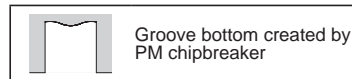


## GDM / GDMS

Classification of usage ● : Continuous-Light Interruption / 1st Choice ◐ : Continuous-Light Interruption / 2nd Choice ● : Continuous / 1st Choice ○ : Continuous / 2nd Choice	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 ~ )					

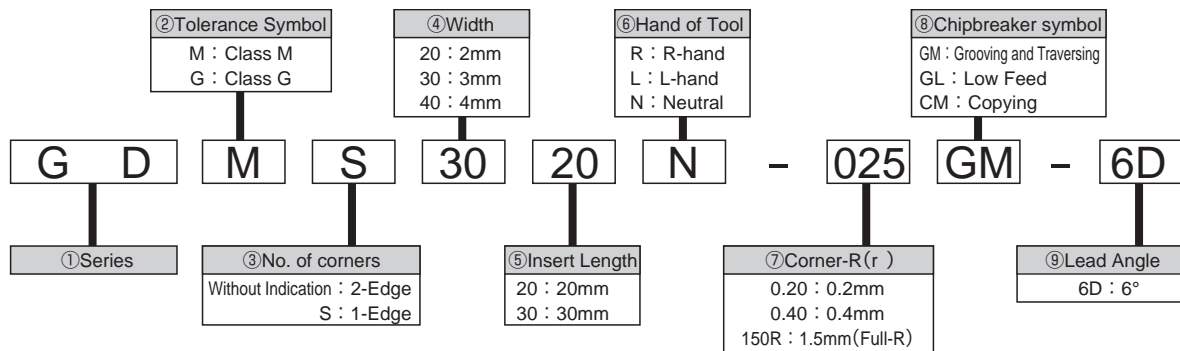
Shape	Description	Dimension (mm)					Angle (°)	Cermet	MEGACOAT	Carbide	Ref. Page for Toolholder				
		W	rε	M	L	H						TN90	PR1225	PR1215	GW15
Handed insert shows R-hand. 2-Edge 	GDM 2020N-020PM	2.0	±0.03	0.2	1.5	20	-		●	●	G26 G27 G28				
	2520N-020PM	2.5		0.2	1.95				●	●					
	3020N-025PM	3.0		0.25	2.3				●	●					
	4020N-030PM	4.0		0.3	3.3				●	●					
2-Edge 	GDM 2020R-020PM-6D	2.0	±0.03	0.2	1.5	20	6°		●	●					
	2520R-020PM-6D	2.5		0.2	1.95				●	●					
	3020R-025PM-6D	3.0		0.25	2.3				●	●					
1-Edge 	GDMS 2020N-020PM	2.0	±0.03	0.2	1.5	20	-		●	●					
	3020N-025PM	3.0		0.25	2.3				●	●					
	4020N-030PM	4.0		0.3	3.3				●	●					
1-Edge 	GDMS 2020R-020PM-6D	2.0	±0.03	0.2	1.5	20	6°		●	●					
	3020R-025PM-6D	3.0		0.25	2.3				●	●					
	4020R-030PM-6D	4.0		0.3	3.3				●	●					

Note 1. Using the PM chipbreaker (for cut-off) for grooving cannot create a flat bottom (See the right figure).



Recommended Cutting Conditions ● G29

### ◆ Indication of Description



## Setting the inserts

1. Use compressed air or other measures to remove chips from the insert mounting part see (Fig. 1).
2. Put the insert into the holder and push it until it makes contact with the back end of the holder's surface (see Fig. 2 and 3).
3. Keeping the insert fit to the surface, tighten the insert clamp bolt at an appropriate torque.
4. Make sure that there is no gap between the insert and the back end of the holder's surface and that the insert is set straight.

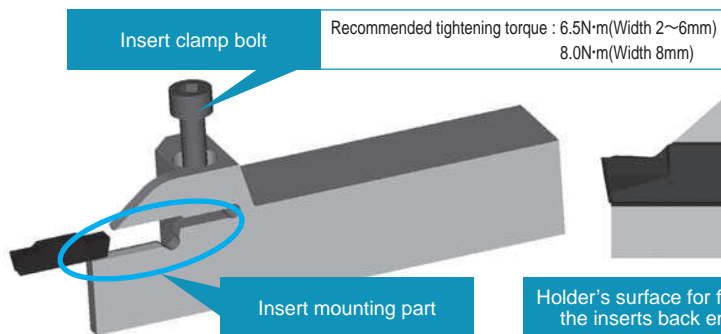


Fig. 1

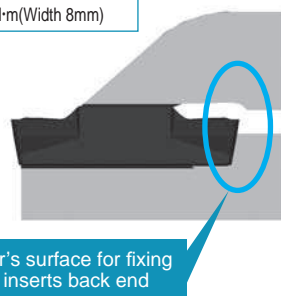


Fig. 2

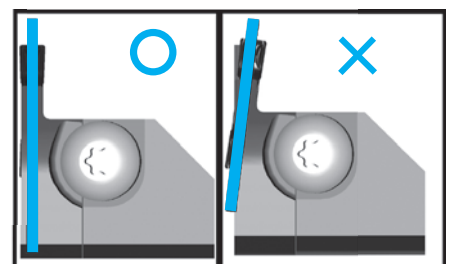


Fig. 3

● : Std. Item