

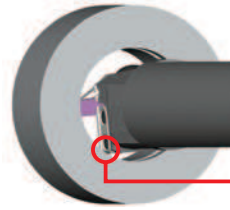
LIMITATION OF THE MAXIMUM GROOVE DEPTH

•When using the mono block type

The maximum groove depth is not limited by the cutting diameter.

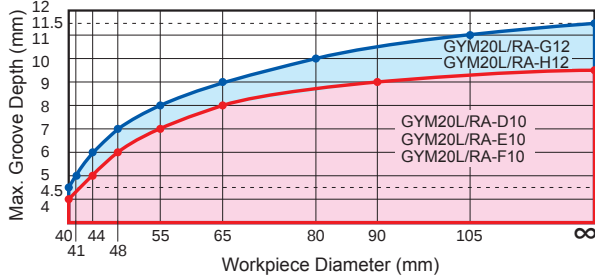
•When using the modular blade type

The maximum groove depth is limited by the cutting diameter.

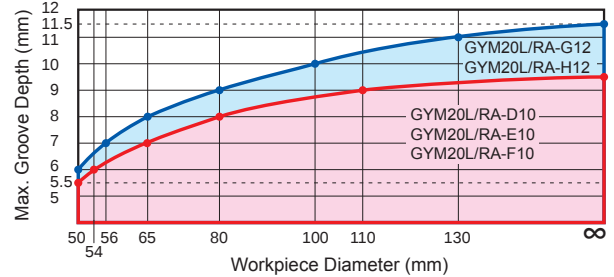


Due to interference of this part, the maximum groove depth is limited by the cutting diameter.

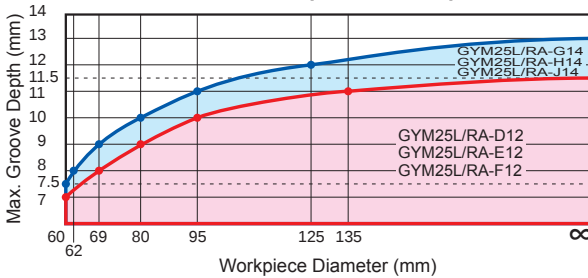
•Shank Diameter=32mm (GYM20 Blade)



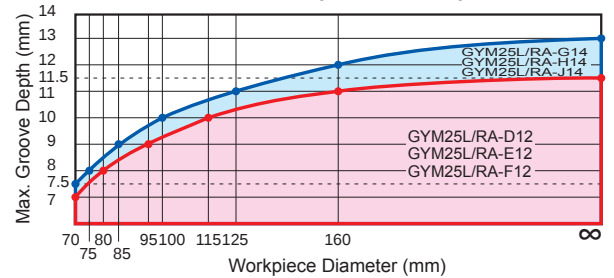
•Shank Diameter=40mm (GYM20 Blade)



•Shank Diameter=40mm (GYM25 Blade)



•Shank Diameter=50mm (GYM25 Blade)



GROOVING

RECOMMENDED CUTTING SPEED (m/min)

	Work Material	Hardness	Grade	Cutting Speed (m/min)					
				50	100	150	200	250	300
P	Mild Steel	≤160HB	VP20RT		80	180			
			VP10RT		90	190			
			NX2525		70	170			
	Carbon Steel Alloy Steel	160—280HB	VP20RT		60	140			
			VP10RT		70	150			
			MY5015		90	210			
		280HB≤	NX2525		55	135			
			VP20RT		50	110			
			VP10RT		60	120			
M	Stainless Steel	≤270HB	MY5015		80	160			
			NX2525		45	105			
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT		50	110			
			VP10RT		60	120			
			MY5015		80	160			
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT		50	110			
			VP10RT		60	120			
			MY5015		80	160			
S	Heat Resistant Alloy Titanium Alloy	—	VP20RT	30	60				
			VP10RT	40	70				
			RT9010	40	70				
H	Hardened steel	50HRC≤	MB8025		60	100			

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

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