GDGS (CBN / PCD) NEW

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

K	Cast Iron				Ref. Page for Toolholder
N	Non-ferrous Metals			●	
S	Titanium Alloy			●	
H	Hard materials (≤40HRC)				
	Hard materials (≥40HRC)	●			
	Powdered Steel		●		

Insert (Right-handed Insert Shown)	Part Number	Dimensions (mm) W inch	W mm	W Tolerance	rε	M	L	H	S	Angle (°) θ	MEGA CBN KBN05M	CBN KBN570	PCD KPD001	Ref. Page for Toolholder
Grooving	GDGS 2020N-020NB	0.079	2.0	±0.0012"	0.008	0.071	0.787	0.169	0.114	-		○	○	G19 ~ G24
	3020N-020NB	0.118	3.0		0.008	0.091	0.787	0.169	0.114				○	
	3020N-040NB	0.118	3.0		0.016	0.091	0.787	0.169	0.114		●	○		
	4020N-020NB	0.158	4.0		0.008	0.130	0.787	0.169	0.114				○	
	4020N-040NB	0.158	4.0		0.016	0.130	0.787	0.169	0.114		●	○		
	5020N-020NB	0.197	5.0		0.008	0.165	0.787	0.169	0.114				○	G20 ~ G24
	5020N-040NB	0.197	5.0		0.016	0.165	0.787	0.169	0.114		○	○		
	6020N-020NB	0.236	6.0		0.008	0.205	0.787	0.169	0.114				○	
	6020N-040NB	0.236	6.0		0.016	0.205	0.787	0.169	0.114		○	○		

NEW
CBN
PCD
1-Edge

Recommended Cutting Conditions ➔ G27~G28

KGD • KGM Combinations

● **Insert Setting Angle of KGD / KGM Toolholders**

KGD...0°	Conventional Tools KGM...5°
0°	5°

New Insert GDM → New Holder KGD
Conventional Insert GMM → Conventional Holder KGM

Installing conventional inserts into the new toolholder is not recommended.

Toolholder Identification System

K G D | **R** | **1616** | **JX** - **3** | **D38** (Integral Type for Automatic Lathe)

Toolholder Hand	Shank Size	Toolholder Length	Applicable Inserts	Cutting Dia.
R : Right-hand **L** : Left-hand	**16**×**16**mm	**120mm**	GDM/GDMS **3~4**mm	ØDmax **38**mm

K G D | **R** | **1616** | **H** - **2** **T** | **06** (Integral Type)

Toolholder Hand	Shank Size	Toolholder Length	Applicable Inserts	Max. Depth of Cut
R : Right-hand **L** : Left-hand	**16**×**16**mm	**100mm**	GDM/GDMS **2~3mm**	**06** : 06mm

K G D
K G D S | **R** | **2020** | **X** - **3** **T** | **10** **S** (Separate Type / Unit Description)

Toolholder Hand	Shank Size	Toolholder Type	Applicable Inserts	Max. Depth of Cut
R : Right-hand **L** : Left-hand	**20**×**20**mm	Unit Description	GDM/GDMS **3~4**mm	**10** : 10mm

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Inserts are sold in 10 piece boxes.

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