

D

D - GROOVING & PARTING OFF

D - 544 | General inserts overview

D - 546 | GROOVING PLUS

D - 546 | Inserts code key

D - 547 | GP Inserts

D - 550 | Blades & Toolholders code key



GROOVING & PARTING OFF



D - 556 | GROOVING & PARTING OFF

D - 556 | Inserts code key & overview

D - 558 | Inserts

D - 562 | Blades code key

D - 563 | Blades & Toolholders

D - 567 | Trigon Inserts

D - 570 | SAL (Swiss Automatic Lathes)

D - 574 | SAL Toolholders

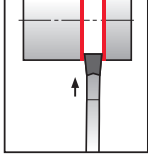
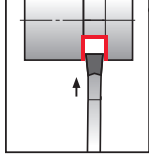
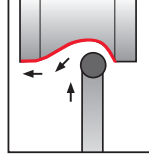

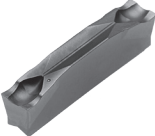







D - 575 | SAL Inserts

D - 580 | LIGHT GROOVING


D - 584 | Spare Parts

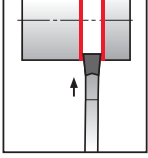
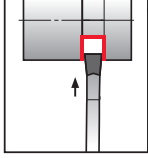
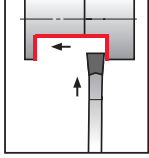
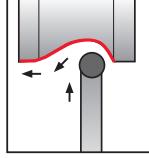
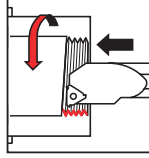



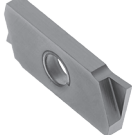

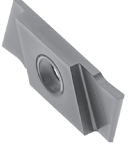


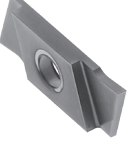

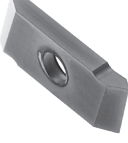

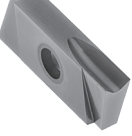

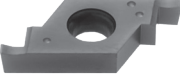

D - 585 | Technical Data

GENERAL INSERTS OVERVIEW


Operation		Parting Off	General Grooving	Turning	Profiling	Threading
						
Insert Type + Chipbreaker						
	GP...-N01-MC GP...-R01-MC GP...-L01-MC					
	GP...-N02-MC GP...-R02-MC GP...-L02-MC					
	GP...-N02-MG					
	GP...-N02-MM					
	GP...-N02-MP					
	GP...-N02-NP					
	GTN...					
	SANCAR...					

 First choice | Primeira opção | Primera opción

 Alternative | Alternativa

Insert Type + Chipbreaker		Operation		Parting Off	General Grooving	Turning	Profiling	Threading
								
	TRIGON							
	SAL GS							
	SAL GR							
	SAL P							
	SAL PT							
	SAL TP							
	LG 0602							

 First choice | Primeira opção | Primera opción

 Alternative | Alternativa

GP INSERTS CODE KEY

Chave de codificação para pastilhas GP | Llave de codificación para plaquitas GP

For R or L Insert type

GP	0300	B	020	-	050	R	02	-	MC
1	2	3	4		5	6	7		8

For N Insert type

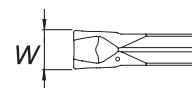
GP	0300	B	020	-	N	02	-	MC
1	2	3	4		6	7		8

1 - Product Line

GP - Grooving Plus

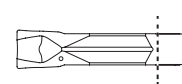
2 - Cutting Width

0200 - 0.079 in | 0300 - 0.118 in | 0400 - 0.157 in | 0500 - 0.197 in | 0600 - 0.236 in



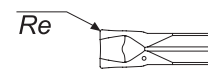
3 - Seat Size

A - 1/16 in | B - 0.091 in | C - 0.130 in | D - 0.169 in | E - 0.193 in | F - 0.260 in

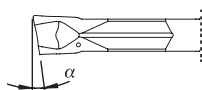


4 - Cutting Radius

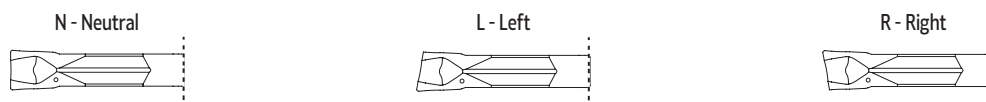
020 - 0.008 in | 025 - 0.010 in | 040 - 0.016 in | 080 - 0.031 in | 300 - 0.118 in | 400 - 0.157 in



5 - Relief Angle



6 - Insert Type



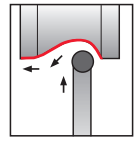
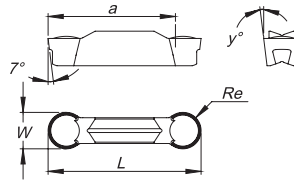
7 - N° of Cutting Edges



8 - Chipbreaker

MC - Medium Cut Off | MG - Medium Grooving | MM - Medium Multi Function | MP - Medium Profiling | NP - Non-Ferrous Profiling

GP...02-MP | Medium Profiling



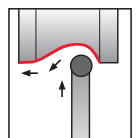
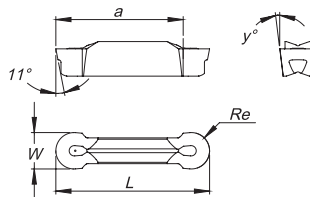
(1) Geometry code	(2) Grade code	P		M		K	S		Dimensions Dimensões Dimensiones (in)					Cutting Conditions Condições de Corte Condiciones de Corte						
		PVD		PVD		CVD	PVD		W	Re	L	a	y°	Seat ² Size	A _p (in)	Min	Max	f _n (in/r)	Min	Max
		G4	T1	G4	T1	L6	G4	T1												
1130607	GP0300B150-N02-MP	⊗	⊗	⊗	⊗	⊗	⊗	⊗	0.118	0.059	0.831	0.728	7.0	B	0.028	0.002	0.043	0.004	0.002	0.005
1130404	GP0600E300-N02-MP	⊗	⊗	⊗	⊗	⊗	⊗	⊗	0.236	0.118	0.992	0.827	7.0	E	0.059	0.002	0.087	0.007	0.006	0.009

⊗ First choice | Primeira opção | 1ª opción ⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta
Disponível bajo consulta Insert order code = (1) Geometry Code + (2) Grade Code

⊗ Stock available until sold out | Stock disponível até acabar o stock | Stock disponible hasta acabar el stock

2 - Correspond to a Specific Holder

GP...02-NP | Non-Ferrous Profiling



(1) Geometry code	(2) Grade code	N		Dimensions Dimensões Dimensiones (in)					Cutting Conditions Condições de Corte Condiciones de Corte						
		UNC		W	Re	L	a	y°	Seat ² Size	A _p (in)	Min	Max	f _n (in/r)	Min	Max
		10													
1130405	GP0600E300-N02-NP	⊗		0.236	0.118	1.000	0.728	7.0	E	0.051	0.020	0.098	0.008	0.006	0.010

⊗ First choice | Primeira opção | 1ª opción ⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta
Disponível bajo consulta Insert order code = (1) Geometry Code + (2) Grade Code

⊗ Stock available until sold out | Stock disponível até acabar o stock | Stock disponible hasta acabar el stock

2 - Correspond to a Specific Holder

BLADES & TOOLHOLDERS CODE KEY

Chave de codificação para lâminas | Llave de codificación de lamas

For Blades

GP	N	C	-	080	25	.A	.0
1	2	3		5	6	7	8

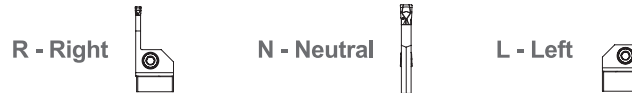
For Toolholders

GP	R	C	-	100	010	25.25	.A	.1
1	2	3		4	5	6	7	8

1 - Product Line

GP - Grooving Plus

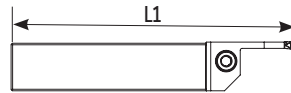
2 - Work Side



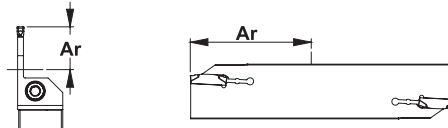
3 - Tool Type

C - Frontal

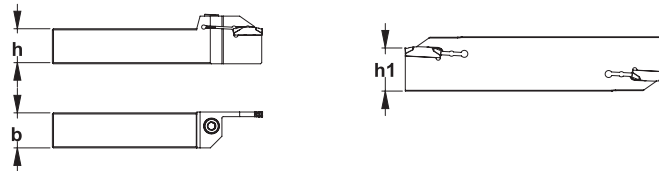
4 - Total toolholder length



5 - Maximum Depth of Cut

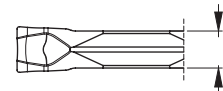


6 - Shaft | Cutting Unit Dimension



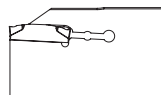
7 - Seat Size

A - 1/16 in | B - 0.091 in | C - 0.130 in | D - 0.169 in | E - 0.157 in | F - 0.260 in

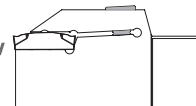


8 - Clamping System

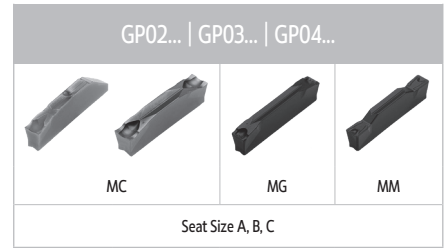
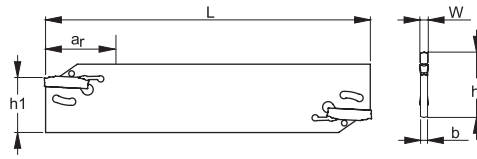
0 - Spring



1 - Screw



GPNC



Order separately

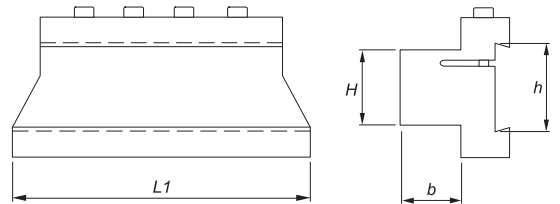
Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)						Seat Size	Insert	Toolholder		Wrench*	Stock
		ar	L1	h	h1	b	W			CPTS	DPTS		
213010000	GPNC-020 25.A.0	0.787	5.906	1.260	0.984	0.059	0.079	A	GP02...	CPTS ...32	DPTS ...32	LE25-30	☉
213009900	GPNC-055 25.B.0	2.165	5.906	1.260	0.984	0.091	0.118	B	GP03...	CPTS ...32	DPTS ...32	LE25-30	☉
213009700	GPNC-055 25.C.0	2.165	5.906	1.260	0.984	0.091	0.157	C	GP04...	CPTS ...32	DPTS ...32	LE25-30	☉

☉ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

*Note: Wrench must be ordered separately

Note: For inserts with 2 cutting edges, the ar is defined by the insert

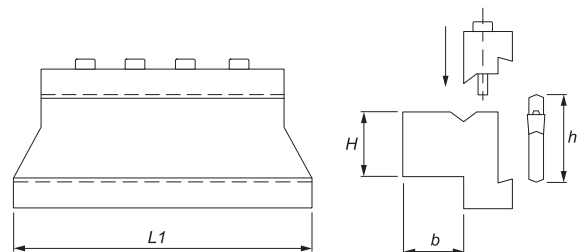
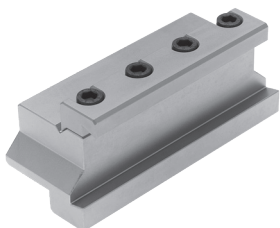
CPTS



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)				lbs	Screw	Wrench	Stock
		h	L1	H	b				
290007700	CPTS 1232	1.250	3.940	0.750	0.750	1.540	D0603600	SS50	○
290007800	CPTS 1632	1.250	4.330	1.000	1.000	2.090	D0603600	SS50	○
290087100	CPTS 2032	1.250	4.750	1.250	1.250	3.080	D0603600	SS50	○
213033300	CPTS 2432	1.250	4.750	1.500	1.640	3.080	D0603600	SS50	○

☉ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

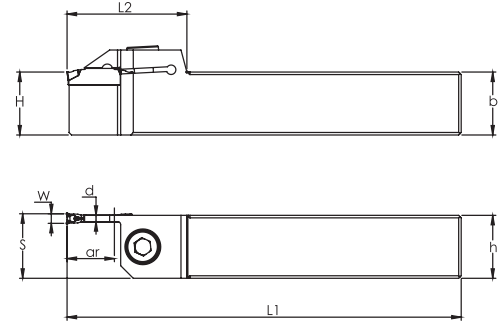
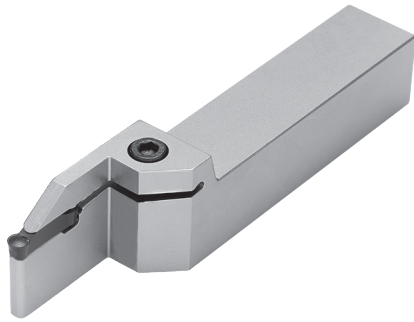
DPTS



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)				lbs	Screw	Wrench	Stock
		h	L1	H	b				
213033000	DPTS 1232	1.250	3.940	0.750	0.750	1.650	D0603600	SS50	○
213032400	DPTS 1632	1.250	4.330	1.000	1.000	2.200	D0603600	SS50	○
213033100	DPTS 2032	1.250	4.750	1.250	1.250	3.190	D0603600	SS50	○
213033200	DPTS 2432	1.250	4.750	1.500	1.640	3.190	D0603600	SS50	○

☉ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

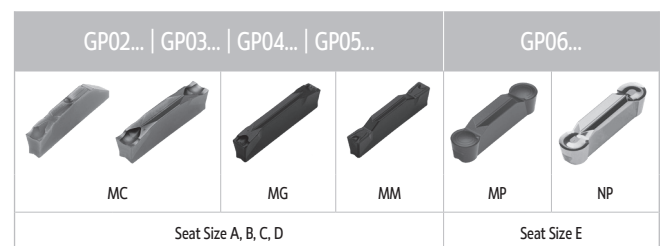
GPLC



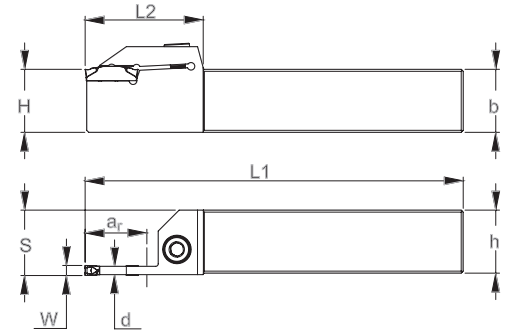
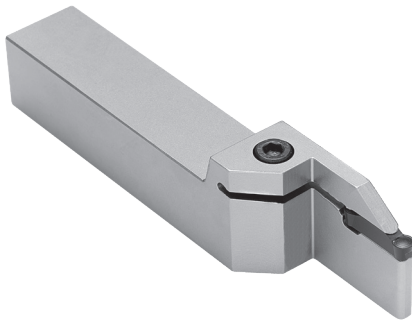
Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)										Seat Size	Insert	Screw	Wrench	lb _f /in	Stock
		ar	L1	h	b	H	L2	S	W								
183027100	GPLC-4.00 0.59 0.625.0.625.A.1	0.59	4.00	0.625	0.625	0.625	1.496	0.635	2	A	GP02...	D0602200	SS50	18.0	○		
183027200	GPLC-5.00 0.59 0.750.0.750.A.1	0.59	5.00	0.750	0.750	0.750	1.535	0.760	2		GP02...	D0602600	SS50	18.0	○		
183027300	GPLC-6.00 0.39 1.000.1.000.A.1	0.39	6.00	1.000	1.000	1.000	1.260	1.010	2		GP02...	D0603100	SS50	18.0	○		
183027400	GPLC-6.00 0.79 1.000.1.000.A.1	0.79	6.00	1.000	1.000	1.000	1.654	1.010	2		GP02...	D0603100	SS50	18.0	○		
183027500	GPLC-4.00 0.59 0.625.0.625.B.1	0.59	4.00	0.625	0.625	0.625	1.496	0.640	3	B	GP03...	D0602200	SS50	18.0	○		
183027600	GPLC-5.00 0.59 0.750.0.750.B.1	0.59	5.00	0.750	0.750	0.750	1.496	0.765	3		GP03...	D0602600	SS50	18.0	○		
183027700	GPLC-6.00 0.39 1.000.1.000.B.1	0.39	6.00	1.000	1.000	1.000	1.260	1.015	3		GP03...	D0603100	SS50	18.0	○		
183027800	GPLC-6.00 0.79 1.000.1.000.B.1	0.79	6.00	1.000	1.000	1.000	1.654	1.015	3		GP03...	D0603100	SS50	18.0	○		
183027900	GPLC-5.00 0.75 0.750.0.750.C.1	0.75	5.00	0.750	0.750	0.750	1.496	0.765	4	C	GP04...	D0602600	SS50	26.0	○		
183028000	GPLC-6.00 0.51 1.000.1.000.C.1	0.51	6.00	1.000	1.000	1.000	1.260	1.015	4		GP04...	D0603100	SS50	26.0	○		
183028100	GPLC-6.00 0.91 1.000.1.000.C.1	0.91	6.00	1.000	1.000	1.000	1.654	1.015	4	D	GP04...	D0603100	SS50	26.0	○		
1830282.00	GPLC-5.00 0.75 0.750.0.750.D.1	0.75	5.00	0.750	0.750	0.750	1.496	0.765	5		GP05...	D0602600	SS50	26.0	○		
183028300	GPLC-6.00 0.51 1.000.1.000.D.1	0.51	6.00	1.000	1.000	1.000	1.260	1.015	5		GP05...	D0603100	SS50	26.0	○		
183028400	GPLC-6.00 0.91 1.000.1.000.D.1	0.91	6.00	1.000	1.000	1.000	1.654	1.015	5	GP05...	D0603100	SS50	26.0	○			
183028500	GPLC-6.00 0.59 1.000.1.000.E.1	0.59	6.00	1.000	1.000	1.000	1.339	1.054	6	E	GP06...	D0603100	SS50	35.0	○		
183028600	GPLC-6.00 0.91 1.000.1.000.E.1	0.91	6.00	1.000	1.000	1.000	1.654	1.035	6		GP06...	D0603100	SS50	35.0	○		

Stock item | Produto de stock | Itens de stock
 Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: For inserts with 2 cutting edges, the ar is defined by the insert



GPRC

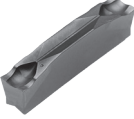
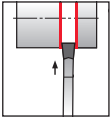
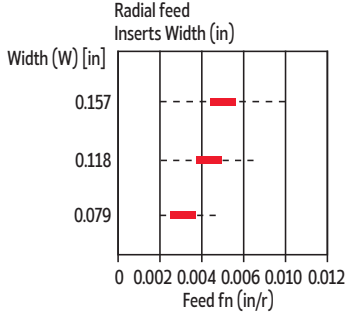

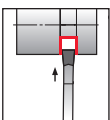
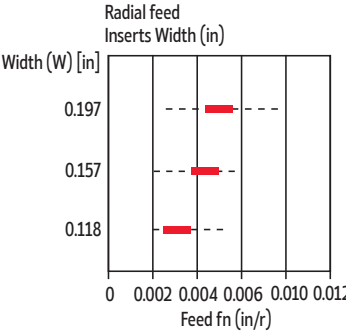

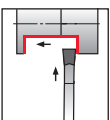
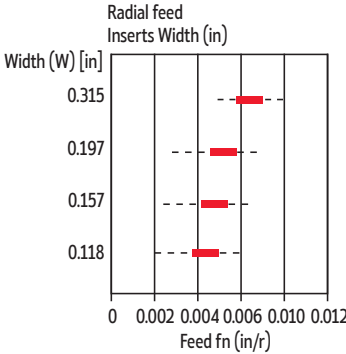
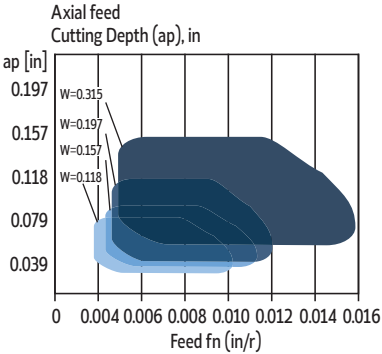


Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)									Seat Size	Insert	Screw	Wrench	lb _f /in	Stock
		ar	L1	h	b	H	L2	S	W							
183025500	GPRC-4.00 0.59 0.625.0.625.A.1	0.59	4.00	0.625	0.625	0.625	1.496	0.635	2	A	GP02...	D0602200	SS50	18.0	☺	
183025600	GPRC-5.00 0.59 0.750.0.750.A.1	0.59	5.00	0.750	0.750	0.750	1.535	0.760	2		GP02...	D0602600	SS50	18.0	☺	
183025700	GPRC-6.00 0.39 1.000.1.000.A.1	0.39	6.00	1.000	1.000	1.000	1.260	1.010	2		GP02...	D0603100	SS50	18.0	☺	
183025800	GPRC-6.00 0.79 1.000.1.000.A.1	0.79	6.00	1.000	1.000	1.000	1.654	1.010	2		GP02...	D0603100	SS50	18.0	☺	
183025900	GPRC-4.00 0.59 0.625.0.625.B.1	0.59	4.00	0.625	0.625	0.625	1.496	0.640	3	B	GP03...	D0602200	SS50	18.0	☺	
183026000	GPRC-5.00 0.59 0.750.0.750.B.1	0.59	5.00	0.750	0.750	0.750	1.496	0.765	3		GP03...	D0602600	SS50	18.0	☺	
183026100	GPRC-6.00 0.39 1.000.1.000.B.1	0.39	6.00	1.000	1.000	1.000	1.260	1.015	3		GP03...	D0603100	SS50	18.0	☺	
183026200	GPRC-6.00 0.79 1.000.1.000.B.1	0.79	6.00	1.000	1.000	1.000	1.654	1.015	3		GP03...	D0603100	SS50	18.0	☺	
183026300	GPRC-5.00 0.75 0.750.0.750.C.1	0.75	5.00	0.750	0.750	0.750	1.496	0.765	4	C	GP04...	D0602600	SS50	26.0	☺	
183026400	GPRC-6.00 0.51 1.000.1.000.C.1	0.51	6.00	1.000	1.000	1.000	1.260	1.015	4		GP04...	D0603100	SS50	26.0	☺	
183026500	GPRC-6.00 0.91 1.000.1.000.C.1	0.91	6.00	1.000	1.000	1.000	1.654	1.015	4		GP04...	D0603100	SS50	26.0	☺	
183026600	GPRC-5.00 0.75 0.750.0.750.D.1	0.75	5.00	0.750	0.750	0.750	1.496	0.765	5	D	GP05...	D0602600	SS50	26.0	☺	
183026700	GPRC-6.00 0.51 1.000.1.000.D.1	0.51	6.00	1.000	1.000	1.000	1.260	1.015	5		GP05...	D0603100	SS50	26.0	☺	
183026800	GPRC-6.00 0.91 1.000.1.000.D.1	0.91	6.00	1.000	1.000	1.000	1.654	1.015	5		GP05...	D0603100	SS50	26.0	☺	
183026900	GPRC-6.00 0.59 1.000.1.000.E.1	0.59	6.00	1.000	1.000	1.000	1.339	1.054	6	E	GP06...	D0603100	SS50	35.0	☺	
183027000	GPRC-6.00 0.91 1.000.1.000.E.1	0.91	6.00	1.000	1.000	1.000	1.654	1.035	6		GP06...	D0603100	SS50	35.0	☺	

☺ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: For inserts with 2 cutting edges, the ar is defined by the insert

GP02... GP03... GP04... GP05...				GP06...	
MC	MG	MM	MP	NP	NP
Seat Size A, B, C, D				Seat Size E	

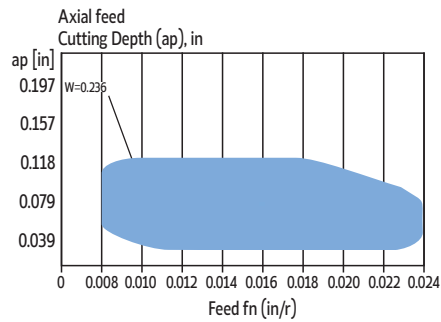
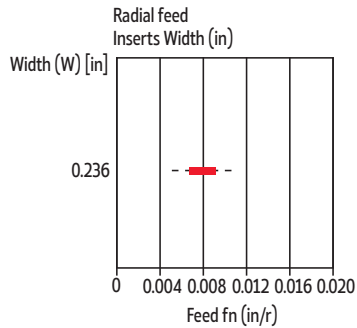
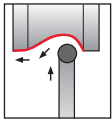
Feed recommendations and geometry descriptions		Grooving & Parting Off	
<p>GP...02-MC</p>  	<p>Radial feed Inserts Width (in)</p> 	<p>Medium Parting Off</p> <p>Recommended for parting off, thin walled tubes and small diameter components in all materials.</p> <p>The positive geometry eliminates the risk of built-up edge.</p> <p>Low cutting forces resulting in reduced vibration.</p>	
<p>GP...02-MG</p>  	<p>Radial feed Inserts Width (in)</p> 	<p>Medium Grooving</p> <p>Outstanding chip control.</p> <p>Reduces chip width giving good surfaces.</p> <p>For all materials.</p>	
<p>GP...02-MM</p>  	<p>Radial feed Inserts Width (in)</p> 	<p>Axial feed Cutting Depth (ap), in</p> 	<p>Medium Multi Function (Grooving & Turning)</p> <p>For grooving and turning in all materials.</p> <p>Good chip control.</p>

— Recommended starting value.
For cutting speed recommendations, see page D - 587.

Feed recommendations and geometry descriptions

Grooving & Parting Off

GP...02-MP



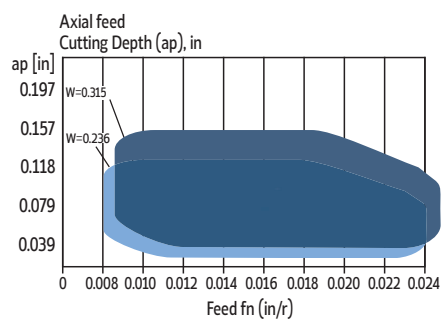
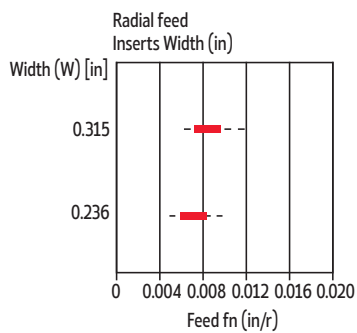
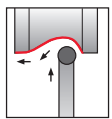
Medium Profiling

For profiling all materials.

Outstanding chip control even at low feeds and small depths of cut.

Good surface finish.

GP...02-NP



Medium Aluminium profiling

First choice for profiling in non-ferrous materials.

Good chip flow provides a better surface finishing.

Sharp cutting edge.

— Recommended starting value.
For cutting speed recommendations, see page D - 587.

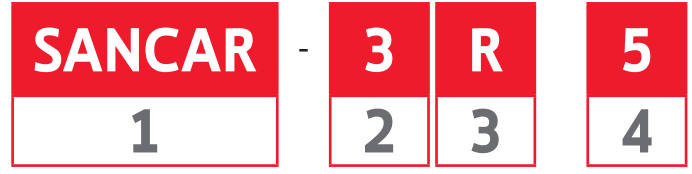
GTN & SANCAR INSERTS CODE KEY

Chave de codificação para pastilhas | Llave de codificación para plaquitas

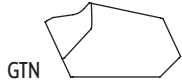
For GTN Inserts



For SANCAR Inserts



1 - Product Line



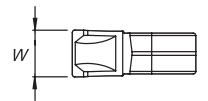
GTN



SANCAR

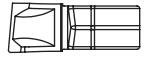
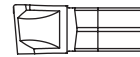
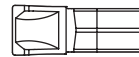
2 - Cutting Width

2 - 0.079 in | 2.4 - 0.094 in | 3 - 0.118 in | 4 - 0.157 in | 4.8 - 0.189 in | 5 - 0.197 in | 6 - 0.236 in | 8 - 0.315 in



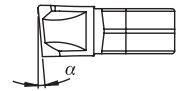
3 - Inserts Type

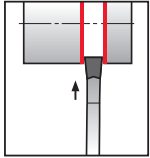
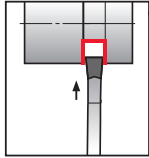
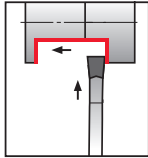
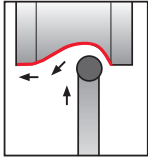






N - Neutral | R - Right | L - Left




4 - Relief Angle

4 - 4° | 5 - 5° | 8 - 8° | 15 - 15°

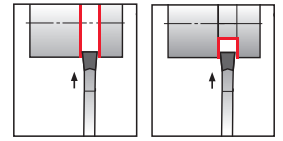
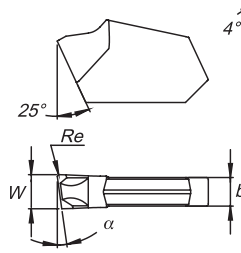


Insert Type + Chipbreaker		Operation		Parting Off	General Grooving	Turning	Profiling
							
	GTN...						
	SANCAR...						

 First choice | Primeira opção | Primera opción

 Alternative | Alternativa

GTN-R



			P		M		K		Dimensions Dimensões Dimensiones (in)				Cutting Conditions		
	(2) Grade code		CVD-MT		CVD-MT		CVD-MT								
	(1) Geometry code	ANSI Reference	ISO Reference	L7	N2	N2	L6	N2	W	b	Re	α°	f_n (in/r)	Min	Max
1130166	GTN-2R 4	GCMX-2R 4	○	○	○	○	○	○	0.087	0.071	0.006	4	0.003	0.002	0.005
1130167	GTN-2R 8	GCMX-2R 8	○	○	○	○	○	○	0.087	0.071	0.006	8	0.002	0.002	0.004
1130255	GTN-2R 15	GCMX-2R 15	○	○	○	○	○	○	0.087	0.071	0.006	15	0.002	0.002	0.004
1130257	GTN-2.4R 4	GCMX-2.4R 4	○	○	○	○	○	○	0.094	0.079	0.006	4	0.003	0.002	0.006
1130233	GTN-2.4R 8	GCMX-2.4R 8	○	○	○	○	○	○	0.094	0.079	0.006	8	0.003	0.002	0.005
1130258	GTN-2.4R 15	GCMX-2.4R 15	○	○	○	○	○	○	0.094	0.079	0.006	15	0.002	0.002	0.004
1130170	GTN-3R 4	GCMX-3R 4	○	○	○	○	○	○	0.122	0.102	0.008	4	0.003	0.002	0.006
1130171	GTN-3R 8	GCMX-3R 8	○	○	○	○	○	○	0.122	0.102	0.008	8	0.003	0.002	0.005
1130253	GTN-3R 15	GCMX-3R 15	○	○	○	○	○	○	0.122	0.102	0.008	15	0.002	0.002	0.004
1130261	GTN-4R 4	GCMX-4R 4	○	○	○	○	○	○	0.161	0.138	0.010	4	0.005	0.003	0.008
1130222	GTN-4R 8	GCMX-4R 8	○	○	○	○	○	○	0.161	0.138	0.010	8	0.004	0.003	0.005
1130262	GTN-4R 15	GCMX-4R 15	○	○	○	○	○	○	0.161	0.138	0.010	15	0.004	0.003	0.005
1130264	GTN-4.8R 4	GCMX-4.8R 4	○	○	○	○	○	○	0.189	0.165	0.011	4	0.007	0.004	0.010
1130230	GTN-4.8R 8	GCMX-4.8R 8	○	○	○	○	○	○	0.189	0.165	0.011	8	0.005	0.004	0.007
1130265	GTN-4.8R 15	GCMX-4.8R 15	○	○	○	○	○	○	0.189	0.165	0.011	15	0.005	0.004	0.006
1130268	GTN-5R 4	GCMX-5R 4	○	○	○	○	○	○	0.201	0.177	0.011	4	0.007	0.004	0.010
1130224	GTN-5R 8	GCMX-5R 8	○	○	○	○	○	○	0.201	0.177	0.011	8	0.005	0.004	0.007
1130269	GTN-5R 15	GCMX-5R 15	○	○	○	○	○	○	0.201	0.177	0.011	15	0.005	0.004	0.006
1130272	GTN-6R 4	GCMX-6R 4	○	○	○	○	○	○	0.252	0.217	0.014	4	0.008	0.004	0.012
1130227	GTN-6R 8	GCMX-6R 8	○	○	○	○	○	○	0.252	0.217	0.014	8	0.007	0.005	0.008
1130276	GTN-6R 15	GCMX-6R 15	○	○	○	○	○	○	0.252	0.217	0.014	15	0.006	0.004	0.007

🟢 First choice | Primeira opção | 1ª opción

🟡 Stock item | Produto de stock | Itens de stock

⊖ Available under request | Disponível sobre consulta
Disponible bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

GROOVING & PARTING OFF

Overview

Grooving Plus

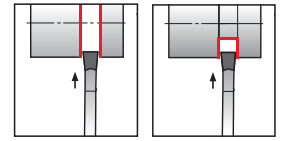
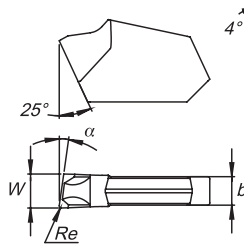
Grooving & Parting Off

SAL - Swiss Automatic Lathes

Light Grooving

Technical Data

GTN-L



(1) Geometry code	ANSI Reference	ISO Reference	P		M		K		Dimensions Dimensões Dimensiones (in)				Cutting Conditions		
			(2) Grade code		CVD-MT	CVD-MT	CVD-MT	W	b	Re	α°	fn (in/r)	Min	Max	
			L7	N2	N2	L6	N2								
			PH5115	PH5135	PH5135	PH5320	PH5135								
1130164	GTN-2L 4	GCMX-2L 4	○	○	○	○	○	0.087	0.071	0.006	4	0.003	0.002	0.005	
1130220	GTN-2L 8	GCMX-2L 8	○	○	○	○	○	0.087	0.071	0.006	8	0.002	0.002	0.004	
1130256	GTN-2L 15	GCMX-2L 15	○	○	○	○	○	0.087	0.071	0.006	15	0.002	0.002	0.004	
1130259	GTN-2.4L 4	GCMX-2.4L 4	○	○	○	○	○	0.094	0.079	0.006	4	0.003	0.002	0.006	
1130232	GTN-2.4L 8	GCMX-2.4L 8	○	○	○	○	○	0.094	0.079	0.006	8	0.003	0.002	0.005	
1130260	GTN-2.4L 15	GCMX-2.4L 15	○	○	○	○	○	0.094	0.079	0.006	15	0.002	0.002	0.004	
1130221	GTN-3L 4	GCMX-3L 4	○	○	○	○	○	0.122	0.102	0.008	4	0.003	0.002	0.006	
1130168	GTN-3L 8	GCMX-3L 8	○	○	○	○	○	0.122	0.102	0.008	8	0.003	0.002	0.005	
1130254	GTN-3L 15	GCMX-3L 15	○	○	○	○	○	0.122	0.102	0.008	15	0.002	0.002	0.004	
1130173	GTN-4L 4	GCMX-4L 4	○	○	○	○	○	0.161	0.138	0.010	4	0.005	0.003	0.008	
1130223	GTN-4L 8	GCMX-4L 8	○	○	○	○	○	0.161	0.138	0.010	8	0.004	0.003	0.005	
1130263	GTN-4L 15	GCMX-4L 15	○	○	○	○	○	0.161	0.138	0.010	15	0.004	0.003	0.005	
1130266	GTN-4.8L 4	GCMX-4.8L 4	○	○	○	○	○	0.189	0.165	0.011	4	0.007	0.004	0.010	
1130231	GTN-4.8L 8	GCMX-4.8L 8	○	○	○	○	○	0.189	0.165	0.011	8	0.005	0.004	0.007	
1130267	GTN-4.8L 15	GCMX-4.8L 15	○	○	○	○	○	0.189	0.165	0.011	15	0.005	0.004	0.006	
1130270	GTN-5L 4	GCMX-5L 4	○	○	○	○	○	0.201	0.177	0.011	4	0.007	0.004	0.010	
1130225	GTN-5L 8	GCMX-5L 8	○	○	○	○	○	0.201	0.177	0.011	8	0.005	0.004	0.007	
1130271	GTN-5L 15	GCMX-5L 15	○	○	○	○	○	0.201	0.177	0.011	15	0.005	0.004	0.006	
1130274	GTN-6L 4	GCMX-6L 4	○	○	○	○	○	0.252	0.217	0.014	4	0.008	0.004	0.012	
1130226	GTN-6L 8	GCMX-6L 8	○	○	○	○	○	0.252	0.217	0.014	8	0.007	0.005	0.008	
1130275	GTN-6L 15	GCMX-6L 15	○	○	○	○	○	0.252	0.217	0.014	15	0.006	0.004	0.007	

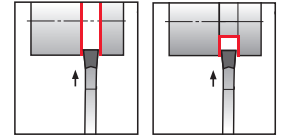
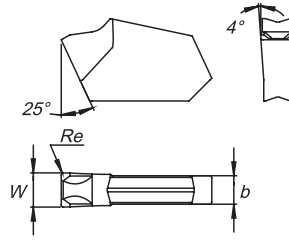
🔑 First choice | Primeira opção | 1ª opción

📦 Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta
Disponível bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

GTN-N



GROOVING & PARTING OFF

Overview

Grooving Plus

Grooving & Parting Off

SAL - Swiss Automatic Lathes

Light Grooving

Technical Data

(1) Geometry code	ANSI Reference	ISO Reference	P		M	K		Dimensions Dimensões Dimensiones (in)				Cutting Conditions		
			(2) Grade code		CVD-MT	CVD-MT	CVD-MT	W	b	Re	α°	fn (in/r)	Min	Max
			L7	N2	N2	L6	N2							
1130165	GTN-2N	GCMX-2N	⊗	⊗	⊗	⊗	⊗	0.087	0.071	0.006	-	0.003	0.002	0.006
1130228	GTN-2.4N	GCMX-2.4N	○	○	○	○	○	0.094	0.079	0.006	-	0.004	0.002	0.007
1130169	GTN-3N	GCMX-3N	⊗	⊗	⊗	⊗	⊗	0.122	0.102	0.008	-	0.006	0.004	0.010
1130174	GTN-4N	GCMX-4N	⊗	⊗	⊗	⊗	⊗	0.161	0.138	0.010	-	0.007	0.004	0.012
1130229	GTN-4.8N	GCMX-4.8N	○	○	○	○	○	0.189	0.165	0.011	-	0.008	0.005	0.014
1130175	GTN-5N	GCMX-5N	⊗	⊗	⊗	⊗	⊗	0.201	0.177	0.011	-	0.008	0.005	0.014
1130176	GTN-6N	GCMX-6N	⊗	⊗	⊗	⊗	⊗	0.252	0.217	0.014	-	0.010	0.006	0.016
1130449	GTN-8N	GCMX-8N	○	○	○	○	○	0.315	0.280	0.016	-	0.011	0.007	0.018

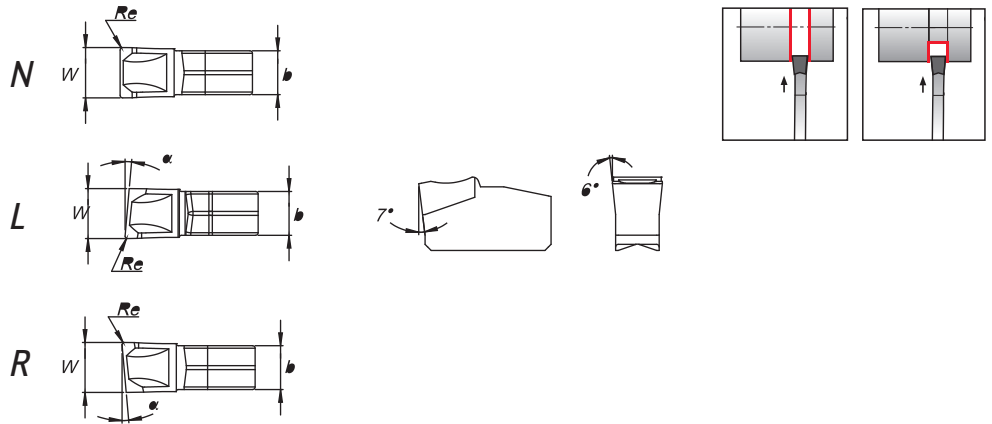
⊗ First choice | Primeira opção | 1ª opción

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta
Disponível bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

SANCAR



(1) Geometry code	ISO Reference	ANSI Reference	P		M	K		Dimensions Dimensões Dimensiones (in)				Cutting Conditions		
			(2) Grade code		CVD-MT	CVD-MT	CVD-MT	W	b	Re	α°	fn (in/r)	Min	Max
			L7	N2	N2	L6	N2							
1130186	SANCAR-3N	SANCAR-3N	⊗	⊗	⊗	⊗	⊗	0.118	0.098	0.010	-	0.005	0.002	0.010
1130187	SANCAR-4N	SANCAR-4N	⊗	⊗	⊗	⊗	⊗	0.157	0.130	0.010	-	0.007	0.004	0.012
1130189	SANCAR-5N	SANCAR-5N	⊗	⊗	⊗	⊗	⊗	0.197	0.169	0.010	-	0.009	0.004	0.014
1130185	SANCAR-3L 5	SANCAR-3L 5	○	○	○	○	○	0.118	0.098	0.010	5	0.004	0.002	0.006
1130390	SANCAR-4L 5	SANCAR-4L 5	○	○	○	○	○	0.157	0.130	0.010	5	0.005	0.003	0.008
1130389	SANCAR-5L 5	SANCAL-5L 5	○	○	○	○	○	0.197	0.169	0.010	5	0.006	0.003	0.010
1130288	SANCAR-3R 5	SANCAR-3R 5	○	○	○	○	○	0.118	0.098	0.010	5	0.004	0.002	0.006
1130188	SANCAR-4R 5	SANCAR-4R 5	○	○	○	○	○	0.157	0.130	0.010	5	0.005	0.003	0.008
1130388	SANCAR-5R 5	SANCAR-5R 5	○	○	○	○	○	0.197	0.169	0.010	5	0.006	0.003	0.010

⊗ First choice | Primeira opção | 1ª opción

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta
Disponível bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

BLADES CODE KEY | Chave de codificação para laminas | Llave de codificación de lamas

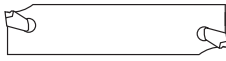


1 - Product Line

BL - Blade

2 - Blade Type

ST - Standard Blade



S - SANCAR Blade



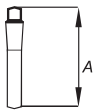
3 - Cutting Width

2 - 0.079 in | 3 - 0.118 in | 4 - 0.157 in | 5 - 0.197 in | 6 - 0.236 in



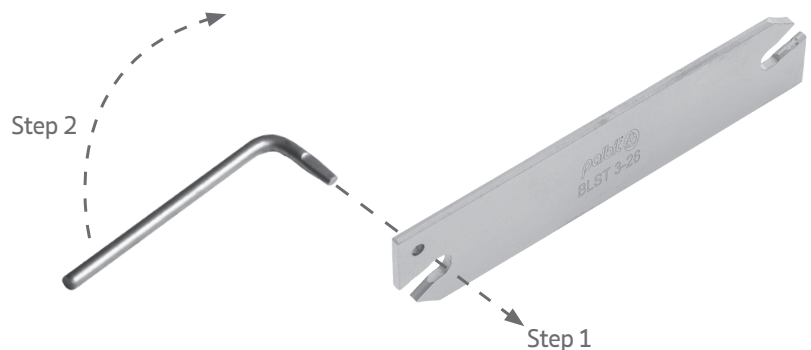
4 - Maximum Depth of Cut

19 - 0.748 in | 26 - 1.024 in | 32 - 1.260 in

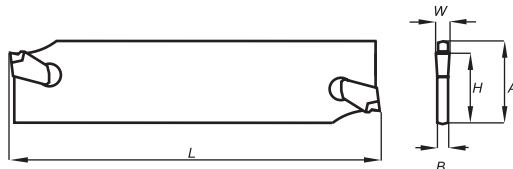


PROCEDURES FOR INSERTS EXTRACTION | Procedimentos para remoção de pastilha | Procedimientos para retirar plaquitas

1. Always use the right key to proceed to inserts extraction.
Use sempre a chave adequada para retirar as pastilhas.
Utilice siempre la llave adecuada para retirar la plaquita.
2. Position LE05 key according to **Step 1** and make sure it fits perfectly.
Posicione a chave LE05 de acordo com o **Passo 1** e certifique que está bem encaixada.
Coloque la llave LE05 de acuerdo con el **Paso 1** y asegúrese de que esté correctamente montada.
3. Hold the blade with one hand. With the other hand rotate the LE05 key as illustrated in **Step 2**.
Segure a lâmina com uma mão. Com a outra rode a chave LE05 como ilustrado no **Passo 2**.
Sostenga la lama con una mano. Con la otra gire la llave LE05 como se ilustra en **Paso 2**.
4. Always replace damaged inserts with new ones.
Substitua sempre as pastilhas danificadas por pastilhas novas.
Siempre reemplace las plaquitas dañadas por plaquitas nuevas.



BLST (GTN)



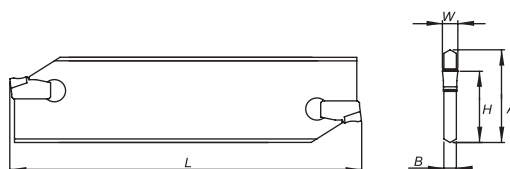
Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)					Inserts	Toolholder		Wrench	Stock
		A	W	H	B	L		CPTS	DPTS		
183008000	BLST 2-19	0.748	0.079	0.630	0.063	3.346	GTN-2...	CPTS ...19	DPTS ...19	LE05	☉
183008100	BLST 2-26	1.024	0.079	0.843	0.063	4.331	GTN-2...	CPTS ...26	DPTS ...26	LE05	☉
213008200	BLST 3-26	1.024	0.118	0.843	0.094	4.331	GTN-3...	CPTS ...26	DPTS ...26	LE05	☉
213008300	BLST 4-26	1.024	0.157	0.843	0.126	4.331	GTN-4...	CPTS ...26	DPTS ...26	LE05	☉
213008400	BLST 5-26	1.024	0.197	0.843	0.157	4.331	GTN-5...	CPTS ...26	DPTS ...26	LE05	☉
213008500	BLST 6-26	1.024	0.236	0.843	0.205	4.331	GTN-6...	CPTS ...26	DPTS ...26	LE05	☉
183008600	BLST 2-32	1.260	0.079	0.984	0.063	5.906	GTN-2...	CPTS ...32	DPTS ...32	LE05	☉
213008700	BLST 3-32	1.260	0.118	0.984	0.094	5.906	GTN-3...	CPTS ...32	DPTS ...32	LE05	☉
213008800	BLST 4-32	1.260	0.157	0.984	0.126	5.906	GTN-4...	CPTS ...32	DPTS ...32	LE05	☉
213008900	BLST 5-32	1.260	0.197	0.984	0.157	5.906	GTN-5...	CPTS ...32	DPTS ...32	LE05	☉
213009000	BLST 6-32	1.260	0.236	0.984	0.205	5.906	GTN-6...	CPTS ...32	DPTS ...32	LE05	☉

☉ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: Check the procedures for inserts extration on page D-562.

BLS (SANCAR)



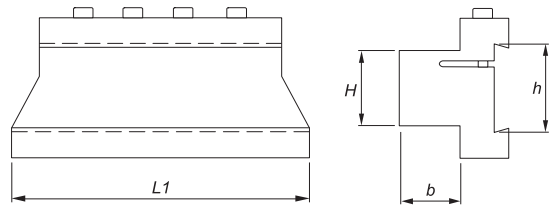
Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)					Inserts	Toolholder		Wrench	Stock
		A	W	H	B	L		CPTS	DPTS		
213004600	BLS 3-32	1.260	0.118	0.984	0.094	5.906	SANCAR 3...	CPTS ...32	DPTS ...32	LE05	☉
213004700	BLS 4-32	1.260	0.157	0.984	0.126	5.906	SANCAR 4...	CPTS ...32	DPTS ...32	LE05	☉
213005500	BLS 5-32	1.260	0.197	0.984	0.157	5.906	SANCAR 5...	CPTS ...32	DPTS ...32	LE05	☉


☉ Stock item | Produto de stock | Itens de stock


○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: Check the procedures for inserts extration on page D-562.

CPTS

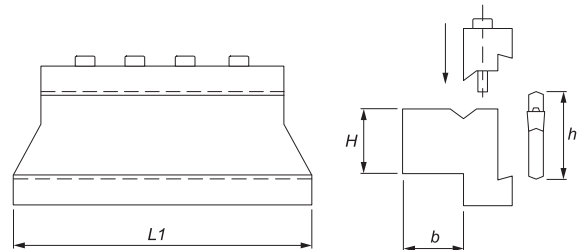



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)				 lbs	Screw	Wrench	Stock
		h	L1	H	b				
290087000	CPTS 1019	0.750	2.990	0.625	0.625	0.660	D0503000	SS40	<input type="radio"/>
290007600	CPTS 1026	1.020	3.430	0.625	0.625	0.990	D0603600	SS50	<input type="radio"/>
290086900	CPTS 1226	1.020	3.430	0.750	0.750	1.100	D0603600	SS50	<input type="radio"/>
290007700	CPTS 1232	1.250	3.940	0.750	0.750	1.540	D0603600	SS50	<input type="radio"/>
290007800	CPTS 1632	1.250	4.330	1.000	1.000	2.090	D0603600	SS50	<input type="radio"/>
290087100	CPTS 2032	1.250	4.750	1.250	1.250	3.080	D0603600	SS50	<input type="radio"/>
213033300	CPTS 2432	1.250	4.750	1.500	1.640	3.080	D0603600	SS50	<input type="radio"/>


 Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

DPTS

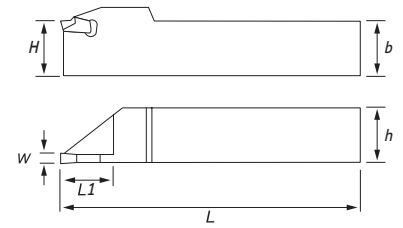
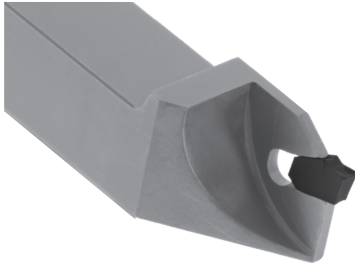


Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)				 lbs	Screw	Wrench	Stock
		h	L1	H	b				
213032900	DPTS 1019	0.750	2.990	0.625	0.625	0.550	D0503000	SS40	<input type="radio"/>
213032200	DPTS 1026	1.020	3.430	0.625	0.625	1.210	D0603600	SS50	<input type="radio"/>
213032300	DPTS 1226	1.020	3.430	0.750	0.750	1.540	D0603600	SS50	<input type="radio"/>
213033000	DPTS 1232	1.250	3.940	0.750	0.750	1.650	D0603600	SS50	<input type="radio"/>
213032400	DPTS 1632	1.250	4.330	1.000	1.000	2.200	D0603600	SS50	<input type="radio"/>
213033100	DPTS 2032	1.250	4.750	1.250	1.250	3.190	D0603600	SS50	<input type="radio"/>
213033200	DPTS 2432	1.250	4.750	1.500	1.640	3.190	D0603600	SS50	<input type="radio"/>

 Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

XLCF R



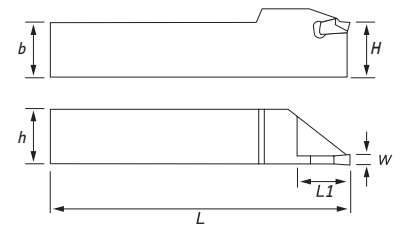
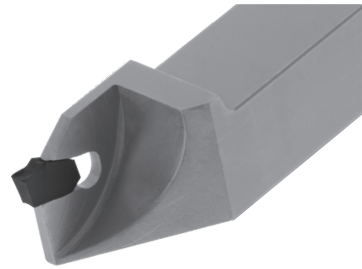
Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)						lbs	Insert	Wrench	Stock
		h	L1	L	H	b	W				
213033400	XLCF R 06-2B	0.375	0.709	4.331	0.375	0.375	0.078	0.176	GTN-2	LE05	○
213032500	XLCF R 08-2B	0.500	0.709	4.331	0.500	0.500	0.078	0.220	GTN-2	LE05	○
213032600	XLCF R 52-3B	0.500	0.787	4.331	0.500	0.500	0.118	0.330	GTN-3	LE05	○
213033500	XLCF R 52-4B	0.500	0.787	4.331	0.500	0.500	0.157	0.330	GTN-4	LE05	○
213032700	XLCF R 62-3C	0.500	0.787	4.921	0.500	0.500	0.118	0.440	GTN-3	LE05	○
213033600	XLCF R 62-4C	0.500	0.787	4.921	0.500	0.500	0.157	0.440	GTN-4	LE05	○
213033700	XLCF R 12-3C	0.750	0.787	4.921	0.750	0.750	0.118	0.770	GTN-3	LE05	○
213033800	XLCF R 12-4C	0.750	0.787	4.921	0.750	0.750	0.157	0.770	GTN-4	LE05	○
213033900	XLCF R 16-3D	1.000	0.787	5.906	1.000	1.000	0.118	1.430	GTN-3	LE05	○
213034000	XLCF R 16-4D	1.000	0.787	5.906	1.000	1.000	0.157	1.430	GTN-4	LE05	○

☑ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: Check the procedures for inserts extration on page D-562.

XLCF L

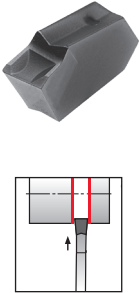
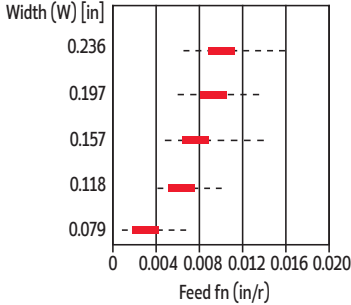
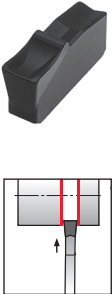
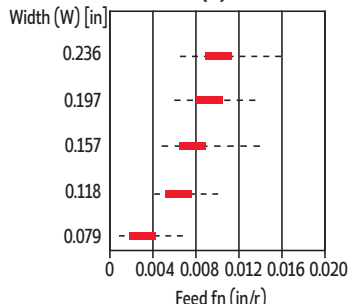


Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)						lbs	Insert	Wrench	Stock
		h	L1	L	H	b	W				
213034100	XLCF L 06-2B	0.375	0.709	4.331	0.375	0.375	0.078	0.176	GTN-2	LE05	○
213034200	XLCF L 08-2B	0.500	0.709	4.331	0.500	0.500	0.078	0.220	GTN-2	LE05	○
213034300	XLCF L 52-3B	0.500	0.787	4.331	0.500	0.500	0.118	0.330	GTN-3	LE05	○
213034400	XLCF L 52-4B	0.500	0.787	4.331	0.500	0.500	0.157	0.330	GTN-4	LE05	○
213034500	XLCF L 62-3C	0.500	0.787	4.921	0.500	0.500	0.118	0.440	GTN-3	LE05	○
213034600	XLCF L 62-4C	0.500	0.787	4.921	0.500	0.500	0.157	0.440	GTN-4	LE05	○
213034700	XLCF L 12-3C	0.750	0.787	4.921	0.750	0.750	0.118	0.770	GTN-3	LE05	○
213034800	XLCF L 12-4C	0.750	0.787	4.921	0.750	0.750	0.157	0.770	GTN-4	LE05	○
213034900	XLCF L 16-3D	1.000	0.787	5.906	1.000	1.000	0.118	1.430	GTN-3	LE05	○
213035000	XLCF L 16-4D	1.000	0.787	5.906	1.000	1.000	0.157	1.430	GTN-4	LE05	○

☑ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: Check the procedures for inserts extration on page D-562.

Feed recommendations and geometry descriptions		Grooving & Parting Off
<p>GTN-...</p> 	<p>Radial feed Inserts Width (in)</p> 	<p>Medium Parting Off</p> <p>Most efficient on stainless steel and most types of steel at moderate feed rates. Superior straightness of cut</p>
<p>SANCAR-...</p> 	<p>Radial feed Inserts Width (in)</p> 	<p>Medium Parting Off</p> <p>Optimizer to minimize pips and burrs on components. Recommended for steel, stainless steel and cast iron.</p>

— Recommended starting value.
For cutting speed recommendations, see page D - 587.

TRIGON INSERTS CODE KEY

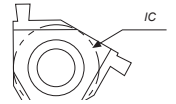
Chave de codificação para pastilhas | Llave de codificación para plaquitas

For Trigon 60° Inserts

16 - **ER** - **W** - **1.00**
1 **2** **3** **4**

1 - Inscribed Circle

16 - 9,525mm



2 - Insert Type

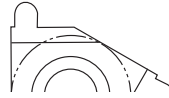
ER - External Right | IR - Internal Right

3 - Cutting Edge Type

W - Rectangular

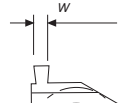


R - Rounded



4 - Cutting Edge Length

0,50 - 0,5mm | 2,25 - 2,25mm



D

GROOVING & PARTING OFF

Overview

Grooving Plus

Grooving & Parting Off

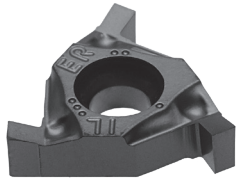
SAL - Swiss Automatic Lathes

Light Grooving

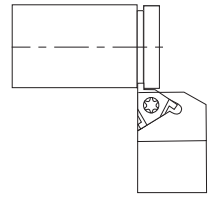
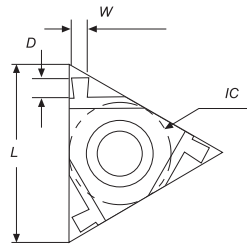
Technical Data

TRIGON INSERTS

FLAT GROOVING



External

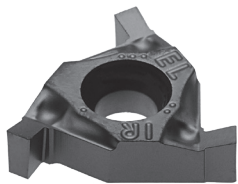


Inserts ER = IL

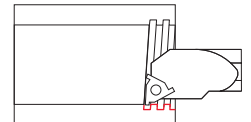
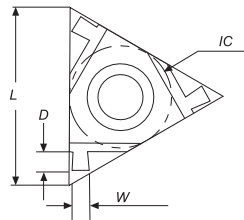
Order code Código	Reference Referência Referencia	Anvil	L (mm)	Dimensions Dimensões Dimensiones (in)			Stock - Grade Code (2)	
				IC	W	D	(68) PH6920	(D0) PH8920
1883721	11 ER W 0.50	-	11	0.250	0.020	0.055	○	○
1883722	11 ER W 0.60	-	11	0.250	0.024	0.055	○	○
1883723	11 ER W 0.70	-	11	0.250	0.028	0.055	○	○
1883724	11 ER W 0.80	-	11	0.250	0.031	0.055	○	○
1883725	11 ER W 1.00	-	11	0.250	0.039	0.055	○	○
1883726	16 ER W 0.50	EA 16	16	0.375	0.020	0.055	○	○
1881125	16 ER W 1.00	EA 16	16	0.375	0.039	0.055	⊗	○
1883707	16 ER W 1.20	EA 16	16	0.375	0.047	0.063	⊗	○
1883720	16 ER W 1.40	EA 16	16	0.375	0.055	0.071	⊗	○
1881129	16 ER W 1.70	EA 16	16	0.375	0.067	0.079	⊗	⊗
1883711	16 ER W 1.95	EA 16	16	0.375	0.077	0.079	⊗	⊗
1883714	16 ER W 2.25	EA 16	16	0.375	0.089	0.089	⊗	⊗

⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: Select the toolholder "SXAN"



Internal



Inserts IR = EL

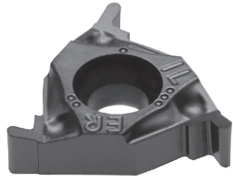
Order code Código	Reference Referência Referencia	Anvil	L (mm)	Dimensions Dimensões Dimensiones (in)			Stock - Grade Code (2)	
				IC	W	D	(68) PH6920	(D0) PH8920
1881142	11 IR W 0.50	-	11	0.250	0.020	0.055	⊗	○
1883727	11 IR W 0.60	-	11	0.250	0.024	0.055	○	○
1883728	11 IR W 0.70	-	11	0.250	0.028	0.055	○	○
1883729	11 IR W 0.80	-	11	0.250	0.031	0.055	○	○
1881144	11 IR W 1.00	-	11	0.250	0.039	0.055	⊗	○
1883730	16 IR W 0.50	EA 16	16	0.375	0.020	0.055	○	○
1881134	16 IR W 1.00	EA 16	16	0.375	0.039	0.055	⊗	○
1883731	16 IR W 1.20	EA 16	16	0.375	0.047	0.063	⊗	○
1883712	16 IR W 1.40	EA 16	16	0.375	0.055	0.071	⊗	○
1881138	16 IR W 1.70	EA 16	16	0.375	0.067	0.079	⊗	○
1883710	16 IR W 1.95	EA 16	16	0.375	0.077	0.079	⊗	○
1883713	16 IR W 2.25	EA 16	16	0.375	0.089	0.089	⊗	○

⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

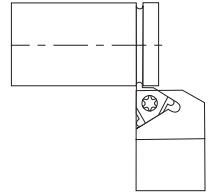
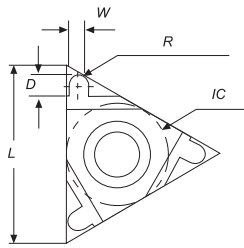
Note: Select the toolholder "SXFN"

Technical Data
page D - 584 page D - 585

FULL RADIUS GROOVING



External



Inserts ER = IL

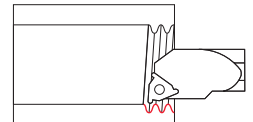
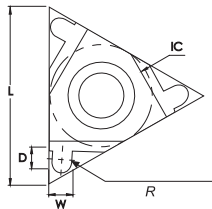
Order code Código	Reference Referência Referencia	Anvil	L (mm)	Dimensions Dimensões Dimensiones (in)				Stock - Grade Code (2)	
				IC	W	R	D	(68) PH6920	(D0) PH8920
1881149	16 ER R 0.50	EA 16	16	0.375	0.039	0.020	0.055	☉	○
1883732	16 ER R 0.60	EA 16	16	0.375	0.047	0.024	0.063	○	○
1883733	16 ER R 0.90	EA 16	16	0.375	0.071	0.035	0.079	○	○
1881151	16 ER R 1.00	EA 16	16	0.375	0.079	0.039	0.079	○	○
1883734	16 ER R 1.10	EA 16	16	0.375	0.087	0.043	0.085	○	○
1883735	16 ER R 1.20	EA 16	16	0.375	0.094	0.047	0.085	○	○

☉ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: Select the toolholder "SXAN"



Internal



Inserts IR = EL

Order code Código	Reference Referência Referencia	Anvil	L (mm)	Dimensions Dimensões Dimensiones (in)				Stock - Grade Code (2)	
				IC	W	R	D	(68) PH6920	(D0) PH8920
1881145	16 IR R 0.50	EA 16	16	0.375	0.039	0.020	0.055	○	○
1883736	16 IR R 0.60	EA 16	16	0.375	0.047	0.024	0.063	○	○
1883737	16 IR R 0.90	EA 16	16	0.375	0.071	0.035	0.079	○	○
1881147	16 IR R 1.00	EA 16	16	0.375	0.079	0.039	0.079	○	○
1883738	16 IR R 1.10	EA 16	16	0.375	0.087	0.043	0.085	○	○
1883739	16 IR R 1.20	EA 16	16	0.375	0.094	0.047	0.085	○	○

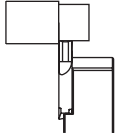
☉ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Note: Select the toolholder "SXFN"

MAIN APLICATIONS | Aplicações principais | Aplicaciones principales

D

GROOVING & PARTING OFF



Turning

INSERTS

4 Different operations:

- Turning
- Parting off
- Grooving
- Threading

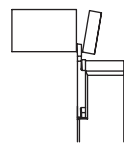
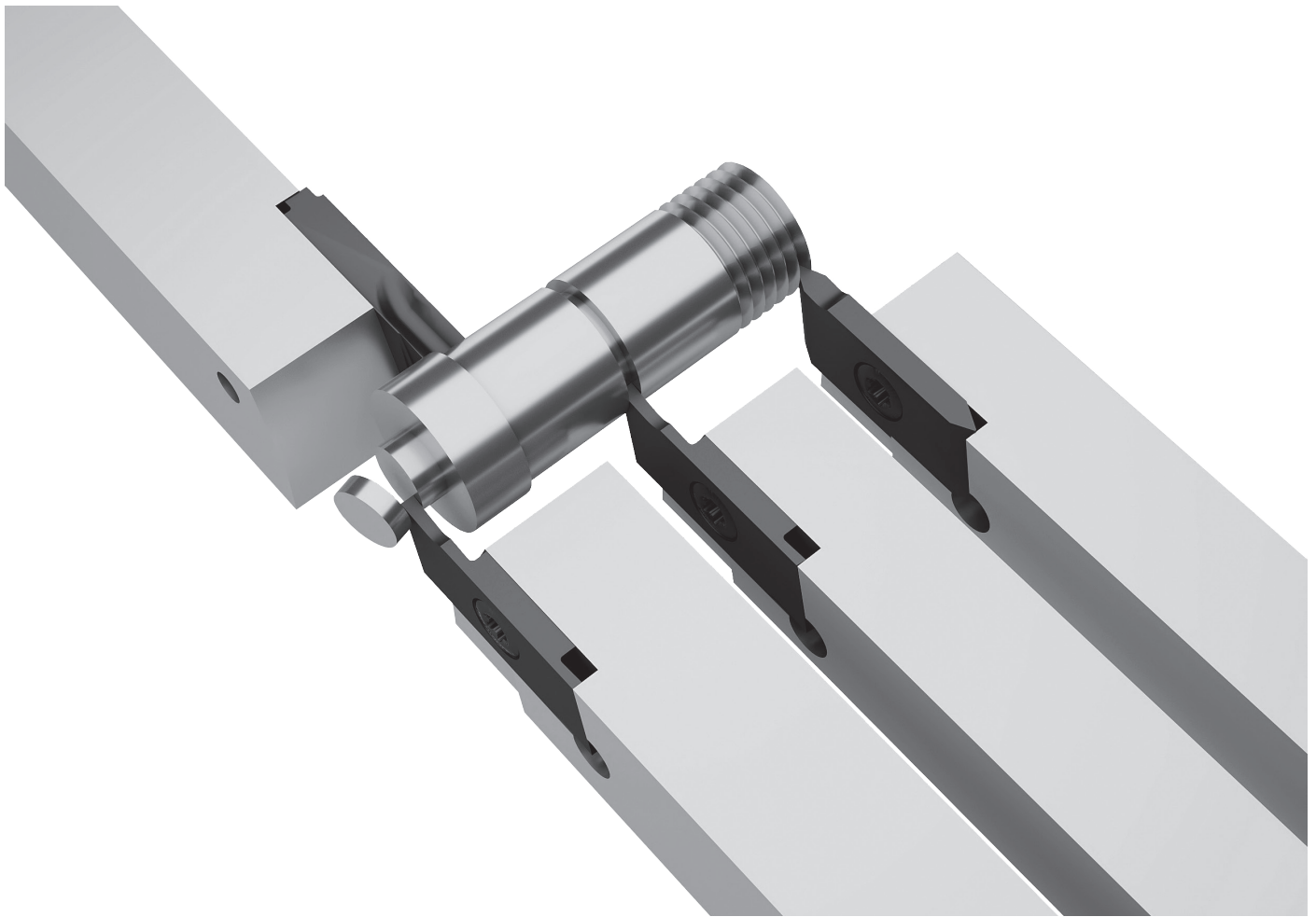
TOOLHOLDERS

Metric:

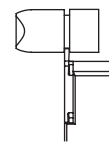
- 08x08mm
- 10x10mm
- 12x12mm
- 16x16mm

Inches:

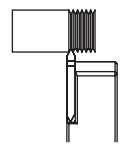
- 0,625 x 0,625"
- 0,500 x 0,500"
- 0,375 x 0,375"
- 0,312 x 0,312"



Parting off



Grooving



Threading

Grooving Plus

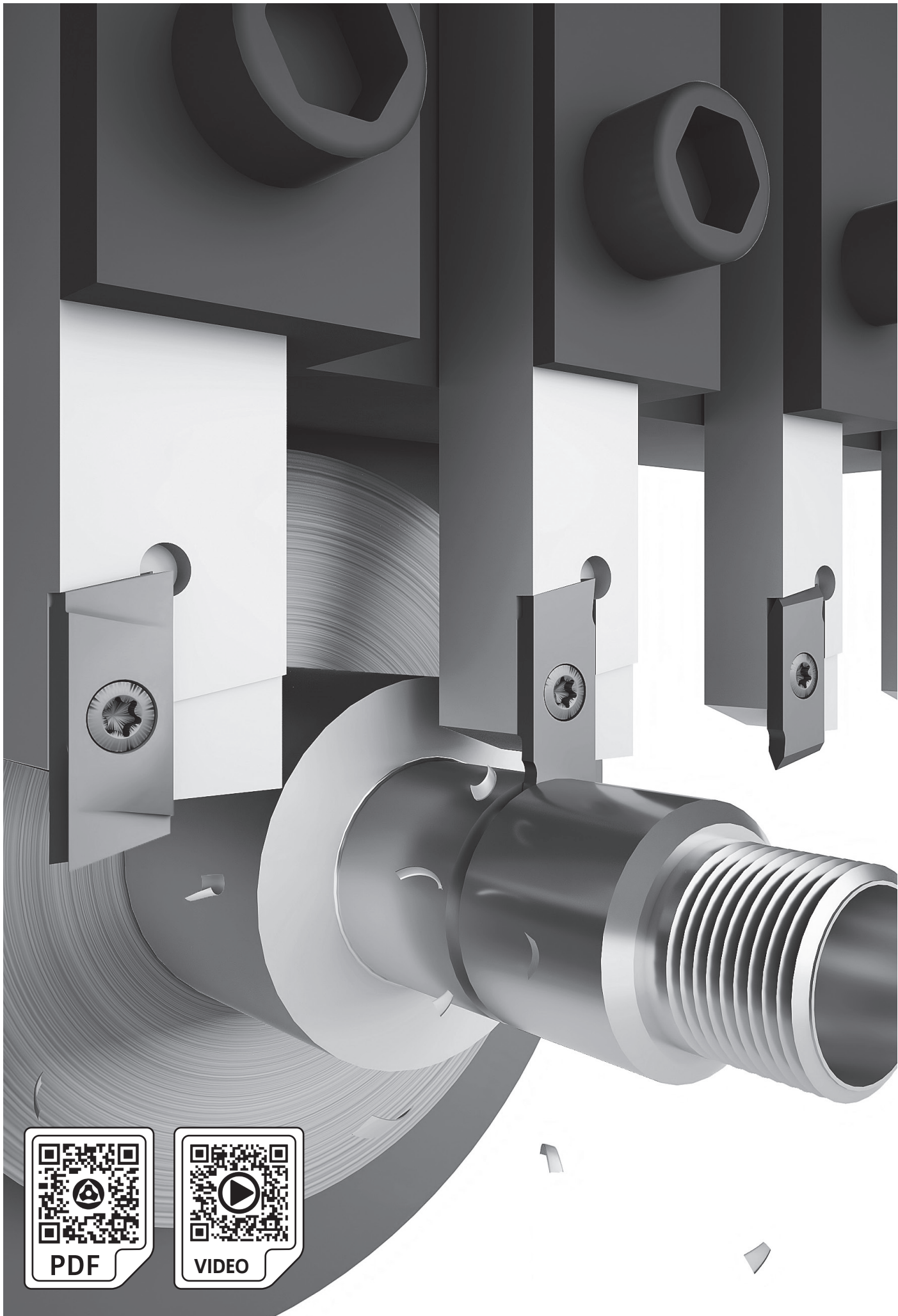
Grooving & Parting Off

SAL - Swiss Automatic Lathes

Light Grooving

Forming Grooving

Technical Data



SAL - SWISS AUTOMATIC LATHES

INSERTS CODE KEY - Chave de codificação para pastilhas | Llave de codificación de plaquitas

Grooving Inserts

SAL	25	G	050	R			GS
1	2	5	6	8	-		11

Parting Off Inserts

SAL	11	P	100	R	N		P07
1	3	5	6	8	9	-	11

Threading Inserts

SAL	100	H	010	R	60		PT
1	4	5	7	8	10	-	11

Turning Inserts

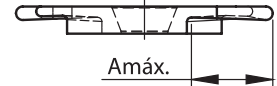
SAL	60	T	300	R			TP
1	2	5	6	8	-		11

1 - Product line

SAL - Swiss Automatic Lathes Line

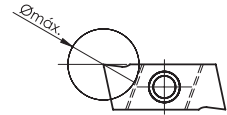
2 - Maximum depth of cut (Turning and Grooving inserts)

25 - 2,5mm | 60 - 6,0mm



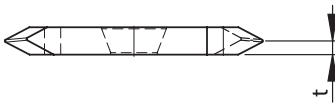
3 - Maximum Cutting Diameter (Parting Off Inserts)

11 - 11,0mm | 13 - 13,0mm



4 - Center distance (Threading Inserts)

050 - 0,5mm | 100 - 1,00mm



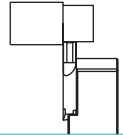
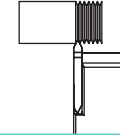
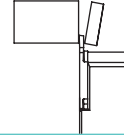
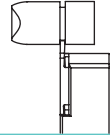
5 - Operations type

G - Grooving

P - Parting off

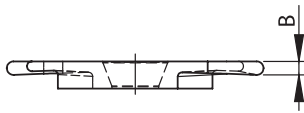
H - Threading

T - Turning



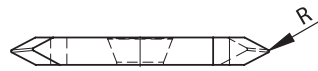
6 - Cut thickness (Grooving, Parting Off and Turning Inserts)

050 - 0,50mm | 070 - 0,70mm | 080 - 0,80mm
090 - 0,90mm | 100 - 1,00mm | 110 - 1,10mm
130 - 1,30mm | 150 - 1,50mm | 160 - 1,60mm
185 - 1,85mm | 200 - 2,00 mm | 300 - 3,00 mm



7 - Corner radius (Threading Inserts)

005 - 0,05mm | 010 - 0,10mm
012 - 0,12mm



8 - Insert / toolholder side

L - Left hand

R - Right hand



9 - Front angle (Parting off)

N - Neutral

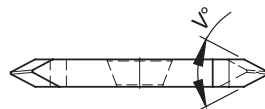
R - Right

L - Left



10 - Angle (Threading Inserts)

55 - 55° | 60 - 60°



11 - Chip Breaker (Turning, Grooving, Parting Off and Threading Inserts)

Turning

TP - Turning steel

Grooving

GS - Square Grooving
GR - Round Grooving

Parting Off

P00 - Front angle 0°
P07 - Front angle 7°

Threading

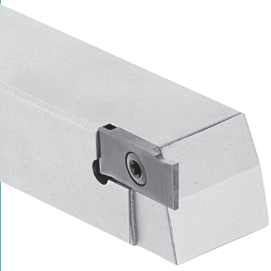
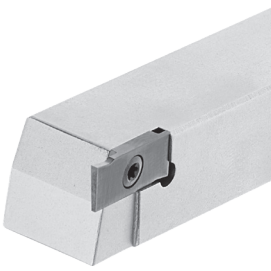
PT - Partial Profile

TOOLHOLDERS CODE KEY - Chave de codificação para suportes | Llave de codificación de herramienta

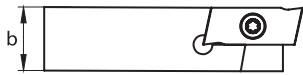
For conventional Toolholders (Metric)									
SAL	H	E	R	-	08	08	-	M	07
1	2	3	4		5	6		7	8

For Conventional Toolholders (Imperial)									
SAL	H	E	L	-	07	05			
1	2	3	4		8	9			

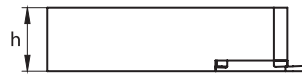
1 - Product line
SAL - Swiss Automatic Lathes Line
2 - Tool type
H - Holder
3 - Internal or External
E - External

4 - Insert / toolholder side	
L - Left hand	R - Right hand
	

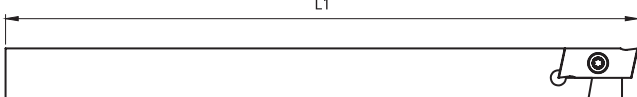
5 - Shank height (metric)
08 - 8 mm
10 - 10 mm
12 - 12 mm
16 - 16 mm



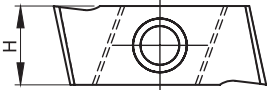
6 - Shank width (metric)
08 - 8 mm
10 - 10 mm
12 - 12 mm
16 - 16 mm



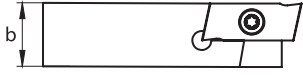
7 - Shank length
L - 140 mm
M - 150 mm



8 - Insert cutting edge length (mm)
07 - 7,0 mm



9 - Shank height (Imperial)
Imperial
05 - 5/16" x 5/16"
06 - 3/8" x 3/8"
08 - 1/2" x 1/2"
10 - 5/8" x 5/8"

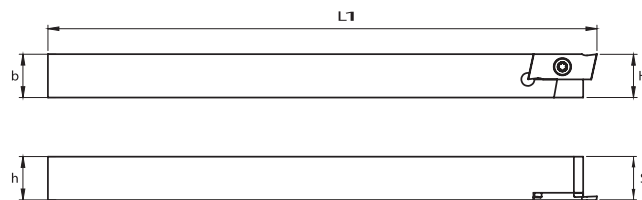


SAL - SWISS AUTOMATIC LATHES

EXTERNAL TOOLHOLDERS | Suportes exteriores | herramientas de tronzado exterior



Left hand style show



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)					* Insert	Screw	Wrench	Stock
		h	b	H	L1	S				
213024700	SALHEL 05-07	0.312	0.312	0.312	6.00	0.312	SAL...L	P0300900	XT 08	☼
213024800	SALHEL 06-07	0.375	0.375	0.375	6.00	0.375	SAL...L	P0300900	XT 08	☼
213024900	SALHEL 08-07	0.500	0.500	0.500	6.00	0.500	SAL...L	P0300900	XT 08	☼
213025000	SALHEL 10-07	0.625	0.625	0.625	6.00	0.625	SAL...L	P0300900	XT 08	☼

☼ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

* Left insert only fits on left toolholder

Grooving Plus

Grooving & Parting Off

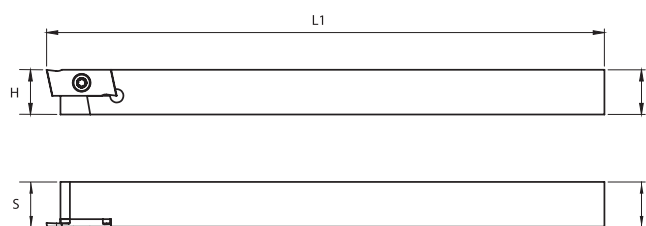
SAL - Swiss Automatic Lathes

Light Grooving

Technical Data



Right hand style show



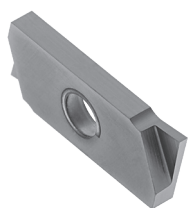
Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (in)					* Insert	Screw	Wrench	Stock
		h	b	H	L1	S				
213024300	SALHER 05-07	0.312	0.312	0.312	6.00	0.312	SAL...R	P0300900	XT 08	☼
213024400	SALHER 06-07	0.375	0.375	0.375	6.00	0.375	SAL...R	P0300900	XT 08	☼
213024500	SALHER 08-07	0.500	0.500	0.500	6.00	0.500	SAL...R	P0300900	XT 08	☼
213024600	SALHER 10-07	0.625	0.625	0.625	6.00	0.625	SAL...R	P0300900	XT 08	☼

☼ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

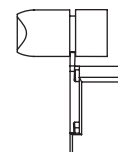
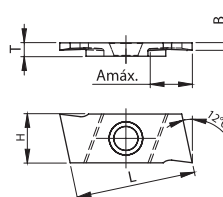
* Right insert only fits on right toolholder

GS SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

For square grooving
Para grooveing quadrado
Para ranurado quadrado



Grooving

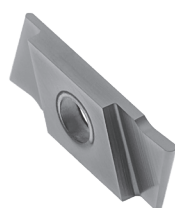
(1) Geometry code	(2) Grade code		PVD								Dimensions Dimensões Dimensiones (in)						Cutting conditions Condições de corte Condiciones de corte			
			P		M		K		S		B	L	T	H	Amáx.	V°	Ømáx.	fn (in/r)	Min.	Max.
			G1	G4	G4	P8	G4	P8	G4	P8										
1130441	SAL25G050R-GS	SAL25G050R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.020	0.669	0.079	0.276	0.098	-	-	0.002	0.001	0.002
1130475	SAL25G070R-GS	SAL25G070R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.028	0.669	0.079	0.276	0.098	-	-	0.002	0.001	0.003
1130477	SAL25G080R-GS	SAL25G080R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.031	0.669	0.079	0.276	0.098	-	-	0.002	0.001	0.004
1130479	SAL25G090R-GS	SAL25G090R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.035	0.669	0.079	0.276	0.098	-	-	0.002	0.001	0.004
1130488	SAL60G110R-GS	SAL60G110R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.043	0.669	0.079	0.276	0.236	-	-	0.002	0.001	0.004
1130490	SAL60G130R-GS	SAL60G130R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.051	0.669	0.079	0.276	0.236	-	-	0.003	0.001	0.005
1130442	SAL60G160R-GS	SAL60G160R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.063	0.669	0.079	0.276	0.236	-	-	0.003	0.001	0.005
1130495	SAL60G185R-GS	SAL60G185R-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.073	0.669	0.079	0.276	0.236	-	-	0.003	0.001	0.006
1130473	SAL25G050L-GS	SAL25G050L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.020	0.669	0.079	0.276	0.098	-	-	0.002	0.001	0.002
1130474	SAL25G070L-GS	SAL25G070L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.028	0.669	0.079	0.276	0.098	-	-	0.002	0.001	0.003
1130476	SAL25G080L-GS	SAL25G080L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.031	0.669	0.079	0.276	0.098	-	-	0.002	0.001	0.004
1130478	SAL25G090L-GS	SAL25G090L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.035	0.669	0.079	0.276	0.098	-	-	0.002	0.001	0.004
1130487	SAL60G110L-GS	SAL60G110L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.043	0.669	0.079	0.276	0.236	-	-	0.002	0.001	0.004
1130489	SAL60G130L-GS	SAL60G130L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.051	0.669	0.079	0.276	0.236	-	-	0.003	0.001	0.005
1130493	SAL60G160L-GS	SAL60G160L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.063	0.669	0.079	0.276	0.236	-	-	0.003	0.001	0.005
1130494	SAL60G185L-GS	SAL60G185L-GS	○	⊗	⊗	○	⊗	○	⊗	○	0.073	0.669	0.079	0.276	0.236	-	-	0.003	0.001	0.006

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

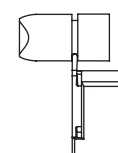
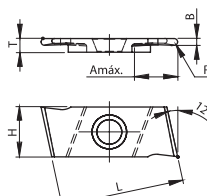
Order code = (1) Geometry code + (2) Grade code

GR SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

For round grooving
Para grooveing redondo
Para ranurado redondo



Grooving

(1) Geometry code	(2) Grade code		PVD								Dimensions Dimensões Dimensiones (in)						Cutting conditions Condições de corte Condiciones de corte			
			P		M		K		S		B	L	T	H	Amáx.	V°	Ømáx.	fn (in/r)	Min.	Max.
			G1	G4	G4	P8	G4	P8	G4	P8										
1130443	SAL60G100R-GR	SAL60G100R-GR	○	⊗	⊗	○	⊗	○	⊗	○	0.039	0.669	0.079	0.276	0.236	-	-	0.002	0.001	0.004
1130492	SAL60G150R-GR	SAL60G150R-GR	○	⊗	⊗	○	⊗	○	⊗	○	0.059	0.669	0.079	0.276	0.236	-	-	0.003	0.001	0.005
1130497	SAL60G200R-GR	SAL60G200R-GR	○	⊗	⊗	○	⊗	○	⊗	○	0.079	0.669	0.079	0.276	0.236	-	-	0.003	0.001	0.006
1130486	SAL60G100L-GR	SAL60G100L-GR	○	⊗	⊗	○	⊗	○	⊗	○	0.039	0.669	0.079	0.276	0.236	-	-	0.002	0.001	0.004
1130491	SAL60G150L-GR	SAL60G150L-GR	○	⊗	⊗	○	⊗	○	⊗	○	0.059	0.669	0.079	0.276	0.236	-	-	0.003	0.001	0.005
1130496	SAL60G200L-GR	SAL60G200L-GR	○	⊗	⊗	○	⊗	○	⊗	○	0.079	0.669	0.079	0.276	0.236	-	-	0.003	0.001	0.006

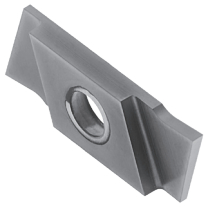
⊗ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

Order code = (1) Geometry code + (2) Grade code

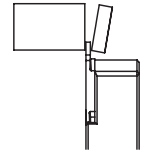
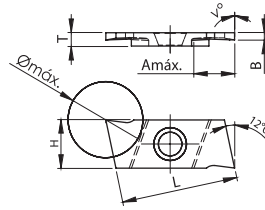
SAL - SWISS AUTOMATIC LATHES

P(P00) SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

Without front angle
Sem ângulo frontal
Sin ángulo frontal



Parting off

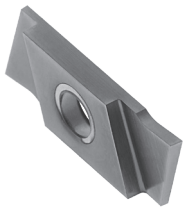
(1) Geometry code	ANSI Reference	ISO Reference	PVD								Dimensions Dimensões Dimensiones (in)						Cutting conditions Condições de corte Condiciones de corte			
			(2) Grade code								B	L	T	H	Amáx.	V°	Ømáx.	fn (in/r)	Min.	Max.
			G1	G4	G4	P8	G4	P8	G4	P8										
1130444	SAL11P100RN-P00	SAL11P100RN-P00	○	⊗	⊗	○	⊗	○	⊗	○	0.039	0.669	0.079	0.276	0.236	0	0.433	0.002	0.001	0.004
1130462	SAL11P150RN-P00	SAL11P150RN-P00	○	⊗	⊗	○	⊗	○	⊗	○	0.059	0.669	0.079	0.276	0.236	0	0.433	0.003	0.001	0.005
1130468	SAL13P200RN-P00	SAL13P200RN-P00	○	⊗	⊗	○	⊗	○	⊗	○	0.079	0.669	0.079	0.276	0.236	0	0.276	0.003	0.001	0.006
1130456	SAL11P100LN-P00	SAL11P100LN-P00	○	⊗	⊗	○	⊗	○	⊗	○	0.039	0.669	0.079	0.276	0.236	0	0.433	0.002	0.001	0.004
1130459	SAL11P150LN-P00	SAL11P150LN-P00	○	⊗	⊗	○	⊗	○	⊗	○	0.059	0.669	0.079	0.276	0.236	0	0.433	0.003	0.001	0.005
1130465	SAL13P200LN-P00	SAL13P200LN-P00	○	⊗	⊗	○	⊗	○	⊗	○	0.079	0.669	0.079	0.276	0.236	0	0.276	0.003	0.001	0.006

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

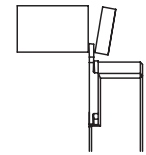
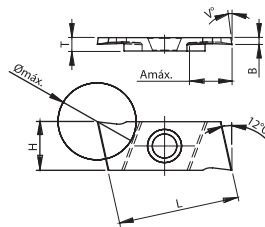
Order code = (1) Geometry code + (2) Grade code

P(P07) SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

Front angle 7°
Ângulo frontal de 7°
Ángulo frontal de 7°



Parting off

(1) Geometry code	ANSI Reference	ISO Reference	PVD								Dimensions Dimensões Dimensiones (in)						Cutting conditions Condições de corte Condiciones de corte			
			(2) Grade code								B	L	T	H	Amáx.	V°	Ømáx.	fn (in/r)	Min.	Max.
			G1	G4	G4	P8	G4	P8	G4	P8										
1130445	SAL11P100RR-P07	SAL11P100RR-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.039	0.669	0.079	0.276	0.236	7	0.433	0.002	0.001	0.003
1130446	SAL11P100RL-P07	SAL11P100RL-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.039	0.669	0.079	0.276	0.236	7	0.433	0.002	0.001	0.003
1130463	SAL11P150RR-P07	SAL11P150RR-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.059	0.669	0.079	0.276	0.236	7	0.433	0.002	0.001	0.004
1130461	SAL11P150RL-P07	SAL11P150RL-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.059	0.669	0.079	0.276	0.236	7	0.433	0.002	0.001	0.004
1130469	SAL13P200RR-P07	SAL13P200RR-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.079	0.669	0.079	0.276	0.236	7	0.276	0.002	0.001	0.005
1130467	SAL13P200RL-P07	SAL13P200RL-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.079	0.669	0.079	0.276	0.236	7	0.276	0.002	0.001	0.005
1130457	SAL11P100LR-P07	SAL11P100LR-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.039	0.669	0.079	0.276	0.236	7	0.433	0.002	0.001	0.003
1130455	SAL11P100LL-P07	SAL11P100LL-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.039	0.669	0.079	0.276	0.236	7	0.433	0.002	0.001	0.003
1130460	SAL11P150LR-P07	SAL11P150LR-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.059	0.669	0.079	0.276	0.236	7	0.433	0.002	0.001	0.004
1130458	SAL11P150LL-P07	SAL11P150LL-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.059	0.669	0.079	0.276	0.236	7	0.433	0.002	0.001	0.004
1130466	SAL13P200LR-P07	SAL13P200LR-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.079	0.669	0.079	0.276	0.236	7	0.276	0.002	0.001	0.005
1130464	SAL13P200LL-P07	SAL13P200LL-P07	○	⊗	⊗	○	⊗	○	⊗	○	0.079	0.669	0.079	0.276	0.236	7	0.276	0.002	0.001	0.005

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

Order code = (1) Geometry code + (2) Grade code

GROOVING & PARTING OFF

Overview

Grooving Plus

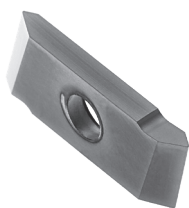
Grooving & Parting Off

SAL - Swiss Automatic Lathes

Light Grooving

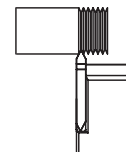
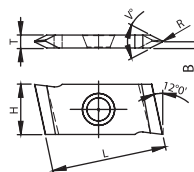
Technical Data

PT SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

For partial profile threading
Para perfil parcial de roscagem
Para perfil parcial de roscado



Threading

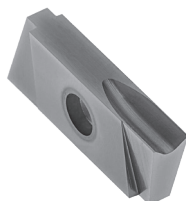
(1) Geometry code	(2) Grade code		PVD								Dimensions Dimensões Dimensiones (in)						Cutting conditions Condições de corte Condiciones de corte			
			P		M		K		S		B	L	T	H	Amáx.	V°	Ømáx.	fn (in/r)	Min.	Max.
			G1	G4	G4	P8	G4	P8	G4	P8										
1130472	SAL100H012R55-PT	SAL100H012R55-PT	○	⊗	⊗	○	⊗	○	⊗	○	0.043	0.669	0.079	0.276	0.005	2.165	-	0.031	0.008	0.079
1130447	SAL100H012R60-PT	SAL100H012R60-PT	○	⊗	⊗	○	⊗	○	⊗	○	0.043	0.669	0.079	0.276	0.005	2.362	-	0.031	0.008	0.079
1130470	SAL100H012L55-PT	SAL100H012L55-PT	○	⊗	⊗	○	⊗	○	⊗	○	0.043	0.669	0.079	0.276	0.005	2.165	-	0.031	0.008	0.079
1130471	SAL100H012L60-PT	SAL100H012L60-PT	○	⊗	⊗	○	⊗	○	⊗	○	0.043	0.669	0.079	0.276	0.005	2.362	-	0.031	0.008	0.079

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

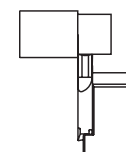
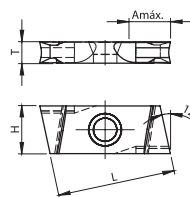
Order code = (1) Geometry code + (2) Grade code

TP SERIES | Inserts | Pastilhas | Plaquetas



Right hand style show

For turning
Para torneamento
Para torneado



Turning

(1) Geometry code	(2) Grade code		PVD								Dimensions Dimensões Dimensiones (in)						Cutting conditions Condições de corte Condiciones de corte			
			P		M		K		S		B	L	T	H	Amáx.	V°	Ømáx.	fn (in/r)	Min.	Max.
			G1	G4	G4	P8	G4	P8	G4	P8										
1130501	SAL60T300R-TP	SAL60T300R-TP	○	⊗	⊗	○	⊗	○	⊗	○	-	0.669	0.125	0.276	0.236	-	-	0.003	0.001	0.005
1130499	SAL60T300L-TP	SAL60T300L-TP	○	⊗	⊗	○	⊗	○	⊗	○	-	0.669	0.125	0.276	0.236	-	-	0.003	0.001	0.005

⊗ Stock item | Produto de stock | Itens de stock

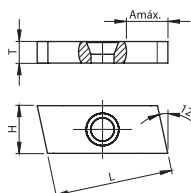
○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

Order code = (1) Geometry code + (2) Grade code

BLANKS FOR GRINDING | Blanks para personalizar | Blanks para personalizar



Right hand style show



Inserts blanks “do it yourself” grinding are available allowing modifications of the insert for any machining operation.

As pastilhas de blank “faça você mesmo” permitem a personalização da pastilha para qualquer operação de maquinação.

Las plaquetas de blank “haga usted mismo” permiten la personalización de la plaqueta para cualquiera operación de maquinación.

(1) Geometry code	(2) Grade code		Uncoated			Dimensions Dimensões Dimensiones (in)						
			10	12	14	B	L	T	H	Amáx.	V°	Ømáx.
			PH0910	PH0920	PH0135							
1130440	BLANK SALR 17x7x2	BLANK SALR 17x7x2	⊗	⊗	⊗	-	0.689	0.079	0.295	-	-	-
1130504	BLANK SALR 17x7x3,17	BLANK SALR 17x7x3,17	⊗	⊗	⊗	-	0.689	0.125	0.295	-	-	-
1130453	BLANK SALL 17x7x2	BLANK SALL 17x7x2	⊗	⊗	⊗	-	0.689	0.079	0.295	-	-	-
1130505	BLANK SALL 17x7x3,17	BLANK SALL 17x7x3,17	⊗	⊗	⊗	-	0.689	0.125	0.295	-	-	-

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

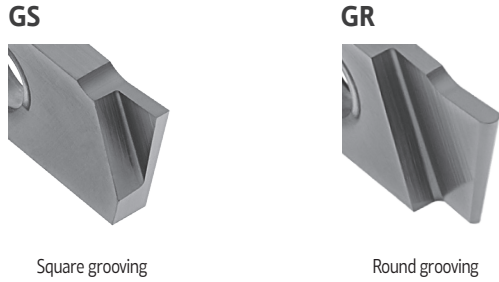
Order code = (1) Geometry code + (2) Grade code

SAL - SWISS AUTOMATIC LATHES

GROOVING | Canais | Ranurado



- High precision
- Close tolerances
- Wide variety of insert widths



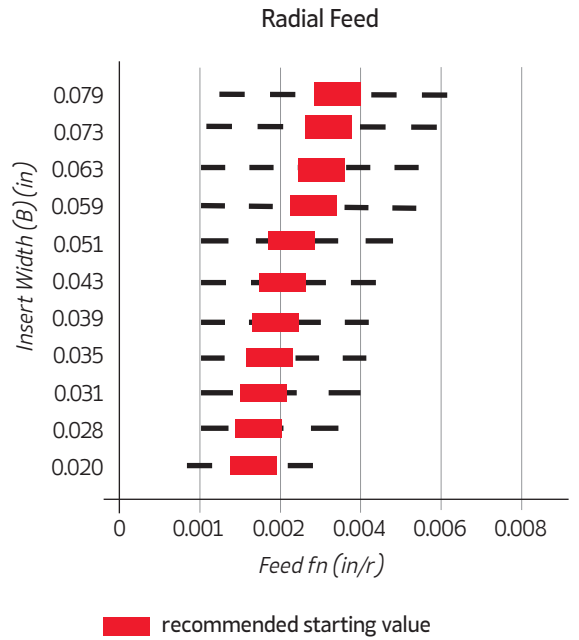
Recommended cutting conditions

P	M	K	S
197-656	197-591	197-492	66-164


Recommended grade PH7920, (Vc) SFM.

Grade PH7910 and PH7135

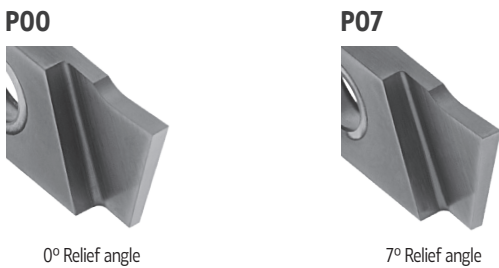
Available under request (4 weeks delivery time)



PARTING OFF | Corte | Tronzado



- When parting off with a sub-spindle, it is more productive to use a straight cutting edge. This is a more stable parting method and will generate the best surface finish.
- When parting off without a sub-spindle, we recommend you use an insert with a maximum 7° front angle to minimize the risk of burr and pips on the component.
- When parting off with 7° front angled inserts, we recommend reducing the feed rate by approximately 30%.



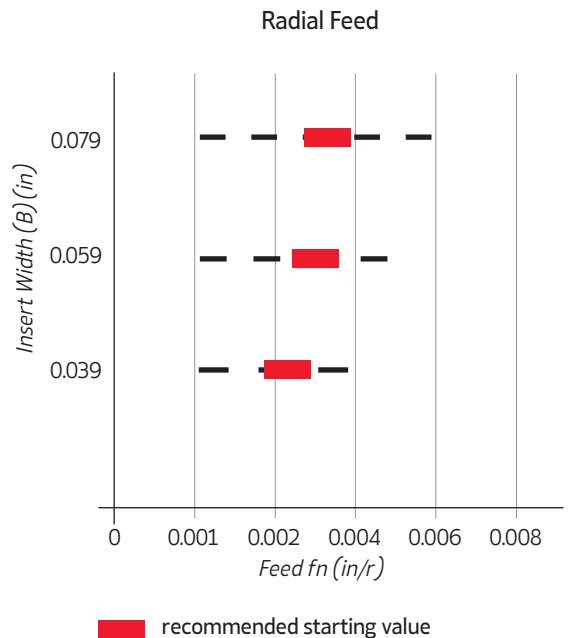
Recommended cutting conditions

P	M	K	S
197-656	197-591	197-492	66-164

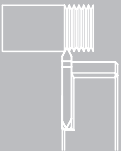
Recommended grade PH7920, (Vc) SFM.

Grade PH7910 and PH7135

Available under request (4 weeks delivery time)



THREADING || Roscagem | Roscado



Two types of threading:

- Partial profile 55°
- Partial profile 60°

Pitch from 12 - 94 TPI / 0.010 - 0.078 in



Partial profile

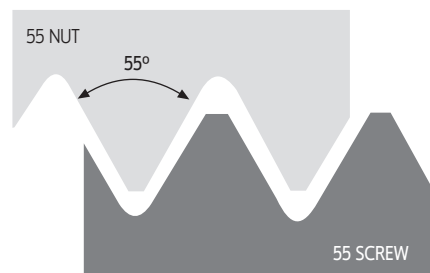
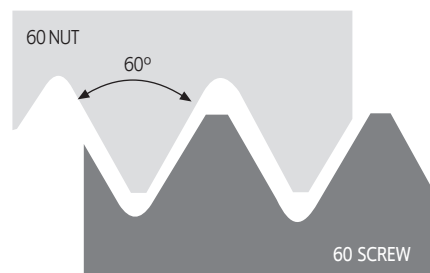
Recommended cutting conditions

P	M	K	S
197-656	197-591	197-492	66-164


Recommended grade PH7920, (Vc) SFM.

Grade PH7910 and PH7135

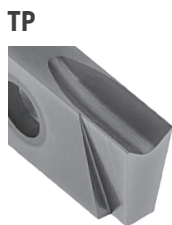
Available under request (4 weeks delivery time)



TURNING || Torneamento | Torneado



- Insert for turning
- Maximum deep of cut is 0.098 in
- Too low cutting speed will result in inadequate tool life and it is advisable to follow cutting speed recommendations.



Turning steel

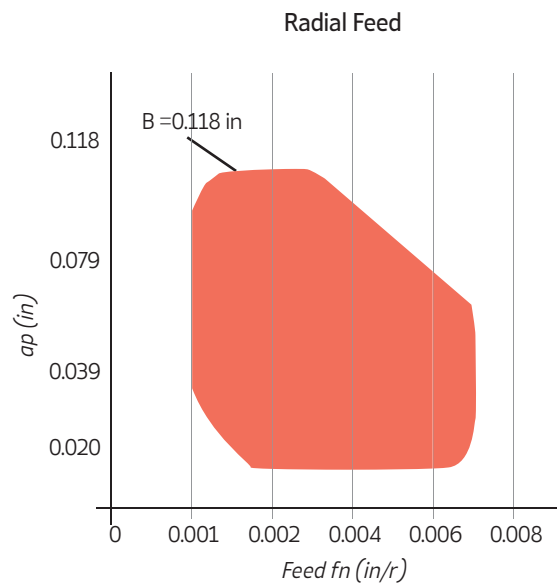
Recommended cutting conditions

P	M	K	S
197-656	197-591	197-492	66-164

Recommended grade PH7920, (Vc) SFM.

Grade PH7910 and PH7135

Available under request (4 weeks delivery time)



■ Machining field



INSERTS | Pastilhas | Plaquetas



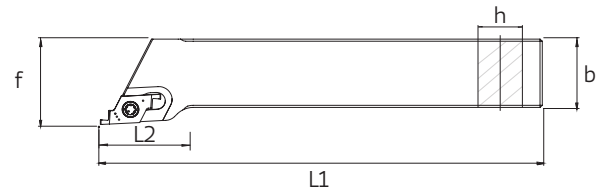
1 - Product Line	LG - Light Grooving
2 - Insert size	06 - IC=6,35 mm 0.250 in
3 - Cutting edges	02 - 2 cutting edges
4 - Work side	R - Right L - Left
5 - Edge width	110=1,1 mm 0.043 in







TOOLHOLDERS | Suportes | Herramientas



1 - Product Line	LG - Light Grooving
2 - Product type	H - Holder
3 - Insert size	06 - IC=6,35 mm 0.250 in
4 - Cutting edges	02 - 2 Cutting edges
5 - Internal / External	I - Internal E - External
6 - Work side	R - Right L - Left
7 - Tool length	150 - 150 mm 5.906 in
8 - Shank dimension	Internal: 16 - Ø16 mm 0.630 in External: 2020 - 20 mm x 20 mm 0.787 x 0.787 in

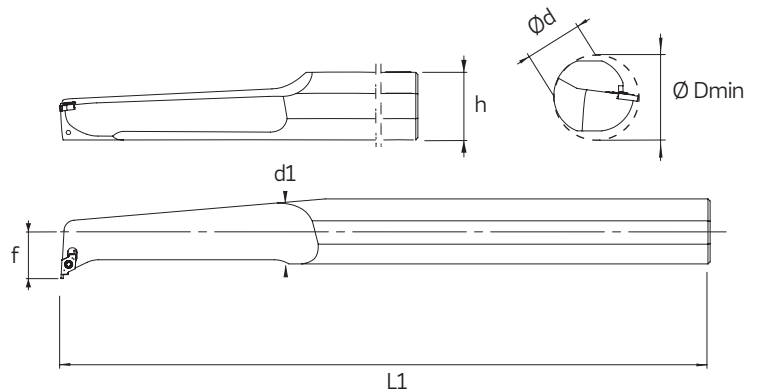
LGH-ER/L













Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Insert	Stock
		h	b1	L1	L2	f		
Right Toolholder								
183031100	LGH 0602-ER 100 1616	16	16	100	21	20	LG 0602R	
183031200	LGH 0602-ER 125 2020	20	20	125	25	25	LG 0602R	
183031300	LGH 0602-ER 150 2525	25	25	150	32	32	LG 0602R	
Left Toolholder								
183030300	LGH 0602-EL 100 1616	16	16	100	21	20	LG 0602L	
183030400	LGH 0602-EL 125 2020	20	20	125	25	25	LG 0602L	
183030500	LGH 0602-EL 150 2525	25	25	150	32	32	LG 0602L	

 Stock item | Produto de stock | Itens de stock  Available under request | Disponível sobre consulta | Disponible bajo consulta

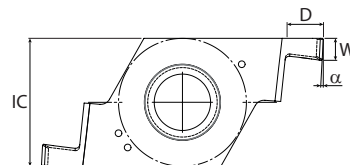
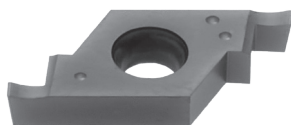
LGH-IR/L



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Insert	ØDmin	Stock
		Ød	h	d1	L1	f			
Right Toolholder									
183031400	LGH 0602-IR 150 12	12	11	11,5	150	9	LG 0602R	16	
183031500	LGH 0602-IR 150 16	16	15	15	150	11	LG 0602R	20	
183031600	LGH 0602-IR 170 20	20	18	19	170	13	LG 0602R	25	
183031700	LGH 0602-IR 200 25	25	23	24	200	17	LG 0602R	32	
183031800	LGH 0602-IR 300 32	32	30	31	300	22	LG 0602R	40	
Left Toolholder									
183030600	LGH 0602-IL 150 12	12	11	11,5	150	9	LG 0602L	16	
183030700	LGH 0602-IL 150 16	16	15	15	150	11	LG 0602L	20	
183030800	LGH 0602-IL 170 20	20	18	19	170	13	LG 0602L	25	
183030900	LGH 0602-IL 200 25	25	23	24	200	17	LG 0602L	32	
183031000	LGH 0602-IL 300 32	32	30	31	300	22	LG 0602L	40	

 Stock item | Produto de stock | Itens de stock  Available under request | Disponível sobre consulta | Disponible bajo consulta

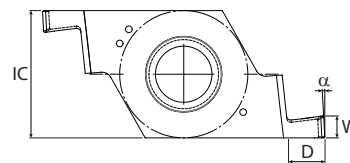
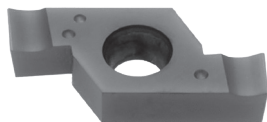
LG-R



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)				For circlip width	Stock
		IC	α	W	D		PH7920
1130597G4	LG 0602R110	6,35	3	1,10	0,8	1,0	
1130598G4	LG 0602R130	6,35	3	1,30	1,4	1,2	
1130599G4	LG 0602R160	6,35	3	1,60	1,7	1,5	
1130600G4	LG 0602R185	6,35	3	1,85	2,0	1,75	
1130601G4	LG 0602R215	6,35	3	2,15	2,4	2,0	
1130602G4	LG 0602R265	6,35	3	2,65	2,7	2,5	
1130603G4	LG 0602R300	6,35	3	3,00	3,0	-	
1130604G4	LG 0602R315	6,35	3	3,15	3,0	3,0	

Stock item | Produto de stock | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta

LG-L



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)				For circlip width	Stock
		IC	α	W	D		PH7920
1130589G4	LG 0602L110	6,35	3	1,10	0,8	1,0	
1130590G4	LG 0602L130	6,35	3	1,30	1,4	1,2	
1130591G4	LG 0602L160	6,35	3	1,60	1,7	1,5	
1130592G4	LG 0602L185	6,35	3	1,85	2	1,75	
1130593G4	LG 0602L215	6,35	3	2,15	2,4	2,0	
1130594G4	LG 0602L265	6,35	3	2,65	2,7	2,5	
1130595G4	LG 0602L300	6,35	3	3,00	3	-	
1130596G4	LG 0602L315	6,35	3	3,15	3	3,0	

Stock item | Produto de stock | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta

SCREWS & KEYS



Screws

Order code Código	Reference Referência Referencia	Stock
290074100	D0503000	<input checked="" type="checkbox"/>
290020700	D0603600	<input checked="" type="checkbox"/>
290062900	D0602200	<input checked="" type="checkbox"/>
290087400	D0602600	<input checked="" type="checkbox"/>
290087500	D0603100	<input checked="" type="checkbox"/>
290044800	P0260700	<input checked="" type="checkbox"/>
290044600	P5401390	<input checked="" type="checkbox"/>
290044900	P5401391	<input checked="" type="checkbox"/>

Keys

Order Code Código	Reference Referência Referencia	Stock
290011700	XT08	<input checked="" type="checkbox"/>
290013100	XT10	<input checked="" type="checkbox"/>

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

WRENCHES



Order code Código	Reference Referência Referencia	Stock
290021200	SS40	<input checked="" type="checkbox"/>
290021300	SS50	<input checked="" type="checkbox"/>

Order code Código	Reference Referência Referencia	Stock
290074400	LE05	<input checked="" type="checkbox"/>

Order code Código	Reference Referência Referencia	Stock
290079600	LE25-30	<input checked="" type="checkbox"/>

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

GROOVING & PARTING OFF GRADES | Graus para Sangramento | Calidades para Tronzado

	1	5	10	15	20	25	30	35	40	45	50			
P STEEL	PH5115			PH5125			PH5135			PHS135 <small>NEW</small>			CVD	
	PH7920			PHP920 <small>NEW</small>			PHP930 <small>NEW</small>							PVD
				PHS135 <small>NEW</small>										
				PH7920			PHP920 <small>NEW</small>			PHP930 <small>NEW</small>				
				PHS135 <small>NEW</small>										
				PH7920			PHP920 <small>NEW</small>			PHP930 <small>NEW</small>				
M STAINLESS SEEL				PHS135 <small>NEW</small>									PVD	
				PH7920			PHP920 <small>NEW</small>			PHP930 <small>NEW</small>				
				PHS135 <small>NEW</small>										
				PH7920			PHP920 <small>NEW</small>			PHP930 <small>NEW</small>				
K CAST IRON	PH5705			PH5320			PH5135			PHS135 <small>NEW</small>			CVD	
				PH5705			PH5320			PHS135 <small>NEW</small>				
				PH5705			PH5320			PHS135 <small>NEW</small>				
				PH5705			PH5320			PHS135 <small>NEW</small>				
N ALUMINIUM & NFM	PH0910												UNCOTED	
S HEAT RESISTENT / TITANIUM ALLOYS	PH7920			PHP920 <small>NEW</small>			PHP930 <small>NEW</small>						PVD	
				PH7920			PHP920 <small>NEW</small>			PHP930 <small>NEW</small>				
				PH7920			PHP920 <small>NEW</small>			PHP930 <small>NEW</small>				

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GROOVING & PARTING OFF

Overview

Grooving Plus

Grooving & Parting Off

SAL - Swiss Automatic Lathes

Light Grooving

Technical Data

GROOVING & PARTING OFF GRADES DESCRIPTION

Graus de Sangramento | Calidades para Tronzado

PVD GRADES

PH7920
 P10-P35
 M10-M25
 S10-S30

A hard carbide substrate coated with PVD coating. Suitable for machining under good conditions or lightly interrupted cuts.

PHP920 NEW
 P10-P35
 M10-M25
 S10-S30

A hard carbide insert coated with revolutionary PVD coating with great adhesion and smoothness. Recommended for machining under good conditions or lightly interrupted cuts at medium to high cutting speeds.

PHP930 NEW
 P20-P40
 M20-M40
 S15-S35

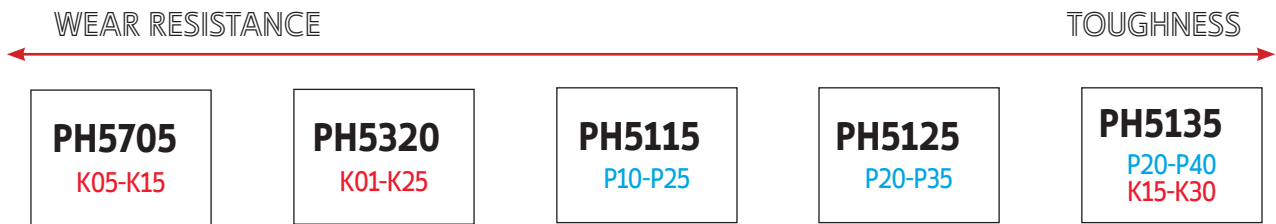
A tough carbide insert coated with revolutionary PVD coating with great adhesion and smoothness. Recommended for machining under lightly to highly interrupted cuts at low to medium cutting speeds.



CVD GRADES

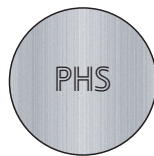
PH5

A thick CVD coating with a smooth surface. Works great at medium temperatures.



PHS

PHS135 NEW
 P20-P40
 M15-M35
 K15-K30



A tough substrate combined with a thin CVD coating with excellent thermal resistance and hardness at high temperature. Excellent solution for difficult operations at low velocities.

UNCOATED CARBIDE GRADE

PH0910
 N01-N20

Uncoated carbide with polished surface. 1st choice for machining aluminum alloys.

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GROOVING & PARTING OFF

Overview

Grooving Plus

Grooving & Parting Off

SAL - Swiss Automatic Lathes

Light Grooving

Technical Data

RECOMMENDED GRADES AND CUTTING SPEEDS (SFM)

Graus recomendados e velocidades de corte (SFM) | Calidades recomendadas y velocidades de corte (SFM)

ISO	Material	Grade fn (in/r) HB (brinell)	CVD Coating				PVD Coating		
			← Wear Resistance				Toughness →		
			PH5115	PH5125	PH5135	PHS135	PH7920	PHP920	PHP930
P	Unalloyed steel	125-170	296-591	263-558	230-525	230-525	197-525	197-525	164-492
	Low-alloy steel	180-350	230-525	197-492	197-460	197-492	197-460	197-492	164-460
	High-alloy steel	200-325	164-492	132-460	132-427	132-460	164-427	164-460	132-427

ISO	Material	Grade fn (in/r) HB (brinell)	CVD Coating	PVD Coating			
			← Wear Resistance			Toughness →	
			PHS135	PH7920	PHP920	PHP930	
M	SS - Ferritic / Martensitic	200-330	230-492	197-460	197-460	164-427	
	SS - Austenitic / Duplex	180-330	197-427	197-394	197-427	164-361	
	SS - Ferritic / Duplex	230-260	132-394	132-361	132-394	132-361	

ISO	Material	Grade fn (in/r) HB (brinell)	CVD Coating				
			← Wear Resistance				Toughness →
			PH5705	PH5320	PH5115	PHS135	
K	Marble cast iron	130-230	328-722	296-689	296-656	263-558	
	Grey cast iron	180-220	328-656	296-624	263-591	230-492	
	Nodular cast iron	160-380	263-558	263-525	230-492	164-460	

ISO	Material	Grade fn (in/r) HB (brinell)	Uncoated
			PH0910
			0.002 - 0.018
N	Aluminium alloys	60-130	623-5904

ISO	Material	Grade fn (in/r) HB (brinell)	PVD Coating			
			← Wear Resistance			Toughness →
			PH7920	PHP920	PHP930	
S	Heat resistant super alloys (Iron base)	200-280	115-296	-	-	
	Heat resistant super alloys (Nickel base)	250-320	73-197	-	-	
	Heat resistant super alloys (Cobalt base)	200-320	99-296	99-296	66-263	