

INSERTS

Geometry	Drill Dia.	Insert Number	Dimensions (mm)			Stock				
			D1	S1	Re	VP15TF	UP20M	GP20M	UE6020	US735
U1 Breaker 	ø12—ø14.5	GCMT040204-U1	5.0	2.38	0.4		●			
	ø15—ø17.5	GPMT060204-U1	5.56	2.38	0.4		●		●	
	ø18—ø22.5	GPMT070204-U1	6.35	2.38	0.4		●		●	
	ø23—ø27.5 ø49—ø56	GPMT090304-U1	7.94	3.18	0.4		●		●	
	ø28—ø34	GPMT11T308-U1	9.525	3.97	0.8		●		●	
	ø35—ø48	GPMT140408-U1	12.70	4.76	0.8		●		●	
U2 Breaker 	ø12—ø14.5	GCMT040204-U2	5.0	2.38	0.4	●		●		
	ø15—ø17.5	GPMT060204-U2	5.56	2.38	0.4	●	●		●	●
	ø18—ø22.5	GPMT070204-U2	6.35	2.38	0.4	●	●		●	●
	ø23—ø27.5 ø49—ø56	GPMT090304-U2	7.94	3.18	0.4	●	●		●	●
	ø28—ø34	GPMT11T308-U2	9.525	3.97	0.8	●	●		●	●
	ø35—ø48	GPMT140408-U2	12.70	4.76	0.8	●	●		●	●
U3 Breaker 	ø15—ø17.5	GPMT060204-U3	5.56	2.38	0.4		●		●	●
	ø18—ø22.5	GPMT070204-U3	6.35	2.38	0.4		●		●	●
	ø23—ø27.5 ø49—ø56	GPMT090304-U3	7.94	3.18	0.4		●		●	●
	ø28—ø34	GPMT11T308-U3	9.525	3.97	0.8		●		●	●
	ø35—ø48	GPMT140408-U3	12.70	4.76	0.8		●		●	●

INSERT RECOMMENDATION

CHIP BREAKER RECOMMENDATION

◎ : 1st Recommendation ○ : 2nd Recommendation

Work Material	P						M		K			
	Mild Steel		Carbon Steel		Alloy Steel		Stainless Steel		Cast Iron		Ductile Cast Iron	
	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT
U1	◎	◎	○	○	○	○	○	○	○	○	○	○
U2	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
U3		○		○		○		○		○		○

INSERT GRADE RECOMMENDATION

◎ : 1st Recommendation ○ : 2nd Recommendation

Work Material	P						M		K			
	Mild Steel		Carbon Steel		Alloy Steel		Stainless Steel		Cast Iron		Ductile Cast Iron	
	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT
VP15TF		○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
UP20M	◎	◎	○	○	○	○	○	○	○	○	○	○
GP20M	○		○		○		○		○		○	
UE6020		○		○		○		○		○		○
US735		○		○		○		○		○		○

CUTTING CONDITIONS > L146
 USAGE NOTE > L149
 TECHNICAL DATA > N001