для заказа - kyocera@kyocera-tools.ru

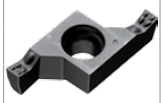
Applicable Inserts

(in)

Part Number	A	L	H	Ød
GER...-CM	0.228	0.452	0.159	0.110
GER...-DM	0.268	0.647	0.199	0.134
GER...-EM	0.376	0.853	0.219	0.173

		Cermet	MEGACOAT	PVD Coated Carbide	Carbide	
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

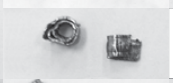
Insert (Right-handed Insert Shown)	Part Number	Unit	Dimensions (in) W inch	W mm	B	C	rε	TN6020	PR1225	PR1025	GW15	KW10	Applicable Toolholders	Ref. Page for Toolholder
 GER100-010CM~250-020M	GER 150-010CM	inch	0.059	1.50	0.098	0.106	0.004		●	●			SIGER...C-EH SIGER...C-WH SIGER...C-WH-90	G55 G56 G57
	200-010CM		0.079	2.00	0.098	0.106	0.004		●	●				
	250-020CM		0.098	2.50	0.098	0.106	0.008		●	●				
	300-020CM		0.118	3.00	0.098	0.106	0.008		●	●				
	350-020CM		0.138	3.50	0.098	0.106	0.008		●	●				
GER150-010DM~200-010DM GER150-010EM~200-010EM	GER 150-010DM		0.059	1.50	0.118	0.189	0.004		●	●			SIGER...D-EH	
	200-010DM		0.079	2.00	0.126	0.189	0.004		●	●				
	230-020DM		0.091	2.30	0.126	0.189	0.008		●	●				
	250-020DM		0.098	2.50	0.126	0.189			●	●				
	300-020DM		0.118	3.00	0.177	0.189	0.008		●	●				
	350-020DM		0.138	3.50	0.177	0.189			●	●				
	400-020DM		0.157	4.00	0.177	0.189			●	●				
 GER230-020DM~250-020DM GER250-020EM~400-020EM	GER 150-010EM		0.059	1.50	0.118	0.268	0.004		●	●			SIGER...E-EH	G55
	200-010EM		0.079	2.00	0.126	0.268	0.004		●	●				
	250-020EM		0.098	2.50	0.177	0.268	0.008		●	●				
	300-020EM		0.118	3.00	0.177	0.268			●	●				
	350-020EM		0.138	3.50	0.217	0.268	0.008		●	●				
	400-020EM		0.157	4.00	0.217	0.268			○	●				
 GER300-020CM~350-020CM GER300-020DM~400-020DM GER450-020EM~500-020EM	450-020EM		0.177	4.50	0.256	0.268	0.008		●	●				
	500-020EM		0.197	5.00	0.256	0.268			●	●				

2-Edge Molded Chipbreaker

• Dimension B shows available grooving depth.

Recommended Cutting Conditions G58

Chip Evacuation Comparison (Molded Chipbreaker)

Toolholder \ f (ipr)	SCM415 (Min. Bore Dia.) 0.0020"	0.0028"	0.0039"	Evaluation
SIGER1612C-EH GER300-020CM (PR1025)				Good Chip Control
Competitor A (Width 0.1181")			Insert Cracks	Unstable Chip Control and Biting
Competitor B (Width 0.1181")				Unstable Chip Control and Biting

(Vc = 330 sfm, D.O.C. = 0.079", Wet) (Internal Evaluation)

Chip Evacuation Comparison

(Min. Cutting Dia. Ø0.3150")

Toolholder \ f (ipr)	SCM415 0.0008"	Evaluation
SIGER0808A-EH GER200-010A (PR1025)		Good Chip Control
Competitor C (Width 0.079")		Unstable Chip Control and Biting

(Vc = 175 sfm, D.O.C. = 0.049", Wet) (Internal Evaluation)

Inserts are sold in 10 piece boxes.

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

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