

Applicable inserts

For face grooving

Cat. No.	Grades			Dimensions (in)			
	Coated		Cermet	w	L	h	r _E
	GH730	AH120	NS9530				
GF30	○	●	○	.118	.394	.138	.008
GF40	○	●	○	.157	.472	.157	
GF50	○	●	○	.196	.472	.177	

For face traversing

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

For face profiling (Full radius)

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

For face grooving of alloys aluminum and non-ferrous metals

Cat. No.	Grades		Dimensions (in)			
	Uncoated		w	L	h	r _E
	KS05F					
GE20-AL	●	○	.078	.393	.137	.008
GE30-AL	●	○	.118	.472	.157	
GE40-AL	●	○	.157	.472	.177	

Parts

(Blade type)

Cat. No.	Clamping screw	Blade fixing screw	Wrench
CGWSR/L□□□□-□□WGR/L			
CGWSR/L□□□□-□□WGR/L-L	CHHM5-18	CSHB-6	P-4

Standard cutting conditions

Work materials	Recommended grade	Cutting speed v _c (SFM)
Low carbon steels Alloy steels (~ 150HB)	T9125	260 ~ 650
	NS9530	330 ~ 650
	AH120	260 ~ 550
Medium carbon steels Alloy steels (150 ~ 250HB)	GH730	160 ~ 590
	T9125	260 ~ 590
	AH120	260 ~ 500
High carbon steels Alloy steels (250HB ~)	NS9530	260 ~ 590
	GH730	160 ~ 500
	T9125	260 ~ 500
Stainless steels	AH120	260 ~ 400
	NS9530	260 ~ 500
	GH730	160 ~ 400
Grey and ductile cast irons	AH120	260 ~ 500
	GH730	160 ~ 400
Aluminum alloys, Non-ferrous metals	KS05F	260 ~ 650

Operation	Feed: f (in/rev)			
	Groove width: W (in)			
	.078	.118	.157	.196
Grooving (GE□□)	.002 ~ .008	.002 ~ .009	.002 ~ .010	.002 ~ .012
Parting off (GE□□R/L)	.001 ~ .003	.001 ~ .006	.001 ~ .006	.001 ~ .006
Traversing (GT□□)	-	ap = .008 ~ .060 f = .002 ~ .006	ap = .020 ~ .078 f = .002 ~ .009	ap = .020 ~ .098 f = .002 ~ .010
Profiling (GR□□)	-	ap = .020 ~ .055 f = .002 ~ .009	ap = .020 ~ .060 f = .002 ~ .010	ap = .020 ~ .062 f = .002 ~ .012
Grooving for Aluminum alloys (GE□□-AL)	.001 ~ .003	.001 ~ .003	.001 ~ .003	-

● : Stocked items
○ : Stocked in Japan