \bigcirc RS- $\bigcirc\bigcirc$ (B), 07RS- $\bigcirc\bigcirc$ (B)	
Round Type Holder φ25mm	RBH2530N	●	030 \bigcirc RS- $\bigcirc\bigcirc$ (B), 03RS- $\bigcirc\bigcirc$ (B)	Tsugami Corporation MIYANO MACHINERY JAPAN INC. NC lathes
	RBH2540N	●	040 \bigcirc RS- $\bigcirc\bigcirc$ (B), 04RS- $\bigcirc\bigcirc$ (B)	
	RBH2550N	●	051 \bigcirc RS- $\bigcirc\bigcirc$ (B), 05RS- $\bigcirc\bigcirc$ (B)	
	RBH2560N	●	061 \bigcirc RS- $\bigcirc\bigcirc$ (B), 06RS- $\bigcirc\bigcirc$ (B)	
	RBH2570N	●	071 \bigcirc RS- $\bigcirc\bigcirc$ (B), 07RS- $\bigcirc\bigcirc$ (B)	
Square Type Holder □10mm	SBH1030R	★	030 \bigcirc RS- $\bigcirc\bigcirc$ (B), 03RS- $\bigcirc\bigcirc$ (B)	NC lathes
	SBH1040R	★	040 \bigcirc RS- $\bigcirc\bigcirc$ (B), 04RS- $\bigcirc\bigcirc$ (B)	
	SBH1050R	★	051 \bigcirc RS- $\bigcirc\bigcirc$ (B), 05RS- $\bigcirc\bigcirc$ (B)	
	SBH1060R	★	061 \bigcirc RS- $\bigcirc\bigcirc$ (B), 06RS- $\bigcirc\bigcirc$ (B)	
	SBH1070R	★	071 \bigcirc RS- $\bigcirc\bigcirc$ (B), 07RS- $\bigcirc\bigcirc$ (B)	

* Mitsubishi Materials obtained the makers' approval before entering their names in the list.

*1 For holder details, refer to Boring Bar Section, page E034—E038.