

Face grooving <b>GX-R/LF</b>			Enlarged view										
Min. bore dia. $\phi D$ (mm)	Max. groove width (mm)	Max. groove depth (mm)	Cat. No.	Stock		Applicable inserts	Dimensions (mm)						
				R	L		$h_1$	$b$	$h$	$L_1$	$L_2$	$f$	$f_1$
55	4.5	6	GX-2020R/LF	○	○	XNL/R63□□	20	20	20	125	35	25	15
			GX-2525R/LF	○	○		25	25	25	150		32	

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

Note: Max. groove width and max. groove depth shown in the above table are the values when the insert with the largest cutting edge width is used.

### Inserts

XNR/L	Dimensions (mm)				Cat. No.	Grades					
	$W \pm 0.05$	Max. Groove depth	G	$r_\epsilon$		Cermet		Uncoated			
						NS9530		TH10		TX10S	
						R	L	R	L	R	L
1	1.5	1.8	0	XNR/L6310S							
			0.2	XNR/L6310-02	○	○	○	○	○		
1.5	2.3	2.5	0	XNR/L6315S							
			0.2	XNR/L6315-02	○	○	○	○	○		
2	3	3.2	0	XNR/L6320S							
			0.2	XNR/L6320-02	○	○	○	○	○	○	
2.5	3.8	3.9	0	XNR/L6325S							
			0.2	XNR/L6325-02	○	○	○	○	○	○	
3	4.5	4.6	0	XNR/L6330S							
			0.2	XNR/L6330-02	○	○	○	○	○	○	
3.5	5.3	5.4	0	XNR/L6335S							
			0.2	XNR/L6335-02	○	○	○	○	○	○	
4	6	6.1	0	XNR/L6340S							
			0.2	XNR/L6340-02	○	○	○	○	○	○	
4.5	6	6.1	0	XNR/L6345S							
			0.2	XNR/L6345-02	○	○	○	○	○	○	

### Parts

Cat. No.	Parts					
	① Shim	Clamp set	④ Clamping screw	⑤ Shim screw	Wrench	
GX-2020R/LF	SL-8R/L	CP81A	RT-1	BHM4-8	P-4	
GX-2525R/LF	SL-3R/L	(② Clamp CP81 ③ Pusher BP-3 Spring)				

### Standard cutting conditions

Work materials	Grades	Cutting speed $v_c$ (SFM)	Feed $f$ (in/rev)		
			$W \leq .078$	$W = .078 - .157$	$W \geq .157$
Carbon steels	NS9530	260 ~ 650	.001 ~ .004	.003 ~ .008	.003 ~ .010
	TX10S	200 ~ 500			
Cast irons, Light alloys	TH10	200 ~ 500	.001 ~ .004	.003 ~ .008	.003 ~ .010
Hardened steels	BX360	60 ~ 500	.001 ~ 0.15	.001 ~ 0.15	.001 ~ .006

○ : Stocked in Japan