

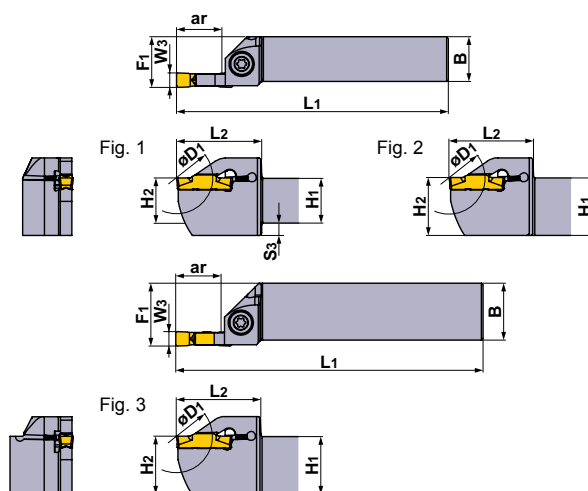
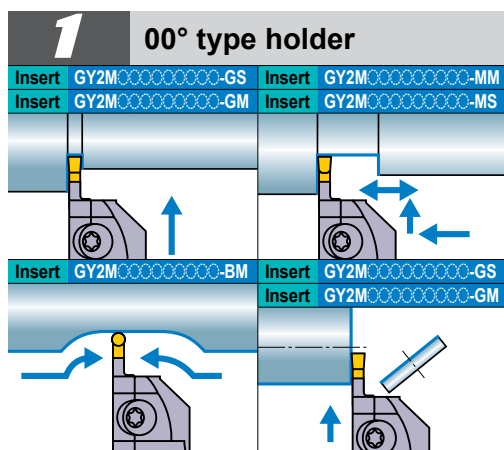
## Grooving System

# GY

## New 8mm mono block holder for wide grooves.



### Tool holder for 8mm insert width



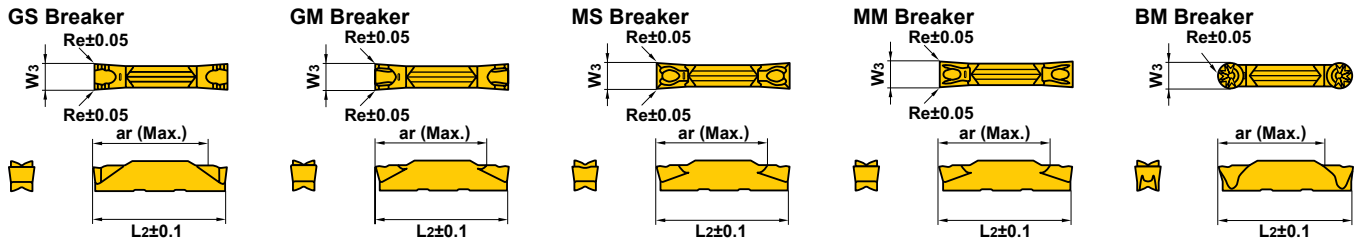
Right hand tool holder shown.

Seat Size	Insert Width W <sub>3</sub> (mm)	Hand (R/L)	Max. Groove Depth ar (mm)	Max. Cut off Diameter D <sub>1</sub> (mm)	ID	Order Number		Dimensions (mm)							Fig
						Holder	Stock	H <sub>1</sub>	B	L <sub>1</sub>	L <sub>2</sub>	H <sub>2</sub>	F <sub>1</sub>	S <sub>3</sub>	
K	8.00	R	25	50	(1G1R9K1)	<b>GYPR2525M00-K25</b>	●	25	25	150	47	25	28	7	1
			25	50	(1Q1R9K1)	<b>3225P00-K25</b>	●	32	25	170	47	32	28	-	2
			25	50	(1J1R9K1)	<b>3232P00-K25</b>	●	32	32	170	47	32	35	-	3
		L	25	50	(1G1L9K1)	<b>GYPL2525M00-K25</b>	●	25	25	150	47	25	28	7	1
			25	50	(1Q1L9K1)	<b>3225P00-K25</b>	●	32	25	170	47	32	28	-	2
			25	50	(1J1L9K1)	<b>3232P00-K25</b>	●	32	32	170	47	32	35	-	3

\* If BM breaker with geometries are used then L<sub>1</sub> and L<sub>2</sub> values will become 0.3mm longer.

●: Inventory maintained.

## Inserts

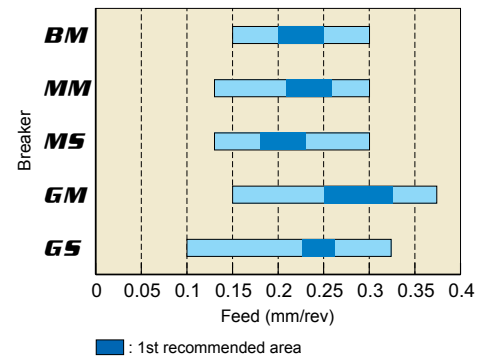


Applications	Order Number	Seat Size	Dimensions (mm)					Stock		
			W3		Re	ar (Max.)	L2	Coated		
			Grooving Width	Tolerance				VP10RT	VP20RT	MY5015
Grooving / Cutting off	<b>GY2M0800K030N-GS</b>	K	8.00	±0.04	0.3	29.1	30.5	●	●	●
	<b>0800K050N-GM</b>			±0.04	0.5	29.3	30.5	●	●	●
Multifunction	<b>GY2M0800K080N-MS</b>			±0.04	0.8	28.5	30.5	●	●	●
	<b>0800K080N-MM</b>			±0.04	0.8	28.5	30.5	●	●	●
Copying	<b>0800K120N-MM</b>			±0.04	1.2	28.1	30.5	●	●	●
	<b>GY2M0800K400N-BM</b>			±0.04	4.0	26.5	30.8	●	●	●

●: Inventory maintained. (10 inserts in one case)

## Recommended cutting conditions

For Grooving / Cutting off



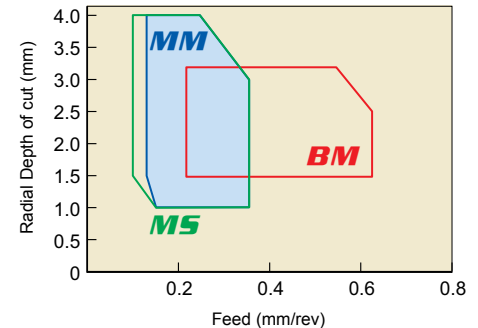
## Recommended Cutting Speed (m/min)

Work Material	Hardness	Grade	Cutting Speed (m/min)				
			50	100	150	200	250
P Mild Steel (S10C, SUM22L)	≤160HB	VP20RT	100 - 220				
		VP10RT	110 - 230				
Carbon Steel Alloy Steel (SUJ2, SCr, SCM)	160-280HB	VP20RT	80 - 180				
		VP10RT	90 - 190				
		MY5015	110 - 250				
	280HB≤	VP20RT	60 - 140				
		VP10RT	70 - 150				
		MY5015	90 - 210				
M Stainless Steel	≤270HB	VP20RT	60 - 140				
		VP10RT	70 - 150				
K Gray Cast Iron	≤300MPa	VP20RT	80 - 180				
		VP10RT	90 - 190				
		MY5015	140 - 300				
		VP20RT	60 - 140				
Ductile Cast Iron	≤800MPa	VP10RT	70 - 150				
		MY5015	90 - 210				
		VP20RT	30 - 60				
S Heat Resistant Alloy Titanium Alloy	-	VP10RT	40 - 70				

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.

(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

## For Turning



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**MMC HARTMETALL GmbH**  
Comeniusstr. 2, 40670 Meerbusch, Germany  
Tel. +49-2159-9189-0 Fax +49-2159-918966  
e-mail admin@mmchg.de

**MMC HARDMETAL U.K. LTD.**  
Mitsubishi House, Galena Close, Tamworth, Staffs. B77 4AS, U.K.  
Tel. +44-1827-312312 Fax +44-1827-312314  
e-mail sales@mitsubishicarbide.co.uk

**MMC METAL FRANCE s.a.r.l.**  
6, Rue Jacques Monod, 91400 Orsay, France  
Tel. +33-1-69 35 53 53 Fax +33-1-69 35 53 50  
e-mail mmfsales@mmc-metal-france.fr

**MITSUBISHI MATERIALS ESPAÑA, S.A.**  
Calle Emperador 2, 46136 Museros/Valencia, Spain  
Tel. +34-96-144-1711 Fax +34-96-144-3786  
e-mail mme@mmevalencia.com

**MMC ITALIA S.r.l.**  
V.le Delle Industrie 2, 20020 Arese (Milano), Italy  
Tel. +39-02 93 77 03 1 Fax +39-02 93 58 90 93  
e-mail info@mmc-italia.it

**MMC HARDMETAL POLAND SP. z o.o.**  
Al. Armii Krajowej 61, 50-541 Wrocław, Poland  
Tel. +48-71335-16-20 Fax +48-71335-16-21  
e-mail sales@mitsubishicarbide.com.pl

**MMC HARDMETAL RUSSIA OOO LTD.**  
UL. Bolschaja Semenovskaya, 11, bld 5, 107023 Moscow, Russia  
Tel. +7-495-72558-85 Fax +7-495-98139-73  
e-mail info@mmc-carbide.ru

