

Inserts: Single Edge

Applicable inserts

For general parting off and grooving

Cat. No.	Grades					Dimensions (in)			
	Coated			Cermet		w	L	h	r _E
	T9125	GH730	AH120	NS9530	NS530				
GE20	●	●	●	●	■	.078		.137	.008
GE30	●	●	●	●	■	.118	.393	.137	
GE40	●	●	●	●	■	.157		.157	
GE50	●	○	●	●	■	.196	.472	.177	

For traversing

Cat. No.	Grades					Dimensions (in)			
	Coated			Cermet		w	L	h	r _E
	T9125	GH730	AH120	NS9530					
GT30	●	○	●	●		.118	.393	.137	.016
GT40	○	○	●	●		.157	.393	.157	
GT50	●	○	●	●		.196	.472	.177	

For parting off (with hand)

Right hand (R) shown.

Cat. No.	Grades					Dimensions (in)			
	Coated					w	L	h	r _E
	GH730	AH120							
GE30R/L	○	○	●	●		.118	.393	.137	.008
GE40R/L	○	○	●	●		.157	.393	.157	
GE50R/L			●	●		.196	.471	.177	

For profiling

Cat. No.	Grades					Dimensions (in)			
	Coated			Cermet		w	L	h	r _E
	T9125	GH730	AH120	NS9530					
GR30		○	●	○		.118	.393	.137	.059
GR40	●	○	●	○		.157	.393	.157	.078
GR50	●	○	●	○		.196	.472	.177	.098

For aluminum and non-ferrous metals

Cat. No.	Grades		Dimensions (in)			
	Uncoated		w	L	h	r _E
	KS05F					
GE20-AL	●		.078	.393	.137	.016
GE30-AL	●		.118		.157	
GE40-AL	●		.157	.472	.177	

Parts

(Mono block type)

Cat. No.	Clamping screw	Wrench
CGSSR/L□□□□-□□		
CGSSR/L□□□□-□□-D	CHHM5-18	P-4

Note: Apply to GR/GL cartridges.

Standard cutting conditions

Work materials	Recommended grade	Cutting speed v _c (SFM)	Operation	Feed: f (in/rev)			
				Groove width: W (in)			
				2	3	4	5
Low carbon steels Alloy steels (~ 150HB)	T9125	260 ~ 650	Grooving (GE□□)	.002 ~ .008	.002 ~ .009	.002 ~ .010	.002 ~ .012
	AH120	260 ~ 550					
	NS9530	330 ~ 650					
Medium carbon steels Alloy steels (150 ~ 250HB)	GH730	160 ~ 590	Parting off (GE□□R/L)	.001 ~ .003	.001 ~ .006	.001 ~ .006	.001 ~ .006
	T9125	260 ~ 590					
	AH120	260 ~ 500					
High carbon steels Alloy steels (250HB ~)	NS9530	260 ~ 590	Traversing (GT□□)	-	ap = .008 ~ .060 f = .002 ~ .006	ap = .020 ~ .078 f = .002 ~ .009	ap = .020 ~ .098 f = .002 ~ .010
	GH730	160 ~ 500					
	T9125	260 ~ 500					
Stainless steels	AH120	260 ~ 400	Profiling (GR□□)	-	ap = .050 ~ .055 f = .002 ~ .009	ap = .008 ~ .060 f = .002 ~ .010	ap = .020 ~ .062 f = .002 ~ .012
	NS9530	260 ~ 500					
	GH730	160 ~ 400					
Grey and ductile cast irons	AH120	260 ~ 500	Grooving for Aluminum alloys (GE□□-AL)	.001 ~ .003	.001 ~ .003	.001 ~ .003	-
	GH730	160 ~ 400					
Aluminum alloys, Non-ferrous metals	KS05F	200 ~ 300					

● : Stocked items
○ : Stocked in Japan
■ : Discontinued