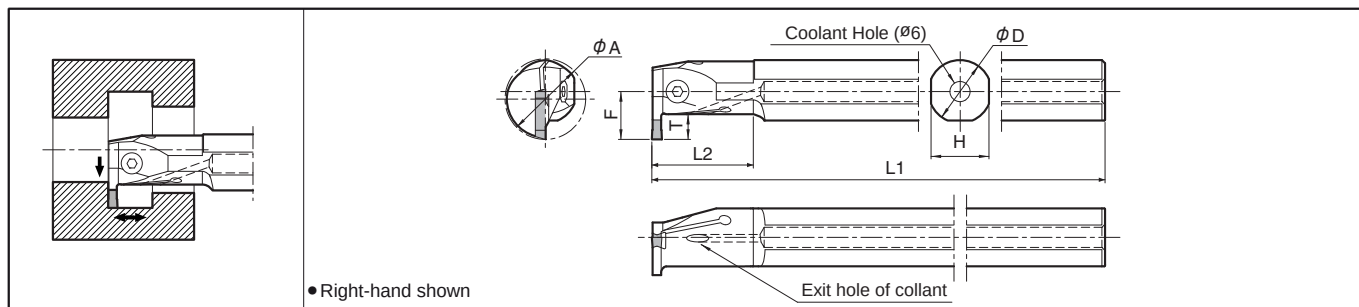


## Internal Grooving Toolholders

## KIGM-V



## ● Toolholder Dimensions

| Description         |          | Std. |   | Min.<br>Cutting Dia. | Dimension (mm) |    |     |    |      |      |  |  | Width<br>(mm) |      | Spare Parts |                                                                                   |                                                                                   |                                                                                   |                                                                                   |
|---------------------|----------|------|---|----------------------|----------------|----|-----|----|------|------|--|--|---------------|------|-------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|
|                     |          |      |   |                      |                |    |     |    |      |      |  |  |               |      | Screw       |                                                                                   | Wrench                                                                            |                                                                                   |                                                                                   |
|                     |          | R    | L | ØA                   | ØD             | H  | L1  | L2 | F    | T    |  |  |               | MIN. | MAX.        |  |  |  |  |
| KIGM <sup>R/L</sup> | 2016B-3V | ●    | ● | 20                   | 16             | 15 | 150 | 25 | 11.5 | 5.5  |  |  |               |      |             |                                                                                   |                                                                                   |                                                                                   |                                                                                   |
|                     | 2520B-3V | ●    | ● | 25                   | 20             | 18 | 180 | 32 | 14.5 | 6.0  |  |  |               | 3.0  | 3.0         | GS-50                                                                             | -                                                                                 | LW-3                                                                              | -                                                                                 |
|                     | 3225B-3V | ●    | ● | 32                   | 25             | 23 | 200 | 40 | 19   | 8.0  |  |  |               |      |             | -                                                                                 | SB-5TR                                                                            | -                                                                                 | LTW-20                                                                            |
|                     | 3225B-4V | ●    | ● | 32                   | 25             | 23 | 200 | 40 | 19   | 8.5  |  |  |               |      |             |                                                                                   |                                                                                   |                                                                                   |                                                                                   |
|                     | 4032B-4V | ●    | ● | 40                   | 32             | 29 | 220 | 50 | 23.5 | 11.0 |  |  |               | 4.0  | 5.0         | -                                                                                 | SB-5TR                                                                            | -                                                                                 | LTW-20                                                                            |

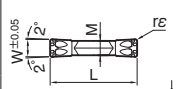
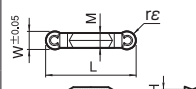
• Dimension T shows available grooving depth.

### Applicable Inserts (mm)

| Description                                                                                   | L    | H   |
|-----------------------------------------------------------------------------------------------|------|-----|
| GMM3015...V  | 15.5 | 4.3 |
| GMM4020...V  | 20   |     |
| GMM5020...V  |      |     |

|   |                              |  |  |   |   |    |                         |
|---|------------------------------|--|--|---|---|----|-------------------------|
| P | Carbon Steel / Alloy Steel   |  |  | ☺ | ☹ |    | Classification of usage |
| 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

| Insert                                                                                                                                      |                                                                                     | Description    | (Previous Description) | Dimension (mm) |                |     | Cermet | CVD Coated Carbide | PVD Coated Carbide |       |       | Carbide | Applicable Toolholder                                 |
|---------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|----------------|------------------------|----------------|----------------|-----|--------|--------------------|--------------------|-------|-------|---------|-------------------------------------------------------|
|                                                                                                                                             |                                                                                     |                |                        | W              | t <sub>R</sub> | M   | TN90   | CR9025             | PR915              | PR930 | PR905 | KW10    |                                                       |
| <br>Chip Control Oriented<br>M Class                     |  | GMM 3015-040V  | GMM 3015-04V           | 3.0            | 0.4            | 2.3 | ●      | ●                  | ●                  | ●     | ●     | ●       | KIGM <sup>®</sup> /L 2016B-3V<br>2520B-3V<br>3225B-3V |
|                                                                                                                                             |                                                                                     | 4020-040V      | 4020-04V               | 4.0            | 0.4            | 3.3 | ●      | ●                  | ●                  | ●     | ●     | ●       | KIGM <sup>®</sup> /L 3225B-4V<br>4032B-4V             |
|                                                                                                                                             |                                                                                     | 5020-080V      | 5020-08V               | 5.0            | 0.8            | 4.2 | ●      | ●                  | ●                  | ●     | ●     | ●       |                                                       |
| <br>Chip Control Oriented<br>M Class<br>Full-R / Copving |  | GMM 3015-150VR | GMM 3015-15VR          | 3.0            | 1.5            | 2.3 | ●      | ●                  |                    | ●     | ●     | ●       | KIGM <sup>®</sup> /L 2016B-3V<br>2520B-3V<br>3225B-3V |
|                                                                                                                                             |                                                                                     | 4020-200VR     | 4020-20VR              | 4.0            | 2.0            | 3.3 |        | ●                  |                    | ●     | ●     | ●       | KIGM <sup>®</sup> /L 3225B-4V<br>4032B-4V             |
|                                                                                                                                             |                                                                                     | 5020-250VR     | 5020-25VR              | 5.0            | 2.5            | 4.2 |        | ●                  |                    | ●     | ●     | ●       |                                                       |

\* It is not recommended to use this for KIGM-V Internal Grooving Toolholders against GMM...V / GMM...VR whose front relief angle is 18°, because the relief angle of the insert used for GMM4020-04 toolholder is 10°.

For recommended cutting conditions, see page  **G76**