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SUMITOMO
CARBIDE - CBN - DIAMOND

Grooving/ Cut-off Tools

Grooving Tool Holders GND Series

Wide Range of Chipbreakers & High Rigidity Body Design

New Now available with through coolant!

SUMITOMO ELECTRIC GROUP

Grooving Tool GND Series

High Stiffness Body

SEC-Grooving Tool Holders GND type which adopts built-in structure and die steel, succeeds the stability processing with controling the vibration.
a not only glooving but also turning, profilling and edge face processing.

Various variety of chipbreakers

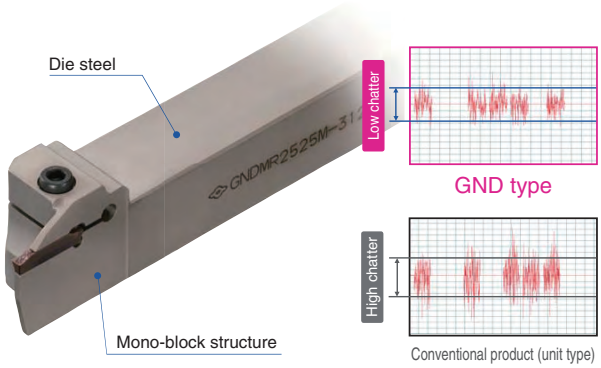
Ten types of chipbreakers are lineuped to accept any processing use in GND Grooving line.
It is possible to stable the chip processing in various scenes.

Grooving / Traverse machining		Grooving / Cut-off			Cut-Off		External Profiling	Profiling / Necking	Many functions
General purpose	Low feed	General purpose	Low feed	Low cutting force	General purpose	Low cutting force	General purpose	General purpose	For non-ferrous metals

● Cutting Performance

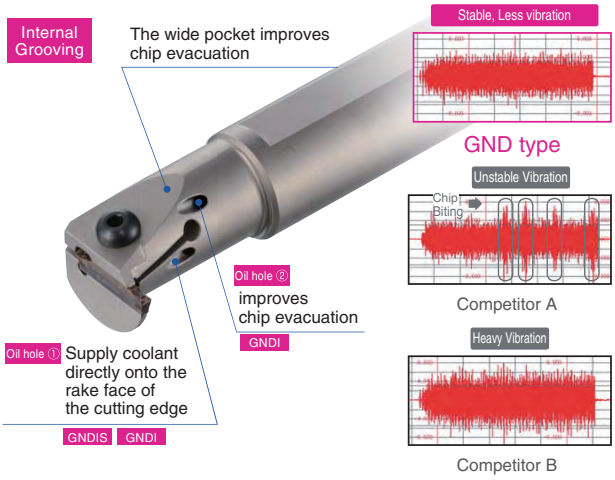
Reduce chattering

The highly rigid design reduces chattering by approximately 30% as compared to the conventional products.



Material: Alloy Steel
Holder: GNDL R2525M-220 Insert: GCM N2002-GG
Cutting conditions: v_c = 330 sfm f = 0.004 IPR a_p = 0.79", wet

High rigidity and efficient chip evacuation

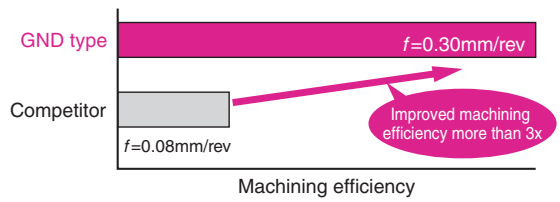


Material: Alloy Steel
Holder: GNDI R2532-T306 Insert: GCM N3002-GG
Cutting conditions: v_c = 330 sfm f = 0.002 IPR a_p = 0.12", Wet

● Application Example

Substantial increase in machining efficiency!!

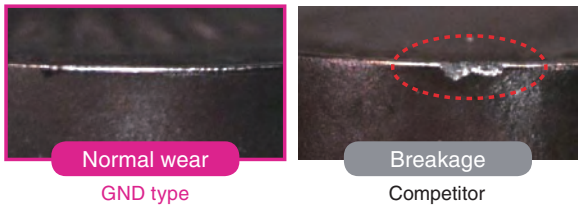
A highly rigid holder allows high load, high speed machining.



Material: 4137 Steel
Holder: GN Insert: GCM N3002-GG (AC530U)
Cutting conditions: v_c = 430 sfm f = 0.012 IPR Wet

Stable, long tool life ensures safety in the automatic production line!!

Reduces chattering and prevents sudden breakage.



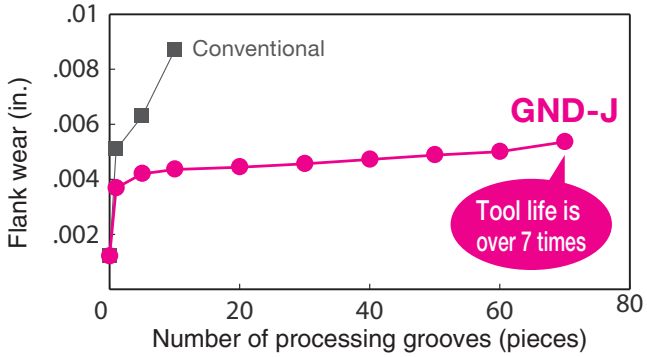
Material: 1050 Steel
Holder: GNDM L2525M-618 Insert: GCM N6030-RG (AC530U)
Cutting conditions: v_c = 430 sfm f = 0.012 IPR Wet

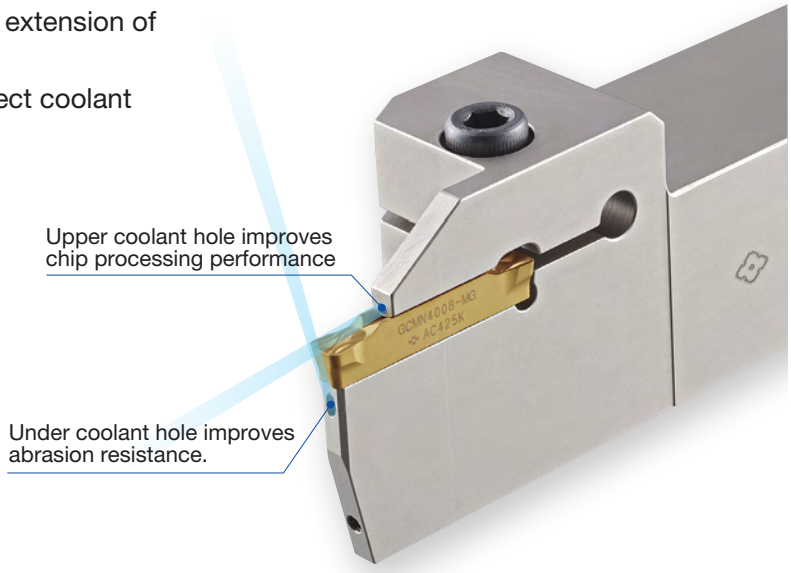
Internal Coolant Grooving Tool

GNDM-J type/GNDL-J type New

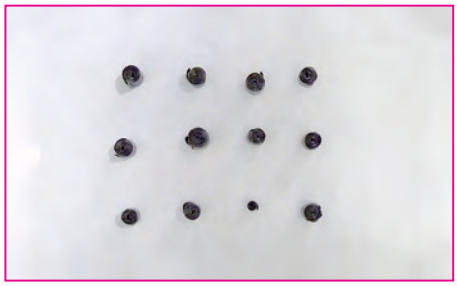
- Internal Coolant Grooving Tool developed to expand Sumitomo's GND Grooving line
- Newly developed 2-hole coolant through design optimizes cooling of the insert and improves chip removal, extending tool life and allowing for improved speeds and feeds in production.
- Grooving width range from 2 to 6mm.
- Acheives both high efficiency in high speed machining and extension of tool life due to internal coolant supply to the cutting edge.
- Improves the chip processing performance by applying direct coolant from cutting edge side.

● Abrasion Resistant Performance





● Chip Control



Coolant Pressure : 7MPa

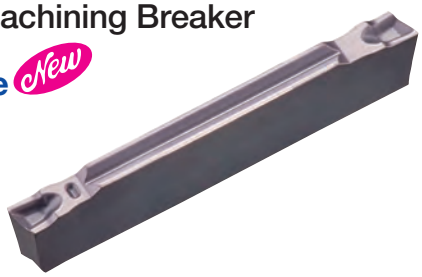
Coolant Pressure : 1MPa

Outside Refuel

Work material: Ti-6Al-4V Holder: GNDM R2525K-312J Insert: GCMN3002-GG(AC530U) Cutting conditions: v_c = 200 sfm f = 0.004 IPR a_p = 0.2 in. Wet

Cut-off Machining Breaker

CF type New



- Read corner 10°/15° is coming up in cut-off machining.
- Excellent chip processing performance by the asymmetry breaker design even difficult chip control with read corner has a chip.

GCMN20003-CF-10

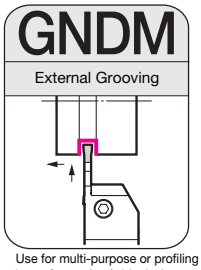
GCMN20003-CF-15

Competitor

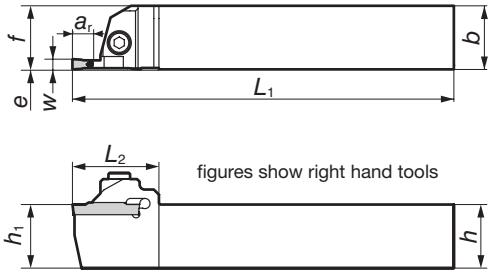
Work material: SS400 Holder: GNDM R2525M-220 Insert: GCMN20003-CF-10,15(AC1030U) Cutting conditions: n = 2,000min^{-1} f = 0.08mm/rev Wet

GND - Coolant Through

GNDM - External Multi-Purpose (Grooving / Turning / Profiling)

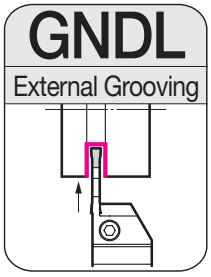


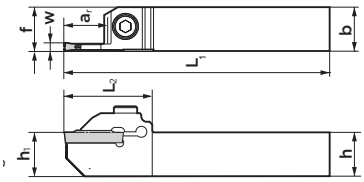
Use for multi-purpose or profiling insert for turning (widening).

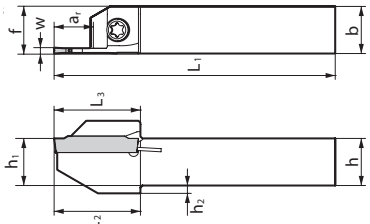


figures show right hand tools

GNDL - External Deep Grooving / Cut-Off







• GND Coolant Through Parts

Product Code	Description	OAL	End 1	End 2	Connection Type
J-HOSE-MJIC1/4-NPT1/8-8.0	COOLANT HOSE 8 INCH	8.000"	1/4" Male JIC	NPT 1/8"	Male-Female
J-HOSE-MJIC1/4-NPT1/8-10.0	COOLANT HOSE 10 INCH	10.000"	1/4" Male JIC	NPT 1/8"	Male-Female
J-HOSE-G1/8-G1/8-200	COOLANT HOSE 200MM	200mm	G1/8	G1/8	Female-Female
J-HOSE-G1/8-G1/8-300	COOLANT HOSE 300MM	300mm	G1/8	G1/8	Female-Female
J-HOSE-R1/8-G1/8-200	COOLANT HOSE 200MM	200mm	R1/8 Male	G1/8	Male-Female
J-HOSE-R1/8-G1/8-300	COOLANT HOSE 300MM	300mm	R1/8 Male	G1/8	Male-Female
J-NPT1/8-R1/8-00	METRIC ADAPTER	-	1/4" Male JIC	R1/8	Male-Female
J-NPT1/8-G1/8-00	METRIC ADAPTER	-	1/4" Male JIC	G1/8	Male-Female
XP03	PLUG	-	-	-	-
BX0520	CAP SCREW	-	5mm Hex	-	-
LH050	WRENCH	-	5mm Hex		

Metric

No.	Series	Cat.No.	Seat	CDX	b	h	LF	WF	HF	LH	Thread
1	GNDM	GNDMR2020K-210J	2	10	20	20	120	20	20	33.6	BSPT 1/8"
2		GNDMR2020K-312J	3	12	20	20	120	20	20	36.6	BSPT 1/8"
3		GNDMR2020K-418J	4	18	20	20	120	20	20	45.0	BSPT 1/8"
4		GNDMR2020K-518J	5	18	20	20	120	20	20	45.0	BSPT 1/8"
5		GNDMR2020K-618J	6	18	20	20	120	20	20	45.0	BSPT 1/8"
6		GNDMR2525K-210J	2	10	25	25	120	25	25	33.6	BSPT 1/8"
7		GNDMR2525K-312J	3	12	25	25	120	25	25	36.6	BSPT 1/8"
8		GNDMR2525K-418J	4	18	25	25	120	25	25	45.0	BSPT 1/8"
9		GNDMR2525K-518J	5	18	25	25	120	25	25	45.0	BSPT 1/8"
10		GNDMR2525K-618J	6	18	25	25	120	25	25	45.0	BSPT 1/8"
11	GNDL	GNDLR2020K-220J	2	20	20	20	120	20	20	44.5	BSPT 1/8"
12		GNDLR2020K-320J	3	20	20	20	120	20	20	44.5	BSPT 1/8"
13		GNDLR2020K-425J	4	25	20	20	120	20	20	50	BSPT 1/8"
14		GNDLR2020K-525J	5	25	20	20	120	20	20	50	BSPT 1/8"
15		GNDLR2020K-625J	6	25	20	20	120	20	20	50	BSPT 1/8"
16		GNDLR2525K-220J	2	20	25	25	120	25	25	44.5	BSPT 1/8"
17		GNDLR2525K-320J	3	20	25	25	120	25	25	44.5	BSPT 1/8"
18		GNDLR2525K-425J	4	25	25	25	120	25	25	50	BSPT 1/8"
19		GNDLR2525K-525J	5	25	25	25	120	25	25	50	BSPT 1/8"
20		GNDLR2525K-625J	6	25	25	25	120	25	25	50	BSPT 1/8"
21	GNDM	GNDML2020K-210J	2	10	20	20	120	20	20	33.6	BSPT 1/8"
22		GNDML2020K-312J	3	12	20	20	120	20	20	36.6	BSPT 1/8"
23		GNDML2020K-418J	4	18	20	20	120	20	20	45.0	BSPT 1/8"
24		GNDML2020K-518J	5	18	20	20	120	20	20	45.0	BSPT 1/8"
25		GNDML2020K-618J	6	18	20	20	120	20	20	45.0	BSPT 1/8"
26		GNDML2525K-210J	2	10	25	25	120	25	25	33.6	BSPT 1/8"
27		GNDML2525K-312J	3	12	25	25	120	25	25	36.6	BSPT 1/8"
28		GNDML2525K-418J	4	18	25	25	120	25	25	45.0	BSPT 1/8"
29		GNDML2525K-518J	5	18	25	25	120	25	25	45.0	BSPT 1/8"
30		GNDML2525K-618J	6	18	25	25	120	25	25	45.0	BSPT 1/8"
31	GNDL	GNDLL2020K-220J	2	20	20	20	120	20	20	44.5	BSPT 1/8"
32		GNDLL2020K-320J	3	20	20	20	120	20	20	44.5	BSPT 1/8"
33		GNDLL2020K-425J	4	25	20	20	120	20	20	50	BSPT 1/8"
34		GNDLL2020K-525J	5	25	20	20	120	20	20	50	BSPT 1/8"
35		GNDLL2020K-625J	6	25	20	20	120	20	20	50	BSPT 1/8"
36		GNDLL2525K-220J	2	20	25	25	120	25	25	44.5	BSPT 1/8"
37		GNDLL2525K-320J	3	20	25	25	120	25	25	44.5	BSPT 1/8"
38		GNDLL2525K-425J	4	25	25	25	120	25	25	50	BSPT 1/8"
39		GNDLL2525K-525J	5	25	25	25	120	25	25	50	BSPT 1/8"
40		GNDLL2525K-625J	6	25	25	25	120	25	25	50	BSPT 1/8"

Inch

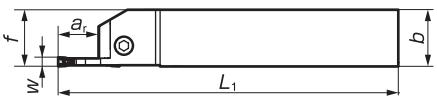
No.	Series	Cat.No.	Seat	CDX	B	H	LF	WF	HF	LH	Thread
1	GNDM	GNDMR122K-050J	2	12.7	19.05	19.05	127	19.05	19.05	33.6	NPT 1/8"
2		GNDMR123K-050J	3	12.7	19.05	19.05	127	19.05	19.05	36.6	NPT 1/8"
3		GNDMR124K-070J	4	17.78	19.05	19.05	127	19.05	19.05	45.0	NPT 1/8"
4		GNDMR125K-070J	5	17.78	19.05	19.05	127	19.05	19.05	45.0	NPT 1/8"
5		GNDMR126K-070J	6	17.78	19.05	19.05	127	19.05	19.05	45.0	NPT 1/8"
6		GNDMR162K-050J	2	12.7	25.4	25.4	127	25.4	25.4	33.6	NPT 1/8"
7		GNDMR163K-050J	3	12.7	25.4	25.4	127	25.4	25.4	36.6	NPT 1/8"
8		GNDMR164K-070J	4	17.78	25.4	25.4	127	25.4	25.4	45.0	NPT 1/8"
9		GNDMR165K-070J	5	17.78	25.4	25.4	127	25.4	25.4	45.0	NPT 1/8"
10		GNDMR166K-070J	6	17.78	25.4	25.4	127	25.4	25.4	45.0	NPT 1/8"
11	GNDL	GNDLR122K-075J	2	19.05	19.05	19.05	127	19.05	19.05	44.5	NPT 1/8"
12		GNDLR123K-075J	3	19.05	19.05	19.05	127	19.05	19.05	44.5	NPT 1/8"
13		GNDLR124K-100J	4	25.4	19.05	19.05	127	19.05	19.05	50	NPT 1/8"
14		GNDLR125K-100J	5	25.4	19.05	19.05	127	19.05	19.05	50	NPT 1/8"
15		GNDLR126K-100J	6	25.4	19.05	19.05	127	19.05	19.05	50	NPT 1/8"
16		GNDLR162K-075J	2	19.05	25.4	25.4	127	25.4	25.4	44.5	NPT 1/8"
17		GNDLR163K-075J	3	19.05	25.4	25.4	127	25.4	25.4	44.5	NPT 1/8"
18		GNDLR164K-100J	4	25.4	25.4	25.4	127	25.4	25.4	50	NPT 1/8"
19		GNDLR165K-100J	5	25.4	25.4	25.4	127	25.4	25.4	50	NPT 1/8"
20		GNDLR166K-100J	6	25.4	25.4	25.4	127	25.4	25.4	50	NPT 1/8"
21	GNDM	GNDML122K-050J	2	12.7	19.05	19.05	127	19.05	19.05	33.6	NPT 1/8"
22		GNDML123K-050J	3	12.7	19.05	19.05	127	19.05	19.05	36.6	NPT 1/8"
23		GNDML124K-070J	4	17.78	19.05	19.05	127	19.05	19.05	45.0	NPT 1/8"
24		GNDML125K-070J	5	17.78	19.05	19.05	127	19.05	19.05	45.0	NPT 1/8"
25		GNDML126K-070J	6	17.78	19.05	19.05	127	19.05	19.05	45.0	NPT 1/8"
26		GNDML162K-050J	2	12.7	25.4	25.4	127	25.4	25.4	33.6	NPT 1/8"
27		GNDML163K-050J	3	12.7	25.4	25.4	127	25.4	25.4	36.6	NPT 1/8"
28		GNDML164K-070J	4	17.78	25.4	25.4	127	25.4	25.4	45.0	NPT 1/8"
29		GNDML165K-070J	5	17.78	25.4	25.4	127	25.4	25.4	45.0	NPT 1/8"
30		GNDML166K-070J	6	17.78	25.4	25.4	127	25.4	25.4	45.0	NPT 1/8"
31	GNDL	GNDLL122K-075J	2	19.05	19.05	19.05	127	19.05	19.05	44.5	NPT 1/8"
32		GNDLL123K-075J	3	19.05	19.05	19.05	127	19.05	19.05	44.5	NPT 1/8"
33		GNDLL124K-100J	4	25.4	19.05	19.05	127	19.05	19.05	50	NPT 1/8"
34		GNDLL125K-100J	5	25.4	19.05	19.05	127	19.05	19.05	50	NPT 1/8"
35		GNDLL126K-100J	6	25.4	19.05	19.05	127	19.05	19.05	50	NPT 1/8"
36		GNDLL162K-075J	2	19.05	25.4	25.4	127	25.4	25.4	44.5	NPT 1/8"
37		GNDLL163K-075J	3	19.05	25.4	25.4	127	25.4	25.4	44.5	NPT 1/8"
38		GNDLL164K-100J	4	25.4	25.4	25.4	127	25.4	25.4	50	NPT 1/8"
39		GNDLL165K-100J	5	25.4	25.4	25.4	127	25.4	25.4	50	NPT 1/8"
40		GNDLL166K-100J	6	25.4	25.4	25.4	127	25.4	25.4	50	NPT 1/8"

GNDM - External Multi-Purpose (Grooving / Turning / Profiling)

GNDMS - External 90° (Side Cut) Multi-Purpose (Grooving / Turning / Profiling)

Grooving | Turning | Profiling

Fig. 1



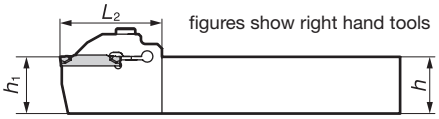
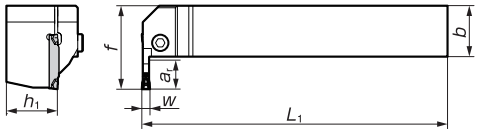
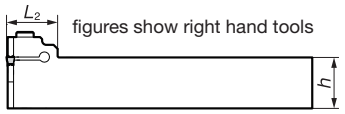
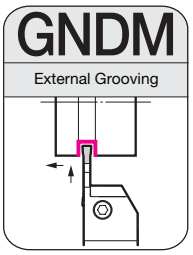


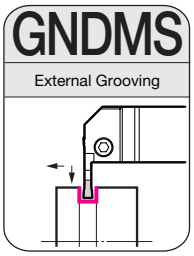
Fig. 2





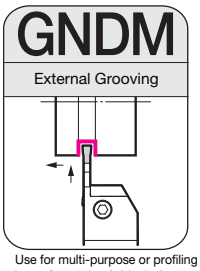


Use for multi-purpose or profiling insert for turning (widening).

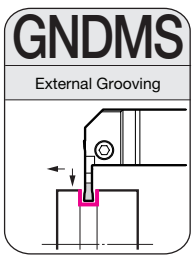


Use for multi-purpose or profiling insert for turning (widening).

INCH Catalog Number	Dimensions (in)						Max.Groove Depth	Insert Seat Size	Fig.	Cap Screw	Wrench
	h	b	L_1	f	h_1	L_2	a_r (inch)				
GNDM R/L101.5JX-038	.625	.625	4.75	.625	-	1.102	.375	1.5	1	BX0515	LH040
GNDM R/L102JX-047	.625	.625	4.75	.625	-	1.181	.472	2	1		
GNDM R/L103JX-047	.625	.625	4.75	.625	-	1.181	.472	3	1		
GNDM L/R 122K-050	.750	.750	5.000	.750	.750	1.441	.500	2	1	BX0520	
GNDM L/R 123K-050	.750	.750	5.000	.750	.750	1.441	.500	3	1		
GNDM L/R 124K-070	.750	.750	5.000	.750	.750	1.772	.700	4	1		
GNDM L/R 125K-070	.750	.750	5.000	.750	.750	1.772	.700	5	1		
GNDM L/R 126K-070	.750	.750	5.000	.750	.750	1.772	.700	6	1		
GNDM L/R 162K-050	1.000	1.000	6.000	1.000	1.000	1.441	.500	2	1		
GNDM L/R 163M-050	1.000	1.000	6.000	1.000	1.000	1.441	.500	3	1		
GNDM L/R 164M-070	1.000	1.000	6.000	1.000	1.000	1.772	.700	4	1		
GNDM L/R 165M-070	1.000	1.000	6.000	1.000	1.000	1.772	.700	5	1		
GNDM L/R 166M-070	1.000	1.000	6.000	1.000	1.000	1.772	.700	6	1		
GNDM L/R 203P-050	1.250	1.250	7.000	1.250	1.250	1.441	.500	3	1	BX0620	LH050
GNDM L/R 204P-070	1.250	1.250	7.000	1.250	1.250	1.772	.700	4	1		
GNDM L/R 205P-070	1.250	1.250	7.000	1.250	1.250	1.772	.700	5	1		
GNDM L/R 206P-070	1.250	1.250	7.000	1.250	1.250	1.772	.700	6	1		
GNDM L/R 207P-070	1.250	1.250	7.000	1.250	1.250	2.000	.700	7	1		
GNDM L/R 208P-070	1.250	1.250	7.000	1.250	1.250	2.000	.700	8	1		
GNDMS L/R 123K-040	.750	.750	5.000	1.222	.750	1.000	.4000	3	2	BX0520	LH040
GNDMS L/R 124K-050	.750	.750	5.000	1.300	.750	1.000	.5000	4	2		
GNDMS L/R 125K-050	.750	.750	5.000	1.300	.750	1.000	.5000	5	2		
GNDMS L/R 163M-050	1.000	1.000	6.000	1.551	1.000	1.000	.5000	3	2		
GNDMS L/R 164M-055	1.000	1.000	6.000	1.630	1.000	1.000	.5500	4	2		
GNDMS L/R 165M-055	1.000	1.000	6.000	1.630	1.000	1.000	.5500	5	2		
GNDMS L/R 166M-055	1.000	1.000	6.000	1.630	1.000	1.000	.5500	6	2		



Use for multi-purpose or profiling insert for turning (widening).

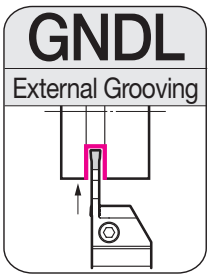


Use for multi-purpose or profiling insert for turning (widening).

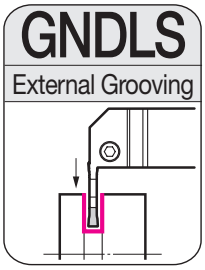
METRIC Catalog Number	Dimensions (mm)						Max. Groove Depth a_r (mm)	Insert Seat Size	Fig.	Cap Screw	Wrench
	h	b	L_1	f	h_1	L_2					
GNDM R/L1616JX-1.2508	16	16	120	16	16	26.0	8	1.25	1	BX0515	LH040
GNDM R/L1616JX-1.510	16	16	120	16	16	26.0	10	1.5	1		
GNDM R/L1616JX-212	16	16	120	16	16	30.0	12	2	1		
GNDM R/L1616JX-312	16	16	120	16	16	30.0	12	3	1		
GNDM R/L2020K-312	20	20	125	20	20	36.6	12	3	1	BX0520	
GNDM R/L2020K-418	20	20	125	20	20	45.0	18	4	1		
GNDM R/L2020K-518	20	20	125	20	20	45.0	18	5	1		
GNDM R/L2020K-618	20	20	125	20	20	45.0	18	6	1		
GNDM R/L2525M-312	25	25	150	25	25	36.6	12	3	1		
GNDM R/L2525M-418	25	25	150	25	25	45.0	18	4	1		
GNDM R/L2525M-518	25	25	150	25	25	45.0	18	5	1		
GNDM R/L2525M-618	25	25	150	25	25	45.0	18	6	1		
GNDM R/L3232P-312	32	32	170	32	32	36.6	12	3	1	BX0620	LH050
GNDM R/L3232P-418	32	32	170	32	32	45	18	4	1		
GNDM R/L3232P-518	32	32	170	32	32	45	18	5	1		
GNDM R/L3232P-618	32	32	170	32	32	45	18	6	1		
GNDM R/L3232P-718	32	32	170	32	32	50	18	7	1		
GNDM R/L3232P-818	32	32	170	32	32	50	18	8	1		
GNDMS R/L 2020K-310	20	20	125	32	20	25	10	3	2	BX0520	LH040
GNDMS R/L 2020K-412	20	20	125	34	20	25	12	4	2		
GNDMS R/L 2020K-512	20	20	125	34	20	25	12	5	2		
GNDMS R/L 2525M-312	25	25	150	39	25	25	12	3	2		
GNDMS R/L 2525M-414	25	25	150	41	25	25	14	4	2		
GNDMS R/L 2525M-514	25	25	150	41	25	25	14	5	2		
GNDMS R/L 2525M-614	25	25	150	41	25	25	14	6	2		

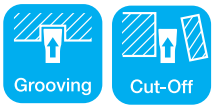
Please see page 11 for applicable inserts

GNDL
External Deep Grooving / Cut-Off



GNDLS
External 90° (Side Cut) Grooving





figures show right hand tools

Fig. 1

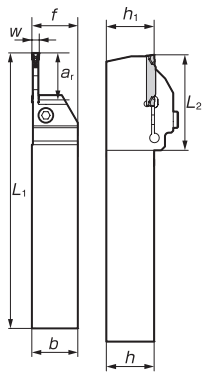


Fig. 2

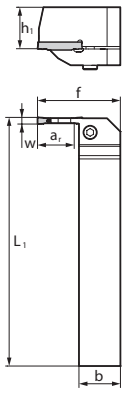


Fig. 3

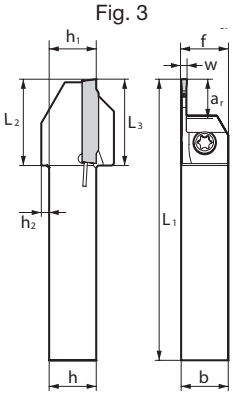
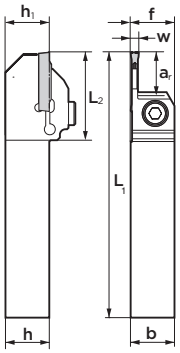


Fig. 4



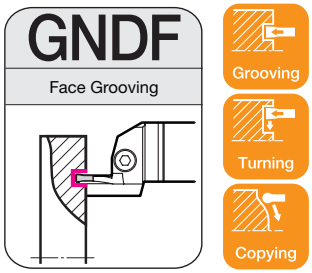
Please see page 11 for applicable inserts

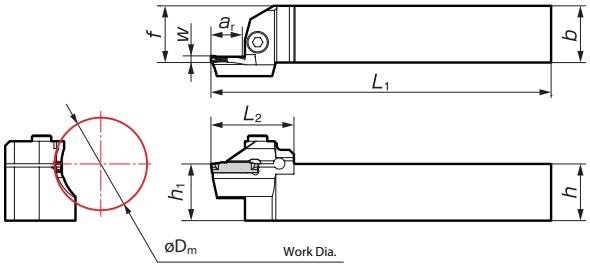
INCH Catalog Number	Dimensions (in)								Max. Groove depth	Insert Seat Size	Fig.
	h	b	L_1	f	h_1	h_2	L_2	L_3	a_r (inch)		
GNDL R/L061.25JX-038	.375	.375	4.75	.375	.375	.079	.709	.720	.375	1.25	3
GNDL R/L061.5JX-038	.375	.375	4.75	.375	.375	.079	.709	.720	.375	1.5	3
GNDL R/L062JX-038	.375	.375	4.75	.375	.375	.079	.866	.878	.375	2	3
GNDL R/L063JX-038	.375	.375	4.75	.375	.375	.079	.866	.878	.375	3	3
GNDL R/L081.25JX-047	.500	.500	4.75	.500	.500	.079	.748	.760	.472	1.25	3
GNDL R/L081.5JX-047	.500	.500	4.75	.500	.500	.079	.748	.760	.472	1.5	3
GNDL R/L082JX-050	.500	.500	4.75	.500	.500	.079	.866	.878	.500	2	3
GNDL R/L083JX-050	.500	.500	4.75	.500	.500	.079	.866	.878	.500	3	3
GNDL R/L101.5JX-050	.625	.625	4.75	.625	.625	-	1.102	-	.500	1.5	4
GNDL R/L102JX-063	.625	.625	4.75	.625	.625	-	1.26	-	.625	2	4
GNDL R/L103JX-063	.625	.625	4.75	.625	.625	-	1.26	-	.625	3	4
GNDL L/R 122K-075	.750	.750	5.00	.750	.750	-	1.752	-	.750	2	1
GNDL L/R 123K-075	.750	.750	5.00	.750	.750	-	1.752	-	.750	3	1
GNDL L/R 124K-100	.750	.750	5.00	.750	.750	-	1.969	-	1.000	4	1
GNDL L/R 125K-100	.750	.750	5.00	.750	.750	-	1.969	-	1.000	5	1
GNDL L/R 126K-100	.750	.750	5.00	.750	.750	-	1.969	-	1.000	6	1
GNDL L/R 162M-075	1.00	1.00	6.00	1.00	1.00	-	1.752	-	.750	2	1
GNDL L/R 163M-075	1.00	1.00	6.00	1.00	1.00	-	1.752	-	.750	3	1
GNDL L/R 164M-100	1.00	1.00	6.00	1.00	1.00	-	1.969	-	1.000	4	1
GNDL L/R 165M-100	1.00	1.00	6.00	1.00	1.00	-	1.969	-	1.000	5	1
GNDL L/R 166M-100	1.00	1.00	6.00	1.00	1.00	-	1.969	-	1.000	6	1
GNDL L/R 203P-090	1.25	1.25	6.75	1.25	1.25	-	1.875	-	0.900	3	1
GNDL L/R 204P-100	1.25	1.25	6.75	1.25	1.25	-	2.00	-	1.000	4	1
GNDL L/R 205P-100	1.25	1.25	6.75	1.25	1.25	-	2.00	-	1.000	5	1
GNDL L/R 206P-100	1.25	1.25	6.75	1.25	1.25	-	2.00	-	1.000	6	1
GNDL L/R 207P-100	1.25	1.25	6.75	1.25	1.25	-	2.00	-	1.000	7	1
GNDL L/R 208P-100	1.25	1.25	6.75	1.25	1.25	-	2.00	-	1.000	8	1
GNDLS L/R 122K-060	.750	.750	5.00	1.459	.750	-	1.00	-	.600	2	2
GNDLS L/R 123K-060	.750	.750	5.00	1.459	.750	-	1.00	-	.600	3	2
GNDLS L/R 124K-070	.750	.750	6.00	1.787	.750	-	1.00	-	.700	4	2
GNDLS L/R 162M-070	1.00	1.00	6.00	1.787	1.00	-	1.00	-	.700	2	2
GNDLS L/R 163M-070	1.00	1.00	6.00	1.787	1.00	-	1.00	-	.700	3	2
GNDLS L/R 164M-090	1.00	1.00	6.00	1.984	1.00	-	1.00	-	.900	4	2
GNDLS L/R 165M-090	1.00	1.00	6.00	1.984	1.00	-	1.00	-	.900	5	2
GNDLS L/R 166M-090	1.00	1.00	6.00	1.984	1.00	-	1.00	-	.900	6	2

METRIC Catalog Number	Dimensions (mm)								Max. Groove Depth a_r (mm)	Insert Seat Size	Fig.
	h	b	L_1	f	h_1	h_2	L_2	L_3			
GNDL R/L1010JX-1.2510	10	10	120	10	10	2.0	18	18.3	10	1.25	3
GNDL R/L1010JX-1.510	10	10	120	10	10	2.0	18	18.3	10	1.50	3
GNDL R/L1010JX-210	10	10	120	10	10	2.0	22.0	22.3	10	2	3
GNDL R/L1010JX-310	10	10	120	10	10	2.0	22.0	22.3	10	3	3
GNDL R/L1212JX-1.2512	12	12	120	12	12	2.0	19	19.3	12.0	1.25	3
GNDL R/L1212JX-1.512	12	12	120	12	12	2.0	19	19.3	12.0	1.5	3
GNDL R/L1212JX-212.5	12	12	120	12	12	2.0	22.0	22.3	12.5	2	3
GNDL R/L1212JX-312.5	12	12	120	12	12	2.0	22.0	22.3	12.5	3	3
GNDL R/L1616JX-1.2512	16	16	120	16	16	-	28.0	-	12.5	1.25	4
GNDL R/L1616JX-1.512.5	16	16	120	16	16	-	28.0	-	12.5	1.50	4
GNDL R/L1616JX-216	16	16	120	16	16	-	32.0	-	16	2	4
GNDL R/L1616JX-316	16	16	120	16	16	-	32.0	-	16	3	4
GNDL R/L2020K-220	20	20	125	20	20	-	44.5	-	20	2	3
GNDL R/L2020K-320	20	20	125	20	20	-	44.5	-	20(18)	3	3
GNDL R/L2020K-425	20	20	125	20	20	-	50.0	-	25(23)	4	3
GNDL R/L2020K-525	20	20	125	20	20	-	50.0	-	25(23)	5	3
GNDL R/L2020K-625	20	20	125	20	20	-	50.0	-	25(23)	6	3
GNDL R/L2525M-220	25	25	150	25	25	-	44.5	-	20	2	3
GNDL R/L2525M-320	25	25	150	25	25	-	44.5	-	20(18)	3	3
GNDL R/L2525M-425	25	25	150	25	25	-	50.0	-	25(23)	4	3
GNDL R/L2525M-525	25	25	150	25	25	-	50.0	-	25(23)	5	3
GNDL R/L2525M-625	25	25	150	25	25	-	50.0	-	25(23)	6	3
GNDL R/L3232P-320	32	32	170	32	32	-	44.5	-	20	3	3
GNDL R/L3232P-425	32	32	170	32	32	-	50	-	25	4	3
GNDL R/L3232P-525	32	32	170	32	32	-	50	-	25	5	3
GNDL R/L3232P-625	32	32	170	32	32	-	50	-	25	6	3
GNDL R/L3232P-725	32	32	170	32	32	-	50	-	25	7	3
GNDL R/L3232P-825	32	32	170	32	32	-	50	-	25	8	3
GNDLS R/L2020K-216	20	20	125	38	20	-	25	-	16	2	2
GNDLS R/L2020K-316	20	20	125	38	20	-	25	-	16	3	2
GNDLS R/L2525M-218	25	25	150	45	25	-	25	-	18	2	2
GNDLS R/L2525M-318	25	25	150	45	25	-	25	-	18	3	2
GNDLS R/L2525M-423	25	25	150	50	25	-	25	-	23	4	2
GNDLS R/L2525M-523	25	25	150	50	25	-	25	-	23	5	2
GNDLS R/L2525M-623	25	25	150	50	25	-	25	-	23	6	2

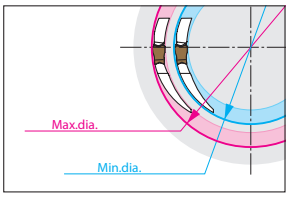
Select holders and inserts with the same grooving widths (*w*). Dimensions in parentheses under maximum grooving depth are for applications that use copying inserts (RG Type Breakers). See 17-18 General Catalog for hardware

Face Grooving - INCH





Above figures show right hand tools

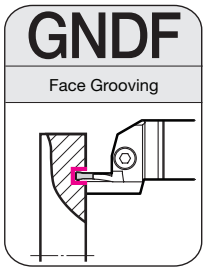


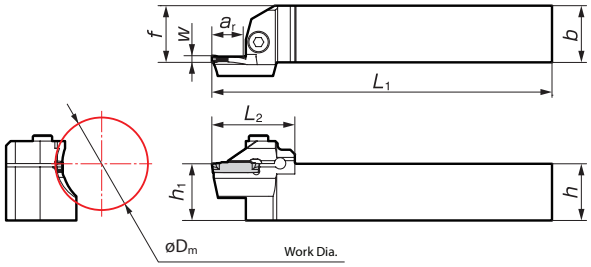
Work diameters in the table below indicate external diameter of face groove.

INCH Catalog Number	Dimensions (in)						Work Dia. ΦDm		Max. Grooving Depth a_r (inch)	Insert Seat Size	Cap Screw	Wrench
	h	b	L_1	f	h_1	L_2	Min.	Max.				
GNDF L/R 123K-050-035	.750	.750	5.000	.750	.750	1.402	1.378	1.772	.500	3	BX0520	LH040
GNDF L/R 123K-050-040	.750	.750	5.000	.750	.750	1.402	1.575	2.165	.500	3		
GNDF L/R 123K-070-050	.750	.750	5.000	.750	.750	1.638	1.969	2.756	.700	3		
GNDF L/R 123K-070-065	.750	.750	5.000	.750	.750	1.638	2.559	3.397	.700	3		
GNDF L/R 123K-070-090	.750	.750	5.000	.750	.750	1.638	3.543	5.906	.700	3		
GNDF L/R 123K-070-140	.750	.750	5.000	.750	.750	1.638	5.512	7.874	.700	3		
GNDF L/R 123K-070-180	.750	.750	5.000	.750	.750	1.638	7.087	11.811	.700	3		
GNDF L/R 124K-070-040	.750	.750	5.000	.750	.750	1.638	1.575	2.165	.700	4	BX0520	LH040
GNDF L/R 124K-090-050	.750	.750	5.000	.750	.750	1.835	1.969	2.756	.900	4		
GNDF L/R 124K-090-065	.750	.750	5.000	.750	.750	1.835	2.559	3.543	.900	4		
GNDF L/R 124K-090-085	.750	.750	5.000	.750	.750	1.835	3.346	5.118	.900	4		
GNDF L/R 124K-090-125	.750	.750	5.000	.750	.750	1.835	4.921	7.874	.900	4		
GNDF L/R 124K-090-180	.750	.750	5.000	.750	.750	1.835	7.087	11.811	.900	4		
GNDF L/R 124K-090-280	.750	.750	5.000	.750	.750	1.835	11.024	39.370	.900	4		
GNDF L/R 125K-090-050	.750	.750	5.000	.750	.750	1.835	1.969	2.756	.900	5	BX0520	LH040
GNDF L/R 125K-090-065	.750	.750	5.000	.750	.750	1.835	2.559	3.543	.900	5		
GNDF L/R 125K-090-085	.750	.750	5.000	.750	.750	1.835	3.346	5.118	.900	5		
GNDF L/R 125K-090-125	.750	.750	5.000	.750	.750	1.835	4.921	7.874	.900	5		
GNDF L/R 125K-090-180	.750	.750	5.000	.750	.750	1.835	7.087	11.811	.900	5		
GNDF L/R 125K-090-280	.750	.750	5.000	.750	.750	1.835	11.024	39.370	.900	5		
GNDF L/R 126K-090-050	.750	.750	5.000	.750	.750	1.835	1.969	2.953	.900	6	BX0520	LH040
GNDF L/R 126K-090-070	.750	.750	5.000	.750	.750	1.835	2.756	4.331	.900	6		
GNDF L/R 126K-090-100	.750	.750	5.000	.750	.750	1.835	3.397	7.874	.900	6		
GNDF L/R 126K-090-180	.750	.750	5.000	.750	.750	1.835	7.087	11.811	.900	6		
GNDF L/R 126K-090-280	.750	.750	5.000	.750	.750	1.835	11.024	39.370	.900	6		
GNDF L/R 163M-050-035	1.000	1.000	6.000	1.000	1.000	1.402	1.378	1.772	.500	3	BX0520	LH040
GNDF L/R 163M-050-040	1.000	1.000	6.000	1.000	1.000	1.402	1.575	2.165	.500	3		
GNDF L/R 163M-070-050	1.000	1.000	6.000	1.000	1.000	1.638	1.969	2.756	.700	3		
GNDF L/R 163M-070-065	1.000	1.000	6.000	1.000	1.000	1.638	2.559	3.397	.700	3		
GNDF L/R 163M-070-090	1.000	1.000	6.000	1.000	1.000	1.638	3.543	5.906	.700	3		
GNDF L/R 163M-070-140	1.000	1.000	6.000	1.000	1.000	1.638	5.512	7.874	.700	3		
GNDF L/R 163M-070-180	1.000	1.000	6.000	1.000	1.000	1.638	7.087	11.811	.700	3		
GNDF L/R 164M-070-040	1.000	1.000	6.000	1.000	1.000	1.638	1.575	2.165	.700	4	BX0520	LH040
GNDF L/R 164M-090-050	1.000	1.000	6.000	1.000	1.000	1.835	1.969	2.756	.900	4		
GNDF L/R 164M-090-065	1.000	1.000	6.000	1.000	1.000	1.835	2.559	3.543	.900	4		
GNDF L/R 164M-090-085	1.000	1.000	6.000	1.000	1.000	1.835	3.346	5.118	.900	4		
GNDF L/R 164M-090-125	1.000	1.000	6.000	1.000	1.000	1.835	4.921	7.874	.900	4		
GNDF L/R 164M-090-180	1.000	1.000	6.000	1.000	1.000	1.835	7.087	11.811	.900	4		
GNDF L/R 164M-090-280	1.000	1.000	6.000	1.000	1.000	1.835	11.024	39.370	.900	4		
GNDF L/R 165M-090-050	1.000	1.000	6.000	1.000	1.000	1.835	1.969	2.756	.900	5	BX0520	LH040
GNDF L/R 165M-090-065	1.000	1.000	6.000	1.000	1.000	1.835	2.559	3.543	.900	5		
GNDF L/R 165M-090-085	1.000	1.000	6.000	1.000	1.000	1.835	3.346	5.118	.900	5		
GNDF L/R 165M-090-125	1.000	1.000	6.000	1.000	1.000	1.835	4.921	7.874	.900	5		
GNDF L/R 165M-090-180	1.000	1.000	6.000	1.000	1.000	1.835	7.087	11.811	.900	5		
GNDF L/R 165M-090-280	1.000	1.000	6.000	1.000	1.000	1.835	11.024	39.370	.900	5		
GNDF L/R 166M-090-050	1.000	1.000	6.000	1.000	1.000	1.835	1.969	2.953	.900	6	BX0520	LH040
GNDF L/R 166M-090-070	1.000	1.000	6.000	1.000	1.000	1.835	2.756	4.331	.900	6		
GNDF L/R 166M-090-100	1.000	1.000	6.000	1.000	1.000	1.835	3.937	7.874	.900	6		
GNDF L/R 166M-090-180	1.000	1.000	6.000	1.000	1.000	1.835	7.087	11.811	.900	6		
GNDF L/R 166M-090-280	1.000	1.000	6.000	1.000	1.000	1.835	11.024	39.370	.900	6		

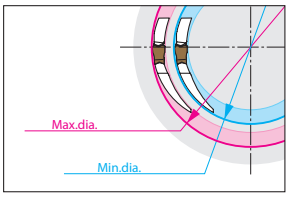
Please see page 11 for applicable inserts

Face Grooving - METRIC





Above figures show right hand tools



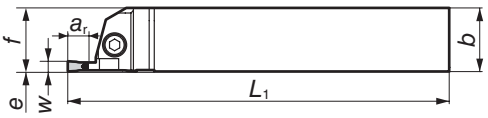
Work diameters in the table below indicate external diameter of face groove.

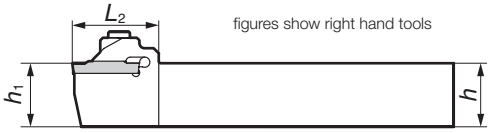
METRIC Catalog Number	Dimensions (mm)						Work Dia. (mm)	Max. Groove Depth a_r (mm)	Insert Seat Size	Cap Screw	Wrench
	h	b	L_1	f	h_1	L_2	ΦD$_m$				
GNDF R/L2020K-312-035	20	20	125	20	20	35.6	35 to 45	12			
GNDF R/L2020K-312-040	20	20	125	20	20	35.6	40 to 55	12			
GNDF R/L2020K-318-050	20	20	125	20	20	41.6	50 to 70	18			
GNDF R/L2020K-318-065	20	20	125	20	20	41.6	65 to 100	18	3	BX0520	LH040
GNDF R/L2020K-318-090	20	20	125	20	20	41.6	90 to 150	18			
GNDF R/L2020K-318-140	20	20	125	20	20	41.6	140 to 200	18			
GNDF R/L2020K-318-180	20	20	125	20	20	41.6	180 to 300	18			
GNDF R/L2020K-418-040	20	20	125	20	20	41.6	40 to 55	18			
GNDF R/L2020K-423-050	20	20	125	20	20	46.6	50 to 70	23			
GNDF R/L2020K-423-065	20	20	125	20	20	46.6	65 to 90	23			
GNDF R/L2020K-423-085	20	20	125	20	20	46.6	85 to 130	23	4	BX0520	LH040
GNDF R/L2020K-423-125	20	20	125	20	20	46.6	125 to 200	23			
GNDF R/L2020K-423-180	20	20	125	20	20	46.6	180 to 300	23			
GNDF R/L2020K-423-280	20	20	125	20	20	46.6	280 to 1000	23			
GNDF R/L2020K-523-050	20	20	125	20	20	46.6	50 to 70	23			
GNDF R/L2020K-523-065	20	20	125	20	20	46.6	65 to 90	23			
GNDF R/L2020K-523-085	20	20	125	20	20	46.6	85 to 130	23			
GNDF R/L2020K-523-125	20	20	125	20	20	46.6	125 to 200	23	5	BX0520	LH040
GNDF R/L2020K-523-180	20	20	125	20	20	46.6	180 to 300	23			
GNDF R/L2020K-523-280	20	20	125	20	20	46.6	280 to 1000	23			
GNDF R/L2020K-623-050	20	20	125	20	20	46.6	50 to 75	23			
GNDF R/L2020K-623-070	20	20	125	20	20	46.6	70 to 110	23			
GNDF R/L2020K-623-100	20	20	125	20	20	46.6	100 to 200	23	6	BX0520	LH040
GNDF R/L2020K-623-180	20	20	125	20	20	46.6	180 to 300	23			
GNDF R/L2020K-623-280	20	20	125	20	20	46.6	280 to 1000	23			
GNDF R/L2525M-312-035	25	25	150	25	25	35.6	35 to 45	12			
GNDF R/L2525M-312-040	25	25	150	25	25	35.6	40 to 55	12			
GNDF R/L2525M-318-050	25	25	150	25	25	41.6	50 to 70	18			
GNDF R/L2525M-318-065	25	25	150	25	25	41.6	65 to 100	18	3	BX0520	LH040
GNDF R/L2525M-318-090	25	25	150	25	25	41.6	90 to 150	18			
GNDF R/L2525M-318-140	25	25	150	25	25	41.6	140 to 200	18			
GNDF R/L2525M-318-180	25	25	150	25	25	41.6	180 to 300	18			
GNDF R/L2525M-418-040	25	25	150	25	25	41.6	40 to 55	18			
GNDF R/L2525M-423-050	25	25	150	25	25	46.6	50 to 70	23			
GNDF R/L2525M-423-065	25	25	150	25	25	46.6	65 to 90	23			
GNDF R/L2525M-423-085	25	25	150	25	25	46.6	85 to 130	23	4	BX0520	LH040
GNDF R/L2525M-423-125	25	25	150	25	25	46.6	125 to 200	23			
GNDF R/L2525M-423-180	25	25	150	25	25	46.6	180 to 300	23			
GNDF R/L2525M-423-280	25	25	150	25	25	46.6	280 to 1000	23			
GNDF R/L2525M-523-050	25	25	150	25	25	46.6	50 to 70	23			
GNDF R/L2525M-523-065	25	25	150	25	25	46.6	65 to 90	23			
GNDF R/L2525M-523-085	25	25	150	25	25	46.6	85 to 130	23			
GNDF R/L2525M-523-125	25	25	150	25	25	46.6	125 to 200	23	5	BX0520	LH040
GNDF R/L2525M-523-180	25	25	150	25	25	46.6	180 to 300	23			
GNDF R/L2525M-523-280	25	25	150	25	25	46.6	280 to 1000	23			
GNDF R/L2525M-623-050	25	25	150	25	25	46.6	50 to 75	23			
GNDF R/L2525M-623-070	25	25	150	25	25	46.6	70 to 110	23			
GNDF R/L2525M-623-100	25	25	150	25	25	46.6	100 to 200	23	6	BX0520	LH040
GNDF R/L2525M-623-180	25	25	150	25	25	46.6	180 to 300	23			
GNDF R/L2525M-623-280	25	25	150	25	25	46.6	280 to 1000	23			

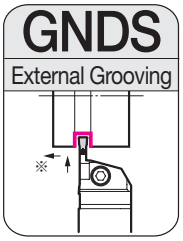
Select holders and inserts with the same grooving widths (*w*).

Please see page 11 for applicable inserts

External Multi-purpose Shallow Grooves Type (Grooving, Turning, and Copying)



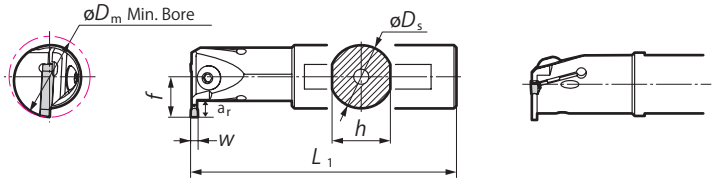




METRIC Catalog Number	Dimensions (mm)						Max. Groove Depth a_r (mm)	Insert Seat Size	Cap Screw	Wrench
	h	b	L_1	f	h_1	L_2				
GNDS R/L2020K-206	20	20	125	20	20	30.0	6	2	BX0520	LH040
GNDS R/L2020K-306	20	20	125	20	20	30.0	6	3		
GNDS R/L2020K-410	20	20	125	20	20	34.0	10	4		
GNDS R/L2020K-510	20	20	125	20	20	34.0	10	5		
GNDS R/L2020K-610	20	20	125	20	20	34.0	10	6		
GNDS R/L2525M-206	25	25	150	25	25	30.0	6	2		
GNDS R/L2525M-306	25	25	150	25	25	30.0	6	3		
GNDS R/L2525M-410	25	25	150	25	25	34.0	10	4		
GNDS R/L2525M-510	25	25	150	25	25	34.0	10	5		
GNDS R/L2525M-610	25	25	150	25	25	34.0	10	6		

Select holders and inserts with the same grooving widths (*w*).

Internal Grooving



■ Inch Boring Bar

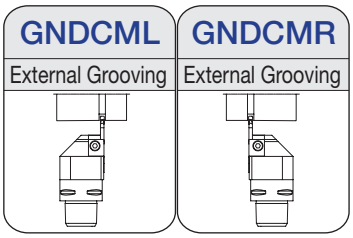
INCH Catalog Number	Dimensions (in)					Max Groove Depth	Insert Seat Size W
	Shank Diameter	h	Overall L1	f	Min. Bore Dm	a_r (inch)	
GNDIR/L162T-25	1.000	0.906	8.000	0.630	1.250	0.250	2
GNDIR/L163T-25	1.000	0.906	8.000	0.630	1.250	0.250	3
GNDIR/L164T-25	1.000	0.906	8.000	0.630	1.250	0.250	4
GNDIR/L165T-25	1.000	0.906	8.000	0.630	1.250	0.250	5
GNDIR/L166T-25	1.000	0.906	8.000	0.630	1.250	0.250	6
GNDIR/L202T-40	1.250	1.181	10.000	1.024	1.575	0.400	2
GNDIR/L203T-40	1.250	1.181	10.000	1.024	1.575	0.400	3
GNDIR/L204T-40	1.250	1.181	10.000	1.024	1.575	0.400	4
GNDIR/L205T-40	1.250	1.181	10.000	1.024	1.575	0.400	5
GNDIR/L206T-40	1.250	1.181	10.000	1.024	1.575	0.400	6
GNDIR/L243T-43	1.500	1.421	12.000	1.145	2.000"	0.430	3
GNDIR/L244T-43	1.500	1.421	12.000	1.145	2.000"	0.430	4
GNDIR/L245T-43	1.500	1.421	12.000	1.145	2.000"	0.430	5
GNDIR/L246T-43	1.500	1.421	12.000	1.145	2.000"	0.430	6

■ Metric Boring Bar

METRIC Catalog Number	Dimensions (mm)					Max. Groove Depth	Insert Seat Size W
	Shank Diameter	h	Overall L1	f	Min. Bore Dm	ar (mm)	
GNDIR/L2532-T206	25	23	200	16	32	6	2
GNDIR/L2532-T306	25	23	200	16	32	6	3
GNDIR/L2532-T406	25	23	200	16	32	6	4
GNDIR/L2532-T506	25	23	200	16	32	6	5
GNDIR/L3240-T210	32	30	250	26	40	10	2
GNDIR/L3240-T310	32	30	250	26	40	10	3
GNDIR/L3240-T410	32	30	250	26	40	10	4
GNDIR/L3240-T510	32	30	250	26	40	10	5
GNDIR/L4050-T311	40	38	300	31	50	11	3
GNDIR/L4050-T411	40	38	300	31	50	11	4
GNDIR/L4050-T511	40	38	300	31	50	11	5
GNDIR/L4050-T611	40	38	300	31	50	11	6

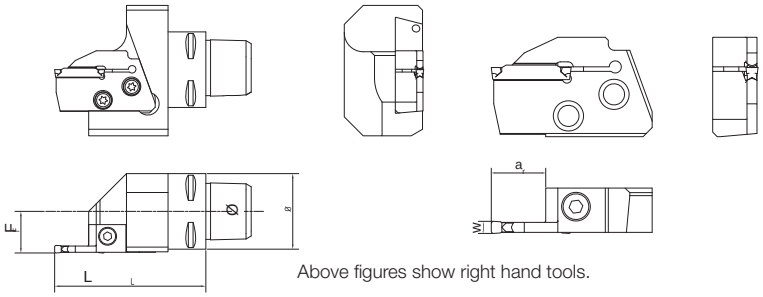
Please see page 11 for applicable inserts

External Multi-Purpose Type (Grooving, Turning, Profiling)



Use for multi-purpose or profiling insert for turning (wide grooves).

Right handed Cassette goes with right handed holder
Left handed Cassette goes with left handed holder

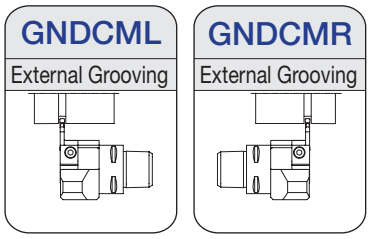


Above figures show right hand tools.

	Catalog Number	Seat Size	Grooving Depth a_r (mm)	Inserts	Cap Screw	Tightening Torque (N·m)	Wrench
Cassette (R/L)	GNDCMR/L212	2	12	GCM □2002-□□	BX0515	5.0	LH040
	GNDCMR/L312	3	12	GCM □30□□-□□			
	GNDCMR/L418	4	18	GCM □40□□-□□		6.0	
	GNDCMR/L518	5	18	GCM □50□□-□□			
	GNDCMR/L618	6	18	GCM □60□□-□□			

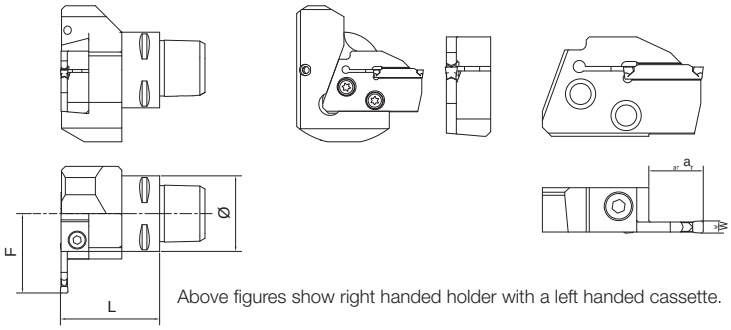
	Catalog Number	Ø	F	L	Cap Screw	Tightening Torque (N·m)	Wrench
Holder (R/L)	PSC40GM00R/L	40 mm	22 mm	80 mm	BFTX0619N	7.5	TRD25
	PSC50GM00R/L	50mm	27 mm	80 mm			

External Multi-Purpose Type (Grooving, Turning, Profiling)



Use for multi-purpose or profiling insert for turning (wide grooves).

Right handed Cassette goes with left handed holder
Left handed Cassette goes with right handed holder



Above figures show right handed holder with a left handed cassette.

	Catalog Number	Seat Size	Grooving Depth a_r (mm)	Inserts	Cap Screw	Tightening Torque (N·m)	Wrench
Cassette (R/L)	GNDCML/R212	2	12	GCM □2002-□□	BX0515	5.0	LH040
	GNDCML/R312	3	12	GCM □30□□-□□			
	GNDCML/R418	4	18	GCM □40□□-□□		6.0	
	GNDCML/R518	5	18	GCM □50□□-□□			
	GNDCML/R618	6	18	GCM □60□□-□□			

	Catalog Number	Ø	F	L	Cap Screw	Tightening Torque (N·m)	Wrench
Holder (R/L)	PSC40GM90R/L	40 mm	22 mm	80 mm	BFTX0619N	7.5	TRD25
	PSC50GM90R/L	50 mm	27 mm	80 mm			

GCMN Inserts

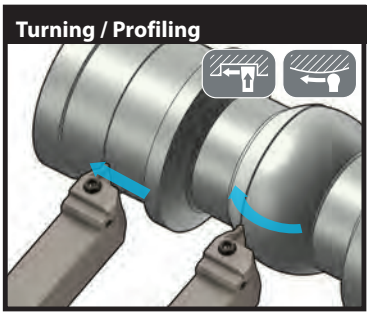
		Cat. No.	Coated Carbide				Cermet	Uncoated Carbide	Dimensions (inch)					Fig.
			S		K	P		N	W	rε	ℓ	Insert Seat Size	S	
			AC1030U	AC520U	AC530U	AC425K	AC830P	T2500A	H10						
Low Cutting Force	GF Type	GCMN125005-GF			●					.049	.0020	.685	1.25	.126	
		GCMN150005-GF			●					.059	.0020	.685	1.5	.146	
		GCMN2002-GF			★			★		.078	.0078	.831	2	.142	
		GCMN3002-GF		★	★		★	★		.118	.0078	.831	3	.150	
		GCMN4002-GF		★	★		★	★		.157	.0078	1.039	4	.157	
		GCMN5002-GF		★	★		★			.197	.0078	1.039	5	.161	
		GCMN6002-GF		★	★		★			.236	.0078	1.039	6	.177	
		GCMN7002-GF		★	★		★			.276	.0078	1.132	7	.217	
		GCMN8002-GF		★	★		★			.315	.0078	1.132	8	.236	
		GCMN7004-GF		★	★		★			.276	.0158	1.132	7	.217	
		GCMN8004-GF		★	★		★			.315	.0158	1.132	8	.236	
Deep Grooving Cut Off	General Feed GG Type	GCMN2002-GG		●	●	●	●			.078	.0078	.831	2	.142	
		GCMN2094R0.5-GG		●	●	●	●			.094	.0078	.831	2	.142	
		GCMN3002-GG		●	●	●	●			.118	.0078	.831	3	.150	
		GCMN3004-GG		●	●	●	●			.118	.0156	.831	3	.150	
		GCMN3125R0.5-GG		●	●	●	●			.125	.0078	.831	3	.150	
		GCMN4002-GG		●	●	●	●			.157	.0078	1.039	4	.157	
		GCMN4004-GG		●	●	●	●			.157	.0156	1.039	4	.157	
		GCMN5187R0.5-GG		●	●	●	●			.187	.0078	1.039	5	.161	
		GCMN5002-GG		●	●	●	●			.197	.0078	1.039	5	.161	
		GCMN5004-GG		●	●	●	●			.197	.0156	1.039	5	.161	
		GCMN6002-GG		●	●	●	●			.236	.0078	1.039	6	.177	
		GCMN6004-GG		●	●	●	●			.236	.0156	1.039	6	.177	
		GCMN6250R0.5-GG		●	●	●	●			.250	.0078	1.039	6	.177	
		GCMN6250R1.0-GG		●	●	●	●			.250	.0156	1.039	6	.177	
		GCMN7004-GG		●	●		●			.276	.0156	1.132	7	.217	
		GCMN8004-GG		●	●		●			.315	.0156	1.132	8	.236	
	Low Feed GL Type	GCMN2002-GL		●	●	●	●	●		.078	.0078	.831	2	.142	1
		GCMN2094R0.5-GL		●	●	●	●			.094	.0078	.831	2	.142	
		GCMN3002-GL		●	●	●	●	●		.118	.0078	.831	3	.150	
		GCMN3125R0.5-GL		●	●	●	●			.125	.0078	.831	3	.150	
		GCMN4002-GL		●	●	●	●	●		.157	.0078	1.039	4	.157	
		GCMN5187R0.5-GL		●	●	●	●			.187	.0078	1.039	5	.161	
		GCMN5002-GL		●	●	●	●			.197	.0078	1.039	5	.161	
		GCMN6002-GL		●	●	●	●			.236	.0078	1.039	6	.177	
		GCMN6250R0.5-GL		●	●	●	●			.250	.0078	1.039	6	.177	
		GCMN7004-GL		●	●		●			.276	.0156	1.132	7	.217	
		GCMN8004-GL		●	●		●			.315	.0156	1.132	8	.236	
Multi function (traversing)	General Feed MG Type	GCMN3004-MG		●	●	●	●			.118	.0156	.831	3	.150	
		GCMN3125R1.0-MG		●	●	●	●			.125	.0156	.831	3	.150	
		GCMN4008-MG		●	●	●	●			.157	.0312	1.039	4	.157	
		GCMN5187R2.0-MG		●	●	●	●			.187	.0312	1.039	5	.161	
		GCMN5008-MG		●	●	●	●			.197	.0312	1.039	5	.161	
		GCMN6008-MG		●	●	●	●			.236	.0312	1.039	6	.177	
		GCMN6250R2.0-MG		●	●	●	●			.250	.0312	1.039	6	.177	
		GCMN7008-MG		●	●	●	●			.276	.0313	1.132	7	.217	
		GCMN8008-MG		●	●	●	●			.315	.0313	1.132	8	.236	
	Low Feed ML Type	GCMN3002-ML		●	●	●	●	●		.118	.0078	.831	3	.150	
		GCMN3125R0.5-ML		●	●	●	●			.125	.0078	.831	3	.150	
		GCMN4004-ML		●	●	●	●	●		.157	.0156	1.039	4	.157	
		GCMN5187R1.0-ML		●	●	●	●			.187	.0156	1.039	5	.161	
		GCMN5004-ML		●	●	●	●			.197	.0156	1.039	5	.161	
		GCMN6004-ML		●	●	●	●			.236	.0156	1.039	6	.177	
		GCMN6250R1.0-ML		●	●	●	●			.250	.0156	1.039	6	.177	
		GCMN7004-ML		●	●	●	●			.276	.0156	1.132	7	.217	
		GCMN8004-ML		●	●	●	●			.315	.0156	1.132	8	.236	
Profiling	General Feed RG Type	GCMN3015-RG		●	●	●	●	●		.118	.059	.831	3	.150	
		GCMN3125-RG		●	●	●	●			.125	.0625	.831	3	.150	
		GCMN4020-RG		●	●	●	●	●		.157	.078	1.039	4	.157	
		GCMN5187-RG		●	●	●	●			.187	.0938	1.039	5	.161	
		GCMN5025-RG		●	●	●	●			.197	.098	1.039	5	.161	2
		GCMN6030-RG		●	●	●	●			.236	.118	1.039	6	.177	
		GCMN6250-RG		●	●	●	●			.250	.125	1.039	6	.177	
		GCMN7035-RG		●	●	●	●			.276	.138	1.144	7	.217	
		GCMN8040-RG		●	●	●	●			.315	.157	1.152	8	.236	
For Non-ferrous Materials	GA Type	GCGN2002-GA							●	.078	.0078	.831	2	.142	1
		GCGN3002-GA							●	.118	.0078	.831	3	.150	
		GCGN4004-GA							●	.157	.0156	1.039	4	.157	
		GCGN5004-GA							●	.197	.0156	1.039	5	.161	
		GCGN6004-GA							●	.236	.0156	1.039	6	.177	

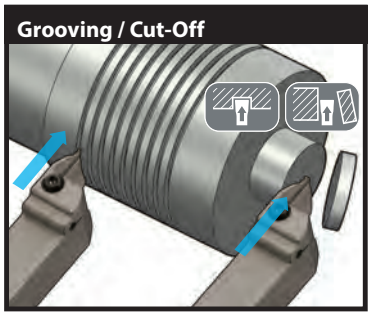
Type		Cat. No.	R	L	R	L	R	L	R	L	R	L	R	L	R	L	Dimensions (inch)					
Cut-off (Handed)	CG-05 Type	GCM_2002-CG-05			●	●	●	●	●	●	●	●					.078	.0078	.831	2	.142	
		GCM_3002-CG-05			●	●	●	●	●	●	●	●					.118	.0078	.831	3	.150	
		GCM_4002-CG-05			●	●	●	●	●	●	●	●					.157	.0078	1.039	4	.157	
Cut-off	CF Type	GCMR20003-CF-10	●	●													.078	.0012	.882	2	.142	
		GCML20003-CF-10	●	●													.078	.0012	.882	2	.142	
		GCMR20003-CF-15	●	●													.078	.0012	.882	2	.142	1
		GCML20003-CF-15	●	●													.078	.0012	.882	2	.142	
		GCMR30003-CF-10	●	●													.118	.0012	.882	3	.150	
		GCML30003-CF-10	●	●													.118	.0012	.882	3	.150	
		GCMR30003-CF-15	●	●													.118	.0012	.882	3	.150	
		GCML30003-CF-15	●	●													.118	.0012	.882	3	.150	

●= USA Stocked item ★= World Wide Warehouse Item

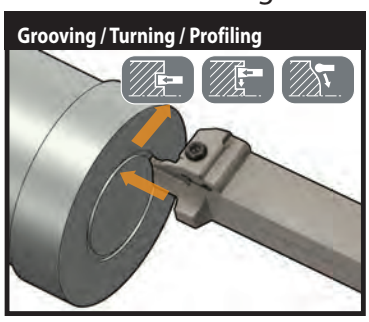
GND Type Holder Selection Guide

External Grooving

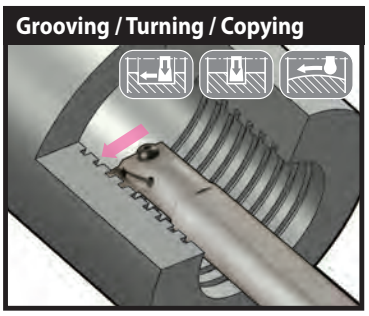




Face Grooving

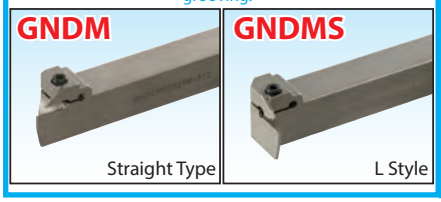


Internal Grooving



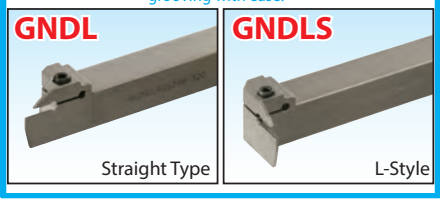
GNDM Type / GNDMS Type

Perfect for turning and profiling. Can also be used for grooving.



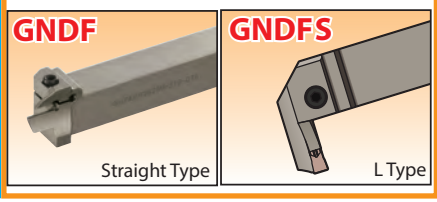
GNDL Type / GNDLS Type

Perfect for grooving and cut-off applications. Handles deep grooving with ease.



GNDF Type / GNDFS Type

For facing work.



GNDI Type

for internal grooving.

Recommended Cutting Conditions

Part Material	P				M			K						S		N
	Carbon Steel/ Alloy Steel				Stainless Steel			Gray Cast Iron			Ductile Cast Iron			Exotic Alloy		Non-ferrous
Grade	AC830P	AC520U	AC530U	T2500A (Cermet)	AC830P	AC520U	AC530U	AC425K	AC520U	AC530U	AC425K	AC520U	AC530U	AC520U	AC530U	H10
Speed (SFM)	260-650	260-650	165-650	350-750	230-500	230-500	165-500	260-650	200-650	165-650	400-600	200-500	165-500	65-260	65-200	500-1000

Grooving & Cutoff

Seat Size	MG Feed (ipr)	ML Feed (ipr)	GG Feed (ipr)	GL Feed (ipr)	RG Feed (ipr)	CG Feed (ipr)	GA Feed (ipr)
2	-	-	.002-.010	.001-.006	-	.002-.008	.002-.010
3	.003-.008	.001-.006	.004-.012	.002-.008	.003-.006	.003-.010	.004-.012
4	.004-.010	.002-.008	.006-.014	.003-.009	.004-.008	.004-.012	.006-.014
5	.005-.012	.003-.010	.008-.016	.004-.010	.006-.010	-	.008-.016
6	.006-.014	.004-.012	.008-.018	.005-.012	.008-.012	-	.008-.018
7	.007-.016	.005-.014	.008-.020	.006-.014	.010-.014	-	-
8	.008-.018	.006-.016	.008-.022	.007-.016	.014-.016	-	-

Turning

Seat Size	MG Feed (ipr)	MG Depth (in)	ML Feed (ipr)	ML Depth (in)	RG Feed (ipr)	RG Depth (in)
3	.003-.010	.016-.06	.002-.007	.012-.060	.004-.016	.012-.048
4	.004-.012	.020-.08	.002-.008	.016-.080	.006-.018	.024-.064
5	.005-.014	.030-.10	.003-.010	.020-.100	.008-.020	.030-.080
6	.006-.016	.040-.12	.004-.012	.020-.120	.012-.024	.040-.090
7	.007-.016	.048-.014	.005-.014	.028-.014	.014-.026	.048-.098
8	.008-.018	.060-.016	.006-.016	.028-.016	.014-.028	.060-.120

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