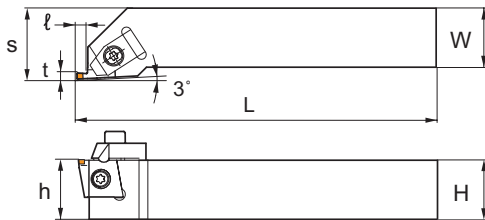
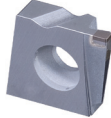
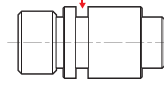

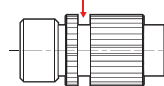


### ■ Features & Benefits

- New double clamping system provides reliable grooving of hardened steel
- 80° tangentially mounted CGA style insert for improved rigidity
- Wide range of widths and grades for continuous and interrupted grooving operations
- New special coated CBN grade BNC30G extends tool life of insert



Grade	Application	Features	Hv (GPa)	TRS (GPa)
 <b>BN2000</b>	 Continuous grooving	General purpose grade with good wear resistance	31-34	1.0-1.1
 <b>BNC30G</b>	 Interrupted grooving	Tough CBN substrate and special coating with high wear and peeling resistance	33-35	1.1-1.2

### ■ GWB SERIES HOLDERS

Sumitomo Cat. No.	Stk.	H in (mm)	W in (mm)	h in (mm)	s in (mm)	t in (mm)	ℓ in (mm)	L in (mm)	Insert (See p. 134 for CGA availability & technical information)
GWBR 165D4	•	1.0 (25.4)	1.0 (25.4)	1.0 (25.4)	1.181 (30.0)	.059 < t ≤ .079 (1.5 < t ≤ 2.0)	.138 (3.5)	6.0 (152.4)	CGA R/L 1504□□
GWBL 165D4						.079 < t ≤ .118 (2.0 < t ≤ 3.0)	.177 (4.5)	6.039 (153.4)	CGA R/L 4□□□
						.118 < t ≤ .177 (3.0 < t ≤ 4.5)	.197 (5.0)		
GWBR 165D6	•	1.0 (25.4)	1.0 (25.4)	1.0 (25.4)	1.181 (30.0)	.177 < t ≤ .236 (4.5 < t ≤ 6.0)		6.039 (153.4)	CGA R/L 1506□□ CGA R/L 6□□□
GWBL 165D6									
GWBR 2525-45	★	.984 (25.0)	.984 (25.0)	.984 (25.0)	1.181 (30.0)	.059 < t ≤ .079 (1.5 < t ≤ 2.0)	.138 (3.5)	6.0 (152.4)	CGA R/L 1504□□
GWBL 2525-45						.079 < t ≤ .118 (2.0 < t ≤ 3.0)	.177 (4.5)	6.039 (153.4)	CGA R/L 4□□□
						.118 < t ≤ .177 (3.0 < t ≤ 4.5)	.197 (5.0)		
GWBR 2525-60	★	.984 (25.0)	.984 (25.0)	.984 (25.0)	1.181 (30.0)	.177 < t ≤ .236 (4.5 < t ≤ 6.0)		6.039 (153.4)	CGA R/L 1506□□ CGA R/L 6□□□
GWBL 2525-60									

- = USA Stocked Item
- ★ = Worldwide Warehouse Item

Please see page 136 for applicable inserts

### ■ RECOMMENDED CUTTING CONDITIONS

For hardened steel:	
<b>Cutting Speed</b>	260 - 400 sfm (80 - 120 m/min)
<b>Feed Rate</b>	.0016 -.0032 ipr (.04 - .08 mm/rev)
<b>Coolant</b>	Continuous cut: dry or wet Interrupted cut: dry
<b>NOTE:</b> To avoid thermal cracking of cutting edge during interrupted cutting applications, please ensure workpiece remains dry.	

### ■ HARDWARE

Clamp	Clamp Screw	Insert Screw	Spring	Wrench
TF-72 (Right hand)	BX0520T	BFTX 0511N	GSP06	TRX20
TF-73 (Left hand)				

