для заказа - kyocera@kyocera-tools.ru

GBA Inserts (Metric)

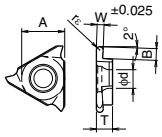
NEW

P	Carbon Steel / Alloy Steel	●	○		◕	◔		◔		
M	Stainless Steel				●	◕		◔		
K	Cast Iron						◕		◔	
N	Non-ferrous Metals								◕	
S	Titanium Alloy								◕	
H	Hard materials (≤40HRC)				●	○		○		
	Hard materials (≥40HRC)									

Classification of Usage
◕ : Light Interruption / 1st Choice
◔ : Light Interruption / 2nd Choice
● : Continuous / 1st Choice
○ : Continuous / 2nd Choice

(mm)

Part Number	A	T	Ød
GBA32_	9.525	3.18	4.4
GBA43_	12.700	4.76	5.5
GBA43℻480	12.700	5.00	5.5

Insert (Right-handed Insert Shown)	Part Number	Previous Part Number	Dimensions (mm) W	B	rε	*MC PV7040	Cermet TN620	Cermet TN90	MEGA COAT PR1215	PVD Coated Carbide PR1115	PVD Coated Carbide PR905	PVD Coated Carbide PR930	Carbide KW10	Applicable Toolholders	Ref. Page for Toolholder
 Molded Chipbreaker		GBA32℻ 200-100R	-	2.00	2.5	1.00				◉	Ⓡ				KGBAR…16 KGBASL…16 KIGBAL…16 (Internal)	G11 G62 (Internal)
				3.00	2.5	1.50				◉	Ⓡ					
Full-R (Round)		GBA43℻ 100-050R	GBA43℻ 050R	1.00	2.0	0.50	○			●	Ⓛ	○			KGBA℻…22-15 KGBAS℻…22-15 KIGBA℻…22 (Internal)	
		150-075R	075R	1.50	3.5	0.75	○			●	○	○				
		200-100R	100R	2.00	3.5	1.00	○			●	Ⓛ	○				
		250-125R	125R	2.50	4.0	1.25				●	○	○			KGBA℻…22-25 KGBAS℻…22-25 KGBA℻…22-25T5 KGBAS℻…22-25T5 KIGBA℻…22 (Internal)	
		300-150R	150R	3.00	4.0	1.50			○	●	Ⓡ	○	Ⓡ	○		
		400-200R	200R	4.00	5.0	2.00				●	○	○			KGBA℻…22-35 KGBAS℻…22-35 KIGBA℻…22 (Internal)	

• Dimension B shows available grooving depth.
*MC stands for MEGACOAT Cermet.

Recommended Cutting Conditions ➡ G123

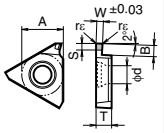
GBA Inserts (Metric)

P	Carbon Steel / Alloy Steel									
M	Stainless Steel									
K	Cast Iron									
N	Non-ferrous Metals							●		
S	Titanium Alloy							●		
H	Hard materials (≤40HRC)									
	Hard materials (≥40HRC)	○	●							

Classification of Usage
◕ : Light Interruption / 1st Choice
◔ : Light Interruption / 2nd Choice
● : Continuous / 1st Choice
○ : Continuous / 2nd Choice

(mm)

Part Number	A	T	Ød
GBA32_	9.525	3.18	4.4
GBA43_	12.700	4.76	5.5
GBA43℻480	12.700	5.00	5.5

Insert (Right-handed Insert Shown)	Part Number	Previous Part Number	Dimensions (mm) W	B	rε	CBN KBN510	CBN KBN525	PCD KPD001	PCD KPD010	Applicable Toolholders	Ref. Page for Toolholder
 1-Edge	 GBA32 S=1.7 GBA43 S=1.9	GBA32℻ 125-010	GBA32℻ 125	1.25	2.0	0.1				Ⓡ	KGBAR…16 KGBASL…16 KIGBAL…16 (Internal)	G11 G62 (Internal)
		150-010	150	1.50	2.0	0.1			Ⓡ	Ⓡ		
		GBA43℻ 125-010	GBA43℻ 125	1.25	2.0	0.1		Ⓡ		○	KGBA℻…22-15 KGBAS℻…22-15 KIGBA℻…22 (Internal)	
		125-020	125	1.25	2.0	0.2	○	○				
		150-010	150	1.50	3.5	0.1		Ⓛ	○	○		
		150-020	150	1.50	3.5	0.2	Ⓛ	○				
		200-010	200	2.00	3.5	0.1			Ⓛ	○		
		200-020	200	2.00	3.5	0.2	Ⓛ	○				
		300-020	300	3.00	4.0	0.2		Ⓡ			KGBA℻…22-25 KGBAS℻…22-25 KGBA℻…22-25T5 KGBAS℻…22-25T5 KIGBA℻…22 (Internal)	

• Dimension B shows available grooving depth

Recommended Cutting Conditions ➡ G123

GBA type applicable for KGBA / KGBAS type toolholders is also usable for KGB / KGBS type toolholders.

Rake Angle (α) after Installment of GBA

GBA32℻○○○-○○○		GBA43℻○○○-○○○		GBA43℻○○○-○○○R (Full-R)		
α (°)	Insert Grade	α (°)	Insert Grade	α (°)	Insert Grade	Full-R
10°	TN90,PV7040,PR930 PR1115,PR1215,PR905 KPD001,KPD010	0°	KBN510, KBN525	10°	TN90,PV7040,PR930 PR1115,PR1215,PR905	050R~150R
		10°	TC40,TN90,PV7040,PR930 PR1115,PR1215,PR905 KPD001, KPD010	14°	TN90,PV7040,PR930 PR1115,PR1215,PR905	200R
20°	KW10	20°	KW10	14°	KW10	050R~200R

For GM Chipbreaker and MY Chipbreaker, see page ➡ G9

Inserts are sold in 10 piece boxes.

CBN & PCD Inserts are sold in 1 piece boxes.

kyocera@kyocera-tools.ru
www.kyocera-tools.ru

● : U.S. Stock Ⓡ : U.S. Stock (R-hand Only) Ⓛ : U.S. Stock (L-hand Only)
○ : World Express (Shipping: 7-10 Business Days) Ⓡ : World Express (R-hand Only) Ⓛ : World Express (L-hand Only)