

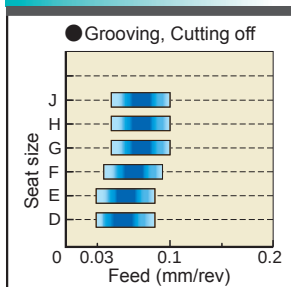
GROOVING SYSTEM

RECOMMENDED CUTTING CONDITIONS [For External Grooving]

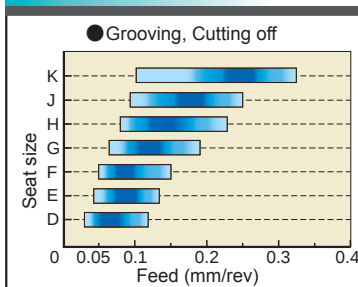
*Below are the recommended cutting conditions when using the modular holder GYHR/L2525M00-M25R/L with the modular blade GYM25○A-○○○.

Recommended feed rate and depth of cut

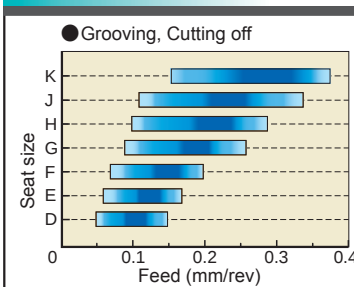
GU BREAKER



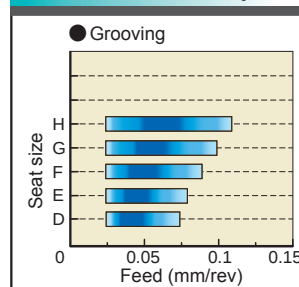
GS BREAKER



GM BREAKER



FLAT TOP GFGS (CBN)

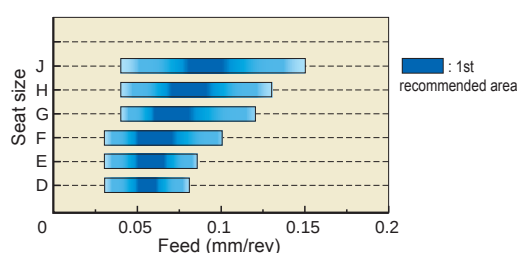


■ : 1st recommended area

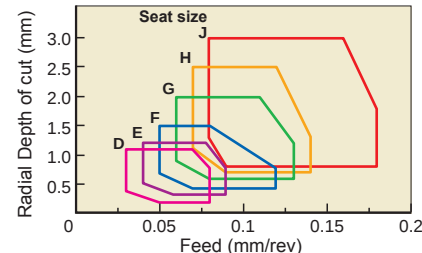
MF BREAKER

● Grooving

Seat Size (mm)			
D	2.00	G	4.00
	2.24		4.24
E	2.39	H	4.75
	2.50		5.00
	2.74		5.24
F	3.00	J	6.00
	3.18		6.31
	3.24		6.35
		K	8.00



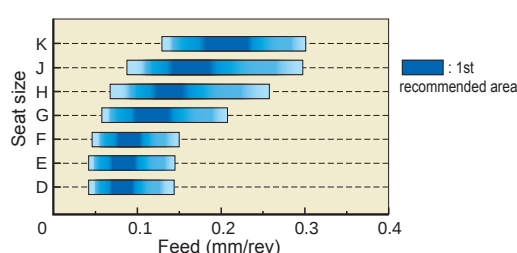
● Turning



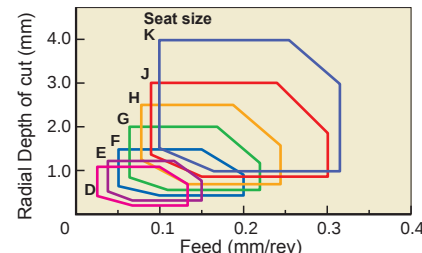
■ : 1st recommended area

MS BREAKER

● Grooving



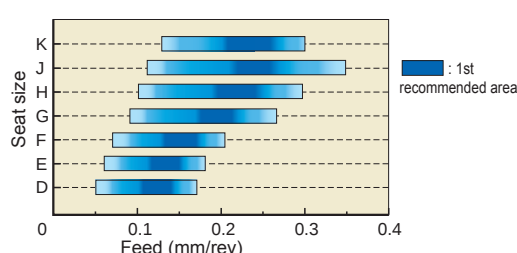
● Turning



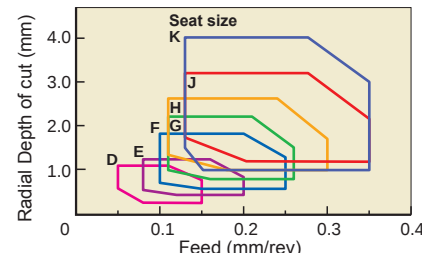
■ : 1st recommended area

MM BREAKER

● Grooving



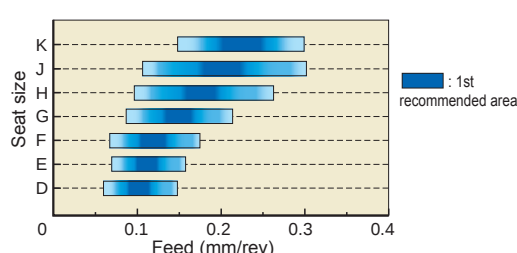
● Turning



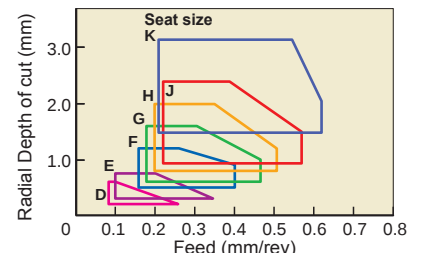
■ : 1st recommended area

BM BREAKER

● Grooving



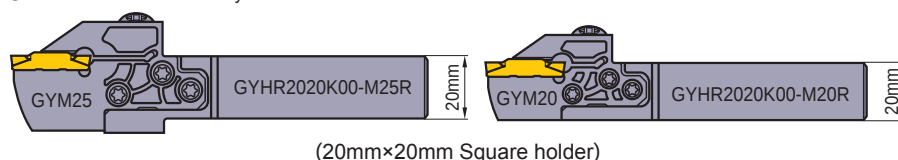
● Turning



■ : 1st recommended area

(Note) When using a combination as shown below, decrease the recommended feed rate by 20% and 40% respectively.

● Decrease the feed rate by 20%.



● Decrease the feed rate by 40%.

