для заказа - kyocera@kyocera-tools.ru

GMM / GMGA / FGG

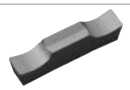
Classification of Usage
- ● : Light Interruption / 1st Choice
- ◔ : Light Interruption / 2nd Choice
- ● : Continuous / 1st Choice
- ○ : Continuous / 2nd Choice

		Cermet	CVD Coated Carbide	PVD Coated Carbide		Carbide	Ref. Page for Toolholder
		TN90	CR9025	PR915	PR930	KW10	
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)						

Insert (Right-handed Insert Shown)	Part Number	Previous Part Number	W inch	W mm	rε	M	L	H	Cermet TN90	CVD Coated Carbide CR9025	PVD Coated Carbide PR915	PVD Coated Carbide PR930	Carbide KW10	Ref. Page for Toolholder
 Sharp-Cutting Oriented / Precision Class / Full-R / Copying	GMGA 6020-300R	GMGA 6020-30R	0.236	6.0	0.118	0.169	0.787	0.169					○	G36 G37
 Sharp Cutting Oriented / Precision Class / Full-R / Copying	GMGA 8030-400R	GMGA 8030-40R	0.315	8.0	0.157	0.236	1.181	0.217					○	G36 G68
 Chip Control Oriented / M Class	GMM 3014-04	-	0.118	3.0	0.016	0.091	0.551	0.169	○	○	●	○	○	
 Chip Control Oriented / M Class Full-R / Copying	GMM 3014-15R	-	0.118	3.0	0.059	0.091	0.551	0.169	○	○		○	○	G38
 Undercutting Chip Control Oriented	GMM 3014-15RU	-	0.118	3.0	0.059	0.091	0.551	0.169				○		
 Face Grooving Chip Control Oriented Precision Class	FGG[R] 3020-02	-	0.118	3.0	0.008	0.091	0.787	0.169	○	○		○	○	G38
	4020-04		0.158	4.0	0.016	0.130				○		○	○	
	5020-04		0.197	5.0	0.016	0.165				○		○	○	

Recommended Cutting Conditions G129

Chipbreakers

Series	Insert	Features
GMM...MW		Excellent chip evacuation during grooving, traversing, and cut-off.
GMG...MG		Low cutting forces with ground chipbreaker.
GMG...MS GMM...MS		Grooving, traversing and cut-off operations have minimum cutting forces with positive edge
GMM...MT		Small corner-R(rε) minimizes the core which remains in the center of the face.
GMM...TK		Large corner-R(rε) with stable performance during cut-off.
GMM...NB		Flat rake face without chipbreaker. Good performance for brass.

Edge Preparation

Edge Preparation	Chamfered + Honed Cutting Edge Corner-R(rε) = 0.05	Chamfered + Honed Cutting Edge Sharp Corner
		
MT-Chipbreaker	CR9025 / PR915	PR930 / KW10
Edge Preparation	Chamfered + Honed Cutting Edge Corner-R(rε) = 0.20~0.30	Sharp Edge Corner-R(rε) = 0.20~0.30
		
TK-Chipbreaker	CR9025 / PR915	PR930 / KW10
Edge Preparation	Honed Cutting Edge Corner-R(rε) = 0.05	Sharp Edge Sharp Corner
		
Without Chipbreaker (-NB)	CR9025	PR930 / KW10

• Sharp Edge Spec. can reduce cutting resistance 40% less than that of chamfer edge

Inserts are sold in 10 piece boxes.

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www.kyocera-tools.ru

● : U.S. Stock Standard
○ : World Express (Shipping: 7-10 Business Days)