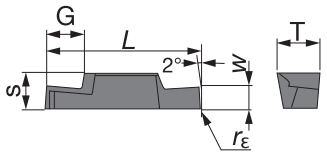
INSERT

GIR/L



Right hand (R) shown.

Designation	W±0.05 (mm)	rε (mm)	Cermet NS9530	Uncoated TH10	S (mm)	T (mm)	L (mm)	G (mm)
GIR5210-02	1	0.2	●	●	3.5	4.4	15	1.5
GIR5215-02	1.5	0.2	●	●	3.5	4.4	15	2.3
GIR5220-02	2	0.2	●	●	3.5	4.4	15	3
GIR5225-02	2.5	0.2	●	●	3.5	4.4	15	3
GIR5230-02	3	0.2	●	●	3.5	4.4	15	3
GIR6310-02	1	0.2	●	●	5.5	6.4	24	1.5
GIR6315-02	1.5	0.2	●	●	5.5	6.4	24	2.3
GIR6320-02	2	0.2	●	●	5.5	6.4	24	3
GIR6325-02	2.5	0.2	●	●	5.5	6.4	24	3.8
GIR6330-02	3	0.2	●	●	5.5	6.4	24	4.5
GIR6335-02	3.5	0.2	●	●	5.5	6.4	24	5.3
GIR6340-02	4.0	0.2	●	●	5.5	6.4	24	5.3
GIR6345-02	4.5	0.2	●	●	5.5	6.4	24	5.3
GIR6350-02	5	0.2	●	●	5.5	6.4	24	5.3

● : Line up

Note:
When using a right or left hand insert, the right hand insert is used with right hand toolholder and the left hand insert is used with left hand toolholder.

STANDARD CUTTING CONDITIONS (EXTERNAL & INTERNAL GROOVING)

ISO	Workpiece material	Grade	Cutting speed Vc (sfm)	Feed f (ipr)		
				W < 0.079"	W = 0.079" - 0.157"	W > 0.157"
P	Carbon steels	NS9530	260 - 500	0.002 - 0.004	0.003 - 0.006	0.003 - 0.008
K	Cast irons, Light alloys	TH10	200 - 500	0.002 - 0.004	0.003 - 0.006	0.003 - 0.008