
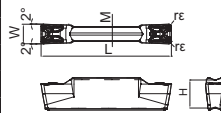
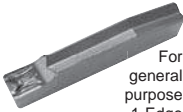
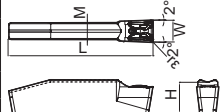

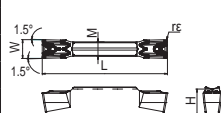

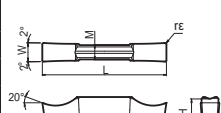

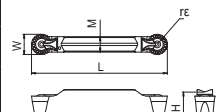

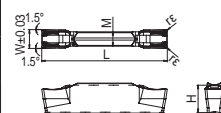

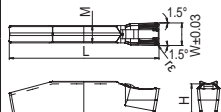


Inserts for Grooving and Cut-off

GDM / GDMS / GDG



| | | | | | | |
|--|---|----------------------------|---|---|---|---|
| Classification of usage | P | Carbon steel / Alloy steel | ● | ● | ☉ | |
| | 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 (~ 40HRC) | | | | |
| | | Hard Materials (40HRC ~) | | | | |

| Shape | Description | Dimension (mm) | | | | | Angle (°) | Cermet | MEGACOAT | Carbide | Ref. Page for Toolholder | | | | | | | | | |
|---|---|----------------|--|---|-------|---------------|-----------|--------|----------|---------|--------------------------|-----|------|--------|--------|------|---|---|---|--|
| | | W | rε | M | L | H | | | | | | θ | TN90 | PR1225 | PR1215 | GW15 | | | | |
| | | | | | | | tolerance | | | | | | | | | | | | | |
|  <p>For general purpose 2-Edge</p> |  | GDM | 2420N-020GM | 2.4 | | 0.2 | 1.95 | 20 | 4.3 | - | ● | ● | ● | | | | | | | |
| | | | 3020N-020GM | 3.0 | | 0.2 | 2.3 | | | | ● | ● | ● | | | | | | | |
| | | | 3020N-040GM | 3.0 | ±0.03 | 0.4 | | | | | ● | ● | ● | | | | | | | |
| | | | 4020N-020GM | 4.0 | | 0.2 | | | | | ● | ● | ● | | | | | | | |
| | | | 4020N-040GM | 4.0 | | 0.4 | 3.3 | | | | ● | ● | ● | | | | | | | |
| | | | 4020N-080GM | 4.0 | | 0.8 | | | | | ● | ● | ● | | | | | | | |
| | | | 5020N-040GM | 5.0 | ±0.04 | 0.4 | 4.2 | | | | ● | ● | ● | | | | | | | |
| | | | 5020N-080GM | 5.0 | | 0.8 | | | | | ● | ● | ● | | | | | | | |
| | | | 6020N-040GM | 6.0 | | 0.4 | 5.2 | | | | ● | ● | ● | | | | | | | |
| | | | 6020N-080GM | 6.0 | | 0.8 | | | | | ● | ● | ● | | | | | | | |
|  <p>For general purpose 1-Edge</p> |  | GDMS | 2220N-020GM | 2.2 | | 0.2 | 1.75 | 20 | 4.3 | - | ● | ● | ● | | | | | | | |
| | | | 3020N-040GM | 3.0 | ±0.03 | 0.4 | 2.3 | | | | ● | ● | ● | | | | | | | |
| | | | 4020N-040GM | 4.0 | | 0.4 | 3.3 | | | | ● | ● | ● | | | | | | | |
| | | | 5020N-080GM | 5.0 | ±0.04 | 0.8 | 4.2 | | | | ● | ● | ● | | | | | | | |
| | | | 6020N-080GM | 6.0 | | 0.8 | 5.2 | | | | ● | ● | ● | | | | | | | |
| | | |  <p>Low Feed 2-Edge</p> |  | GDM | 2420N-020GL | 2.4 | | | | | 0.2 | 1.95 | 20 | 4.3 | - | ● | ● | ● | |
| | | | | | | 3020N-020GL | 3.0 | | | | ±0.03 | 0.2 | 2.3 | | | | ● | ● | ● | |
| | | | | | | 3020N-040GL | 3.0 | | | | | 0.4 | | | | | ● | ● | ● | |
| | | | | | | 4020N-020GL | 4.0 | | | | | 0.2 | 3.3 | | | | ● | ● | ● | |
| | | | | | | 4020N-040GL | 4.0 | | | | | 0.4 | | | | | ● | ● | ● | |
| 6020N-040GL | 6.0 | ±0.04 | | | | 0.4 | 5.2 | ● | ● | ● | | | | | | | | | | |
|  <p>Low cutting force 2-Edge</p> |  | GDG | 2520N-020GS | 2.5 | | 0.2 | 2.0 | 20 | 4.3 | - | ● | ● | ● | ● | | | | | | |
| | | | 3020N-020GS | 3.0 | | 0.2 | 2.3 | | | | ● | ● | ● | ● | | | | | | |
| | | | 3520N-020GS | 3.5 | ±0.02 | 0.2 | 2.8 | | | | ● | ● | ● | ● | | | | | | |
| | | | 4020N-040GS | 4.0 | | 0.4 | 3.3 | | | | ● | ● | ● | ● | | | | | | |
| | | | 5020N-040GS | 5.0 | | 0.4 | 4.2 | | | | ● | ● | ● | ● | | | | | | |
| | | | 6020N-040GS | 6.0 | | 0.4 | 5.2 | | | | ● | ● | ● | ● | | | | | | |
| | | | 8030N-040GS | 8.0 | | 0.4 | 6.0 | | | | ● | ● | ● | ● | | | | | | |
| | | |  <p>Full-R / Copying 2-Edge</p> |  | GDM | 3020N-150R-CM | 3.0 | | | | ±0.03 | 1.5 | 2.3 | 20 | 4.3 | - | ● | ● | ● | |
| 4020N-200R-CM | 4.0 | | | | | 2.0 | 3.3 | ● | ● | ● | | | | | | | | | | |
| 5020N-250R-CM | 5.0 | ±0.04 | | | | 2.5 | 4.2 | ● | ● | ● | | | | | | | | | | |
| 6020N-300R-CM | 6.0 | | | | | 3.0 | 5.2 | ● | ● | ● | | | | | | | | | | |
|  <p>High feed rate 2-Edge</p> |  | GDM | 2020N-020PH | 2.0 | ±0.03 | 0.2 | 1.5 | 20 | 4.3 | - | ● | ● | ● | | | | | | | |
| | | | 3020N-030PH | 3.0 | | 0.3 | 2.3 | | | | ● | ● | ● | | | | | | | |
| | | | 4020N-030PH | 4.0 | | 0.3 | 3.3 | | | | ● | ● | ● | | | | | | | |
| | | |  <p>High feed rate 1-Edge</p> |  | GDMS | 2020N-020PH | 2.0 | | | | ±0.03 | 0.2 | 1.5 | 20 | - | ● | ● | ● | | |
| | | | | | | 3020N-030PH | 3.0 | | | | | 0.3 | 2.3 | | | ● | ● | ● | | |
| | | | | | | 4020N-030PH | 4.0 | | | | | 0.3 | 3.3 | | | ● | ● | ● | | |


Recommended Cutting Conditions ● G29

◆ Note for the holder and insert combination of KGD type (new) and KGM type (conventional)

● Insert setting angle for grooving toolholders

| KGD...0° | Conventional tools KGM...5° |
|---|---|
|  |  |


New Insert
GDM



↓

New Toolholder
KGD

Conventional Insert
GMM



↓

Conventional Toolholder
KGM

Installing conventional inserts to the new toolholder is not recommended.

● : Std. Item