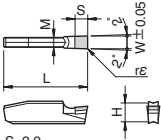


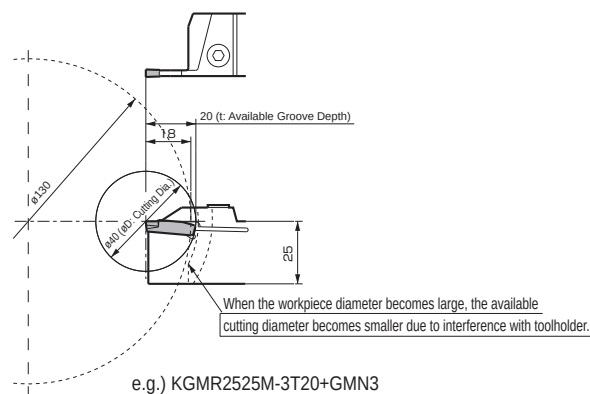
GMN

 GMN		Classification of usage		P	Carbon Steel / Alloy Steel							Ref. Page for Toolholder		
				M	Stainless Steel									
		● : Continuous-Light Interruption / 1st Choice ⚡ : Continuous-Light Interruption / 2nd Choice ● : Continuous / 1st Choice ○ : Continuous / 2nd Choice		K	Cast Iron									
				N	Non-ferrous Metals					●				
				S	Titanium Alloy					●				
				H	Hard materials (under 40HRC)									
					Hard materials (over 40HRC)			○	●					
Insert		Description	Dimension (mm)					Angle (°)	CBN			PCD		
			W	rε	M	L	H	θ	KBN10B	KBN510	KBN525	KPD001	KPD010	
 Deep Grooving 1-Edge	 S=2.9	GMN 2	2.0	0.2 0.4	1.8	20	4.3	-	●	●	●	●	●	G22 G23 G24
		3	3.0	0.2 0.4	2.3							●	●	
		4	4.0	0.2 0.4	3.3							●	●	
		5	5.0	0.2 0.4	4.2							●	●	
		6	6.0	0.2 0.4	5.2								●	

For recommended cutting conditions, see page **G74**

**Available cutting diameter of KGM
(For automatic lathe) / KGM-T type**

- There is a limit to available grooving depth depending on the workpiece diameter.



◆ KGM Available Cutting Diameter Table

Toolholder		ØD (Cutting Dia.)																				
KGM [®] /L	0810K-1.5-125	-	-	-	-	-	-	-	-	-	-	-	10	14	16	32	∞					
	1010K-1.5-125	-	-	-	-	-	-	-	20	25	32	40	60	∞	∞	∞		∞				
	1212F-1.5-85	-	-	-	-	25	26	28	32	36	40	60	100									
	1212M-1.5-150	-	-	-	-	25	26	28	32	36	40	60	100	∞	∞	∞		∞				
	0810K-2-125	-	-	-	-	-	-	-	-	-	-	-	-									
	1010K-2-125	-	-	-	-	-	-	-	20	25	32	40	60									
	1212F-2-85	-	-	-	-	25	26	28	50	∞	∞	∞	∞									
	1212M-2-150	-	-	-	-	25	26	28	50													
	1616M-2-150	32	40	50	60	80	100	∞	∞	∞	∞	∞	∞									
	1010K-2.5-125	-	-	-	-	-	-	-	20										25	32	40	60
	1212F-2.5-85	-	-	-	-	25	26	28	32										36	40	60	100
	1212M-2.5-150	-	-	-	-	25	26	28	32										36	40	60	100
	1616M-2.5-150	32	40	50	60	80	100	∞	∞										∞	∞	∞	∞
	1616M-3-150	32	40	50	60	80	100															
Available Grooving Depth t (mm)		16	15	14	13	12.5	12	11	10	9	8	7	6	5	4	3	2					

◆ **KGM-T Available Cutting Diameter Table** (GMN, GM% When using 1-edge insert)

Toolholder		øD (Cutting Dia.)												
KGM ^{R/L}	2012K-2T17													
	2020K-2T17	-	-	-	-	-	-	-	-	66	80	130	260	
	2525M-2T17													
	1616H-3T20	-	-	-	-	-	40	54	70	100	180			
	2012K-3T20													
	2020K-3T20													
	2525M-3T20	-	-	-	-	-	40	90	130	240				
	2020K-4T20													
	2525M-4T20													
	2525M-4T25	-	-	50	140	240								
	2525M-5T25						∞	∞	∞	∞				
	3232P-5T25	-	-	50	280	600								
2525M-6T30	100	300	∞	∞	∞									
Available Grooving Depth t (mm)		30	27	25	23	22	20	19	18	17	16	15	14	Under 13

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

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CBN & PCD Inserts are sold in 1 piece boxes.