

GMM / GMGA / FGG

Insert R-hand shown		Description	(Previous Description)	Dimension (mm)					Camel TN90	CVD Coated Carbide CR9025	PVD Coated Carbide PR915	PVD Coated Carbide PR930	Carbide KW10	Ref. Page for Toolholder	
				W	rε	M	L	H							
				Classification of usage											
				P	Carbon Steel / Alloy Steel								☺	☺	
				M	Stainless Steel								●	☺	
				K	Cast Iron									●	
				N	Non-ferrous Metals									●	
				S	Titanium Alloy									●	
				H	Hard materials (under 40HRC)								○	●	
					Hard materials (over 40HRC)										
				● : Continuous-Light Interruption / 1st Choice ☺ : Continuous-Light Interruption / 2nd Choice ● : Continuous / 1st Choice ○ : Continuous / 2nd Choice											
GMGA 6020-300R		GMGA 6020-30R	6.0	3.0	4.3	20	4.3						●	G23	
GMGA 8030-400R		GMGA 8030-40R	8.0	4.0	6.0	30	5.5						●		
GMM 3014-04		-	3.0	0.4	2.3	14	4.3	●	●	●	●	●		G24	
GMM 3014-15R		-	3.0	1.5	2.3	14	4.3	●	●			●	●		
GMM 3014-15RU		-	3.0	1.5	2.3	14	4.3		●			●	●		
FGG ^{R/L} 3020-02 4020-04 5020-04		-	3.0 4.0 5.0	0.2 0.4 0.4	2.3 3.3 4.2	20	4.3	● ● ●	● ● ●			● ● ●	● ● ●	G24	

For recommended cutting conditions, see page [G76~G77](#)

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Grooving

Multi-Function Tool CERACUT Plunge & Turn Chipbreakers

Series	Shape	Features
GMM-MW		Excellent chip evacuation at Grooving, Traversing, Cut-Off.
GMG-MG		Low cutting force with ground chipbreaker.
GMG-MS GMM-MS		Grooving / Traversing / Cut-Off operations are minimum cutting force at Positive Edge.
GMM-MT		Small corner-R(r _ε) and minimize the core which remains in the center of the face.
GMM-TK		Large corner-R(r _ε) and stable performance at cut off.
GMM-NB		Flat rake face and non-chipbreaker. It works well for brass.

◆ Edge Preparation

Edge Preparation	Chamfer + R-honed Corner-R(r _ε) = 0.05	Chamfer + R-honed Sharp Corner
		
MT Chipbreaker.	CR9025 / PR915	PR930 / KW10
Edge Preparation	Chamfer + R-honed Corner-R(r _ε) = 0.2-0.3	Sharp Edge Corner-R(r _ε) = 0.2-0.3
		
TK Chipbreaker	CR9025 / PR915	PR930 / KW10
Edge Preparation	R Honing Corner-R(r _ε) = 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.

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)

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www.kyocera-tools.ruInserts are sold
in 10 piece boxes.

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