

# GROOVING SYSTEMS

BY **GUHRING**

***NEW!***

***INTERACTIVE PDF***

Click on the underlined text

**NEW**

- Boring out
- Grooving
- Threading
- Broaching
- Special tools



// FLEXIBLE  
// ECONOMICAL  
// ACCURATE

**GUHRING**

# GROOVING SYSTEMS

BY **GUHRING**



# GROOVING SYSTEMS

highest quality and flexibility thanks  
to a vast product offering



## GRINDING – INDEXABLE INSERTS AND CUTTING INSERTS

Production completed entirely on  
Guhring-built grinding machines



## COATING – INDEXABLE INSERTS AND CUTTING INSERTS

// In-house coating on  
Guhring-built coating systems  
// Latest coating technology  
and coating types



**MILLING/TURNING –  
HOLDER PRODUCTION**



**GUHRING'S IN-HOUSE CARBIDE PRODUCTION**

Blanks – Indexable inserts and cutting inserts  
Guhring-produced carbide grades



Guhring R&D for innovative tool developments

Highest quality standard world-wide

Pooled expertise under one roof

Vast product offering

Machining technology with an edge



**GUHRING**

Production location

Grooving tools







Dr. Jörg Gühring

President



Oliver Gühring

Sales and Marketing  
Director

7000

Employees  
world-wide



3500

Employees  
Germany



Internal training and further  
education program



International knowledge transfer thanks  
to world-wide exchange program for  
employees





## Dietmar Pfränger

R&D, Logistics, Technical and  
Production Director



## Bernd Schatz

Financial and Commercial  
Director

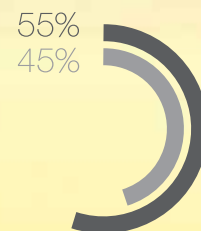


50000

Standard tools

2000

Tool types



■ Standard tools  
■ Special tools

# Everything from one supplier – comprehensive and global

With a global network of manufacturing sites Guhring develops and produces precision tools for every major market. Customers from various industries rely on our innovative cutting tools, manufactured to the highest level of uniform quality standards across the globe.

28

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With innovative technologies Guhring meets specific customer requirements from process proposal to production application of precision tools – flexibly, promptly, globally. To aid in this experience, field experts across the world are available to offer on-site support at customer locations. Production, service and contact persons are available from one supplier world-wide.

In-house carbide production

In-house machine construction

In-house coating plants

Highest quality standards world-wide

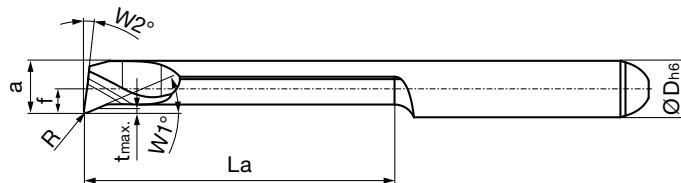


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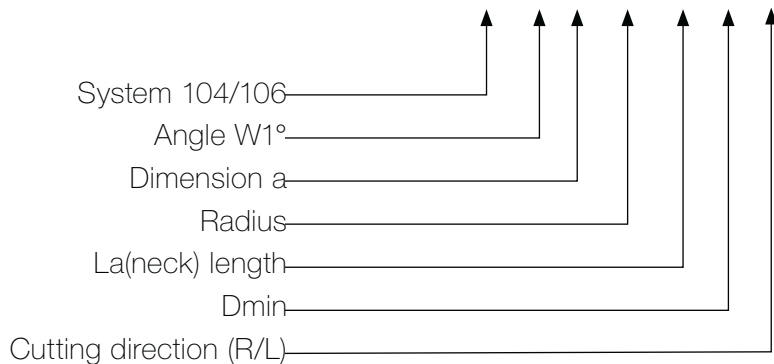
# GROOVING SYSTEMS

Explanation of the article description

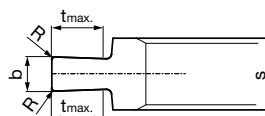
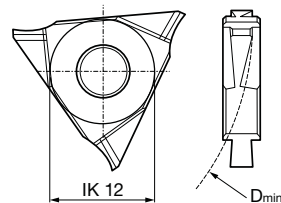
## Article description System 104/106



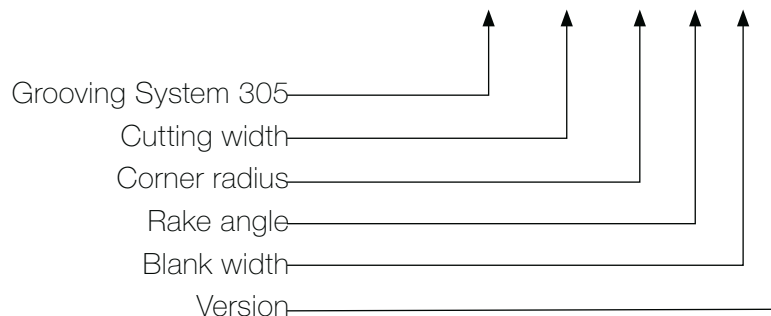
Tool description: Example: GT104.2326.010.22.30.R



## Article description System 305



Tool description: Example: GE305.0250.020.BA.04.N



When ordering please always state the  
**Series no. and the Code No. i.e.:**  
 Article GG104.VM02.040.04.15.R,  
 TiN-coated = **25164 4.001**

## Ordering example

Micro-precision tools for internal threading

Cutting insert for internal threading, full profile - metric standard threads



• pitch P = 0.4-0.8

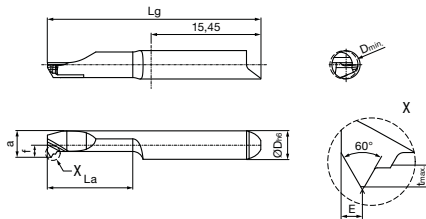
for tool holders type GH104/GB104 see from page 16

**GUHRING** NAVIGATOR

Cutting data page 15Q

Tool material	Solid carbide		
Type	GG 104	GG 104	GG 104
Surface	Ⓢ	ⓐ	○
	TiN	TiAlN-nanoA	bright

System 104



Right hand version shown  
 Left hand version mirror image



Article no. **25164** **25166** **25170**

Cutting direction

Series no.

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.VM02.040.04.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	4.00	25.00	4.00
4.002	GG104.VM02.040.07.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	7.00	25.00	4.00
4.003	GG104.VM02.040.12.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	12.00	30.00	4.00
4.004	GG104.VM03.050.04.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.35	4.00	25.00	4.00
4.005	GG104.VM03.050.07.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.35	7.00	25.00	4.00

Code No.



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## GROOVING SYSTEMS

Highest quality and flexibility  
thanks to a vast product offering.  
All from one supplier.



# SYSTEM 104

## Micro-precision tools from Ø 0.7 mm

Tool holder..... from page 15

Cutting inserts..... from page 28

## Broaching from Ø 1.5 mm

Tool holder..... from page 56

Cutting inserts..... from page 57



# SYSTEM 106

## Micro-precision tools from Ø 5 mm

Tool holder..... from page 61

Cutting inserts..... from page 74

## Broaching from Ø 6 mm

Tool holder..... from page 118

Cutting inserts..... from page 119



# SYSTEM 305

## Grooving and parting off

Tool holder..... from page 121

Indexable inserts..... from page 137

**Navigator & Technical information**..... from page 148

**Spare Parts**..... from page 160

**Special Solutions**..... from page 162

# 104





# SYSTEM 104

## MICRO-PRECISION TOOLS



Round shank holder

from page 16



Square shank holder

from page 23



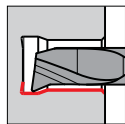
Modular holder

from page 25

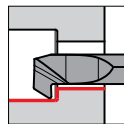


Round shank holder  
Broaching  
page 56

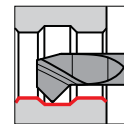
Tool holder



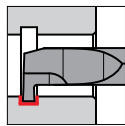
Boring out  
and profiling  
from page 28



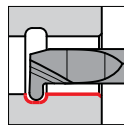
Back boring  
and profiling  
from page 39



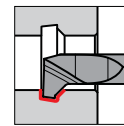
Boring out  
and chamfering  
page 41



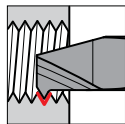
Internal grooving,  
straight slots  
page 42



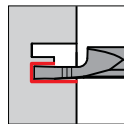
Internal grooving,  
full radius slots  
page 44



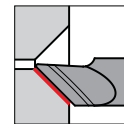
Internal pre-grooving  
and chamfering  
page 45



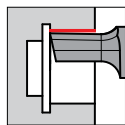
Internal threading  
from page 51



Axial grooving bores  
from page 46



Axial chamfering  
bores  
page 50



Broaching  
from page 57

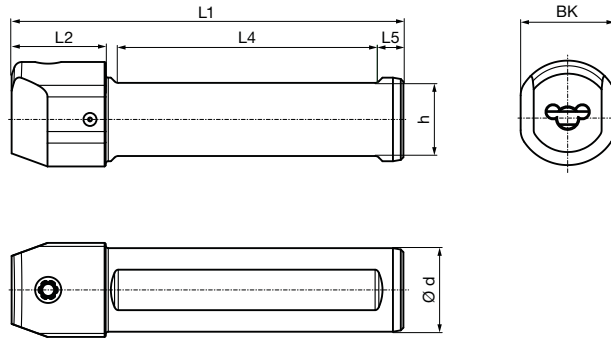
Cutting inserts from hole-Ø 0.7 mm



**Round shank holder, clamping screw top**

- for inserts type 104
- with internal coolant delivery

Type GB 104



Series no. **25000**

version left and right

Code no.	Description	d	d	h	L1	L2	L4	L5	BK
		mm	inch						
<a href="#">4.001</a>	GB104.0010.075.00.15.N.IK	10.00		9.00	75.00	18.00	50.00	5.00	12.0
<a href="#">4.002</a>	GB104.0012.075.00.15.N.IK	12.00		11.00	75.00	18.00	50.00	5.00	14.0
<a href="#">4.015</a>	GB104.0500.354.00.15.N.IK		1/2	11.00	89.92	17.78	54.86	5.08	13.9
<a href="#">4.016</a>	GB104.0625.354.00.15.N.IK		5/8	14.00	89.92	17.78	54.86	5.08	17.7
<a href="#">4.003</a>	GB104.0016.075.00.15.N.IK	16.00		14.00	75.00	18.00	50.00	5.00	18.0
<a href="#">4.017</a>	GB104.0750.380.00.15.N.IK		3/4	17.04	96.52	17.78	69.85	5.08	
<a href="#">4.004</a>	GB104.0020.090.00.15.N.IK	20.00		18.00	90.00		55.00	5.00	
<a href="#">4.005</a>	GB104.0022.090.00.15.N.IK	22.00		20.00	90.00		55.00	5.00	
<a href="#">4.006</a>	GB104.0025.100.00.15.N.IK	25.00		23.00	100.00		55.00	5.00	
<a href="#">4.018</a>	GB104.1000.380.00.15.N.IK		1"	23.39	96.52		69.85	5.08	

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

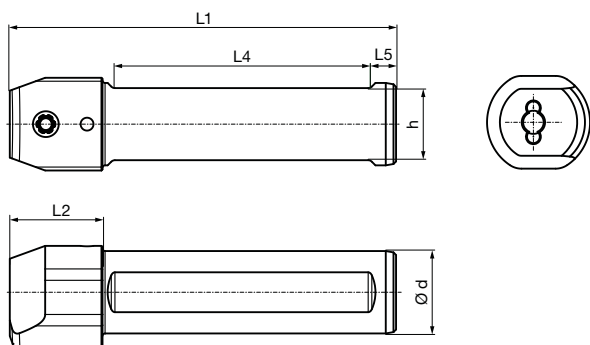
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Round shank holder, clamping screw lateral**

- for inserts type 104
- with internal coolant delivery

Type GB 104



Series no. **25001**

version left and right

Code no.	Description	d	d	h	L1	L2	L4	L5
		mm	inch	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GB104.0010.075.00.15.N.IK.90	10.00		9.00	75.00	18.00	50.00	5.00
<a href="#">4.002</a>	GB104.0012.075.00.15.N.IK.90	12.00		11.00	75.00	18.00	50.00	5.00
<a href="#">4.015</a>	GB104.0500.354.00.15.N.IK.90		1/2	11.00	89.92	17.78	54.86	5.08
<a href="#">4.016</a>	GB104.0625.354.00.15.N.IK.90		5/8	14.00	89.92	17.78	54.86	5.08
<a href="#">4.003</a>	GB104.0016.075.00.15.N.IK.90	16.00		14.00	75.00	18.00	50.00	5.00
<a href="#">4.017</a>	GB104.0750.380.00.15.N.IK.90		3/4	17.04	96.52	17.78	69.85	5.08
<a href="#">4.004</a>	GB104.0020.090.00.15.N.IK.90	20.00		18.00	90.00		55.00	5.00
<a href="#">4.005</a>	GB104.0022.090.00.15.N.IK.90	22.00		20.00	90.00		55.00	5.00
<a href="#">4.006</a>	GB104.0025.100.00.15.N.IK.90	25.00		23.00	100.00		55.00	5.00
<a href="#">4.018</a>	GB104.1000.380.00.15.N.IK.90		1"	23.39	96.52		69.85	5.08

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

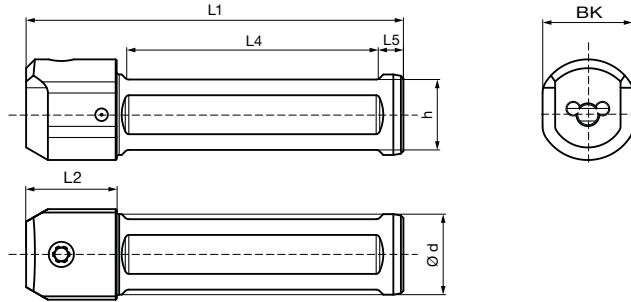
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Round shank holder, clamping screw above, four clamping surfaces**

- for inserts type 104
- with internal coolant delivery

Type GB 104



Series no. **25018**

version left and right

Code no.	Description	d	h	L1	L2	L4	L5	BK
		mm	mm	mm	mm	mm	mm	mm
<a href="#">4.010</a>	GB104.0016.075.00.15.N.IK.VSP	16.00	14.00	75.00	18.00	50.00	5.00	18.0
<a href="#">4.020</a>	GB104.0020.090.00.15.N.IK.VSP	20.00	18.00	90.00		55.00	5.00	
<a href="#">4.030</a>	GB104.0022.090.00.15.N.IK.VSP	22.00	20.00	90.00		55.00	5.00	
<a href="#">4.040</a>	GB104.0025.100.00.15.N.IK.VSP	25.00	23.00	100.00		55.00	5.00	

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

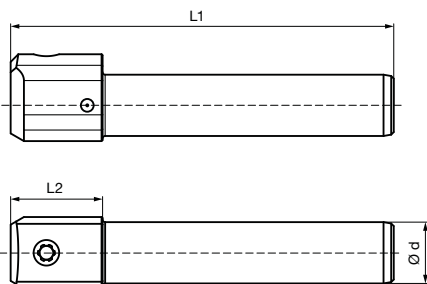
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Round shank holder, clamping screw above, without clamping surfaces**

- for inserts type 104
- with internal coolant delivery

Type GB 104



Series no. **25017**

version left and right

Code no.	Description	d	L1	L2	BK
		mm	mm	mm	mm
<a href="#">4.010</a>	GB104.0010.075.00.15.N.IK.RND	10.00	75.00	18.00	12.0
<a href="#">4.020</a>	GB104.0012.075.00.15.N.IK.RND	12.00	75.00	18.00	14.0
<a href="#">4.030</a>	GB104.0016.075.00.15.N.IK.RND	16.00	75.00	18.00	18.0

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

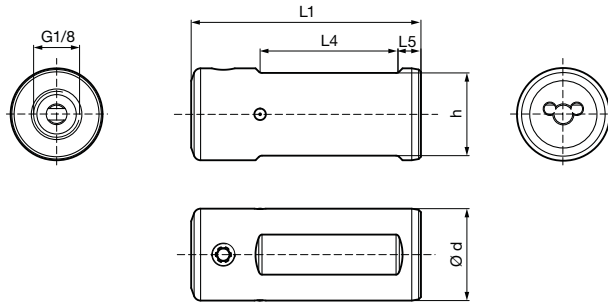
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Round shank holder, clamping screw above, for Citizen machine**

- for inserts type 104
- with internal coolant delivery

Type GB 104



Series no. **25021**

version left and right

Code no.	Description	d	d	h	L1	L4	L5
		mm	inch				
<a href="#">4.110</a>	GB104.0750.040.00.15.N.IK.CIT		3/4	17.04	40.00	20.32	5.08
<a href="#">4.120</a>	GB104.0750.050.00.15.N.IK.CIT		3/4	17.04	50.00	31.75	5.08
<a href="#">4.130</a>	GB104.0750.070.00.15.N.IK.CIT		3/4	17.04	70.00	44.45	5.08
<a href="#">4.140</a>	GB104.0750.100.00.15.N.IK.CIT		3/4	17.04	100.00	76.20	5.08
<a href="#">4.010</a>	GB104.0020.050.00.15.N.IK.CIT	20.00		18.00	50.00	30.00	5.00
<a href="#">4.020</a>	GB104.0020.030.00.15.N.IK.CIT	20.00		18.00	30.00	13.00	5.00
<a href="#">4.150</a>	GB104.1000.060.00.15.N.IK.CIT		1"	23.39	60.00	38.10	5.08
<a href="#">4.160</a>	GB104.1000.100.00.15.N.IK.CIT		1"	23.39	100.00	76.20	5.08

**Spare parts**

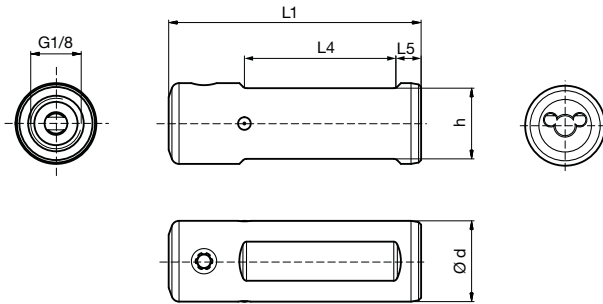
Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle


**Round shank holder, clamping screw above, for Star machine**

- for inserts type 104
- with internal coolant delivery

Type GB 104

Series no. **25022**

version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
<a href="#">4.010</a>	GB104.0016.030.00.15.N.IK.STA	16.00	14.00	30.00	13.00	5.00
<a href="#">4.020</a>	GB104.0016.050.00.15.N.IK.STA	16.00	14.00	50.00	30.00	5.00
<a href="#">4.030</a>	GB104.0016.070.00.15.N.IK.STA	16.00	14.00	70.00	50.00	5.00
<a href="#">4.040</a>	GB104.0022.038.00.15.N.IK.STA	22.00	20.00	38.00	18.00	5.00
<a href="#">4.050</a>	GB104.0022.050.00.15.N.IK.STA	22.00	20.00	50.00	30.00	5.00
<a href="#">4.060</a>	GB104.0022.070.00.15.N.IK.STA	22.00	20.00	70.00	50.00	5.00
<a href="#">4.070</a>	GB104.0022.100.00.15.N.IK.STA	22.00	20.00	100.00	80.00	5.00
<a href="#">4.080</a>	GB104.0022.120.00.15.N.IK.STA	22.00	20.00	120.00	100.00	5.00

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

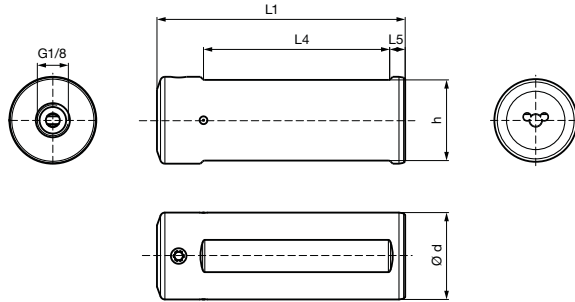
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Round shank holder, clamping screw above, for Tornos machine**

- for inserts type 104
- with internal coolant delivery

Type GB 104



Series no. **25023**

version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
<a href="#">4.010</a>	GB104.0018.310.00.15.N.IK.TOR	18.00	16.00	310.00	290.00	5.00
<a href="#">4.020</a>	GB104.0020.170.00.15.N.IK.TOR	20.00	18.00	170.00	150.00	5.00
<a href="#">4.030</a>	GB104.0020.185.00.15.N.IK.TOR	20.00	18.00	185.00	165.00	5.00
<a href="#">4.040</a>	GB104.0025.100.00.15.N.IK.TOR	25.00	23.00	100.00	80.00	5.00
<a href="#">4.050</a>	GB104.0025.150.00.15.N.IK.TOR	25.00	23.00	150.00	130.00	5.00
<a href="#">4.060</a>	GB104.0028.080.00.15.N.IK.TOR	28.00	26.00	80.00	60.00	5.00

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

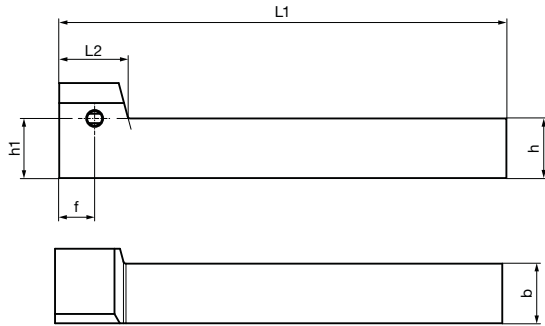




**Square shank holder, 90° offset**

- for inserts type 104
- without internal coolant delivery

Type GH 104



Right hand version shown  
Left hand version mirror image

Series no. **25002**

version right-hand

Code no.	Description	b	b	h	h1	f	L1	L2
		mm	inch	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GH104.0808.090.90.15.R	8.00		8.00	8.00	9.50	90.00	18.50
<a href="#">4.010</a>	GH104.0375.350.90.15.R		3/8	9.52	9.52	7.62	88.90	16.51
<a href="#">4.002</a>	GH104.1010.090.90.15.R	10.00		10.00	10.00	9.50	90.00	18.50
<a href="#">4.003</a>	GH104.1212.090.90.15.R	12.00		12.00	12.00	9.50	90.00	18.50
<a href="#">4.011</a>	GH104.0500.350.90.15.R		1/2	12.70	12.70	7.62	88.90	16.51
<a href="#">4.012</a>	GH104.0625.400.90.15.R		5/8	15.87	15.87	7.62	101.60	16.51
<a href="#">4.004</a>	GH104.1616.120.90.15.R	16.00		16.00	16.00	9.50	120.00	18.50

Series no. **25003**

version left-hand

Code no.	Description	b	b	h	h1	f	L1	L2
		mm	inch	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GH104.0808.090.90.15.L	8.00		8.00	8.00	9.50	90.00	18.50
<a href="#">4.010</a>	GH104.0375.350.90.15.L		3/8	9.52	9.52	7.62	88.90	16.51
<a href="#">4.002</a>	GH104.1010.090.90.15.L	10.00		10.00	10.00	9.50	90.00	18.50
<a href="#">4.003</a>	GH104.1212.090.90.15.L	12.00		12.00	12.00	9.50	90.00	18.50
<a href="#">4.011</a>	GH104.0500.350.90.15.L		1/2	12.70	12.70	7.62	88.90	16.51
<a href="#">4.012</a>	GH104.0625.400.90.15.L		5/8	15.87	15.87	7.62	101.60	16.51
<a href="#">4.004</a>	GH104.1616.120.90.15.L	16.00		16.00	16.00	9.50	120.00	18.50

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

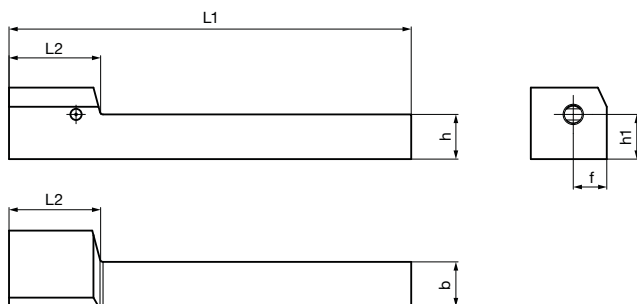
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Square shank holder, straight 0°**

- for inserts type 104
- without internal coolant delivery

Type GH 104



Right hand version shown  
Left hand version mirror image

Series no. **25019**

version right-hand

Code no.	Description	b	b	h	h1	f	L1	L2
		mm	inch	mm	mm	mm	mm	mm
<a href="#">4.010</a>	GH104.0808.090.00.15.R	8.00		8.00	8.00	7.50	90.00	20.50
<a href="#">4.100</a>	GH104.0375.350.00.15.R		3/8	9.52	9.52	7.62	88.90	20.00
<a href="#">4.020</a>	GH104.1010.090.00.15.R	10.00		10.00	10.00	7.50	90.00	20.50
<a href="#">4.030</a>	GH104.1212.090.00.15.R	12.00		12.00	12.00	7.50	90.00	20.50
<a href="#">4.110</a>	GH104.0500.350.00.15.R		1/2	12.70	12.70	7.62	88.90	20.00
<a href="#">4.120</a>	GH104.0625.400.00.15.R		5/8	15.87	15.87	7.62	101.60	20.00
<a href="#">4.040</a>	GH104.1616.100.00.15.R	16.00		16.00	16.00	7.50	100.00	20.50

Series no. **25020**

version left-hand

Code no.	Description	b	b	h	h1	f	L1	L2
		mm	inch	mm	mm	mm	mm	mm
<a href="#">4.010</a>	GH104.0808.090.00.15.L	8.00		8.00	8.00	7.50	90.00	20.50
<a href="#">4.100</a>	GH104.0375.350.00.15.L		3/8	9.52	9.52	7.62	88.90	20.00
<a href="#">4.020</a>	GH104.1010.090.00.15.L	10.00		10.00	10.00	7.50	90.00	20.50
<a href="#">4.030</a>	GH104.1212.090.00.15.L	12.00		12.00	12.00	7.50	90.00	20.50
<a href="#">4.110</a>	GH104.0500.350.00.15.L		1/2	12.70	12.70	7.62	88.90	20.00
<a href="#">4.120</a>	GH104.0625.400.00.15.L		5/8	15.87	15.87	7.62	101.60	20.00
<a href="#">4.040</a>	GH104.1616.100.00.15.L	16.00		16.00	16.00	7.50	100.00	20.50

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

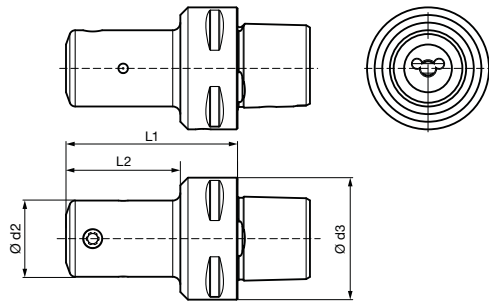
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Polygon shank holder, to ISO 26623, straight 0°**

- for inserts type 104
- with internal coolant delivery

Type GH 104



Series no. **25010**

version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
<a href="#">4.001</a>	GH104.PO32.045.00.15.N.IK	20.00	PSC 32	45.00	30.00
<a href="#">4.002</a>	GH104.PO40.050.00.15.N.IK	20.00	PSC 40	50.00	30.00
<a href="#">4.003</a>	GH104.PO50.050.00.15.N.IK	20.00	PSC 50	50.00	30.00
<a href="#">4.004</a>	GH104.PO63.052.00.15.N.IK	20.00	PSC 63	52.00	30.00

**Spare parts**

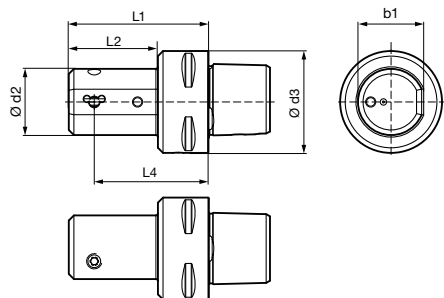
Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

**Polygon shank holder, to ISO 26623, off-set 90°**

- for inserts type 104
- with internal coolant delivery

Type GH 104



Right hand version shown  
Left hand version mirror image



Series no. **25012**  
version right-hand

Code no.	Description	d2	d3	L1	L2	L4	b1
		mm		mm	mm	mm	mm
<a href="#">4.001</a>	GH104.PO32.045.90.15.R.IK	26.00	PSC 32	55.00	40.00	45.00	25.00
<a href="#">4.002</a>	GH104.PO40.050.90.15.R.IK	26.00	PSC 40	55.00	35.00	45.00	25.00
<a href="#">4.003</a>	GH104.PO50.050.90.15.R.IK	26.00	PSC 50	55.00	35.00	45.00	25.00
<a href="#">4.004</a>	GH104.PO63.052.90.15.R.IK	26.00	PSC 63	55.00	33.00	45.00	25.00

Series no. **25013**  
version left-hand

Code no.	Description	d2	d3	L1	L2	L4	b1
		mm		mm	mm	mm	mm
<a href="#">4.001</a>	GH104.PO32.045.90.15.L.IK	26.00	PSC 32	55.00	40.00	45.00	25.00
<a href="#">4.002</a>	GH104.PO40.050.90.15.L.IK	26.00	PSC 40	55.00	35.00	45.00	25.00
<a href="#">4.003</a>	GH104.PO50.050.90.15.L.IK	26.00	PSC 50	55.00	35.00	45.00	25.00
<a href="#">4.004</a>	GH104.PO63.052.90.15.L.IK	26.00	PSC 63	55.00	33.00	45.00	25.00

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

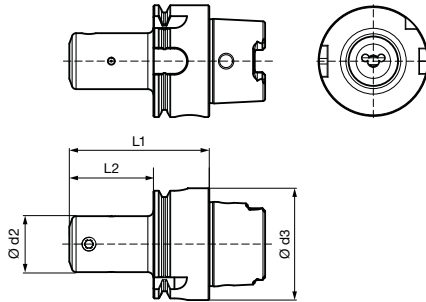
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**HSK-T holder, to ISO 12164-3, straight 0°**

- for inserts type 104
- with internal coolant delivery

Type GH 104



Series no. **25016**

version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
<a href="#">4.001</a>	GH104.HS40.050.00.15.N.IK	20.00	HSK-T 40	50.00	30.00
<a href="#">4.002</a>	GH104.HS63.056.00.15.N.IK	20.00	HSK-T 63	56.00	30.00

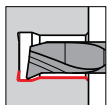
**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



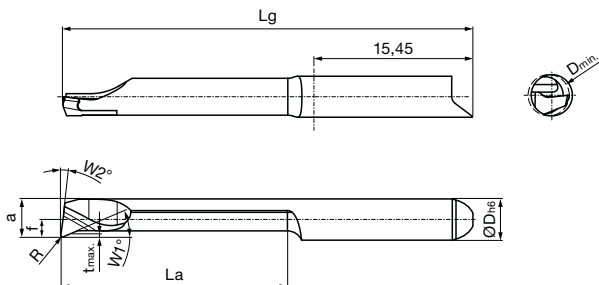
Cutting insert for boring out and profiling



• radial free 23°

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GT 104	GT 104	GT 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Code no.	Description	D min mm	R mm	W1 °	W2 °	f mm	a mm	t max mm	La mm	Lg mm	D h6 mm	Series no.		
												25050	25052	25056
												Cutting direction		
												(R)	(R)	(R)
4.001	GT104.2306.005.03.07.R	0.70	0.05	23	8	1.95	0.60	0.05	3.00	25.00	4.00			
4.002	GT104.2309.005.04.10.R	1.00	0.05	23	8	1.95	0.90	0.10	4.00	25.00	4.00			
4.003	GT104.2309.005.07.10.R	1.00	0.05	23	8	1.95	0.90	0.10	7.00	25.00	4.00			
4.004	GT104.2314.005.04.15.R	1.50	0.05	23	8	1.95	1.40	0.15	4.00	25.00	4.00			
4.007	GT104.2314.010.04.15.R	1.50	0.10	23	8	1.95	1.40	0.15	4.00	25.00	4.00			
4.005	GT104.2314.005.07.15.R	1.50	0.05	23	8	1.95	1.40	0.15	7.00	25.00	4.00			
4.008	GT104.2314.010.07.15.R	1.50	0.10	23	8	1.95	1.40	0.15	7.00	25.00	4.00			
4.006	GT104.2314.005.12.15.R	1.50	0.05	23	8	1.95	1.40	0.15	12.00	30.00	4.00			
4.009	GT104.2314.010.12.15.R	1.50	0.10	23	8	1.95	1.40	0.15	12.00	30.00	4.00			
4.010	GT104.2319.005.04.20.R	2.00	0.05	23	8	1.95	1.90	0.15	4.00	25.00	4.00			
4.014	GT104.2319.010.04.20.R	2.00	0.10	23	8	1.95	1.90	0.15	4.00	25.00	4.00			
4.018	GT104.2319.015.04.20.R	2.00	0.15	23	8	1.95	1.90	0.15	4.00	25.00	4.00			
4.011	GT104.2319.005.07.20.R	2.00	0.05	23	8	1.95	1.90	0.15	7.00	25.00	4.00			
4.015	GT104.2319.010.07.20.R	2.00	0.10	23	8	1.95	1.90	0.15	7.00	25.00	4.00			
4.019	GT104.2319.015.07.20.R	2.00	0.15	23	8	1.95	1.90	0.15	7.00	25.00	4.00			
4.012	GT104.2319.005.12.20.R	2.00	0.05	23	8	1.95	1.90	0.15	12.00	30.00	4.00			
4.016	GT104.2319.010.12.20.R	2.00	0.10	23	8	1.95	1.90	0.15	12.00	30.00	4.00			
4.020	GT104.2319.015.12.20.R	2.00	0.15	23	8	1.95	1.90	0.15	12.00	30.00	4.00			
4.013	GT104.2319.005.17.20.R	2.00	0.05	23	8	1.95	1.90	0.15	17.00	35.00	4.00			
4.017	GT104.2319.010.17.20.R	2.00	0.10	23	8	1.95	1.90	0.15	17.00	35.00	4.00			
4.021	GT104.2319.015.17.20.R	2.00	0.15	23	8	1.95	1.90	0.15	17.00	35.00	4.00			
4.022	GT104.2326.005.07.30.R	3.00	0.05	23	8	1.95	2.60	0.20	7.00	25.00	4.00			
4.026	GT104.2326.010.07.30.R	3.00	0.10	23	8	1.95	2.60	0.20	7.00	25.00	4.00			
4.030	GT104.2326.020.07.30.R	3.00	0.20	23	8	1.95	2.60	0.20	7.00	25.00	4.00			
4.023	GT104.2326.005.12.30.R	3.00	0.05	23	8	1.95	2.60	0.20	12.00	30.00	4.00			
4.027	GT104.2326.010.12.30.R	3.00	0.10	23	8	1.95	2.60	0.20	12.00	30.00	4.00			
4.031	GT104.2326.020.12.30.R	3.00	0.20	23	8	1.95	2.60	0.20	12.00	30.00	4.00			
4.024	GT104.2326.005.17.30.R	3.00	0.05	23	8	1.95	2.60	0.20	17.00	35.00	4.00			
4.028	GT104.2326.010.17.30.R	3.00	0.10	23	8	1.95	2.60	0.20	17.00	35.00	4.00			
4.032	GT104.2326.020.17.30.R	3.00	0.20	23	8	1.95	2.60	0.20	17.00	35.00	4.00			
4.025	GT104.2326.005.22.30.R	3.00	0.05	23	8	1.95	2.60	0.20	22.00	40.00	4.00			
4.029	GT104.2326.010.22.30.R	3.00	0.10	23	8	1.95	2.60	0.20	22.00	40.00	4.00			
4.033	GT104.2326.020.22.30.R	3.00	0.20	23	8	1.95	2.60	0.20	22.00	40.00	4.00			
4.034	GT104.2337.005.12.40.R	4.00	0.05	23	8	1.70	3.70	0.30	12.00	30.00	4.00			
4.039	GT104.2337.015.12.40.R	4.00	0.15	23	8	1.70	3.70	0.30	12.00	30.00	4.00			
4.044	GT104.2337.025.12.40.R	4.00	0.25	23	8	1.70	3.70	0.30	12.00	30.00	4.00			
4.035	GT104.2337.005.17.40.R	4.00	0.05	23	8	1.70	3.70	0.30	17.00	35.00	4.00			
4.040	GT104.2337.015.17.40.R	4.00	0.15	23	8	1.70	3.70	0.30	17.00	35.00	4.00			
4.045	GT104.2337.025.17.40.R	4.00	0.25	23	8	1.70	3.70	0.30	17.00	35.00	4.00			
4.036	GT104.2337.005.22.40.R	4.00	0.05	23	8	1.70	3.70	0.30	22.00	40.00	4.00			



Series no. **25050** **25052** **25056**

Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.041</a>	GT104.2337.015.22.40.R	4.00	0.15	23	8	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.046</a>	GT104.2337.025.22.40.R	4.00	0.25	23	8	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.037</a>	GT104.2337.005.27.40.R	4.00	0.05	23	8	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.042</a>	GT104.2337.015.27.40.R	4.00	0.15	23	8	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.047</a>	GT104.2337.025.27.40.R	4.00	0.25	23	8	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.038</a>	GT104.2337.005.32.40.R	4.00	0.05	23	8	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.043</a>	GT104.2337.015.32.40.R	4.00	0.15	23	8	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.048</a>	GT104.2337.025.32.40.R	4.00	0.25	23	8	1.70	3.70	0.30	32.00	50.00	4.00

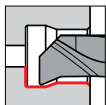
Series no. **25051** **25053** **25057**

Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GT104.2306.005.03.07.L	0.70	0.05	23	8	1.95	0.60	0.05	3.00	25.00	4.00
<a href="#">4.002</a>	GT104.2309.005.04.10.L	1.00	0.05	23	8	1.95	0.90	0.10	4.00	25.00	4.00
<a href="#">4.003</a>	GT104.2309.005.07.10.L	1.00	0.05	23	8	1.95	0.90	0.10	7.00	25.00	4.00
<a href="#">4.004</a>	GT104.2314.005.04.15.L	1.50	0.05	23	8	1.95	1.40	0.15	4.00	25.00	4.00
<a href="#">4.007</a>	GT104.2314.010.04.15.L	1.50	0.10	23	8	1.95	1.40	0.15	4.00	25.00	4.00
<a href="#">4.005</a>	GT104.2314.005.07.15.L	1.50	0.05	23	8	1.95	1.40	0.15	7.00	25.00	4.00
<a href="#">4.008</a>	GT104.2314.010.07.15.L	1.50	0.10	23	8	1.95	1.40	0.15	7.00	25.00	4.00
<a href="#">4.006</a>	GT104.2314.005.12.15.L	1.50	0.05	23	8	1.95	1.40	0.15	12.00	30.00	4.00
<a href="#">4.009</a>	GT104.2314.010.12.15.L	1.50	0.10	23	8	1.95	1.40	0.15	12.00	30.00	4.00
<a href="#">4.010</a>	GT104.2319.005.04.20.L	2.00	0.05	23	8	1.95	1.90	0.15	4.00	25.00	4.00
<a href="#">4.014</a>	GT104.2319.010.04.20.L	2.00	0.10	23	8	1.95	1.90	0.15	4.00	25.00	4.00
<a href="#">4.018</a>	GT104.2319.015.04.20.L	2.00	0.15	23	8	1.95	1.90	0.15	4.00	25.00	4.00
<a href="#">4.011</a>	GT104.2319.005.07.20.L	2.00	0.05	23	8	1.95	1.90	0.15	7.00	25.00	4.00
<a href="#">4.015</a>	GT104.2319.010.07.20.L	2.00	0.10	23	8	1.95	1.90	0.15	7.00	25.00	4.00
<a href="#">4.019</a>	GT104.2319.015.07.20.L	2.00	0.15	23	8	1.95	1.90	0.15	7.00	25.00	4.00
<a href="#">4.012</a>	GT104.2319.005.12.20.L	2.00	0.05	23	8	1.95	1.90	0.15	12.00	30.00	4.00
<a href="#">4.016</a>	GT104.2319.010.12.20.L	2.00	0.10	23	8	1.95	1.90	0.15	12.00	30.00	4.00
<a href="#">4.020</a>	GT104.2319.015.12.20.L	2.00	0.15	23	8	1.95	1.90	0.15	12.00	30.00	4.00
<a href="#">4.013</a>	GT104.2319.005.17.20.L	2.00	0.05	23	8	1.95	1.90	0.15	17.00	35.00	4.00
<a href="#">4.017</a>	GT104.2319.010.17.20.L	2.00	0.10	23	8	1.95	1.90	0.15	17.00	35.00	4.00
<a href="#">4.021</a>	GT104.2319.015.17.20.L	2.00	0.15	23	8	1.95	1.90	0.15	17.00	35.00	4.00
<a href="#">4.022</a>	GT104.2326.005.07.30.L	3.00	0.05	23	8	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.026</a>	GT104.2326.010.07.30.L	3.00	0.10	23	8	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.030</a>	GT104.2326.020.07.30.L	3.00	0.20	23	8	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.023</a>	GT104.2326.005.12.30.L	3.00	0.05	23	8	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.027</a>	GT104.2326.010.12.30.L	3.00	0.10	23	8	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.031</a>	GT104.2326.020.12.30.L	3.00	0.20	23	8	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.024</a>	GT104.2326.005.17.30.L	3.00	0.05	23	8	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.028</a>	GT104.2326.010.17.30.L	3.00	0.10	23	8	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.032</a>	GT104.2326.020.17.30.L	3.00	0.20	23	8	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.025</a>	GT104.2326.005.22.30.L	3.00	0.05	23	8	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.029</a>	GT104.2326.010.22.30.L	3.00	0.10	23	8	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.033</a>	GT104.2326.020.22.30.L	3.00	0.20	23	8	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.034</a>	GT104.2337.005.12.40.L	4.00	0.05	23	8	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.039</a>	GT104.2337.015.12.40.L	4.00	0.15	23	8	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.044</a>	GT104.2337.025.12.40.L	4.00	0.25	23	8	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.035</a>	GT104.2337.005.17.40.L	4.00	0.05	23	8	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.040</a>	GT104.2337.015.17.40.L	4.00	0.15	23	8	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.045</a>	GT104.2337.025.17.40.L	4.00	0.25	23	8	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.036</a>	GT104.2337.005.22.40.L	4.00	0.05	23	8	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.041</a>	GT104.2337.015.22.40.L	4.00	0.15	23	8	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.046</a>	GT104.2337.025.22.40.L	4.00	0.25	23	8	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.037</a>	GT104.2337.005.27.40.L	4.00	0.05	23	8	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.042</a>	GT104.2337.015.27.40.L	4.00	0.15	23	8	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.047</a>	GT104.2337.025.27.40.L	4.00	0.25	23	8	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.038</a>	GT104.2337.005.32.40.L	4.00	0.05	23	8	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.043</a>	GT104.2337.015.32.40.L	4.00	0.15	23	8	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.048</a>	GT104.2337.025.32.40.L	4.00	0.25	23	8	1.70	3.70	0.30	32.00	50.00	4.00



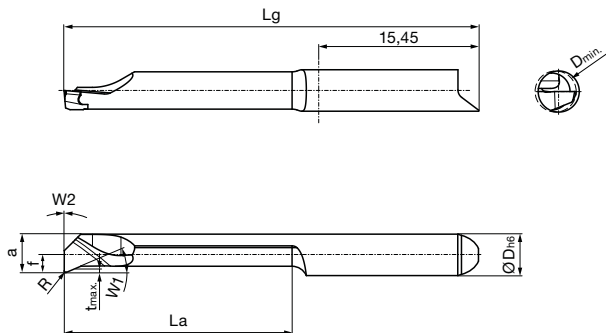
Cutting insert for boring out and profiling



• face flat 90°

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GT 104	GT 104	GT 104
Surface	S	a	○
	TiN	TiAlN-nanoA	bright



		Series no.			Cutting direction							
		25058	25060	25064	(R)	(R)	(R)					
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6	
		mm	mm	°	°	mm	mm	mm	mm	mm	mm	
4.001	GT104.9006.005.03.07.R	0.70	0.05	23	0	1.95	0.60	0.05	3.00	25.00	4.00	
4.002	GT104.9009.005.04.10.R	1.00	0.05	23	0	1.95	0.90	0.10	4.00	25.00	4.00	
4.003	GT104.9009.005.07.10.R	1.00	0.05	23	0	1.95	0.90	0.10	7.00	25.00	4.00	
4.004	GT104.9014.005.04.15.R	1.50	0.05	23	0	1.95	1.40	0.15	4.00	25.00	4.00	
4.007	GT104.9014.010.04.15.R	1.50	0.10	23	0	1.95	1.40	0.15	4.00	25.00	4.00	
4.005	GT104.9014.005.07.15.R	1.50	0.05	23	0	1.95	1.40	0.15	7.00	25.00	4.00	
4.008	GT104.9014.010.07.15.R	1.50	0.10	23	0	1.95	1.40	0.15	7.00	25.00	4.00	
4.006	GT104.9014.005.12.15.R	1.50	0.05	23	0	1.95	1.40	0.15	12.00	30.00	4.00	
4.009	GT104.9014.010.12.15.R	1.50	0.10	23	0	1.95	1.40	0.15	12.00	30.00	4.00	
4.010	GT104.9019.005.04.20.R	2.00	0.05	23	0	1.95	1.90	0.15	4.00	25.00	4.00	
4.014	GT104.9019.010.04.20.R	2.00	0.10	23	0	1.95	1.90	0.15	4.00	25.00	4.00	
4.018	GT104.9019.015.04.20.R	2.00	0.15	23	0	1.95	1.90	0.15	4.00	25.00	4.00	
4.011	GT104.9019.005.07.20.R	2.00	0.05	23	0	1.95	1.90	0.15	7.00	25.00	4.00	
4.015	GT104.9019.010.07.20.R	2.00	0.10	23	0	1.95	1.90	0.15	7.00	25.00	4.00	
4.019	GT104.9019.015.07.20.R	2.00	0.15	23	0	1.95	1.90	0.15	7.00	25.00	4.00	
4.012	GT104.9019.005.12.20.R	2.00	0.05	23	0	1.95	1.90	0.15	12.00	30.00	4.00	
4.016	GT104.9019.010.12.20.R	2.00	0.10	23	0	1.95	1.90	0.15	12.00	30.00	4.00	
4.020	GT104.9019.015.12.20.R	2.00	0.15	23	0	1.95	1.90	0.15	12.00	30.00	4.00	
4.013	GT104.9019.005.17.20.R	2.00	0.05	23	0	1.95	1.90	0.15	17.00	35.00	4.00	
4.017	GT104.9019.010.17.20.R	2.00	0.10	23	0	1.95	1.90	0.15	17.00	35.00	4.00	
4.021	GT104.9019.015.17.20.R	2.00	0.15	23	0	1.95	1.90	0.15	17.00	35.00	4.00	
4.022	GT104.9026.005.07.30.R	3.00	0.05	23	0	1.95	2.60	0.20	7.00	25.00	4.00	
4.026	GT104.9026.010.07.30.R	3.00	0.10	23	0	1.95	2.60	0.20	7.00	25.00	4.00	
4.030	GT104.9026.020.07.30.R	3.00	0.20	23	0	1.95	2.60	0.20	7.00	25.00	4.00	
4.023	GT104.9026.005.12.30.R	3.00	0.05	23	0	1.95	2.60	0.20	12.00	30.00	4.00	
4.027	GT104.9026.010.12.30.R	3.00	0.10	23	0	1.95	2.60	0.20	12.00	30.00	4.00	
4.031	GT104.9026.020.12.30.R	3.00	0.20	23	0	1.95	2.60	0.20	12.00	30.00	4.00	
4.024	GT104.9026.005.17.30.R	3.00	0.05	23	0	1.95	2.60	0.20	17.00	35.00	4.00	
4.028	GT104.9026.010.17.30.R	3.00	0.10	23	0	1.95	2.60	0.20	17.00	35.00	4.00	
4.032	GT104.9026.020.17.30.R	3.00	0.20	23	0	1.95	2.60	0.20	17.00	35.00	4.00	
4.025	GT104.9026.005.22.30.R	3.00	0.05	23	0	1.95	2.60	0.20	22.00	40.00	4.00	
4.029	GT104.9026.010.22.30.R	3.00	0.10	23	0	1.95	2.60	0.20	22.00	40.00	4.00	
4.033	GT104.9026.020.22.30.R	3.00	0.20	23	0	1.95	2.60	0.20	22.00	40.00	4.00	
4.034	GT104.9037.005.12.40.R	4.00	0.05	23	0	1.70	3.70	0.30	12.00	30.00	4.00	
4.039	GT104.9037.015.12.40.R	4.00	0.15	23	0	1.70	3.70	0.30	12.00	30.00	4.00	
4.044	GT104.9037.025.12.40.R	4.00	0.25	23	0	1.70	3.70	0.30	12.00	30.00	4.00	
4.035	GT104.9037.005.17.40.R	4.00	0.05	23	0	1.70	3.70	0.30	17.00	35.00	4.00	
4.040	GT104.9037.015.17.40.R	4.00	0.15	23	0	1.70	3.70	0.30	17.00	35.00	4.00	
4.045	GT104.9037.025.17.40.R	4.00	0.25	23	0	1.70	3.70	0.30	17.00	35.00	4.00	



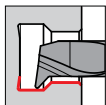


		Series no. 25058			25060			25064			
		Cutting direction									
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.036</a>	GT104.9037.005.22.40.R	4.00	0.05	23	0	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.041</a>	GT104.9037.015.22.40.R	4.00	0.15	23	0	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.046</a>	GT104.9037.025.22.40.R	4.00	0.25	23	0	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.037</a>	GT104.9037.005.27.40.R	4.00	0.05	23	0	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.042</a>	GT104.9037.015.27.40.R	4.00	0.15	23	0	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.047</a>	GT104.9037.025.27.40.R	4.00	0.25	23	0	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.038</a>	GT104.9037.005.32.40.R	4.00	0.05	23	0	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.043</a>	GT104.9037.015.32.40.R	4.00	0.15	23	0	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.048</a>	GT104.9037.025.32.40.R	4.00	0.25	23	0	1.70	3.70	0.30	32.00	50.00	4.00

		Series no. 25059			25061			25065			
		Cutting direction									
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GT104.9006.005.03.07.L	0.70	0.05	23	0	1.95	0.60	0.05	3.00	25.00	4.00
<a href="#">4.002</a>	GT104.9009.005.04.10.L	1.00	0.05	23	0	1.95	0.90	0.10	4.00	25.00	4.00
<a href="#">4.003</a>	GT104.9009.005.07.10.L	1.00	0.05	23	0	1.95	0.90	0.10	7.00	25.00	4.00
<a href="#">4.004</a>	GT104.9014.005.04.15.L	1.50	0.05	23	0	1.95	1.40	0.15	4.00	25.00	4.00
<a href="#">4.007</a>	GT104.9014.010.04.15.L	1.50	0.10	23	0	1.95	1.40	0.15	4.00	25.00	4.00
<a href="#">4.005</a>	GT104.9014.005.07.15.L	1.50	0.05	23	0	1.95	1.40	0.15	7.00	25.00	4.00
<a href="#">4.008</a>	GT104.9014.010.07.15.L	1.50	0.10	23	0	1.95	1.40	0.15	7.00	25.00	4.00
<a href="#">4.006</a>	GT104.9014.005.12.15.L	1.50	0.05	23	0	1.95	1.40	0.15	12.00	30.00	4.00
<a href="#">4.009</a>	GT104.9014.010.12.15.L	1.50	0.10	23	0	1.95	1.40	0.15	12.00	30.00	4.00
<a href="#">4.010</a>	GT104.9019.005.04.20.L	2.00	0.05	23	0	1.95	1.90	0.15	4.00	25.00	4.00
<a href="#">4.014</a>	GT104.9019.010.04.20.L	2.00	0.10	23	0	1.95	1.90	0.15	4.00	25.00	4.00
<a href="#">4.018</a>	GT104.9019.015.04.20.L	2.00	0.15	23	0	1.95	1.90	0.15	4.00	25.00	4.00
<a href="#">4.011</a>	GT104.9019.005.07.20.L	2.00	0.05	23	0	1.95	1.90	0.15	7.00	25.00	4.00
<a href="#">4.015</a>	GT104.9019.010.07.20.L	2.00	0.10	23	0	1.95	1.90	0.15	7.00	25.00	4.00
<a href="#">4.019</a>	GT104.9019.015.07.20.L	2.00	0.15	23	0	1.95	1.90	0.15	7.00	25.00	4.00
<a href="#">4.012</a>	GT104.9019.005.12.20.L	2.00	0.05	23	0	1.95	1.90	0.15	12.00	30.00	4.00
<a href="#">4.016</a>	GT104.9019.010.12.20.L	2.00	0.10	23	0	1.95	1.90	0.15	12.00	30.00	4.00
<a href="#">4.020</a>	GT104.9019.015.12.20.L	2.00	0.15	23	0	1.95	1.90	0.15	12.00	30.00	4.00
<a href="#">4.013</a>	GT104.9019.005.17.20.L	2.00	0.05	23	0	1.95	1.90	0.15	17.00	35.00	4.00
<a href="#">4.017</a>	GT104.9019.010.17.20.L	2.00	0.10	23	0	1.95	1.90	0.15	17.00	35.00	4.00
<a href="#">4.021</a>	GT104.9019.015.17.20.L	2.00	0.15	23	0	1.95	1.90	0.15	17.00	35.00	4.00
<a href="#">4.022</a>	GT104.9026.005.07.30.L	3.00	0.05	23	0	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.026</a>	GT104.9026.010.07.30.L	3.00	0.10	23	0	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.030</a>	GT104.9026.020.07.30.L	3.00	0.20	23	0	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.023</a>	GT104.9026.005.12.30.L	3.00	0.05	23	0	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.027</a>	GT104.9026.010.12.30.L	3.00	0.10	23	0	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.031</a>	GT104.9026.020.12.30.L	3.00	0.20	23	0	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.024</a>	GT104.9026.005.17.30.L	3.00	0.05	23	0	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.028</a>	GT104.9026.010.17.30.L	3.00	0.10	23	0	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.032</a>	GT104.9026.020.17.30.L	3.00	0.20	23	0	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.025</a>	GT104.9026.005.22.30.L	3.00	0.05	23	0	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.029</a>	GT104.9026.010.22.30.L	3.00	0.10	23	0	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.033</a>	GT104.9026.020.22.30.L	3.00	0.20	23	0	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.034</a>	GT104.9037.005.12.40.L	4.00	0.05	23	0	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.039</a>	GT104.9037.015.12.40.L	4.00	0.15	23	0	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.044</a>	GT104.9037.025.12.40.L	4.00	0.25	23	0	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.035</a>	GT104.9037.005.17.40.L	4.00	0.05	23	0	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.040</a>	GT104.9037.015.17.40.L	4.00	0.15	23	0	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.045</a>	GT104.9037.025.17.40.L	4.00	0.25	23	0	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.036</a>	GT104.9037.005.22.40.L	4.00	0.05	23	0	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.041</a>	GT104.9037.015.22.40.L	4.00	0.15	23	0	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.046</a>	GT104.9037.025.22.40.L	4.00	0.25	23	0	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.037</a>	GT104.9037.005.27.40.L	4.00	0.05	23	0	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.042</a>	GT104.9037.015.27.40.L	4.00	0.15	23	0	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.047</a>	GT104.9037.025.27.40.L	4.00	0.25	23	0	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.038</a>	GT104.9037.005.32.40.L	4.00	0.05	23	0	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.043</a>	GT104.9037.015.32.40.L	4.00	0.15	23	0	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.048</a>	GT104.9037.025.32.40.L	4.00	0.25	23	0	1.70	3.70	0.30	32.00	50.00	4.00



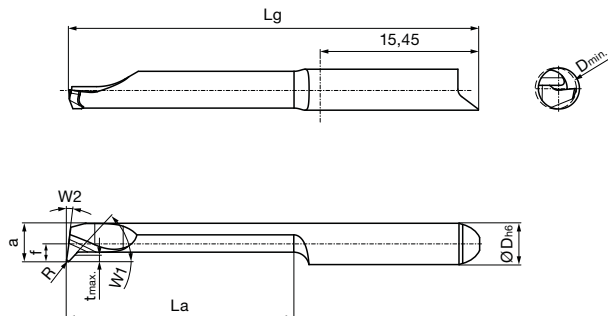
Cutting insert for boring out and profiling



• radial free 47°

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GT 104	GT 104	GT 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6	Series no.		
												25066	25068	25072
												Cutting direction		
												(R)	(R)	(R)
												mm	mm	mm
4.001	GT104.4717.005.04.20.R	2.00	0.05	47	8	1.95	1.70	0.35	4.00	25.00	4.00			
4.005	GT104.4717.010.04.20.R	2.00	0.10	47	8	1.95	1.70	0.35	4.00	25.00	4.00			
4.009	GT104.4717.015.04.20.R	2.00	0.15	47	8	1.95	1.70	0.35	4.00	25.00	4.00			
4.002	GT104.4717.005.07.20.R	2.00	0.05	47	8	1.95	1.70	0.35	7.00	25.00	4.00			
4.006	GT104.4717.010.07.20.R	2.00	0.10	47	8	1.95	1.70	0.35	7.00	25.00	4.00			
4.010	GT104.4717.015.07.20.R	2.00	0.15	47	8	1.95	1.70	0.35	7.00	25.00	4.00			
4.003	GT104.4717.005.12.20.R	2.00	0.05	47	8	1.95	1.70	0.35	12.00	30.00	4.00			
4.007	GT104.4717.010.12.20.R	2.00	0.10	47	8	1.95	1.70	0.35	12.00	30.00	4.00			
4.011	GT104.4717.015.12.20.R	2.00	0.15	47	8	1.95	1.70	0.35	12.00	30.00	4.00			
4.004	GT104.4717.005.17.20.R	2.00	0.05	47	8	1.95	1.70	0.35	17.00	35.00	4.00			
4.008	GT104.4717.010.17.20.R	2.00	0.10	47	8	1.95	1.70	0.35	17.00	35.00	4.00			
4.012	GT104.4717.015.17.20.R	2.00	0.15	47	8	1.95	1.70	0.35	17.00	35.00	4.00			
4.013	GT104.4727.005.07.30.R	3.00	0.05	47	8	1.95	2.70	0.55	7.00	25.00	4.00			
4.017	GT104.4727.010.07.30.R	3.00	0.10	47	8	1.95	2.70	0.55	7.00	25.00	4.00			
4.021	GT104.4727.025.07.30.R	3.00	0.25	47	8	1.95	2.70	0.55	7.00	25.00	4.00			
4.014	GT104.4727.005.12.30.R	3.00	0.05	47	8	1.95	2.70	0.55	12.00	30.00	4.00			
4.018	GT104.4727.010.12.30.R	3.00	0.10	47	8	1.95	2.70	0.55	12.00	30.00	4.00			
4.022	GT104.4727.025.12.30.R	3.00	0.25	47	8	1.95	2.70	0.55	12.00	30.00	4.00			
4.015	GT104.4727.005.17.30.R	3.00	0.05	47	8	1.95	2.70	0.55	17.00	35.00	4.00			
4.019	GT104.4727.010.17.30.R	3.00	0.10	47	8	1.95	2.70	0.55	17.00	35.00	4.00			
4.023	GT104.4727.025.17.30.R	3.00	0.25	47	8	1.95	2.70	0.55	17.00	35.00	4.00			
4.016	GT104.4727.005.22.30.R	3.00	0.05	47	8	1.95	2.70	0.55	22.00	40.00	4.00			
4.020	GT104.4727.010.22.30.R	3.00	0.10	47	8	1.95	2.70	0.55	22.00	40.00	4.00			
4.024	GT104.4727.025.22.30.R	3.00	0.25	47	8	1.95	2.70	0.55	22.00	40.00	4.00			
4.025	GT104.4737.005.12.40.R	4.00	0.05	47	8	1.70	3.70	0.60	12.00	30.00	4.00			
4.030	GT104.4737.015.12.40.R	4.00	0.15	47	8	1.70	3.70	0.60	12.00	30.00	4.00			
4.035	GT104.4737.025.12.40.R	4.00	0.25	47	8	1.70	3.70	0.60	12.00	30.00	4.00			
4.026	GT104.4737.005.17.40.R	4.00	0.05	47	8	1.70	3.70	0.60	17.00	35.00	4.00			
4.031	GT104.4737.015.17.40.R	4.00	0.15	47	8	1.70	3.70	0.60	17.00	35.00	4.00			
4.036	GT104.4737.025.17.40.R	4.00	0.25	47	8	1.70	3.70	0.60	17.00	35.00	4.00			
4.027	GT104.4737.005.22.40.R	4.00	0.05	47	8	1.70	3.70	0.60	22.00	40.00	4.00			
4.032	GT104.4737.015.22.40.R	4.00	0.15	47	8	1.70	3.70	0.60	22.00	40.00	4.00			
4.037	GT104.4737.025.22.40.R	4.00	0.25	47	8	1.70	3.70	0.60	22.00	40.00	4.00			
4.028	GT104.4737.005.27.40.R	4.00	0.05	47	8	1.70	3.70	0.60	27.00	45.00	4.00			
4.033	GT104.4737.015.27.40.R	4.00	0.15	47	8	1.70	3.70	0.60	27.00	45.00	4.00			
4.038	GT104.4737.025.27.40.R	4.00	0.25	47	8	1.70	3.70	0.60	27.00	45.00	4.00			
4.029	GT104.4737.005.32.40.R	4.00	0.05	47	8	1.70	3.70	0.60	32.00	50.00	4.00			
4.034	GT104.4737.015.32.40.R	4.00	0.15	47	8	1.70	3.70	0.60	32.00	50.00	4.00			
4.039	GT104.4737.025.32.40.R	4.00	0.25	47	8	1.70	3.70	0.60	32.00	50.00	4.00			

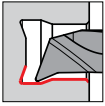


Series no. **25067** **25069** **25073**

Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GT104.4717.005.04.20.L	2.00	0.05	47	8	1.95	1.70	0.35	4.00	25.00	4.00
<a href="#">4.005</a>	GT104.4717.010.04.20.L	2.00	0.10	47	8	1.95	1.70	0.35	4.00	25.00	4.00
<a href="#">4.009</a>	GT104.4717.015.04.20.L	2.00	0.15	47	8	1.95	1.70	0.35	4.00	25.00	4.00
<a href="#">4.002</a>	GT104.4717.005.07.20.L	2.00	0.05	47	8	1.95	1.70	0.35	7.00	25.00	4.00
<a href="#">4.006</a>	GT104.4717.010.07.20.L	2.00	0.10	47	8	1.95	1.70	0.35	7.00	25.00	4.00
<a href="#">4.010</a>	GT104.4717.015.07.20.L	2.00	0.15	47	8	1.95	1.70	0.35	7.00	25.00	4.00
<a href="#">4.003</a>	GT104.4717.005.12.20.L	2.00	0.05	47	8	1.95	1.70	0.35	12.00	30.00	4.00
<a href="#">4.007</a>	GT104.4717.010.12.20.L	2.00	0.10	47	8	1.95	1.70	0.35	12.00	30.00	4.00
<a href="#">4.011</a>	GT104.4717.015.12.20.L	2.00	0.15	47	8	1.95	1.70	0.35	12.00	30.00	4.00
<a href="#">4.004</a>	GT104.4717.005.17.20.L	2.00	0.05	47	8	1.95	1.70	0.35	17.00	35.00	4.00
<a href="#">4.008</a>	GT104.4717.010.17.20.L	2.00	0.10	47	8	1.95	1.70	0.35	17.00	35.00	4.00
<a href="#">4.012</a>	GT104.4717.015.17.20.L	2.00	0.15	47	8	1.95	1.70	0.35	17.00	35.00	4.00
<a href="#">4.013</a>	GT104.4727.005.07.30.L	3.00	0.05	47	8	1.95	2.70	0.55	7.00	25.00	4.00
<a href="#">4.017</a>	GT104.4727.010.07.30.L	3.00	0.10	47	8	1.95	2.70	0.55	7.00	25.00	4.00
<a href="#">4.021</a>	GT104.4727.025.07.30.L	3.00	0.25	47	8	1.95	2.70	0.55	7.00	25.00	4.00
<a href="#">4.014</a>	GT104.4727.005.12.30.L	3.00	0.05	47	8	1.95	2.70	0.55	12.00	30.00	4.00
<a href="#">4.018</a>	GT104.4727.010.12.30.L	3.00	0.10	47	8	1.95	2.70	0.55	12.00	30.00	4.00
<a href="#">4.022</a>	GT104.4727.025.12.30.L	3.00	0.25	47	8	1.95	2.70	0.55	12.00	30.00	4.00
<a href="#">4.015</a>	GT104.4727.005.17.30.L	3.00	0.05	47	8	1.95	2.70	0.55	17.00	35.00	4.00
<a href="#">4.019</a>	GT104.4727.010.17.30.L	3.00	0.10	47	8	1.95	2.70	0.55	17.00	35.00	4.00
<a href="#">4.023</a>	GT104.4727.025.17.30.L	3.00	0.25	47	8	1.95	2.70	0.55	17.00	35.00	4.00
<a href="#">4.016</a>	GT104.4727.005.22.30.L	3.00	0.05	47	8	1.95	2.70	0.55	22.00	40.00	4.00
<a href="#">4.020</a>	GT104.4727.010.22.30.L	3.00	0.10	47	8	1.95	2.70	0.55	22.00	40.00	4.00
<a href="#">4.024</a>	GT104.4727.025.22.30.L	3.00	0.25	47	8	1.95	2.70	0.55	22.00	40.00	4.00
<a href="#">4.025</a>	GT104.4737.005.12.40.L	4.00	0.05	47	8	1.70	3.70	0.60	12.00	30.00	4.00
<a href="#">4.030</a>	GT104.4737.015.12.40.L	4.00	0.15	47	8	1.70	3.70	0.60	12.00	30.00	4.00
<a href="#">4.035</a>	GT104.4737.025.12.40.L	4.00	0.25	47	8	1.70	3.70	0.60	12.00	30.00	4.00
<a href="#">4.026</a>	GT104.4737.005.17.40.L	4.00	0.05	47	8	1.70	3.70	0.60	17.00	35.00	4.00
<a href="#">4.031</a>	GT104.4737.015.17.40.L	4.00	0.15	47	8	1.70	3.70	0.60	17.00	35.00	4.00
<a href="#">4.036</a>	GT104.4737.025.17.40.L	4.00	0.25	47	8	1.70	3.70	0.60	17.00	35.00	4.00
<a href="#">4.027</a>	GT104.4737.005.22.40.L	4.00	0.05	47	8	1.70	3.70	0.60	22.00	40.00	4.00
<a href="#">4.032</a>	GT104.4737.015.22.40.L	4.00	0.15	47	8	1.70	3.70	0.60	22.00	40.00	4.00
<a href="#">4.037</a>	GT104.4737.025.22.40.L	4.00	0.25	47	8	1.70	3.70	0.60	22.00	40.00	4.00
<a href="#">4.028</a>	GT104.4737.005.27.40.L	4.00	0.05	47	8	1.70	3.70	0.60	27.00	45.00	4.00
<a href="#">4.033</a>	GT104.4737.015.27.40.L	4.00	0.15	47	8	1.70	3.70	0.60	27.00	45.00	4.00
<a href="#">4.038</a>	GT104.4737.025.27.40.L	4.00	0.25	47	8	1.70	3.70	0.60	27.00	45.00	4.00
<a href="#">4.029</a>	GT104.4737.005.32.40.L	4.00	0.05	47	8	1.70	3.70	0.60	32.00	50.00	4.00
<a href="#">4.034</a>	GT104.4737.015.32.40.L	4.00	0.15	47	8	1.70	3.70	0.60	32.00	50.00	4.00
<a href="#">4.039</a>	GT104.4737.025.32.40.L	4.00	0.25	47	8	1.70	3.70	0.60	32.00	50.00	4.00

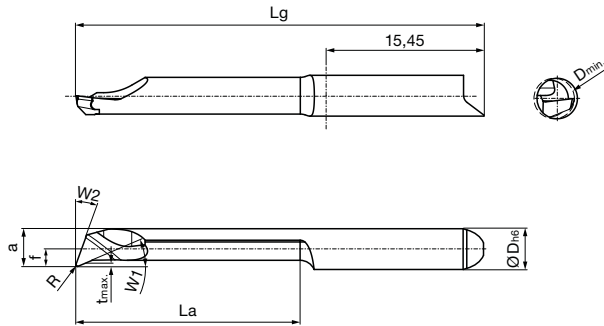
## Cutting insert for boring out and profiling



- face free 20°

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GT 104	GT 104	GT 104
Surface	S	a	○
	TiN	TiAlN-nanoA	bright



Series no.	25074	25076	25080
Cutting direction	(R)	(R)	(R)

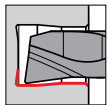
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GT104.2026.005.07.30.R	3.00	0.05	23	20	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.005</a>	GT104.2026.010.07.30.R	3.00	0.10	23	20	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.009</a>	GT104.2026.020.07.30.R	3.00	0.20	23	20	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.002</a>	GT104.2026.005.12.30.R	3.00	0.05	23	20	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.006</a>	GT104.2026.010.12.30.R	3.00	0.10	23	20	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.010</a>	GT104.2026.020.12.30.R	3.00	0.20	23	20	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.003</a>	GT104.2026.005.17.30.R	3.00	0.05	23	20	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.007</a>	GT104.2026.010.17.30.R	3.00	0.10	23	20	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.011</a>	GT104.2026.020.17.30.R	3.00	0.20	23	20	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.004</a>	GT104.2026.005.22.30.R	3.00	0.05	23	20	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.008</a>	GT104.2026.010.22.30.R	3.00	0.10	23	20	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.012</a>	GT104.2026.020.22.30.R	3.00	0.20	23	20	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.013</a>	GT104.2037.005.12.40.R	4.00	0.05	23	20	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.018</a>	GT104.2037.015.12.40.R	4.00	0.15	23	20	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.023</a>	GT104.2037.025.12.40.R	4.00	0.25	23	20	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.014</a>	GT104.2037.005.17.40.R	4.00	0.05	23	20	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.019</a>	GT104.2037.015.17.40.R	4.00	0.15	23	20	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.024</a>	GT104.2037.025.17.40.R	4.00	0.25	23	20	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.015</a>	GT104.2037.005.22.40.R	4.00	0.05	23	20	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.020</a>	GT104.2037.015.22.40.R	4.00	0.15	23	20	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.025</a>	GT104.2037.025.22.40.R	4.00	0.25	23	20	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.016</a>	GT104.2037.005.27.40.R	4.00	0.05	23	20	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.021</a>	GT104.2037.015.27.40.R	4.00	0.15	23	20	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.026</a>	GT104.2037.025.27.40.R	4.00	0.25	23	20	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.017</a>	GT104.2037.005.32.40.R	4.00	0.05	23	20	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.022</a>	GT104.2037.015.32.40.R	4.00	0.15	23	20	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.027</a>	GT104.2037.025.32.40.R	4.00	0.25	23	20	1.70	3.70	0.30	32.00	50.00	4.00

Series no. **25075** **25077** **25081**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GT104.2026.005.07.30.L	3.00	0.05	23	20	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.005</a>	GT104.2026.010.07.30.L	3.00	0.10	23	20	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.009</a>	GT104.2026.020.07.30.L	3.00	0.20	23	20	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.002</a>	GT104.2026.005.12.30.L	3.00	0.05	23	20	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.006</a>	GT104.2026.010.12.30.L	3.00	0.10	23	20	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.010</a>	GT104.2026.020.12.30.L	3.00	0.20	23	20	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.003</a>	GT104.2026.005.17.30.L	3.00	0.05	23	20	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.007</a>	GT104.2026.010.17.30.L	3.00	0.10	23	20	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.011</a>	GT104.2026.020.17.30.L	3.00	0.20	23	20	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.004</a>	GT104.2026.005.22.30.L	3.00	0.05	23	20	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.008</a>	GT104.2026.010.22.30.L	3.00	0.10	23	20	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.012</a>	GT104.2026.020.22.30.L	3.00	0.20	23	20	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.013</a>	GT104.2037.005.12.40.L	4.00	0.05	23	20	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.018</a>	GT104.2037.015.12.40.L	4.00	0.15	23	20	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.023</a>	GT104.2037.025.12.40.L	4.00	0.25	23	20	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.014</a>	GT104.2037.005.17.40.L	4.00	0.05	23	20	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.019</a>	GT104.2037.015.17.40.L	4.00	0.15	23	20	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.024</a>	GT104.2037.025.17.40.L	4.00	0.25	23	20	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.015</a>	GT104.2037.005.22.40.L	4.00	0.05	23	20	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.020</a>	GT104.2037.015.22.40.L	4.00	0.15	23	20	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.025</a>	GT104.2037.025.22.40.L	4.00	0.25	23	20	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.016</a>	GT104.2037.005.27.40.L	4.00	0.05	23	20	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.021</a>	GT104.2037.015.27.40.L	4.00	0.15	23	20	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.026</a>	GT104.2037.025.27.40.L	4.00	0.25	23	20	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.017</a>	GT104.2037.005.32.40.L	4.00	0.05	23	20	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.022</a>	GT104.2037.015.32.40.L	4.00	0.15	23	20	1.70	3.70	0.30	32.00	50.00	4.00
<a href="#">4.027</a>	GT104.2037.025.32.40.L	4.00	0.25	23	20	1.70	3.70	0.30	32.00	50.00	4.00



Cutting insert for boring out and profiling

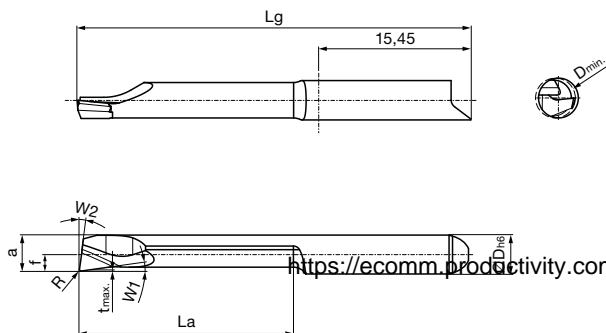


• radial free 8°

for tool holders type GH104/GB104 see from page 16

Tool material	Solid carbide			
	Type	GT 104	GT 104	GT 104
Surface	<b>S</b>	<b>a</b>	○	
	TiN	TiAlN-nanoA	bright	

Cutting data page 148



Right hand version shown  
Left hand version mirror image

<https://ecommerce.productivity.com/products/search/?Keyword=GU112508>

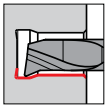
Series no.	25082	25084	25088
Cutting direction	(R)	(R)	(R)

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GT104.0827.005.07.30.R	3.00	0.05	8	8	1.95	2.70	0.15	7.00	25.00	4.00
<a href="#">4.005</a>	GT104.0827.010.07.30.R	3.00	0.10	8	8	1.95	2.70	0.15	7.00	25.00	4.00
<a href="#">4.009</a>	GT104.0827.020.07.30.R	3.00	0.20	8	8	1.95	2.70	0.15	7.00	25.00	4.00
<a href="#">4.002</a>	GT104.0827.005.12.30.R	3.00	0.05	8	8	1.95	2.70	0.15	12.00	30.00	4.00
<a href="#">4.006</a>	GT104.0827.010.12.30.R	3.00	0.10	8	8	1.95	2.70	0.15	12.00	30.00	4.00
<a href="#">4.010</a>	GT104.0827.020.12.30.R	3.00	0.20	8	8	1.95	2.70	0.15	12.00	30.00	4.00
<a href="#">4.003</a>	GT104.0827.005.17.30.R	3.00	0.05	8	8	1.95	2.70	0.15	17.00	35.00	4.00
<a href="#">4.007</a>	GT104.0827.010.17.30.R	3.00	0.10	8	8	1.95	2.70	0.15	17.00	35.00	4.00
<a href="#">4.011</a>	GT104.0827.020.17.30.R	3.00	0.20	8	8	1.95	2.70	0.15	17.00	35.00	4.00
<a href="#">4.004</a>	GT104.0827.005.22.30.R	3.00	0.05	8	8	1.95	2.70	0.15	22.00	40.00	4.00
<a href="#">4.008</a>	GT104.0827.010.22.30.R	3.00	0.10	8	8	1.95	2.70	0.15	22.00	40.00	4.00
<a href="#">4.012</a>	GT104.0827.020.22.30.R	3.00	0.20	8	8	1.95	2.70	0.15	22.00	40.00	4.00
<a href="#">4.013</a>	GT104.0837.005.12.40.R	4.00	0.05	8	8	1.70	3.70	0.15	12.00	30.00	4.00
<a href="#">4.018</a>	GT104.0837.015.12.40.R	4.00	0.15	8	8	1.70	3.70	0.15	12.00	30.00	4.00
<a href="#">4.023</a>	GT104.0837.025.12.40.R	4.00	0.25	8	8	1.70	3.70	0.15	12.00	30.00	4.00
<a href="#">4.014</a>	GT104.0837.005.17.40.R	4.00	0.05	8	8	1.70	3.70	0.15	17.00	35.00	4.00
<a href="#">4.019</a>	GT104.0837.015.17.40.R	4.00	0.15	8	8	1.70	3.70	0.15	17.00	35.00	4.00
<a href="#">4.024</a>	GT104.0837.025.17.40.R	4.00	0.25	8	8	1.70	3.70	0.15	17.00	35.00	4.00
<a href="#">4.015</a>	GT104.0837.005.22.40.R	4.00	0.05	8	8	1.70	3.70	0.15	22.00	40.00	4.00
<a href="#">4.020</a>	GT104.0837.015.22.40.R	4.00	0.15	8	8	1.70	3.70	0.15	22.00	40.00	4.00
<a href="#">4.025</a>	GT104.0837.025.22.40.R	4.00	0.25	8	8	1.70	3.70	0.15	22.00	40.00	4.00
<a href="#">4.016</a>	GT104.0837.005.27.40.R	4.00	0.05	8	8	1.70	3.70	0.15	27.00	45.00	4.00
<a href="#">4.021</a>	GT104.0837.015.27.40.R	4.00	0.15	8	8	1.70	3.70	0.15	27.00	45.00	4.00
<a href="#">4.026</a>	GT104.0837.025.27.40.R	4.00	0.25	8	8	1.70	3.70	0.15	27.00	45.00	4.00
<a href="#">4.017</a>	GT104.0837.005.32.40.R	4.00	0.05	8	8	1.70	3.70	0.15	32.00	50.00	4.00
<a href="#">4.022</a>	GT104.0837.015.32.40.R	4.00	0.15	8	8	1.70	3.70	0.15	32.00	50.00	4.00
<a href="#">4.027</a>	GT104.0837.025.32.40.R	4.00	0.25	8	8	1.70	3.70	0.15	32.00	50.00	4.00

Series no. **25083** **25085** **25089**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GT104.0827.005.07.30.L	3.00	0.05	8	8	1.95	2.70	0.15	7.00	25.00	4.00
<a href="#">4.005</a>	GT104.0827.010.07.30.L	3.00	0.10	8	8	1.95	2.70	0.15	7.00	25.00	4.00
<a href="#">4.009</a>	GT104.0827.020.07.30.L	3.00	0.20	8	8	1.95	2.70	0.15	7.00	25.00	4.00
<a href="#">4.002</a>	GT104.0827.005.12.30.L	3.00	0.05	8	8	1.95	2.70	0.15	12.00	30.00	4.00
<a href="#">4.006</a>	GT104.0827.010.12.30.L	3.00	0.10	8	8	1.95	2.70	0.15	12.00	30.00	4.00
<a href="#">4.010</a>	GT104.0827.020.12.30.L	3.00	0.20	8	8	1.95	2.70	0.15	12.00	30.00	4.00
<a href="#">4.003</a>	GT104.0827.005.17.30.L	3.00	0.05	8	8	1.95	2.70	0.15	17.00	35.00	4.00
<a href="#">4.007</a>	GT104.0827.010.17.30.L	3.00	0.10	8	8	1.95	2.70	0.15	17.00	35.00	4.00
<a href="#">4.011</a>	GT104.0827.020.17.30.L	3.00	0.20	8	8	1.95	2.70	0.15	17.00	35.00	4.00
<a href="#">4.004</a>	GT104.0827.005.22.30.L	3.00	0.05	8	8	1.95	2.70	0.15	22.00	40.00	4.00
<a href="#">4.008</a>	GT104.0827.010.22.30.L	3.00	0.10	8	8	1.95	2.70	0.15	22.00	40.00	4.00
<a href="#">4.012</a>	GT104.0827.020.22.30.L	3.00	0.20	8	8	1.95	2.70	0.15	22.00	40.00	4.00
<a href="#">4.013</a>	GT104.0837.005.12.40.L	4.00	0.05	8	8	1.70	3.70	0.15	12.00	30.00	4.00
<a href="#">4.018</a>	GT104.0837.015.12.40.L	4.00	0.15	8	8	1.70	3.70	0.15	12.00	30.00	4.00
<a href="#">4.023</a>	GT104.0837.025.12.40.L	4.00	0.25	8	8	1.70	3.70	0.15	12.00	30.00	4.00
<a href="#">4.014</a>	GT104.0837.005.17.40.L	4.00	0.05	8	8	1.70	3.70	0.15	17.00	35.00	4.00
<a href="#">4.019</a>	GT104.0837.015.17.40.L	4.00	0.15	8	8	1.70	3.70	0.15	17.00	35.00	4.00
<a href="#">4.024</a>	GT104.0837.025.17.40.L	4.00	0.25	8	8	1.70	3.70	0.15	17.00	35.00	4.00
<a href="#">4.015</a>	GT104.0837.005.22.40.L	4.00	0.05	8	8	1.70	3.70	0.15	22.00	40.00	4.00
<a href="#">4.020</a>	GT104.0837.015.22.40.L	4.00	0.15	8	8	1.70	3.70	0.15	22.00	40.00	4.00
<a href="#">4.025</a>	GT104.0837.025.22.40.L	4.00	0.25	8	8	1.70	3.70	0.15	22.00	40.00	4.00
<a href="#">4.016</a>	GT104.0837.005.27.40.L	4.00	0.05	8	8	1.70	3.70	0.15	27.00	45.00	4.00
<a href="#">4.021</a>	GT104.0837.015.27.40.L	4.00	0.15	8	8	1.70	3.70	0.15	27.00	45.00	4.00
<a href="#">4.026</a>	GT104.0837.025.27.40.L	4.00	0.25	8	8	1.70	3.70	0.15	27.00	45.00	4.00
<a href="#">4.017</a>	GT104.0837.005.32.40.L	4.00	0.05	8	8	1.70	3.70	0.15	32.00	50.00	4.00
<a href="#">4.022</a>	GT104.0837.015.32.40.L	4.00	0.15	8	8	1.70	3.70	0.15	32.00	50.00	4.00
<a href="#">4.027</a>	GT104.0837.025.32.40.L	4.00	0.25	8	8	1.70	3.70	0.15	32.00	50.00	4.00

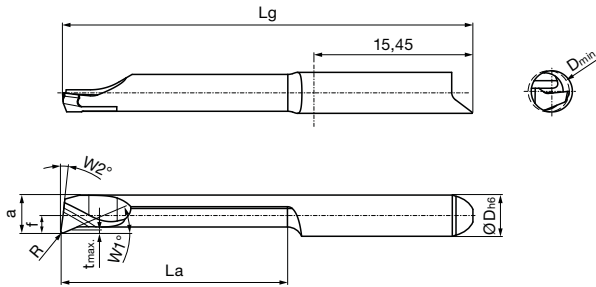
## Cutting insert for boring out and profiling



- WIPER-geometry

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide			
	Type	GJ 104	GJ 104	GJ 104
Surface	<b>S</b>	<b>a</b>	○	
	TiN	TiAlN-nanoA	bright	



Series no.	25090	25092	25096
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GJ104.2319.010.04.20.R	2.00	0.10	23	8	1.95	1.90	0.15	4.00	25.00	4.00
<a href="#">4.002</a>	GJ104.2319.010.07.20.R	2.00	0.10	23	8	1.95	1.90	0.15	7.00	25.00	4.00
<a href="#">4.003</a>	GJ104.2319.010.12.20.R	2.00	0.10	23	8	1.95	1.90	0.15	12.00	30.00	4.00
<a href="#">4.004</a>	GJ104.2319.010.17.20.R	2.00	0.10	23	8	1.95	1.90	0.15	17.00	35.00	4.00
<a href="#">4.005</a>	GJ104.2326.015.07.30.R	3.00	0.15	23	8	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.006</a>	GJ104.2326.015.12.30.R	3.00	0.15	23	8	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.007</a>	GJ104.2326.015.17.30.R	3.00	0.15	23	8	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.008</a>	GJ104.2326.015.22.30.R	3.00	0.15	23	8	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.009</a>	GJ104.2337.020.12.40.R	4.00	0.20	23	8	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.010</a>	GJ104.2337.020.17.40.R	4.00	0.20	23	8	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.011</a>	GJ104.2337.020.22.40.R	4.00	0.20	23	8	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.012</a>	GJ104.2337.020.27.40.R	4.00	0.20	23	8	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.013</a>	GJ104.2337.020.32.40.R	4.00	0.20	23	8	1.70	3.70	0.30	32.00	50.00	4.00

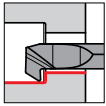
Series no.	25091	25093	25097
Cutting direction	<b>(L)</b>	<b>(L)</b>	<b>(L)</b>

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GJ104.2319.010.04.20.L	2.00	0.10	23	8	1.95	1.90	0.15	4.00	25.00	4.00
<a href="#">4.002</a>	GJ104.2319.010.07.20.L	2.00	0.10	23	8	1.95	1.90	0.15	7.00	25.00	4.00
<a href="#">4.003</a>	GJ104.2319.010.12.20.L	2.00	0.10	23	8	1.95	1.90	0.15	12.00	30.00	4.00
<a href="#">4.004</a>	GJ104.2319.010.17.20.L	2.00	0.10	23	8	1.95	1.90	0.15	17.00	35.00	4.00
<a href="#">4.005</a>	GJ104.2326.015.07.30.L	3.00	0.15	23	8	1.95	2.60	0.20	7.00	25.00	4.00
<a href="#">4.006</a>	GJ104.2326.015.12.30.L	3.00	0.15	23	8	1.95	2.60	0.20	12.00	30.00	4.00
<a href="#">4.007</a>	GJ104.2326.015.17.30.L	3.00	0.15	23	8	1.95	2.60	0.20	17.00	35.00	4.00
<a href="#">4.008</a>	GJ104.2326.015.22.30.L	3.00	0.15	23	8	1.95	2.60	0.20	22.00	40.00	4.00
<a href="#">4.009</a>	GJ104.2337.020.12.40.L	4.00	0.20	23	8	1.70	3.70	0.30	12.00	30.00	4.00
<a href="#">4.010</a>	GJ104.2337.020.17.40.L	4.00	0.20	23	8	1.70	3.70	0.30	17.00	35.00	4.00
<a href="#">4.011</a>	GJ104.2337.020.22.40.L	4.00	0.20	23	8	1.70	3.70	0.30	22.00	40.00	4.00
<a href="#">4.012</a>	GJ104.2337.020.27.40.L	4.00	0.20	23	8	1.70	3.70	0.30	27.00	45.00	4.00
<a href="#">4.013</a>	GJ104.2337.020.32.40.L	4.00	0.20	23	8	1.70	3.70	0.30	32.00	50.00	4.00





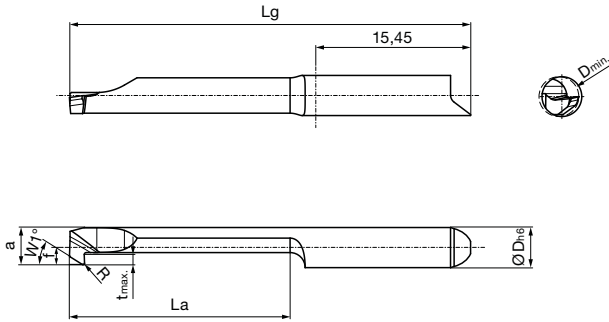
Cutting insert for back boring and profiling



• radial free 32°

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image



Series no. **25106** **25108** **25112**

Cutting direction

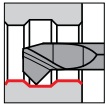
Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GT104.3217.010.04.20.R	2.00	0.10	32	1.95	1.70	0.30	4.00	25.00	4.00
<a href="#">4.002</a>	GT104.3217.010.07.20.R	2.00	0.10	32	1.95	1.70	0.30	7.00	25.00	4.00
<a href="#">4.003</a>	GT104.3217.010.12.20.R	2.00	0.10	32	1.95	1.70	0.30	12.00	30.00	4.00
<a href="#">4.004</a>	GT104.3217.010.17.20.R	2.00	0.10	32	1.95	1.70	0.70	17.00	35.00	4.00
<a href="#">4.005</a>	GT104.3226.005.07.30.R	3.00	0.05	32	1.95	2.60	0.70	7.00	25.00	4.00
<a href="#">4.009</a>	GT104.3226.010.07.30.R	3.00	0.10	32	1.95	2.60	0.70	7.00	25.00	4.00
<a href="#">4.006</a>	GT104.3226.005.12.30.R	3.00	0.05	32	1.95	2.60	0.70	12.00	30.00	4.00
<a href="#">4.010</a>	GT104.3226.010.12.30.R	3.00	0.10	32	1.95	2.60	0.70	12.00	30.00	4.00
<a href="#">4.007</a>	GT104.3226.005.17.30.R	3.00	0.05	32	1.95	2.60	0.70	17.00	35.00	4.00
<a href="#">4.011</a>	GT104.3226.010.17.30.R	3.00	0.10	32	1.95	2.60	0.70	17.00	35.00	4.00
<a href="#">4.008</a>	GT104.3226.005.22.30.R	3.00	0.05	32	1.95	2.60	0.70	22.00	40.00	4.00
<a href="#">4.012</a>	GT104.3226.010.22.30.R	3.00	0.10	32	1.95	2.60	0.70	22.00	40.00	4.00
<a href="#">4.013</a>	GT104.3237.010.12.40.R	4.00	0.10	32	1.7	3.70	1.00	12.00	30.00	4.00
<a href="#">4.018</a>	GT104.3237.015.12.40.R	4.00	0.15	32	1.7	3.70	1.00	12.00	30.00	4.00
<a href="#">4.014</a>	GT104.3237.010.17.40.R	4.00	0.10	32	1.7	3.70	1.00	17.00	35.00	4.00
<a href="#">4.019</a>	GT104.3237.015.17.40.R	4.00	0.15	32	1.7	3.70	1.00	17.00	35.00	4.00
<a href="#">4.015</a>	GT104.3237.010.22.40.R	4.00	0.10	32	1.7	3.70	1.00	22.00	40.00	4.00
<a href="#">4.020</a>	GT104.3237.015.22.40.R	4.00	0.15	32	1.7	3.70	1.00	22.00	40.00	4.00
<a href="#">4.016</a>	GT104.3237.010.27.40.R	4.00	0.10	32	1.7	3.70	1.00	27.00	45.00	4.00
<a href="#">4.021</a>	GT104.3237.015.27.40.R	4.00	0.15	32	1.7	3.70	1.00	27.00	45.00	4.00
<a href="#">4.017</a>	GT104.3237.010.32.40.R	4.00	0.10	32	1.7	3.70	1.00	32.00	50.00	4.00
<a href="#">4.022</a>	GT104.3237.015.32.40.R	4.00	0.15	32	1.7	3.70	1.00	32.00	50.00	4.00

Series no. **25107** **25109** **25113**Cutting direction   

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GT104.3217.010.04.20.L	2.00	0.10	32	1.95	1.70	0.30	4.00	25.00	4.00
<a href="#">4.002</a>	GT104.3217.010.07.20.L	2.00	0.10	32	1.95	1.70	0.30	7.00	25.00	4.00
<a href="#">4.003</a>	GT104.3217.010.12.20.L	2.00	0.10	32	1.95	1.70	0.30	12.00	30.00	4.00
<a href="#">4.004</a>	GT104.3217.010.17.20.L	2.00	0.10	32	1.95	1.70	0.70	17.00	35.00	4.00
<a href="#">4.005</a>	GT104.3226.005.07.30.L	3.00	0.05	32	1.95	2.60	0.70	7.00	25.00	4.00
<a href="#">4.009</a>	GT104.3226.010.07.30.L	3.00	0.10	32	1.95	2.60	0.70	7.00	25.00	4.00
<a href="#">4.006</a>	GT104.3226.005.12.30.L	3.00	0.05	32	1.95	2.60	0.70	12.00	30.00	4.00
<a href="#">4.010</a>	GT104.3226.010.12.30.L	3.00	0.10	32	1.95	2.60	0.70	12.00	30.00	4.00
<a href="#">4.007</a>	GT104.3226.005.17.30.L	3.00	0.05	32	1.95	2.60	0.70	17.00	35.00	4.00
<a href="#">4.011</a>	GT104.3226.010.17.30.L	3.00	0.10	32	1.95	2.60	0.70	17.00	35.00	4.00
<a href="#">4.008</a>	GT104.3226.005.22.30.L	3.00	0.05	32	1.95	2.60	0.70	22.00	40.00	4.00
<a href="#">4.012</a>	GT104.3226.010.22.30.L	3.00	0.10	32	1.95	2.60	0.70	22.00	40.00	4.00
<a href="#">4.013</a>	GT104.3237.010.12.40.L	4.00	0.10	32	1.7	3.70	1.00	12.00	30.00	4.00
<a href="#">4.018</a>	GT104.3237.015.12.40.L	4.00	0.15	32	1.7	3.70	1.00	12.00	30.00	4.00
<a href="#">4.014</a>	GT104.3237.010.17.40.L	4.00	0.10	32	1.7	3.70	1.00	17.00	35.00	4.00
<a href="#">4.019</a>	GT104.3237.015.17.40.L	4.00	0.15	32	1.7	3.70	1.00	17.00	35.00	4.00
<a href="#">4.015</a>	GT104.3237.010.22.40.L	4.00	0.10	32	1.7	3.70	1.00	22.00	40.00	4.00
<a href="#">4.020</a>	GT104.3237.015.22.40.L	4.00	0.15	32	1.7	3.70	1.00	22.00	40.00	4.00
<a href="#">4.016</a>	GT104.3237.010.27.40.L	4.00	0.10	32	1.7	3.70	1.00	27.00	45.00	4.00
<a href="#">4.021</a>	GT104.3237.015.27.40.L	4.00	0.15	32	1.7	3.70	1.00	27.00	45.00	4.00
<a href="#">4.017</a>	GT104.3237.010.32.40.L	4.00	0.10	32	1.7	3.70	1.00	32.00	50.00	4.00
<a href="#">4.022</a>	GT104.3237.015.32.40.L	4.00	0.15	32	1.7	3.70	1.00	32.00	50.00	4.00



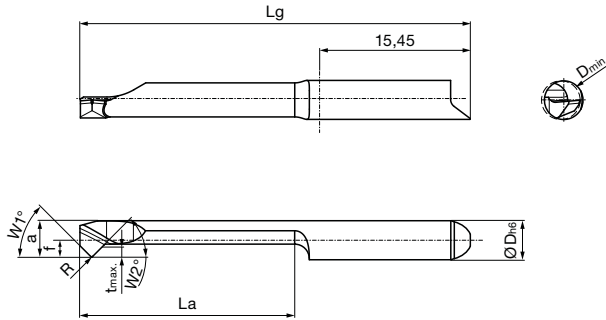
Cutting insert for boring out and chamfering



• 45° both sides

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GT 104	GT 104	GT 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Series no. **25114**    **25116**    **25120**

Cutting direction

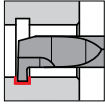
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GT104.4518.010.04.20.R	2.00	0.10	45	45	1.95	1.80	0.50	4.00	25.00	4.00
<a href="#">4.002</a>	GT104.4518.010.07.20.R	2.00	0.10	45	45	1.95	1.80	0.50	7.00	25.00	4.00
<a href="#">4.003</a>	GT104.4518.010.12.20.R	2.00	0.10	45	45	1.95	1.80	0.50	12.00	30.00	4.00
<a href="#">4.004</a>	GT104.4518.010.17.20.R	2.00	0.10	45	45	1.95	1.80	0.50	17.00	35.00	4.00
<a href="#">4.005</a>	GT104.4527.010.07.30.R	3.00	0.10	45	45	1.95	2.70	0.70	7.00	25.00	4.00
<a href="#">4.006</a>	GT104.4527.010.12.30.R	3.00	0.10	45	45	1.95	2.70	0.70	12.00	30.00	4.00
<a href="#">4.007</a>	GT104.4527.010.17.30.R	3.00	0.10	45	45	1.95	2.70	0.70	17.00	35.00	4.00
<a href="#">4.008</a>	GT104.4527.010.22.30.R	3.00	0.10	45	45	1.95	2.70	0.70	22.00	40.00	4.00
<a href="#">4.009</a>	GT104.4537.015.12.40.R	4.00	0.15	45	45	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.010</a>	GT104.4537.015.17.40.R	4.00	0.15	45	45	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.011</a>	GT104.4537.015.22.40.R	4.00	0.15	45	45	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.012</a>	GT104.4537.015.27.40.R	4.00	0.15	45	45	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.013</a>	GT104.4537.015.32.40.R	4.00	0.15	45	45	1.70	3.70	1.00	32.00	50.00	4.00

Series no. **25115**    **25117**    **25121**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GT104.4518.010.04.20.L	2.00	0.10	45	45	1.95	1.80	0.50	4.00	25.00	4.00
<a href="#">4.002</a>	GT104.4518.010.07.20.L	2.00	0.10	45	45	1.95	1.80	0.50	7.00	25.00	4.00
<a href="#">4.003</a>	GT104.4518.010.12.20.L	2.00	0.10	45	45	1.95	1.80	0.50	12.00	30.00	4.00
<a href="#">4.004</a>	GT104.4518.010.17.20.L	2.00	0.10	45	45	1.95	1.80	0.50	17.00	35.00	4.00
<a href="#">4.005</a>	GT104.4527.010.07.30.L	3.00	0.10	45	45	1.95	2.70	0.70	7.00	25.00	4.00
<a href="#">4.006</a>	GT104.4527.010.12.30.L	3.00	0.10	45	45	1.95	2.70	0.70	12.00	30.00	4.00
<a href="#">4.007</a>	GT104.4527.010.17.30.L	3.00	0.10	45	45	1.95	2.70	0.70	17.00	35.00	4.00
<a href="#">4.008</a>	GT104.4527.010.22.30.L	3.00	0.10	45	45	1.95	2.70	0.70	22.00	40.00	4.00
<a href="#">4.009</a>	GT104.4537.015.12.40.L	4.00	0.15	45	45	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.010</a>	GT104.4537.015.17.40.L	4.00	0.15	45	45	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.011</a>	GT104.4537.015.22.40.L	4.00	0.15	45	45	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.012</a>	GT104.4537.015.27.40.L	4.00	0.15	45	45	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.013</a>	GT104.4537.015.32.40.L	4.00	0.15	45	45	1.70	3.70	1.00	32.00	50.00	4.00

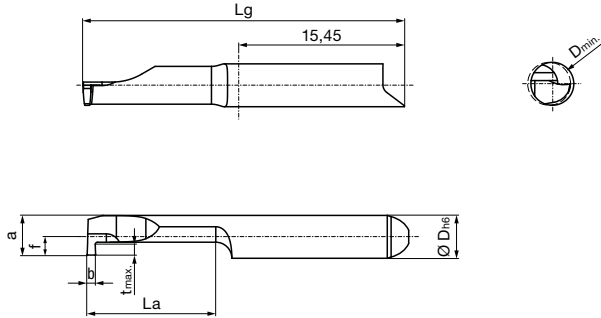
## Cutting insert for internal grooving, straight slots



- grooving depth up to 1 mm

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GE 104	GE 104	GE 104
Surface			
	TiN	TiAlN-nanoA	bright



Series no.	25124	25126	25130
Cutting direction			

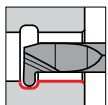
Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GE104.0030.000.04.10.R	1.00	0.30	1.95	0.85	0.20	4.00	25.00	4.00
<a href="#">4.002</a>	GE104.0030.000.07.10.R	1.00	0.30	1.95	0.85	0.20	7.00	25.00	4.00
<a href="#">4.003</a>	GE104.0040.000.04.15.R	1.50	0.40	1.95	1.30	0.40	4.00	25.00	4.00
<a href="#">4.004</a>	GE104.0040.000.07.15.R	1.50	0.40	1.95	1.30	0.40	7.00	25.00	4.00
<a href="#">4.005</a>	GE104.0040.000.12.15.R	1.50	0.40	1.95	1.30	0.40	12.00	30.00	4.00
<a href="#">4.006</a>	GE104.0050.000.04.20.R	2.00	0.50	1.95	1.80	0.50	4.00	25.00	4.00
<a href="#">4.007</a>	GE104.0050.000.07.20.R	2.00	0.50	1.95	1.80	0.50	7.00	25.00	4.00
<a href="#">4.008</a>	GE104.0050.000.12.20.R	2.00	0.50	1.95	1.80	0.50	12.00	30.00	4.00
<a href="#">4.009</a>	GE104.0050.000.17.20.R	2.00	0.50	1.95	1.80	0.50	17.00	35.00	4.00
<a href="#">4.010</a>	GE104.0070.000.07.30.R	3.00	0.70	1.95	2.70	0.70	7.00	25.00	4.00
<a href="#">4.011</a>	GE104.0070.000.12.30.R	3.00	0.70	1.95	2.70	0.70	12.00	30.00	4.00
<a href="#">4.012</a>	GE104.0070.000.17.30.R	3.00	0.70	1.95	2.70	0.70	17.00	35.00	4.00
<a href="#">4.013</a>	GE104.0070.000.22.30.R	3.00	0.70	1.95	2.70	0.70	22.00	40.00	4.00
<a href="#">4.014</a>	GE104.0079.000.12.40.R	4.00	0.79	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.015</a>	GE104.0079.000.17.40.R	4.00	0.79	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.016</a>	GE104.0079.000.22.40.R	4.00	0.79	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.017</a>	GE104.0079.000.27.40.R	4.00	0.79	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.018</a>	GE104.0079.000.32.40.R	4.00	0.79	1.70	3.70	1.00	32.00	50.00	4.00
<a href="#">4.019</a>	GE104.0100.000.12.40.R	4.00	1.00	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.020</a>	GE104.0100.000.17.40.R	4.00	1.00	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.021</a>	GE104.0100.000.22.40.R	4.00	1.00	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.022</a>	GE104.0100.000.27.40.R	4.00	1.00	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.023</a>	GE104.0100.000.32.40.R	4.00	1.00	1.70	3.70	1.00	32.00	50.00	4.00
<a href="#">4.024</a>	GE104.0150.000.12.40.R	4.00	1.50	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.025</a>	GE104.0150.000.17.40.R	4.00	1.50	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.026</a>	GE104.0150.000.22.40.R	4.00	1.50	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.027</a>	GE104.0150.000.27.40.R	4.00	1.50	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.028</a>	GE104.0150.000.32.40.R	4.00	1.50	1.70	3.70	1.00	32.00	50.00	4.00

Series no. **25125** **25127** **25131**Cutting direction   

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GE104.0030.000.04.10.L	1.00	0.30	1.95	0.85	0.20	4.00	25.00	4.00
<a href="#">4.002</a>	GE104.0030.000.07.10.L	1.00	0.30	1.95	0.85	0.20	7.00	25.00	4.00
<a href="#">4.003</a>	GE104.0040.000.04.15.L	1.50	0.40	1.95	1.30	0.40	4.00	25.00	4.00
<a href="#">4.004</a>	GE104.0040.000.07.15.L	1.50	0.40	1.95	1.30	0.40	7.00	25.00	4.00
<a href="#">4.005</a>	GE104.0040.000.12.15.L	1.50	0.40	1.95	1.30	0.40	12.00	30.00	4.00
<a href="#">4.006</a>	GE104.0050.000.04.20.L	2.00	0.50	1.95	1.80	0.50	4.00	25.00	4.00
<a href="#">4.007</a>	GE104.0050.000.07.20.L	2.00	0.50	1.95	1.80	0.50	7.00	25.00	4.00
<a href="#">4.008</a>	GE104.0050.000.12.20.L	2.00	0.50	1.95	1.80	0.50	12.00	30.00	4.00
<a href="#">4.009</a>	GE104.0050.000.17.20.L	2.00	0.50	1.95	1.80	0.50	17.00	35.00	4.00
<a href="#">4.010</a>	GE104.0070.000.07.30.L	3.00	0.70	1.95	2.70	0.70	7.00	25.00	4.00
<a href="#">4.011</a>	GE104.0070.000.12.30.L	3.00	0.70	1.95	2.70	0.70	12.00	30.00	4.00
<a href="#">4.012</a>	GE104.0070.000.17.30.L	3.00	0.70	1.95	2.70	0.70	17.00	35.00	4.00
<a href="#">4.013</a>	GE104.0070.000.22.30.L	3.00	0.70	1.95	2.70	0.70	22.00	40.00	4.00
<a href="#">4.014</a>	GE104.0079.000.12.40.L	4.00	0.79	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.015</a>	GE104.0079.000.17.40.L	4.00	0.79	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.016</a>	GE104.0079.000.22.40.L	4.00	0.79	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.017</a>	GE104.0079.000.27.40.L	4.00	0.79	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.018</a>	GE104.0079.000.32.40.L	4.00	0.79	1.70	3.70	1.00	32.00	50.00	4.00
<a href="#">4.019</a>	GE104.0100.000.12.40.L	4.00	1.00	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.020</a>	GE104.0100.000.17.40.L	4.00	1.00	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.021</a>	GE104.0100.000.22.40.L	4.00	1.00	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.022</a>	GE104.0100.000.27.40.L	4.00	1.00	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.023</a>	GE104.0100.000.32.40.L	4.00	1.00	1.70	3.70	1.00	32.00	50.00	4.00
<a href="#">4.024</a>	GE104.0150.000.12.40.L	4.00	1.50	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.025</a>	GE104.0150.000.17.40.L	4.00	1.50	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.026</a>	GE104.0150.000.22.40.L	4.00	1.50	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.027</a>	GE104.0150.000.27.40.L	4.00	1.50	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.028</a>	GE104.0150.000.32.40.L	4.00	1.50	1.70	3.70	1.00	32.00	50.00	4.00



Cutting insert for internal grooving, full radius slots

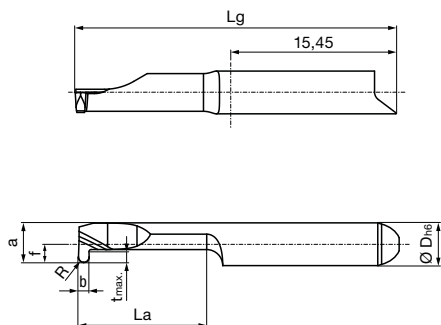


- full radius R0.4-R0.58

for tool holders type GH104/GB104 see from page 16

Cutting data page 148

Tool material	Solid carbide		
Type	GE 104	GE 104	GE 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Right hand version shown  
Left hand version mirror image



Series no.	<b>25132</b>	<b>25134</b>	<b>25138</b>
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

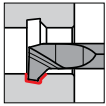
Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GE104.0080.040.07.30.R	3.00	0.80	0.40	1.95	2.70	0.70	7.00	25.00	4.00
<a href="#">4.002</a>	GE104.0080.040.12.30.R	3.00	0.80	0.40	1.95	2.70	0.70	12.00	30.00	4.00
<a href="#">4.003</a>	GE104.0080.040.17.30.R	3.00	0.80	0.40	1.95	2.70	0.70	17.00	35.00	4.00
<a href="#">4.004</a>	GE104.0080.040.22.30.R	3.00	0.80	0.40	1.95	2.70	0.70	22.00	40.00	4.00
<a href="#">4.005</a>	GE104.0100.050.12.40.R	4.00	1.00	0.50	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.006</a>	GE104.0100.050.17.40.R	4.00	1.00	0.50	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.007</a>	GE104.0100.050.22.40.R	4.00	1.00	0.50	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.008</a>	GE104.0100.050.27.40.R	4.00	1.00	0.50	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.009</a>	GE104.0100.050.32.40.R	4.00	1.00	0.50	1.70	3.70	1.00	32.00	50.00	4.00
<a href="#">4.010</a>	GE104.0117.058.12.40.R	4.00	1.17	0.58	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.011</a>	GE104.0117.058.17.40.R	4.00	1.17	0.58	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.012</a>	GE104.0117.058.22.40.R	4.00	1.17	0.58	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.013</a>	GE104.0117.058.27.40.R	4.00	1.17	0.58	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.014</a>	GE104.0117.058.32.40.R	4.00	1.17	0.58	1.70	3.70	1.00	32.00	50.00	4.00

Series no.	<b>25133</b>	<b>25135</b>	<b>25139</b>
Cutting direction	<b>(L)</b>	<b>(L)</b>	<b>(L)</b>

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GE104.0080.040.07.30.L	3.00	0.80	0.40	1.95	2.70	0.70	7.00	25.00	4.00
<a href="#">4.002</a>	GE104.0080.040.12.30.L	3.00	0.80	0.40	1.95	2.70	0.70	12.00	30.00	4.00
<a href="#">4.003</a>	GE104.0080.040.17.30.L	3.00	0.80	0.40	1.95	2.70	0.70	17.00	35.00	4.00
<a href="#">4.004</a>	GE104.0080.040.22.30.L	3.00	0.80	0.40	1.95	2.70	0.70	22.00	40.00	4.00
<a href="#">4.005</a>	GE104.0100.050.12.40.L	4.00	1.00	0.50	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.006</a>	GE104.0100.050.17.40.L	4.00	1.00	0.50	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.007</a>	GE104.0100.050.22.40.L	4.00	1.00	0.50	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.008</a>	GE104.0100.050.27.40.L	4.00	1.00	0.50	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.009</a>	GE104.0100.050.32.40.L	4.00	1.00	0.50	1.70	3.70	1.00	32.00	50.00	4.00
<a href="#">4.010</a>	GE104.0117.058.12.40.L	4.00	1.17	0.58	1.70	3.70	1.00	12.00	30.00	4.00
<a href="#">4.011</a>	GE104.0117.058.17.40.L	4.00	1.17	0.58	1.70	3.70	1.00	17.00	35.00	4.00
<a href="#">4.012</a>	GE104.0117.058.22.40.L	4.00	1.17	0.58	1.70	3.70	1.00	22.00	40.00	4.00
<a href="#">4.013</a>	GE104.0117.058.27.40.L	4.00	1.17	0.58	1.70	3.70	1.00	27.00	45.00	4.00
<a href="#">4.014</a>	GE104.0117.058.32.40.L	4.00	1.17	0.58	1.70	3.70	1.00	32.00	50.00	4.00



Cutting insert for internal pre-grooving and chamfering

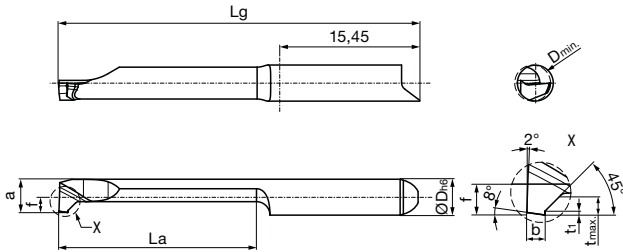


• 45° chamfer

for tool holders type GH104/GB104 see from page 16

Cutting data page 148

Tool material	Solid carbide		
Type	GV 104	GV 104	GV 104
Surface	S	a	O
	TiN	TiAlN-nanoA	bright



Right hand version shown  
Left hand version mirror image



Series no.	25140	25142	25146
Cutting direction			

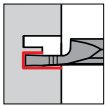
Code no.	Description	D min	b	f	t1	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GV104.0807.045.04.20.R	2.00	0.70	1.95	0.20	1.80	0.50	4.00	25.00	4.00
4.002	GV104.0807.045.07.20.R	2.00	0.70	1.95	0.20	1.80	0.50	7.00	25.00	4.00
4.003	GV104.0807.045.12.20.R	2.00	0.70	1.95	0.20	1.80	0.50	12.00	30.00	4.00
4.004	GV104.0807.045.17.20.R	2.00	0.70	1.95	0.20	1.80	0.50	17.00	35.00	4.00
4.005	GV104.0807.045.07.30.R	3.00	0.70	1.95	0.20	2.70	0.70	7.00	25.00	4.00
4.006	GV104.0807.045.12.30.R	3.00	0.70	1.95	0.20	2.70	0.70	12.00	30.00	4.00
4.007	GV104.0807.045.17.30.R	3.00	0.70	1.95	0.20	2.70	0.70	17.00	35.00	4.00
4.008	GV104.0807.045.22.30.R	3.00	0.70	1.95	0.20	2.70	0.70	22.00	40.00	4.00
4.009	GV104.0810.045.12.40.R	4.00	1.00	1.70	0.20	3.70	1.00	12.00	30.00	4.00
4.010	GV104.0810.045.17.40.R	4.00	1.00	1.70	0.20	3.70	1.00	17.00	35.00	4.00
4.011	GV104.0810.045.22.40.R	4.00	1.00	1.70	0.20	3.70	1.00	22.00	40.00	4.00
4.012	GV104.0810.045.27.40.R	4.00	1.00	1.70	0.20	3.70	1.00	27.00	45.00	4.00
4.013	GV104.0810.045.32.40.R	4.00	1.00	1.70	0.20	3.70	1.00	32.00	50.00	4.00

Series no.	25141	25143	25147
Cutting direction			

Code no.	Description	D min	b	f	t1	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GV104.0807.045.04.20.L	2.00	0.70	1.95	0.20	1.80	0.50	4.00	25.00	4.00
4.002	GV104.0807.045.07.20.L	2.00	0.70	1.95	0.20	1.80	0.50	7.00	25.00	4.00
4.003	GV104.0807.045.12.20.L	2.00	0.70	1.95	0.20	1.80	0.50	12.00	30.00	4.00
4.004	GV104.0807.045.17.20.L	2.00	0.70	1.95	0.20	1.80	0.50	17.00	35.00	4.00
4.005	GV104.0807.045.07.30.L	3.00	0.70	1.95	0.20	2.70	0.70	7.00	25.00	4.00
4.006	GV104.0807.045.12.30.L	3.00	0.70	1.95	0.20	2.70	0.70	12.00	30.00	4.00
4.007	GV104.0807.045.17.30.L	3.00	0.70	1.95	0.20	2.70	0.70	17.00	35.00	4.00
4.008	GV104.0807.045.22.30.L	3.00	0.70	1.95	0.20	2.70	0.70	22.00	40.00	4.00
4.009	GV104.0810.045.12.40.L	4.00	1.00	1.70	0.20	3.70	1.00	12.00	30.00	4.00
4.010	GV104.0810.045.17.40.L	4.00	1.00	1.70	0.20	3.70	1.00	17.00	35.00	4.00
4.011	GV104.0810.045.22.40.L	4.00	1.00	1.70	0.20	3.70	1.00	22.00	40.00	4.00
4.012	GV104.0810.045.27.40.L	4.00	1.00	1.70	0.20	3.70	1.00	27.00	45.00	4.00
4.013	GV104.0810.045.32.40.L	4.00	1.00	1.70	0.20	3.70	1.00	32.00	50.00	4.00



**Cutting insert for axial grooving bores, straight slots**

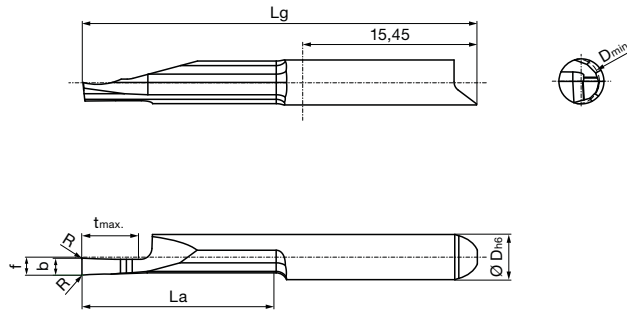


- grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

Tool material	Solid carbide		
Type	GA 104	GA 104	GA 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright

Cutting data page 148



Right hand version shown  
Left hand version mirror image



Series no.	25188	25190	25194
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GA104.0100.005.12.40.R	4.00	1.00	0.05	1.60	2.00	12.00	30.00	4.00
<a href="#">4.002</a>	GA104.0100.005.17.40.R	4.00	1.00	0.05	1.60	2.00	17.00	35.00	4.00
<a href="#">4.003</a>	GA104.0150.005.12.40.R	4.00	1.50	0.05	1.60	3.00	12.00	30.00	4.00
<a href="#">4.004</a>	GA104.0150.005.17.40.R	4.00	1.50	0.05	1.60	3.00	17.00	35.00	4.00
<a href="#">4.005</a>	GA104.0200.005.12.50.R	5.00	2.00	0.05	1.60	5.00	12.00	30.00	4.00
<a href="#">4.006</a>	GA104.0200.005.17.50.R	5.00	2.00	0.05	1.60	5.00	17.00	35.00	4.00

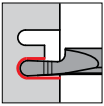
Series no.	25189	25191	25195
Cutting direction	<b>(L)</b>	<b>(L)</b>	<b>(L)</b>

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GA104.0100.005.12.40.L	4.00	1.00	0.05	1.60	2.00	12.00	30.00	4.00
<a href="#">4.002</a>	GA104.0100.005.17.40.L	4.00	1.00	0.05	1.60	2.00	17.00	35.00	4.00
<a href="#">4.003</a>	GA104.0150.005.12.40.L	4.00	1.50	0.05	1.60	3.00	12.00	30.00	4.00
<a href="#">4.004</a>	GA104.0150.005.17.40.L	4.00	1.50	0.05	1.60	3.00	17.00	35.00	4.00
<a href="#">4.005</a>	GA104.0200.005.12.50.L	5.00	2.00	0.05	1.60	5.00	12.00	30.00	4.00
<a href="#">4.006</a>	GA104.0200.005.17.50.L	5.00	2.00	0.05	1.60	5.00	17.00	35.00	4.00





**Cutting insert for axial grooving bores, full radius slots**

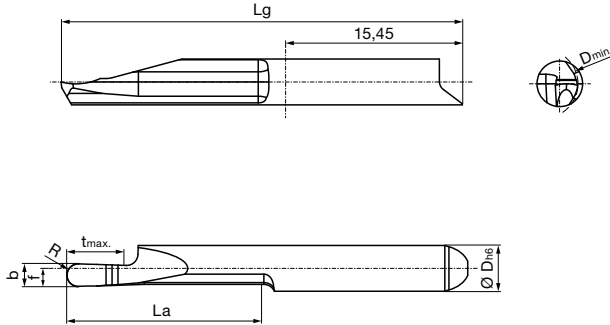


- grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

Tool material	Solid carbide		
Type	GA 104	GA 104	GA 104
Surface			
	TiN	TiAlN-nanoA	bright

Cutting data page 148



Right hand version shown  
Left hand version mirror image



Series no.	25196	25198	25202
Cutting direction			

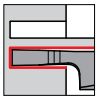
Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GA104.0100.050.12.60.R	6.00	1.00	0.50	1.60	2.00	12.00	30.00	4.00
<a href="#">4.002</a>	GA104.0100.050.17.60.R	6.00	1.00	0.50	1.60	2.00	17.00	35.00	4.00
<a href="#">4.003</a>	GA104.0150.075.12.60.R	6.00	1.50	0.75	1.60	3.00	12.00	30.00	4.00
<a href="#">4.004</a>	GA104.0150.075.17.60.R	6.00	1.50	0.75	1.60	3.00	17.00	35.00	4.00
<a href="#">4.005</a>	GA104.0200.100.12.60.R	6.00	2.00	1.00	1.60	5.00	12.00	30.00	4.00
<a href="#">4.006</a>	GA104.0200.100.17.60.R	6.00	2.00	1.00	1.60	5.00	17.00	35.00	4.00

Series no.	25197	25199	25203
Cutting direction			

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GA104.0100.050.12.60.L	6.00	1.00	0.50	1.60	2.00	12.00	30.00	4.00
<a href="#">4.002</a>	GA104.0100.050.17.60.L	6.00	1.00	0.50	1.60	2.00	17.00	35.00	4.00
<a href="#">4.003</a>	GA104.0150.075.12.60.L	6.00	1.50	0.75	1.60	3.00	12.00	30.00	4.00
<a href="#">4.004</a>	GA104.0150.075.17.60.L	6.00	1.50	0.75	1.60	3.00	17.00	35.00	4.00
<a href="#">4.005</a>	GA104.0200.100.12.60.L	6.00	2.00	1.00	1.60	5.00	12.00	30.00	4.00
<a href="#">4.006</a>	GA104.0200.100.17.60.L	6.00	2.00	1.00	1.60	5.00	17.00	35.00	4.00



**Cutting insert for axial grooving studs, straight slots**

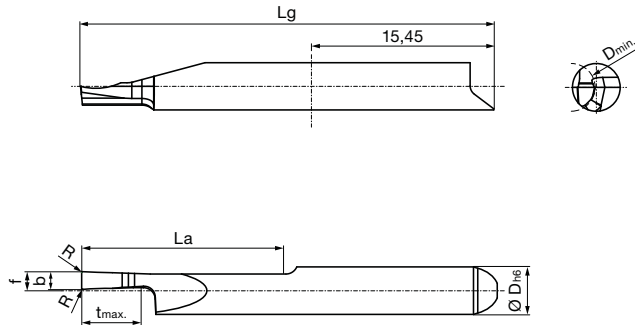


- grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

Tool material	Solid carbide		
Type	GA 104	GA 104	GA 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright

Cutting data page 148



Right hand version shown  
Left hand version mirror image



Series no.	25204	25206	25210
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

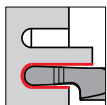
Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GA104.Z100.005.12.40.R	4.00	1.00	0.05	1.60	2.00	12.00	30.00	4.00
<a href="#">4.002</a>	GA104.Z100.005.17.40.R	4.00	1.00	0.05	1.60	2.00	17.00	35.00	4.00
<a href="#">4.003</a>	GA104.Z150.005.12.40.R	4.00	1.50	0.05	1.60	3.00	12.00	30.00	4.00
<a href="#">4.004</a>	GA104.Z150.005.17.40.R	4.00	1.50	0.05	1.60	3.00	17.00	35.00	4.00
<a href="#">4.005</a>	GA104.Z200.005.12.50.R	5.00	2.00	0.05	1.60	5.00	12.00	30.00	4.00
<a href="#">4.006</a>	GA104.Z200.005.17.50.R	5.00	2.00	0.05	1.60	5.00	17.00	35.00	4.00

Series no.	25205	25207	25211
Cutting direction	<b>(L)</b>	<b>(L)</b>	<b>(L)</b>

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GA104.Z100.005.12.40.L	4.00	1.00	0.05	1.60	2.00	12.00	30.00	4.00
<a href="#">4.002</a>	GA104.Z100.005.17.40.L	4.00	1.00	0.05	1.60	2.00	17.00	35.00	4.00
<a href="#">4.003</a>	GA104.Z150.005.12.40.L	4.00	1.50	0.05	1.60	3.00	12.00	30.00	4.00
<a href="#">4.004</a>	GA104.Z150.005.17.40.L	4.00	1.50	0.05	1.60	3.00	17.00	35.00	4.00
<a href="#">4.005</a>	GA104.Z200.005.12.50.L	5.00	2.00	0.05	1.60	5.00	12.00	30.00	4.00
<a href="#">4.006</a>	GA104.Z200.005.17.50.L	5.00	2.00	0.05	1.60	5.00	17.00	35.00	4.00



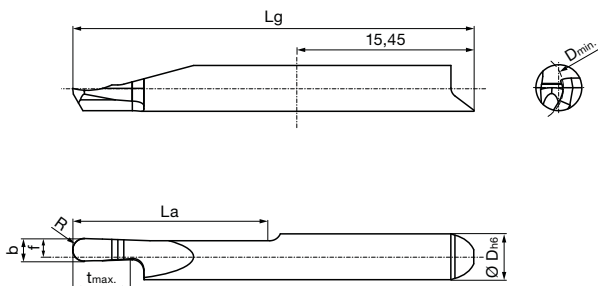
**Cutting insert for axial grooving studs, full radius slots**



• grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image



Series no. **25212** **25214** **25218**

Cutting direction

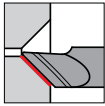
Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GA104.Z100.050.12.60.R	6.00	1.00	0.50	1.60	2.00	12.00	30.00	4.00
<a href="#">4.002</a>	GA104.Z100.050.17.60.R	6.00	1.00	0.50	1.60	2.00	17.00	35.00	4.00
<a href="#">4.003</a>	GA104.Z150.075.12.60.R	6.00	1.50	0.75	1.60	3.00	12.00	30.00	4.00
<a href="#">4.004</a>	GA104.Z150.075.17.60.R	6.00	1.50	0.75	1.60	3.00	17.00	35.00	4.00
<a href="#">4.005</a>	GA104.Z200.100.12.60.R	6.00	2.00	1.00	1.60	5.00	12.00	30.00	4.00
<a href="#">4.006</a>	GA104.Z200.100.17.60.R	6.00	2.00	1.00	1.60	5.00	17.00	35.00	4.00

Series no. **25213** **25215** **25219**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GA104.Z100.050.12.60.L	6.00	1.00	0.50	1.60	2.00	12.00	30.00	4.00
<a href="#">4.002</a>	GA104.Z100.050.17.60.L	6.00	1.00	0.50	1.60	2.00	17.00	35.00	4.00
<a href="#">4.003</a>	GA104.Z150.075.12.60.L	6.00	1.50	0.75	1.60	3.00	12.00	30.00	4.00
<a href="#">4.004</a>	GA104.Z150.075.17.60.L	6.00	1.50	0.75	1.60	3.00	17.00	35.00	4.00
<a href="#">4.005</a>	GA104.Z200.100.12.60.L	6.00	2.00	1.00	1.60	5.00	12.00	30.00	4.00
<a href="#">4.006</a>	GA104.Z200.100.17.60.L	6.00	2.00	1.00	1.60	5.00	17.00	35.00	4.00

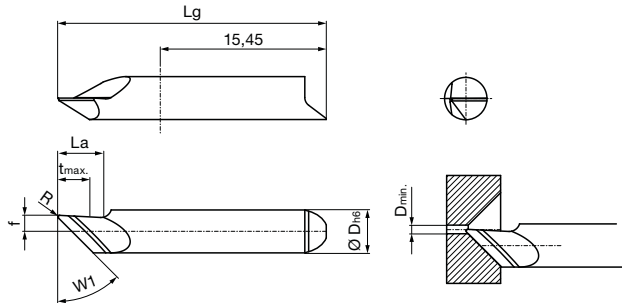
## Cutting insert for axial chamfering bores





- 45°/60°/75° chamfer angle

for tool holders type GH104/GB104 see from page 16

Cutting data page 148




Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GA 104	GA 104	GA 104
Surface			
	TiN	TiAlN-nanoA	bright



Series no.	25220	25222	25226
Cutting direction			

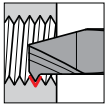
Code no.	Description	D min	R	W1	f	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GA104.F045.015.04.08.R	0.80	0.15	45.00	1.50	3.00	4.00	25.00	4.00
<a href="#">4.002</a>	GA104.F060.015.04.08.R	0.80	0.15	60.00	0.50	3.50	4.00	25.00	4.00
<a href="#">4.003</a>	GA104.F075.015.04.08.R	0.80	0.15	75.00	0.50	2.00	4.00	25.00	4.00

Series no.	25221	25223	25227
Cutting direction			

Code no.	Description	D min	R	W1	f	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GA104.F045.015.04.08.L	0.80	0.15	45.00	1.50	3.00	4.00	25.00	4.00
<a href="#">4.002</a>	GA104.F060.015.04.08.L	0.80	0.15	60.00	0.50	3.50	4.00	25.00	4.00
<a href="#">4.003</a>	GA104.F075.015.04.08.L	0.80	0.15	75.00	0.50	2.00	4.00	25.00	4.00



Cutting insert for internal threading, partial profile - metric standard threads

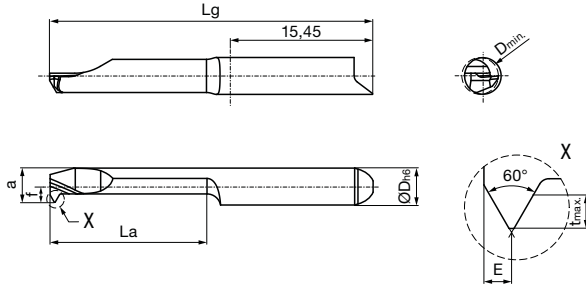


• pitch P = 0.4-1.0

for tool holders type GH104/GB104 see from page 16

Cutting data page 148

Tool material	Solid carbide		
	GG 104	GG 104	GG 104
Type	GG 104	GG 104	GG 104
Surface	Ⓢ TiN	ⓐ TiAlN-nanoA	○ bright



Right hand version shown  
Left hand version mirror image



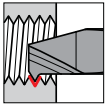
Series no.	25148	25150	25154
Cutting direction	Ⓡ	Ⓡ	Ⓡ

Code no.	Description	G	P	D min	f	t max	a	E	La	Lg	D h6
				mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TM02.040.04.15.R	M2/M2.5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	4.00	25.00	4.00
4.002	GG104.TM02.040.07.15.R	M2/M2.5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	7.00	25.00	4.00
4.003	GG104.TM02.040.12.15.R	M2/M2.5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	12.00	30.00	4.00
4.004	GG104.TM03.050.04.25.R	M3	0.50	2.50	1.95	0.30	2.20	0.30	4.00	25.00	4.00
4.005	GG104.TM03.050.07.25.R	M3	0.50	2.50	1.95	0.30	2.20	0.30	7.00	25.00	4.00
4.006	GG104.TM03.050.12.25.R	M3	0.50	2.50	1.95	0.30	2.20	0.30	12.00	30.00	4.00
4.007	GG104.TM04.070.07.33.R	M4	0.70	3.30	1.95	0.40	3.00	0.40	7.00	25.00	4.00
4.008	GG104.TM04.070.12.33.R	M4	0.70	3.30	1.95	0.40	3.00	0.40	12.00	30.00	4.00
4.009	GG104.TM04.070.17.33.R	M4	0.70	3.30	1.95	0.40	3.00	0.40	17.00	35.00	4.00
4.010	GG104.TM05.080.12.40.R	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	12.00	30.00	4.00
4.011	GG104.TM05.080.17.40.R	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	17.00	35.00	4.00
4.012	GG104.TM05.080.22.40.R	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	22.00	40.00	4.00

Series no.	25149	25151	25155
Cutting direction	Ⓛ	Ⓛ	Ⓛ

Code no.	Description	G	P	D min	f	t max	a	E	La	Lg	D h6
				mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TM02.040.04.15.L	M2/M2.5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	4.00	25.00	4.00
4.002	GG104.TM02.040.07.15.L	M2/M2.5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	7.00	25.00	4.00
4.003	GG104.TM02.040.12.15.L	M2/M2.5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	12.00	30.00	4.00
4.004	GG104.TM03.050.04.25.L	M3	0.50	2.50	1.95	0.30	2.20	0.30	4.00	25.00	4.00
4.005	GG104.TM03.050.07.25.L	M3	0.50	2.50	1.95	0.30	2.20	0.30	7.00	25.00	4.00
4.006	GG104.TM03.050.12.25.L	M3	0.50	2.50	1.95	0.30	2.20	0.30	12.00	30.00	4.00
4.007	GG104.TM04.070.07.33.L	M4	0.70	3.30	1.95	0.40	3.00	0.40	7.00	25.00	4.00
4.008	GG104.TM04.070.12.33.L	M4	0.70	3.30	1.95	0.40	3.00	0.40	12.00	30.00	4.00
4.009	GG104.TM04.070.17.33.L	M4	0.70	3.30	1.95	0.40	3.00	0.40	17.00	35.00	4.00
4.010	GG104.TM05.080.12.40.L	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	12.00	30.00	4.00
4.011	GG104.TM05.080.17.40.L	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	17.00	35.00	4.00
4.012	GG104.TM05.080.22.40.L	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	22.00	40.00	4.00

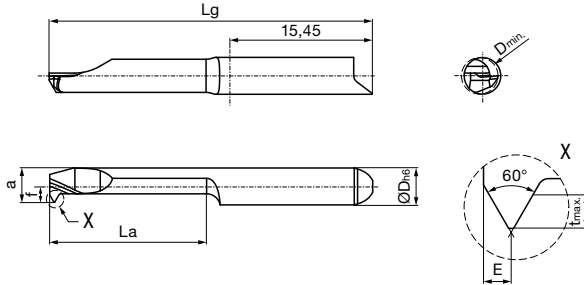
## Cutting insert for internal threading, partial profile - metric fine threads



- pitch  $P = 0.2-0.5$

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image



Series no.	25156	25158	25162
Cutting direction	(R)	(R)	(R)

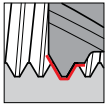
Code no.	Description	G	P	D min	f	t max	a	E	La	Lg	D h6
				mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GG104.TM02.020.04.17.R	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	4.00	25.00	4.00
<a href="#">4.002</a>	GG104.TM02.020.07.17.R	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	7.00	25.00	4.00
<a href="#">4.003</a>	GG104.TM02.020.12.17.R	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	12.00	30.00	4.00
<a href="#">4.004</a>	GG104.TM04.035.07.35.R	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	7.00	25.00	4.00
<a href="#">4.005</a>	GG104.TM04.035.12.35.R	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	12.00	30.00	4.00
<a href="#">4.006</a>	GG104.TM04.035.17.35.R	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	17.00	35.00	4.00

Series no.	25157	25159	25163
Cutting direction	(L)	(L)	(L)

Code no.	Description	G	P	D min	f	t max	a	E	La	Lg	D h6
				mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GG104.TM02.020.04.17.L	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	4.00	25.00	4.00
<a href="#">4.002</a>	GG104.TM02.020.07.17.L	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	7.00	25.00	4.00
<a href="#">4.003</a>	GG104.TM02.020.12.17.L	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	12.00	30.00	4.00
<a href="#">4.004</a>	GG104.TM04.035.07.35.L	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	7.00	25.00	4.00
<a href="#">4.005</a>	GG104.TM04.035.12.35.L	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	12.00	30.00	4.00
<a href="#">4.006</a>	GG104.TM04.035.17.35.L	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	17.00	35.00	4.00



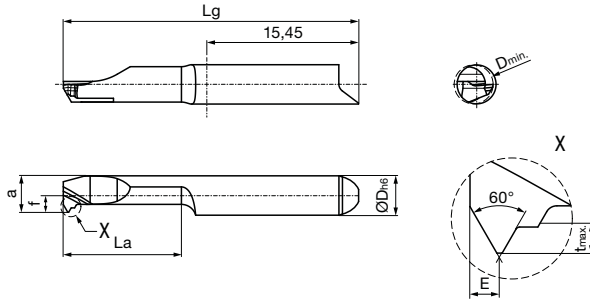
Cutting insert for internal threading, full profile - metric standard threads



• pitch P = 0.4-0.8

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
	GG 104	GG 104	GG 104
Type			
Surface	<b>S</b> TiN	<b>a</b> TiAlN-nanoA	<b>○</b> bright



Series no.	25164	25166	25170
Cutting direction	<b>R</b>	<b>R</b>	<b>R</b>

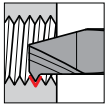
Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.VM02.040.04.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	4.00	25.00	4.00
4.002	GG104.VM02.040.07.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	7.00	25.00	4.00
4.003	GG104.VM02.040.12.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	12.00	30.00	4.00
4.004	GG104.VM03.050.04.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.35	4.00	25.00	4.00
4.005	GG104.VM03.050.07.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.35	7.00	25.00	4.00
4.006	GG104.VM03.050.12.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.35	12.00	30.00	4.00
4.007	GG104.VM04.070.07.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.45	7.00	25.00	4.00
4.008	GG104.VM04.070.12.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.45	12.00	30.00	4.00
4.009	GG104.VM04.070.17.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.45	17.00	35.00	4.00
4.010	GG104.VM04.070.22.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.45	22.00	40.00	4.00
4.011	GG104.VM05.080.12.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.50	12.00	30.00	4.00
4.012	GG104.VM05.080.17.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.50	17.00	35.00	4.00
4.013	GG104.VM05.080.22.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.50	22.00	40.00	4.00
4.014	GG104.VM05.080.27.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.50	27.00	45.00	4.00

Series no.	25165	25167	25171
Cutting direction	<b>L</b>	<b>L</b>	<b>L</b>

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.VM02.040.04.15.L	M2	0.40	1.50	1.95	0.20	1.35	0.25	4.00	25.00	4.00
4.002	GG104.VM02.040.07.15.L	M2	0.40	1.50	1.95	0.20	1.35	0.25	7.00	25.00	4.00
4.003	GG104.VM02.040.12.15.L	M2	0.40	1.50	1.95	0.20	1.35	0.25	12.00	30.00	4.00
4.004	GG104.VM03.050.04.24.L	M3	0.50	2.40	1.95	0.30	1.95	0.35	4.00	25.00	4.00
4.005	GG104.VM03.050.07.24.L	M3	0.50	2.40	1.95	0.30	1.95	0.35	7.00	25.00	4.00
4.006	GG104.VM03.050.12.24.L	M3	0.50	2.40	1.95	0.30	1.95	0.35	12.00	30.00	4.00
4.007	GG104.VM04.070.07.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.45	7.00	25.00	4.00
4.008	GG104.VM04.070.12.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.45	12.00	30.00	4.00
4.009	GG104.VM04.070.17.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.45	17.00	35.00	4.00
4.010	GG104.VM04.070.22.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.45	22.00	40.00	4.00
4.011	GG104.VM05.080.12.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.50	12.00	30.00	4.00
4.012	GG104.VM05.080.17.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.50	17.00	35.00	4.00
4.013	GG104.VM05.080.22.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.50	22.00	40.00	4.00
4.014	GG104.VM05.080.27.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.50	27.00	45.00	4.00



Cutting insert for internal threading, partial profile - UN-threads

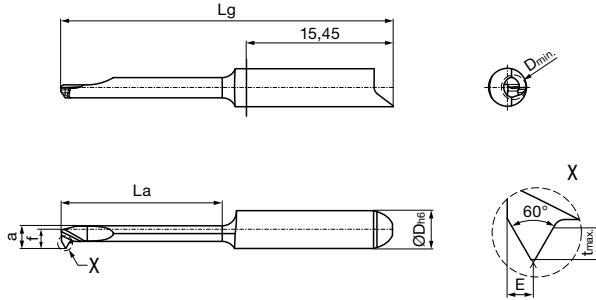


- pitch 32-40 thread/inch

for tool holders type GH104/GB104 see from page 16

Tool material	Solid carbide		
Type	GG 104	GG 104	GG 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Series no.	25172	25174	25178
Cutting direction	<b>R</b>	<b>R</b>	<b>R</b>

Code no.	Description	P	D min	f	t max	a	E	La	Lg	D h6
		Thread/inch	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GG104.TU32.040.17.26.R	32-40	2.60	1.95	0.55	2.35	0.45	17.00	35.00	4.00

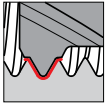
Series no.	25173	25175	25179
Cutting direction	<b>L</b>	<b>L</b>	<b>L</b>

Code no.	Description	P	D min	f	t max	a	E	La	Lg	D h6
		Thread/inch	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GG104.TU32.040.17.26.L	32-40	2.60	1.95	0.55	2.35	0.45	17.00	35.00	4.00





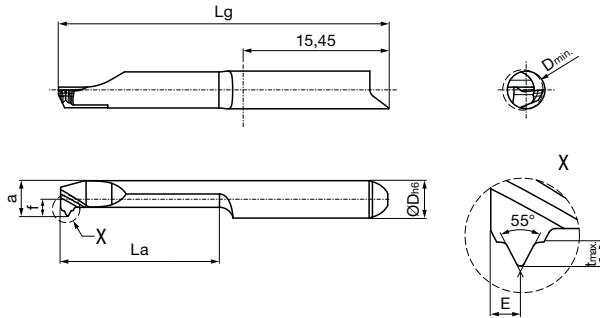
**Cutting insert for internal threading, full profile - Whitworth pipe threads**



• pitch 24-28 thread/inch

for tool holders type GH104/GB104 see from page 16

Cutting data page 148



Right hand version shown  
Left hand version mirror image



Series no. **25180** **25182** **25186**

Cutting direction

Code no.	Description	P	D min	f	t max	a	E	La	Lg	D h6
		Thread/inch	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.003</a>	GG104.VW24.106.17.33.R	24	3.30	1.95	0.75	3.00	0.80	17.00	35.00	4.00
<a href="#">4.002</a>	GG104.VW26.098.17.49.R	26	4.90	1.95	0.70	3.95	0.80	17.00	35.00	4.00
<a href="#">4.001</a>	GG104.VW28.091.17.43.R	28	4.30	1.80	0.65	3.80	0.75	17.00	35.00	4.00

Series no. **25181** **25183** **25187**

Cutting direction

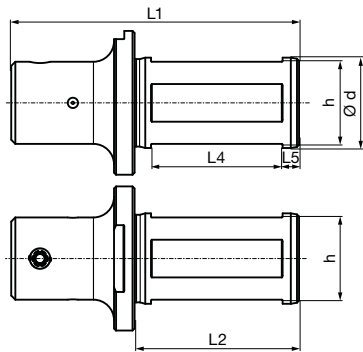
Code no.	Description	P	D min	f	t max	a	E	La	Lg	D h6
		Thread/inch	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">4.003</a>	GG104.VW24.106.17.33.L	24	3.30	1.95	0.75	3.00	0.80	17.00	35.00	4.00
<a href="#">4.002</a>	GG104.VW26.098.17.49.L	26	4.90	1.95	0.70	3.95	0.80	17.00	35.00	4.00
<a href="#">4.001</a>	GG104.VW28.091.17.43.L	28	4.30	1.80	0.65	3.80	0.75	17.00	35.00	4.00



**Round shank holder, 4 clamping surfaces**

- for inserts type 104
- with internal coolant delivery

Type GB 104



Series no. **25006**

Code no.	Description	d	d	h	L1	L2	L4	L5
		mm	inch	mm	mm	mm	mm	mm
4.010	GB104.0750.275.00.15.S.IK		3/4	17.05	69.85	40.00	32.00	4.00
<a href="#">4.001</a>	GB104.0020.070.00.15.S.IK	20.00		18.00	70.00	40.00	32.00	4.00
<a href="#">4.002</a>	GB104.0022.070.00.15.S.IK	22.00		20.00	70.00	40.00	32.00	4.00
<a href="#">4.003</a>	GB104.0025.070.00.15.S.IK	25.00		23.00	70.00	40.00	32.00	4.00
<a href="#">4.011</a>	GB104.1000.275.00.15.S.IK		1"	23.40	69.85	40.00	32.00	4.00

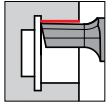
**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



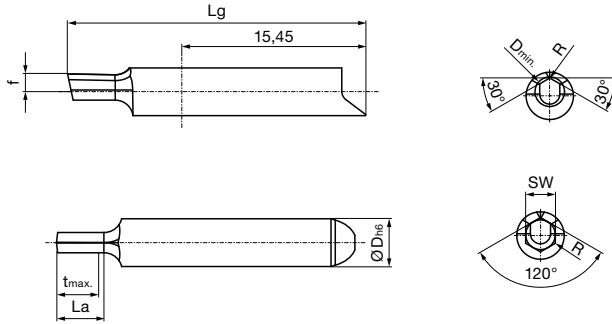
**Cutting insert for internal hexagon**



• SW 1.5-4.0

for tool holders type GB104 Art. No. 25006 see page 56

Cutting data page 148

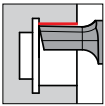


Series no. **25228** **25229** **25231**

Code no.	Description	SW	D min	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GN104.SW15.005.04.15.N	1.50-2.00	1.50	0.05	1.50	3.50	4.00	25.00	4.00
<a href="#">4.002</a>	GN104.SW20.005.04.20.N	2.00-2.50	2.00	0.05	1.50	3.50	4.00	25.00	4.00
<a href="#">4.003</a>	GN104.SW25.005.04.25.N	2.50-2.90	2.50	0.05	1.50	3.50	4.00	25.00	4.00
<a href="#">4.004</a>	GN104.SW29.005.05.29.N	2.90-3.50	2.90	0.05	1.50	4.50	5.00	25.00	4.00
<a href="#">4.005</a>	GN104.SW35.005.06.35.N	3.50-4.00	3.50	0.05	1.50	5.50	6.00	25.00	4.00



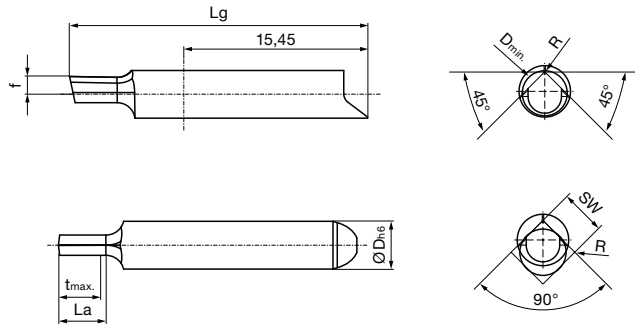
**Cutting insert for internal square**



• SW 1.5-4.0

for tool holders type GB104 Art. No. 25006 see page 56

Cutting data page 148

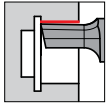


Series no. **25232** **25233** **25235**

Code no.	Description	SW	D min	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GN104.4545.005.04.15.N	1.50-2.00	1.50	0.05	1.50	3.50	4.00	25.00	4.00
<a href="#">4.002</a>	GN104.4545.005.04.20.N	2.00-2.50	2.00	0.05	1.50	3.50	4.00	25.00	4.00
<a href="#">4.003</a>	GN104.4545.005.04.25.N	2.50-2.90	2.50	0.05	1.50	3.50	4.00	25.00	4.00
<a href="#">4.004</a>	GN104.4545.005.05.29.N	2.90-3.50	2.90	0.05	1.50	4.50	5.00	25.00	4.00
<a href="#">4.005</a>	GN104.4545.005.06.35.N	3.50-4.00	3.50	0.05	1.50	5.50	6.00	25.00	4.00



**Cutting insert for Torx**

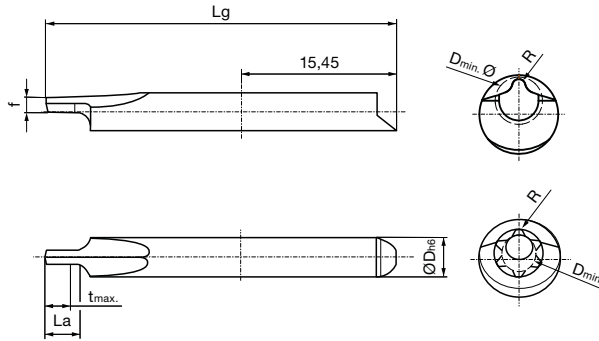


• Torx 8-30

for tool holders type GB104 Art. No. 25006 see page 56

Tool material	Solid carbide		
Type	GN 104	GN 104	GN 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright

Cutting data page 148



Series no. **25236** **25237** **25239**

Code no.	Description	Torx	D min	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm
<a href="#">4.001</a>	GN104.TX08.024.03.17.N	T8	1.70	0.24	1.80	2.50	3.00	35.00	4.00
<a href="#">4.002</a>	GN104.TX10.028.03.20.N	T10	2.00	0.28	1.80	2.50	3.00	35.00	4.00
<a href="#">4.003</a>	GN104.TX15.033.04.24.N	T15	2.40	0.33	1.80	3.50	4.00	40.00	4.00
<a href="#">4.004</a>	GN104.TX20.039.04.28.N	T20	2.80	0.39	1.80	3.50	4.00	40.00	4.00
<a href="#">4.005</a>	GN104.TX25.045.05.32.N	T25	3.20	0.45	1.80	4.50	5.00	40.00	4.00
<a href="#">4.006</a>	GN104.TX30.056.05.40.N	T30	4.00	0.56	1.80	4.50	5.00	40.00	4.00

# 106





# SYSTEM 106

## MICRO-PRECISION TOOLS



Round shank holder

from page 62



Square shank holder

from page 69



Modular holder

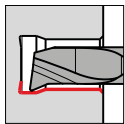
from page 71



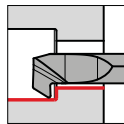
Round shank holder  
Broaching  
page 118

Tool holder

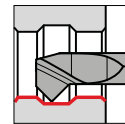
System 106



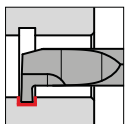
Boring out  
and profiling  
from page 74



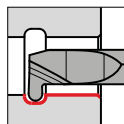
Back boring  
and profiling  
page 84



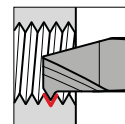
Boring out  
and chamfering  
page 85



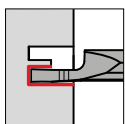
Internal grooving,  
straight slots  
from page 87



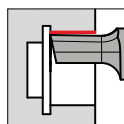
Internal grooving,  
full radius slots  
from page 89



Internal threading  
from page 113



Axial grooving bores  
from page 109



Broaching  
page 119

Cutting inserts from hole-Ø 5 mm

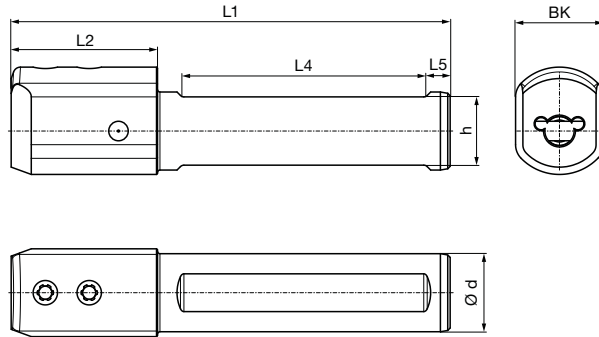


**Round shank holder, clamping screw top**

- for inserts type 106
- with internal coolant delivery

Type GB 106

System 106



Series no. 25300

Code no.	Description	d	d	h	L1	L2	L4	L5	BK
		mm	inch	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GB106.0010.090.00.22.N.IK	10.00		9.00	90.00	30.00	50.00	5.00	13.0
<a href="#">6.002</a>	GB106.0012.090.00.22.N.IK	12.00		11.00	90.00	30.00	50.00	5.00	14.0
<a href="#">6.015</a>	GB106.0500.354.00.22.N.IK		1/2	11.00	89.92	26.67	54.86	5.08	13.9
<a href="#">6.016</a>	GB106.0625.354.00.22.N.IK		5/8	14.00	89.92	26.67	54.86	5.08	17.7
<a href="#">6.003</a>	GB106.0016.090.00.22.N.IK	16.00		14.00	90.00	30.00	50.00	5.00	18.0
<a href="#">6.017</a>	GB106.0750.415.00.22.N.IK		3/4	17.04	105.41	26.67	69.85	5.08	
<a href="#">6.004</a>	GB106.0020.095.00.22.N.IK	20.00		18.00	95.00	30.00	55.00	5.00	
<a href="#">6.005</a>	GB106.0022.095.00.22.N.IK	22.00		20.00	95.00		55.00	5.00	
<a href="#">6.006</a>	GB106.0025.100.00.22.N.IK	25.00		23.00	100.00		55.00	5.00	
<a href="#">6.018</a>	GB106.1000.415.00.22.N.IK		1"	23.39	105.41		69.85	5.08	

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

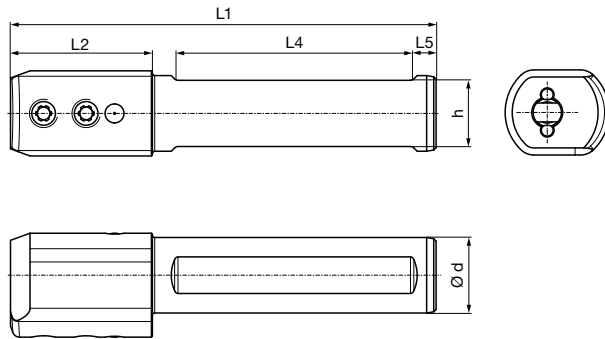




**Round shank holder, clamping screw lateral**

- for inserts type 106
- with internal coolant delivery

Type GB 106



System 106

Series no. 25301

Code no.	Description	d	d	h	L1	L2	L4	L5
		mm	inch	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GB106.0010.090.00.22.N.IK.90	10.00		9.00	90.00	30.00	50.00	5.00
<a href="#">6.002</a>	GB106.0012.090.00.22.N.IK.90	12.00		11.00	90.00	30.00	50.00	5.00
<a href="#">6.015</a>	GB106.0500.354.00.22.N.IK.90		1/2	11.00	89.92	26.67	54.86	5.08
<a href="#">6.016</a>	GB106.0625.354.00.22.N.IK.90		5/8	14.00	89.92	26.67	54.86	5.08
<a href="#">6.003</a>	GB106.0016.090.00.22.N.IK.90	16.00		14.00	90.00	30.00	50.00	5.00
<a href="#">6.017</a>	GB106.0750.415.00.22.N.IK.90		3/4	17.04	105.41	26.67	69.85	5.08
<a href="#">6.004</a>	GB106.0020.095.00.22.N.IK.90	20.00		18.00	95.00	30.00	55.00	5.00
<a href="#">6.005</a>	GB106.0022.095.00.22.N.IK.90	22.00		20.00	95.00		55.00	5.00
<a href="#">6.006</a>	GB106.0025.100.00.22.N.IK.90	25.00		23.00	100.00		55.00	5.00
<a href="#">6.018</a>	GB106.1000.415.00.22.N.IK.90		1"	23.39	105.41		69.85	5.08

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15P	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

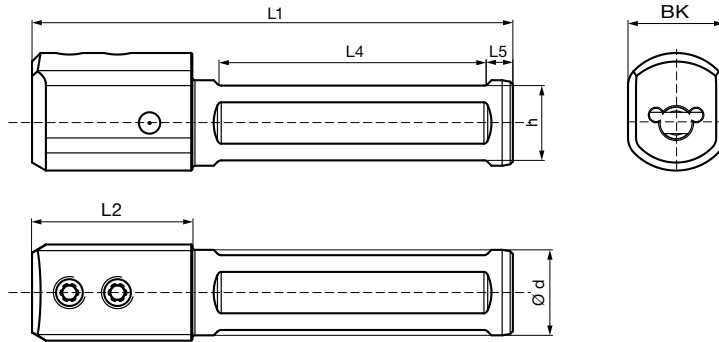


**Round shank holder, clamping screw above, four clamping surfaces**

- for inserts type 106
- with internal coolant delivery

Type GB 106

System 106



Series no. **25320**

version left and right

Code no.	Description	d	h	L1	L2	L4	L5	BK
		mm	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GB106.0016.090.00.22.N.IK.VSP	16.00	14.00	90.00	30.00	50.00	5.00	18.0
<a href="#">6.020</a>	GB106.0020.095.00.22.N.IK.VSP	20.00	18.00	95.00	30.00	55.00	5.00	
<a href="#">6.030</a>	GB106.0022.095.00.22.N.IK.VSP	22.00	20.00	95.00		55.00	5.00	
<a href="#">6.040</a>	GB106.0025.100.00.22.N.IK.VSP	25.00	23.00	100.00		55.00	5.00	

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

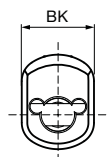
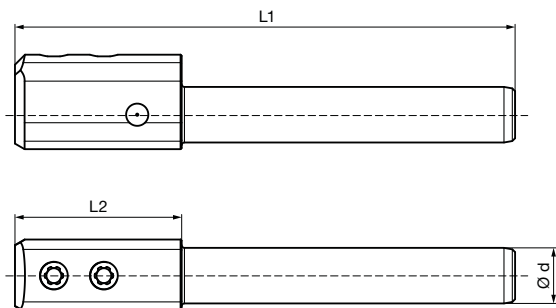
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Round shank holder, clamping screw above, without clamping surfaces**

- for inserts type 106
- with internal coolant delivery

Type	GB 106
------	--------



System 106

Series no. **25319**  
version left and right

Code no.	Description	d	L1	L2	BK
		mm	mm	mm	mm
<a href="#">6.010</a>	GB106.0010.090.00.22.N.IK.RND	10.00	90.00	30.00	13.0
<a href="#">6.020</a>	GB106.0012.090.00.22.N.IK.RND	12.00	90.00	30.00	14.0
<a href="#">6.030</a>	GB106.0016.090.00.22.N.IK.RND	16.00	90.00	30.00	18.0

**Spare parts**

Series no.	Clamping screw	Tightening torque
		Nm
25900		
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

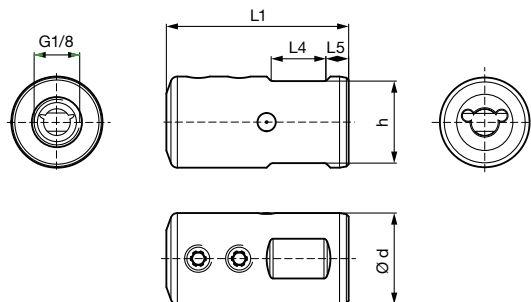
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Round shank holder, clamping screw above, for Citizen machine**

- for inserts type 106
- with internal coolant delivery

Type GB 106



Series no. **25316**

version left and right

Code no.	Description	d		h	L1	L4	L5
		mm	inch				
<a href="#">6.110</a>	GB106.0750.040.00.22.N.IK.CIT		3/4	17.05	40.00	12.70	5.08
<a href="#">6.120</a>	GB106.0750.050.00.22.N.IK.CIT		3/4	17.05	50.00	22.86	5.08
<a href="#">6.130</a>	GB106.0750.070.00.22.N.IK.CIT		3/4	17.05	70.00	44.45	5.08
<a href="#">6.140</a>	GB106.0750.100.00.22.N.IK.CIT		3/4	17.05	100.00	73.66	5.08
<a href="#">6.010</a>	GB106.0020.040.00.22.N.IK.CIT	20.00		18.00	40.00	12.00	5.00
<a href="#">6.020</a>	GB106.0020.050.00.22.N.IK.CIT	20.00		18.00	50.00	22.00	5.00
<a href="#">6.150</a>	GB106.1000.060.00.22.N.IK.CIT		1"	23.40	60.00	31.75	5.08
<a href="#">6.160</a>	GB106.1000.100.00.22.N.IK.CIT		1"	23.40	100.00	73.66	5.08

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

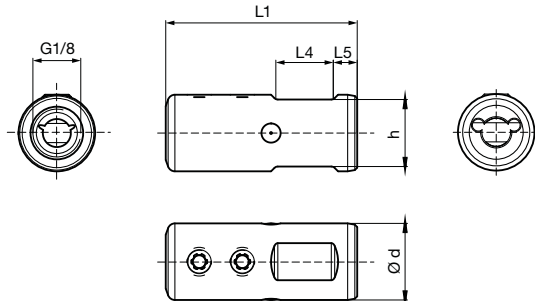
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Round shank holder, clamping screw above, for Star machine**

- for inserts type 106
- with internal coolant delivery

Type GB 106



Series no. **25317**  
version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
<a href="#">6.010</a>	GB106.0016.040.00.22.N.IK.STA	16.00	14.00	40.00	12.00	5.00
<a href="#">6.020</a>	GB106.0016.050.00.22.N.IK.STA	16.00	14.00	50.00	22.00	5.00
<a href="#">6.030</a>	GB106.0016.070.00.22.N.IK.STA	16.00	14.00	70.00	42.00	5.00
<a href="#">6.040</a>	GB106.0022.038.00.22.N.IK.STA	22.00	20.00	38.00	10.00	5.00
<a href="#">6.050</a>	GB106.0022.050.00.22.N.IK.STA	22.00	20.00	50.00	20.00	5.00
<a href="#">6.060</a>	GB106.0022.070.00.22.N.IK.STA	22.00	20.00	70.00	40.00	5.00
<a href="#">6.070</a>	GB106.0022.100.00.22.N.IK.STA	22.00	20.00	100.00	70.00	5.00
<a href="#">6.080</a>	GB106.0022.120.00.22.N.IK.STA	22.00	20.00	120.00	90.00	5.00

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

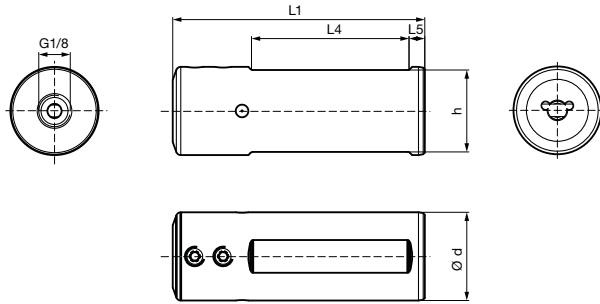


**Round shank holder, clamping screw above, for Tornos machine**

- for inserts type 106
- with internal coolant delivery

Type GB 106

System 106



Series no. **25318**  
version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
<a href="#">6.010</a>	GB106.0018.310.00.22.N.IK.TOR	18.00	16.00	310.00	280.00	5.00
<a href="#">6.020</a>	GB106.0020.170.00.22.N.IK.TOR	20.00	18.00	170.00	140.00	5.00
<a href="#">6.030</a>	GB106.0020.185.00.22.N.IK.TOR	20.00	18.00	185.00	155.00	5.00
<a href="#">6.040</a>	GB106.0025.100.00.22.N.IK.TOR	25.00	23.00	100.00	70.00	5.00
<a href="#">6.050</a>	GB106.0025.150.00.22.N.IK.TOR	25.00	23.00	150.00	120.00	5.00
<a href="#">6.060</a>	GB106.0028.080.00.22.N.IK.TOR	28.00	26.00	80.00	50.00	5.00

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

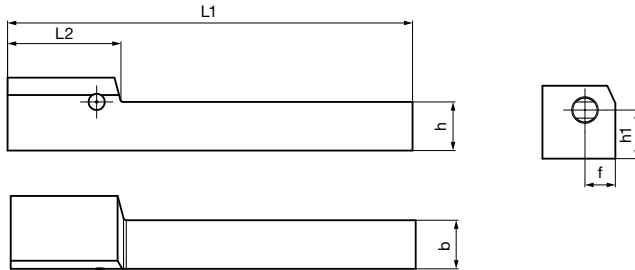
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Square shank holder, straight 0°**

- for inserts type 106
- without internal coolant delivery

Type GH 106



Right hand version shown  
Left hand version mirror image

Series no. **25314**

version right-hand

Code no.	Description	b	b	h	h1	f	L1	L2
		mm	inch	mm	mm	mm	mm	mm
<a href="#">6.110</a>	GH106.0375.350.00.22.R		3/8	9.52	9.52	7.62	88.90	27.94
<a href="#">6.010</a>	GH106.1010.100.00.22.R	10.00		10.00	10.00	7.50	100.00	28.00
<a href="#">6.020</a>	GH106.1212.100.00.22.R	12.00		12.00	12.00	7.50	100.00	28.00
<a href="#">6.120</a>	GH106.0500.350.00.22.R		1/2	12.70	12.70	7.62	88.90	27.94
<a href="#">6.130</a>	GH106.0625.400.00.22.R		5/8	15.87	15.87	7.62	101.60	27.94
<a href="#">6.030</a>	GH106.1616.120.00.22.R	16.00		16.00	16.00	7.50	120.00	28.00

Series no. **25315**

version left-hand

Code no.	Description	b	b	h	h1	f	L1	L2
		mm	inch	mm	mm	mm	mm	mm
<a href="#">6.110</a>	GH106.0375.350.00.22.L		3/8	9.52	9.52	7.62	88.90	27.94
<a href="#">6.010</a>	GH106.1010.100.00.22.L	10.00		10.00	10.00	7.50	100.00	28.00
<a href="#">6.020</a>	GH106.1212.100.00.22.L	12.00		12.00	12.00	7.50	100.00	28.00
<a href="#">6.120</a>	GH106.0500.350.00.22.L		1/2	12.70	12.70	7.62	88.90	27.94
<a href="#">6.130</a>	GH106.0625.400.00.22.L		5/8	15.87	15.87	7.62	101.60	27.94
<a href="#">6.030</a>	GH106.1616.120.00.22.L	16.00		16.00	16.00	7.50	120.00	28.00

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

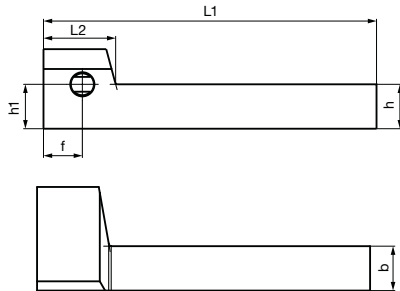
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Square shank holder, 90° offset**

- for inserts type 106
- without internal coolant delivery

Type GH 106



Right hand version shown  
Left hand version mirror image

Series no. **25304**  
version right-hand

Code no.	Description	b mm	b inch	h mm	h1 mm	f mm	L1 mm	L2 mm
<a href="#">6.010</a>	GH106.0375.350.90.22.R		3/8	9.52	9.52	22.00	88.90	19.50
<a href="#">6.001</a>	GH106.1010.090.90.22.R	10.00		10.00	10.00	22.00	90.00	19.50
<a href="#">6.002</a>	GH106.1212.090.90.22.R	12.00		12.00	12.00	22.00	90.00	19.50
<a href="#">6.011</a>	GH106.0500.350.90.22.R		1/2	12.70	12.70	22.00	88.90	19.50
<a href="#">6.012</a>	GH106.0625.400.90.22.R		5/8	15.87	15.87	22.00	101.60	19.50
<a href="#">6.003</a>	GH106.1616.120.90.22.R	16.00		16.00	16.00	22.00	120.00	19.50

Series no. **25305**  
version left-hand

Code no.	Description	b mm	b inch	h mm	h1 mm	f mm	L1 mm	L2 mm
<a href="#">6.010</a>	GH106.0375.350.90.22.L		3/8	9.52	9.52	22.00	88.90	19.50
<a href="#">6.001</a>	GH106.1010.090.90.22.L	10.00		10.00	10.00	22.00	90.00	19.50
<a href="#">6.002</a>	GH106.1212.090.90.22.L	12.00		12.00	12.00	22.00	90.00	19.50
<a href="#">6.011</a>	GH106.0500.350.90.22.L		1/2	12.70	12.70	22.00	88.90	19.50
<a href="#">6.012</a>	GH106.0625.400.90.22.L		5/8	15.87	15.87	22.00	101.60	19.50
<a href="#">6.003</a>	GH106.1616.120.90.22.L	16.00		16.00	16.00	22.00	120.00	19.50

**Spare parts**

Series no.	Clamping screw	Tightening torque Nm
25900		
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

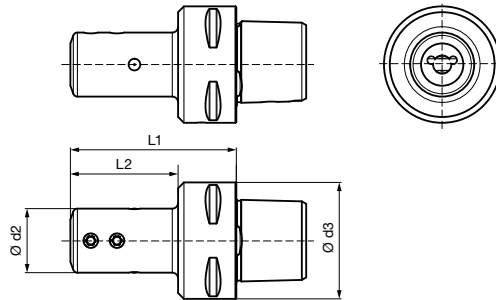




**Polygon shank holder, to ISO 26623, straight 0°**

- for inserts type 106
- with internal coolant delivery

Type GH 106



Series no. **25307**

version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
<a href="#">6.001</a>	GH106.PO32.052.00.22.N.IK	22.00	PSC 32	52.00	37.00
<a href="#">6.002</a>	GH106.PO40.057.00.22.N.IK	22.00	PSC 40	57.00	37.00
<a href="#">6.003</a>	GH106.PO50.057.00.22.N.IK	22.00	PSC 50	57.00	37.00
<a href="#">6.004</a>	GH106.PO63.060.00.22.N.IK	22.00	PSC 63	60.00	38.00

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

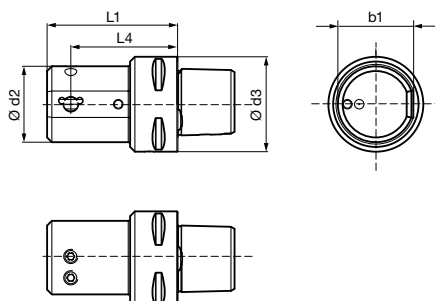


**Polygon shank holder, to ISO 26623, off-set 90°**

- for inserts type 106
- with internal coolant delivery

Type GH 106

System 106



Right hand version shown  
Left hand version mirror image

Series no. **25308**

version right-hand

Code no.	Description	d2	d3	L1	L4	b1
		mm		mm	mm	mm
<a href="#">6.001</a>	GH106.PO32.045.90.22.R.IK	32.00	PSC 32	55.00	45.00	31.00
<a href="#">6.002</a>	GH106.PO40.045.90.22.R.IK	32.00	PSC 40	55.00	45.00	31.00
<a href="#">6.003</a>	GH106.PO50.050.90.22.R.IK	32.00	PSC 50	60.00	50.00	31.00
<a href="#">6.004</a>	GH106.PO63.050.90.22.R.IK	32.00	PSC 63	60.00	50.00	31.00

Series no. **25309**

version left-hand

Code no.	Description	d2	d3	L1	L4	b1
		mm		mm	mm	mm
<a href="#">6.001</a>	GH106.PO32.045.90.22.L.IK	32.00	PSC 32	55.00	45.00	31.00
<a href="#">6.002</a>	GH106.PO40.045.90.22.L.IK	32.00	PSC 40	55.00	45.00	31.00
<a href="#">6.003</a>	GH106.PO50.050.90.22.L.IK	32.00	PSC 50	60.00	50.00	31.00
<a href="#">6.004</a>	GH106.PO63.050.90.22.L.IK	32.00	PSC 63	60.00	50.00	31.00

**Spare parts**

Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

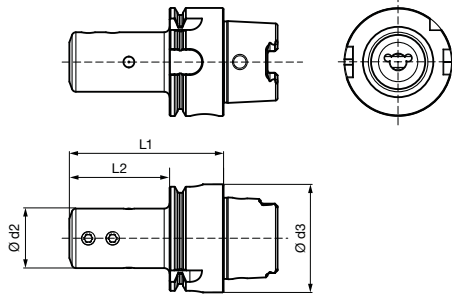
Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**HSK-T holder, to ISO 12164-3, straight 0°**

- for inserts type 106
- with internal coolant delivery

Type GH 106



System 106

Series no. **25311**

version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
<a href="#">6.001</a>	GH106.HS40.057.00.22.N.IK	22.00	HSK-T 40	57.00	37.00
<a href="#">6.002</a>	GH106.HS63.063.00.22.N.IK	22.00	HSK-T 63	63.00	37.00

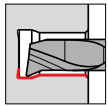
**Spare parts**

Series no.	Clamping screw	Tightening torque
		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



Cutting insert for boring out and profiling

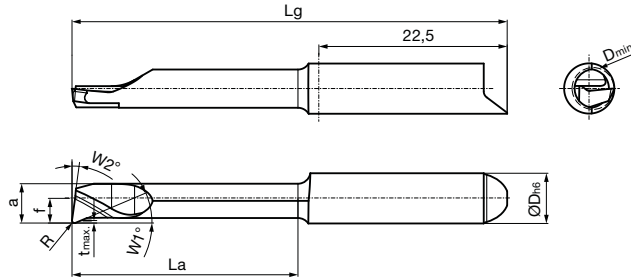


• radial free 23°

for tool holders type GB106 see from page 62

Cutting data page 148

System 106



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide			
	Type	GT 106	GT 106	GT 106
Surface	<b>S</b>	<b>a</b>	○	
	TiN	nano-A	bright	






Series no.	25832	25834	25838
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.2347.005.12.50.R	5.00	0.05	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GT106.2347.005.17.50.R	5.00	0.05	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GT106.2347.005.22.50.R	5.00	0.05	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.040	GT106.2347.005.27.50.R	5.00	0.05	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.050	GT106.2347.005.32.50.R	5.00	0.05	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.060	GT106.2347.005.37.50.R	5.00	0.05	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.070	GT106.2347.005.42.50.R	5.00	0.05	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.110	GT106.2347.010.12.50.R	5.00	0.10	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.120	GT106.2347.010.17.50.R	5.00	0.10	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.130	GT106.2347.010.22.50.R	5.00	0.10	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.140	GT106.2347.010.27.50.R	5.00	0.10	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.150	GT106.2347.010.32.50.R	5.00	0.10	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.160	GT106.2347.010.37.50.R	5.00	0.10	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.170	GT106.2347.010.42.50.R	5.00	0.10	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.210	GT106.2347.015.12.50.R	5.00	0.15	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.220	GT106.2347.015.17.50.R	5.00	0.15	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.230	GT106.2347.015.22.50.R	5.00	0.15	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.240	GT106.2347.015.27.50.R	5.00	0.15	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.250	GT106.2347.015.32.50.R	5.00	0.15	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.260	GT106.2347.015.37.50.R	5.00	0.15	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.270	GT106.2347.015.42.50.R	5.00	0.15	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.310	GT106.2347.020.12.50.R	5.00	0.20	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.320	GT106.2347.020.17.50.R	5.00	0.20	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.330	GT106.2347.020.22.50.R	5.00	0.20	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.340	GT106.2347.020.27.50.R	5.00	0.20	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.350	GT106.2347.020.32.50.R	5.00	0.20	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.360	GT106.2347.020.37.50.R	5.00	0.20	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.370	GT106.2347.020.42.50.R	5.00	0.20	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.410	GT106.2347.030.12.50.R	5.00	0.30	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.420	GT106.2347.030.17.50.R	5.00	0.30	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.430	GT106.2347.030.22.50.R	5.00	0.30	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.440	GT106.2347.030.27.50.R	5.00	0.30	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.450	GT106.2347.030.32.50.R	5.00	0.30	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.460	GT106.2347.030.37.50.R	5.00	0.30	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.470	GT106.2347.030.42.50.R	5.00	0.30	23	8	2.95	4.70	0.30	42.00	67.00	6.00



Series no. **25833** **25835** **25839**

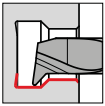
Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.2347.005.12.50.L	5.00	0.05	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.2347.005.17.50.L	5.00	0.05	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.2347.005.22.50.L	5.00	0.05	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.2347.005.27.50.L	5.00	0.05	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.2347.005.32.50.L	5.00	0.05	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.2347.005.37.50.L	5.00	0.05	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.2347.005.42.50.L	5.00	0.05	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.110</a>	GT106.2347.010.12.50.L	5.00	0.10	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.120</a>	GT106.2347.010.17.50.L	5.00	0.10	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.130</a>	GT106.2347.010.22.50.L	5.00	0.10	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.140</a>	GT106.2347.010.27.50.L	5.00	0.10	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.150</a>	GT106.2347.010.32.50.L	5.00	0.10	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.160</a>	GT106.2347.010.37.50.L	5.00	0.10	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.170</a>	GT106.2347.010.42.50.L	5.00	0.10	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.210</a>	GT106.2347.015.12.50.L	5.00	0.15	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.220</a>	GT106.2347.015.17.50.L	5.00	0.15	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.230</a>	GT106.2347.015.22.50.L	5.00	0.15	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.240</a>	GT106.2347.015.27.50.L	5.00	0.15	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.250</a>	GT106.2347.015.32.50.L	5.00	0.15	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.260</a>	GT106.2347.015.37.50.L	5.00	0.15	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.270</a>	GT106.2347.015.42.50.L	5.00	0.15	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.310</a>	GT106.2347.020.12.50.L	5.00	0.20	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.320</a>	GT106.2347.020.17.50.L	5.00	0.20	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.330</a>	GT106.2347.020.22.50.L	5.00	0.20	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.340</a>	GT106.2347.020.27.50.L	5.00	0.20	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.350</a>	GT106.2347.020.32.50.L	5.00	0.20	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.360</a>	GT106.2347.020.37.50.L	5.00	0.20	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.370</a>	GT106.2347.020.42.50.L	5.00	0.20	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.410</a>	GT106.2347.030.12.50.L	5.00	0.30	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.420</a>	GT106.2347.030.17.50.L	5.00	0.30	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.430</a>	GT106.2347.030.22.50.L	5.00	0.30	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.440</a>	GT106.2347.030.27.50.L	5.00	0.30	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.450</a>	GT106.2347.030.32.50.L	5.00	0.30	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.460</a>	GT106.2347.030.37.50.L	5.00	0.30	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.470</a>	GT106.2347.030.42.50.L	5.00	0.30	23	8	2.95	4.70	0.30	42.00	67.00	6.00

System 106



Cutting insert for boring out and profiling



• radial free 47°, tmax 0.6

for tool holders type GB106 see from page 62

Tool material

Solid carbide

Type

GT 106

GT 106

GT 106

Surface

S

a

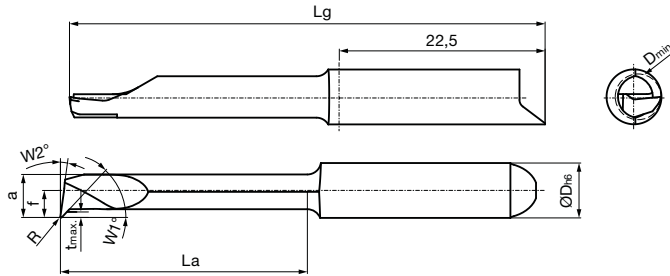
○

TiN

nano-A

bright

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Series no. 25840

25842

25846

Cutting direction

R

R

R

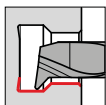
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.4747.005.12.50.R	5.00	0.05	47	8	2.95	4.70	0.60	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.4747.005.17.50.R	5.00	0.05	47	8	2.95	4.70	0.60	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.4747.005.22.50.R	5.00	0.05	47	8	2.95	4.70	0.60	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.4747.005.27.50.R	5.00	0.05	47	8	2.95	4.70	0.60	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.4747.005.32.50.R	5.00	0.05	47	8	2.95	4.70	0.60	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.4747.005.37.50.R	5.00	0.05	47	8	2.95	4.70	0.60	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.4747.005.42.50.R	5.00	0.05	47	8	2.95	4.70	0.60	42.00	67.00	6.00
<a href="#">6.110</a>	GT106.4747.010.12.50.R	5.00	0.10	47	8	2.95	4.70	0.60	12.00	37.00	6.00
<a href="#">6.120</a>	GT106.4747.010.17.50.R	5.00	0.10	47	8	2.95	4.70	0.60	17.00	42.00	6.00
<a href="#">6.130</a>	GT106.4747.010.22.50.R	5.00	0.10	47	8	2.95	4.70	0.60	22.00	47.00	6.00
<a href="#">6.140</a>	GT106.4747.010.27.50.R	5.00	0.10	47	8	2.95	4.70	0.60	27.00	52.00	6.00
<a href="#">6.150</a>	GT106.4747.010.32.50.R	5.00	0.10	47	8	2.95	4.70	0.60	32.00	57.00	6.00
<a href="#">6.160</a>	GT106.4747.010.37.50.R	5.00	0.10	47	8	2.95	4.70	0.60	37.00	62.00	6.00
<a href="#">6.170</a>	GT106.4747.010.42.50.R	5.00	0.10	47	8	2.95	4.70	0.60	42.00	67.00	6.00
<a href="#">6.210</a>	GT106.4747.015.12.50.R	5.00	0.15	47	8	2.95	4.70	0.60	12.00	37.00	6.00
<a href="#">6.220</a>	GT106.4747.015.17.50.R	5.00	0.15	47	8	2.95	4.70	0.60	17.00	42.00	6.00
<a href="#">6.230</a>	GT106.4747.015.22.50.R	5.00	0.15	47	8	2.95	4.70	0.60	22.00	47.00	6.00
<a href="#">6.240</a>	GT106.4747.015.27.50.R	5.00	0.15	47	8	2.95	4.70	0.60	27.00	52.00	6.00
<a href="#">6.250</a>	GT106.4747.015.32.50.R	5.00	0.15	47	8	2.95	4.70	0.60	32.00	57.00	6.00
<a href="#">6.260</a>	GT106.4747.015.37.50.R	5.00	0.15	47	8	2.95	4.70	0.60	37.00	62.00	6.00
<a href="#">6.270</a>	GT106.4747.015.42.50.R	5.00	0.15	47	8	2.95	4.70	0.60	42.00	67.00	6.00
<a href="#">6.310</a>	GT106.4747.020.12.50.R	5.00	0.20	47	8	2.95	4.70	0.60	12.00	37.00	6.00
<a href="#">6.320</a>	GT106.4747.020.17.50.R	5.00	0.20	47	8	2.95	4.70	0.60	17.00	42.00	6.00
<a href="#">6.330</a>	GT106.4747.020.22.50.R	5.00	0.20	47	8	2.95	4.70	0.60	22.00	47.00	6.00
<a href="#">6.340</a>	GT106.4747.020.27.50.R	5.00	0.20	47	8	2.95	4.70	0.60	27.00	52.00	6.00
<a href="#">6.350</a>	GT106.4747.020.32.50.R	5.00	0.20	47	8	2.95	4.70	0.60	32.00	57.00	6.00
<a href="#">6.360</a>	GT106.4747.020.37.50.R	5.00	0.20	47	8	2.95	4.70	0.60	37.00	62.00	6.00
<a href="#">6.370</a>	GT106.4747.020.42.50.R	5.00	0.20	47	8	2.95	4.70	0.60	42.00	67.00	6.00
<a href="#">6.410</a>	GT106.4747.030.12.50.R	5.00	0.30	47	8	2.95	4.70	0.60	12.00	37.00	6.00
<a href="#">6.420</a>	GT106.4747.030.17.50.R	5.00	0.30	47	8	2.95	4.70	0.60	17.00	42.00	6.00
<a href="#">6.430</a>	GT106.4747.030.22.50.R	5.00	0.30	47	8	2.95	4.70	0.60	22.00	47.00	6.00
<a href="#">6.440</a>	GT106.4747.030.27.50.R	5.00	0.30	47	8	2.95	4.70	0.60	27.00	52.00	6.00
<a href="#">6.450</a>	GT106.4747.030.32.50.R	5.00	0.30	47	8	2.95	4.70	0.60	32.00	57.00	6.00
<a href="#">6.460</a>	GT106.4747.030.37.50.R	5.00	0.30	47	8	2.95	4.70	0.60	37.00	62.00	6.00
<a href="#">6.470</a>	GT106.4747.030.42.50.R	5.00	0.30	47	8	2.95	4.70	0.60	42.00	67.00	6.00

Series no. **25841** **25843** **25847**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.4747.005.12.50.L	5.00	0.05	47	8	2.95	4.70	0.60	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.4747.005.17.50.L	5.00	0.05	47	8	2.95	4.70	0.60	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.4747.005.22.50.L	5.00	0.05	47	8	2.95	4.70	0.60	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.4747.005.27.50.L	5.00	0.05	47	8	2.95	4.70	0.60	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.4747.005.32.50.L	5.00	0.05	47	8	2.95	4.70	0.60	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.4747.005.37.50.L	5.00	0.05	47	8	2.95	4.70	0.60	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.4747.005.42.50.L	5.00	0.05	47	8	2.95	4.70	0.60	42.00	67.00	6.00
<a href="#">6.110</a>	GT106.4747.010.12.50.L	5.00	0.10	47	8	2.95	4.70	0.60	12.00	37.00	6.00
<a href="#">6.120</a>	GT106.4747.010.17.50.L	5.00	0.10	47	8	2.95	4.70	0.60	17.00	42.00	6.00
<a href="#">6.130</a>	GT106.4747.010.22.50.L	5.00	0.10	47	8	2.95	4.70	0.60	22.00	47.00	6.00
<a href="#">6.140</a>	GT106.4747.010.27.50.L	5.00	0.10	47	8	2.95	4.70	0.60	27.00	52.00	6.00
<a href="#">6.150</a>	GT106.4747.010.32.50.L	5.00	0.10	47	8	2.95	4.70	0.60	32.00	57.00	6.00
<a href="#">6.160</a>	GT106.4747.010.37.50.L	5.00	0.10	47	8	2.95	4.70	0.60	37.00	62.00	6.00
<a href="#">6.170</a>	GT106.4747.010.42.50.L	5.00	0.10	47	8	2.95	4.70	0.60	42.00	67.00	6.00
<a href="#">6.210</a>	GT106.4747.015.12.50.L	5.00	0.15	47	8	2.95	4.70	0.60	12.00	37.00	6.00
<a href="#">6.220</a>	GT106.4747.015.17.50.L	5.00	0.15	47	8	2.95	4.70	0.60	17.00	42.00	6.00
<a href="#">6.230</a>	GT106.4747.015.22.50.L	5.00	0.15	47	8	2.95	4.70	0.60	22.00	47.00	6.00
<a href="#">6.240</a>	GT106.4747.015.27.50.L	5.00	0.15	47	8	2.95	4.70	0.60	27.00	52.00	6.00
<a href="#">6.250</a>	GT106.4747.015.32.50.L	5.00	0.15	47	8	2.95	4.70	0.60	32.00	57.00	6.00
<a href="#">6.260</a>	GT106.4747.015.37.50.L	5.00	0.15	47	8	2.95	4.70	0.60	37.00	62.00	6.00
<a href="#">6.270</a>	GT106.4747.015.42.50.L	5.00	0.15	47	8	2.95	4.70	0.60	42.00	67.00	6.00
<a href="#">6.310</a>	GT106.4747.020.12.50.L	5.00	0.20	47	8	2.95	4.70	0.60	12.00	37.00	6.00
<a href="#">6.320</a>	GT106.4747.020.17.50.L	5.00	0.20	47	8	2.95	4.70	0.60	17.00	42.00	6.00
<a href="#">6.330</a>	GT106.4747.020.22.50.L	5.00	0.20	47	8	2.95	4.70	0.60	22.00	47.00	6.00
<a href="#">6.340</a>	GT106.4747.020.27.50.L	5.00	0.20	47	8	2.95	4.70	0.60	27.00	52.00	6.00
<a href="#">6.350</a>	GT106.4747.020.32.50.L	5.00	0.20	47	8	2.95	4.70	0.60	32.00	57.00	6.00
<a href="#">6.360</a>	GT106.4747.020.37.50.L	5.00	0.20	47	8	2.95	4.70	0.60	37.00	62.00	6.00
<a href="#">6.370</a>	GT106.4747.020.42.50.L	5.00	0.20	47	8	2.95	4.70	0.60	42.00	67.00	6.00
<a href="#">6.410</a>	GT106.4747.030.12.50.L	5.00	0.30	47	8	2.95	4.70	0.60	12.00	37.00	6.00
<a href="#">6.420</a>	GT106.4747.030.17.50.L	5.00	0.30	47	8	2.95	4.70	0.60	17.00	42.00	6.00
<a href="#">6.430</a>	GT106.4747.030.22.50.L	5.00	0.30	47	8	2.95	4.70	0.60	22.00	47.00	6.00
<a href="#">6.440</a>	GT106.4747.030.27.50.L	5.00	0.30	47	8	2.95	4.70	0.60	27.00	52.00	6.00
<a href="#">6.450</a>	GT106.4747.030.32.50.L	5.00	0.30	47	8	2.95	4.70	0.60	32.00	57.00	6.00
<a href="#">6.460</a>	GT106.4747.030.37.50.L	5.00	0.30	47	8	2.95	4.70	0.60	37.00	62.00	6.00
<a href="#">6.470</a>	GT106.4747.030.42.50.L	5.00	0.30	47	8	2.95	4.70	0.60	42.00	67.00	6.00



**Cutting insert for boring out and profiling**

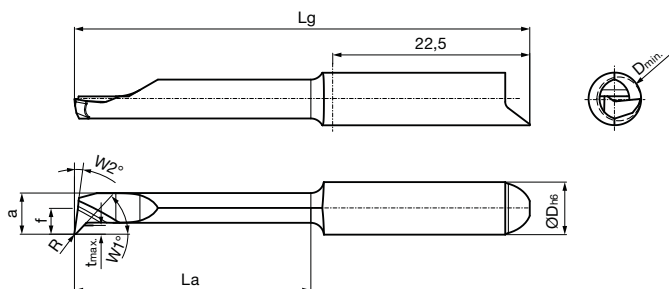


- radial free 47°, tmax 1

for tool holders type GB106 see from page 62

Cutting data page 148

System 106



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Surface			
	TiN	nano-A	bright

Series no.	<b>25888</b>	<b>25890</b>	<b>25894</b>
Cutting direction			

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.4747.005.12.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.020	GT106.4747.005.17.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.030	GT106.4747.005.22.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.040	GT106.4747.005.27.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.050	GT106.4747.005.32.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.060	GT106.4747.005.37.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.070	GT106.4747.005.42.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.110	GT106.4747.010.12.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.120	GT106.4747.010.17.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.130	GT106.4747.010.22.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.140	GT106.4747.010.27.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.150	GT106.4747.010.32.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.160	GT106.4747.010.37.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.170	GT106.4747.010.42.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.210	GT106.4747.015.12.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.220	GT106.4747.015.17.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.230	GT106.4747.015.22.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.240	GT106.4747.015.27.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.250	GT106.4747.015.32.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.260	GT106.4747.015.37.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.270	GT106.4747.015.42.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.310	GT106.4747.020.12.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.320	GT106.4747.020.17.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.330	GT106.4747.020.22.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.340	GT106.4747.020.27.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.350	GT106.4747.020.32.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.360	GT106.4747.020.37.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.370	GT106.4747.020.42.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.410	GT106.4747.030.12.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.420	GT106.4747.030.17.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.430	GT106.4747.030.22.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.440	GT106.4747.030.27.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.450	GT106.4747.030.32.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.460	GT106.4747.030.37.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.470	GT106.4747.030.42.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	42.00	67.00	6.00

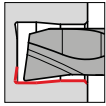


Series no. **25889** **25891** **25895**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.4747.005.12.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.4747.005.17.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.4747.005.22.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.4747.005.27.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.4747.005.32.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.4747.005.37.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.4747.005.42.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	42.00	67.00	6.00
<a href="#">6.110</a>	GT106.4747.010.12.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	12.00	37.00	6.00
<a href="#">6.120</a>	GT106.4747.010.17.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	17.00	42.00	6.00
<a href="#">6.130</a>	GT106.4747.010.22.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	22.00	47.00	6.00
<a href="#">6.140</a>	GT106.4747.010.27.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	27.00	52.00	6.00
<a href="#">6.150</a>	GT106.4747.010.32.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	32.00	57.00	6.00
<a href="#">6.160</a>	GT106.4747.010.37.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	37.00	62.00	6.00
<a href="#">6.170</a>	GT106.4747.010.42.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	42.00	67.00	6.00
<a href="#">6.210</a>	GT106.4747.015.12.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	12.00	37.00	6.00
<a href="#">6.220</a>	GT106.4747.015.17.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	17.00	42.00	6.00
<a href="#">6.230</a>	GT106.4747.015.22.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	22.00	47.00	6.00
<a href="#">6.240</a>	GT106.4747.015.27.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	27.00	52.00	6.00
<a href="#">6.250</a>	GT106.4747.015.32.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	32.00	57.00	6.00
<a href="#">6.260</a>	GT106.4747.015.37.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	37.00	62.00	6.00
<a href="#">6.270</a>	GT106.4747.015.42.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	42.00	67.00	6.00
<a href="#">6.310</a>	GT106.4747.020.12.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	12.00	37.00	6.00
<a href="#">6.320</a>	GT106.4747.020.17.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	17.00	42.00	6.00
<a href="#">6.330</a>	GT106.4747.020.22.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	22.00	47.00	6.00
<a href="#">6.340</a>	GT106.4747.020.27.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	27.00	52.00	6.00
<a href="#">6.350</a>	GT106.4747.020.32.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	32.00	57.00	6.00
<a href="#">6.360</a>	GT106.4747.020.37.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	37.00	62.00	6.00
<a href="#">6.370</a>	GT106.4747.020.42.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	42.00	67.00	6.00
<a href="#">6.410</a>	GT106.4747.030.12.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	12.00	37.00	6.00
<a href="#">6.420</a>	GT106.4747.030.17.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	17.00	42.00	6.00
<a href="#">6.430</a>	GT106.4747.030.22.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	22.00	47.00	6.00
<a href="#">6.440</a>	GT106.4747.030.27.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	27.00	52.00	6.00
<a href="#">6.450</a>	GT106.4747.030.32.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	32.00	57.00	6.00
<a href="#">6.460</a>	GT106.4747.030.37.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	37.00	62.00	6.00
<a href="#">6.470</a>	GT106.4747.030.42.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	42.00	67.00	6.00



Cutting insert for boring out and profiling



• radial free 8°

for tool holders type GB106 see from page 62

Cutting data page 148

Tool material

Solid carbide

Type

GT 106

GT 106

GT 106

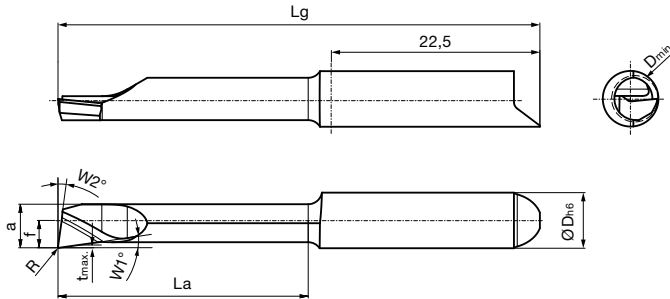
Surface



TiN

nano-A

bright



Right hand version shown  
Left hand version mirror image

Series no. 25500

25502

25506

Cutting direction



Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.0847.005.12.50.R	5.00	0.05	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GT106.0847.005.17.50.R	5.00	0.05	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GT106.0847.005.22.50.R	5.00	0.05	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.040	GT106.0847.005.27.50.R	5.00	0.05	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.050	GT106.0847.005.32.50.R	5.00	0.05	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.060	GT106.0847.005.37.50.R	5.00	0.05	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.070	GT106.0847.005.42.50.R	5.00	0.05	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.110	GT106.0847.010.12.50.R	5.00	0.10	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.120	GT106.0847.010.17.50.R	5.00	0.10	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.130	GT106.0847.010.22.50.R	5.00	0.10	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.140	GT106.0847.010.27.50.R	5.00	0.10	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.150	GT106.0847.010.32.50.R	5.00	0.10	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.160	GT106.0847.010.37.50.R	5.00	0.10	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.170	GT106.0847.010.42.50.R	5.00	0.10	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.210	GT106.0847.015.12.50.R	5.00	0.15	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.220	GT106.0847.015.17.50.R	5.00	0.15	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.230	GT106.0847.015.22.50.R	5.00	0.15	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.240	GT106.0847.015.27.50.R	5.00	0.15	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.250	GT106.0847.015.32.50.R	5.00	0.15	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.260	GT106.0847.015.37.50.R	5.00	0.15	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.270	GT106.0847.015.42.50.R	5.00	0.15	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.310	GT106.0847.020.12.50.R	5.00	0.20	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.320	GT106.0847.020.17.50.R	5.00	0.20	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.330	GT106.0847.020.22.50.R	5.00	0.20	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.340	GT106.0847.020.27.50.R	5.00	0.20	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.350	GT106.0847.020.32.50.R	5.00	0.20	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.360	GT106.0847.020.37.50.R	5.00	0.20	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.370	GT106.0847.020.42.50.R	5.00	0.20	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.410	GT106.0847.030.12.50.R	5.00	0.30	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.420	GT106.0847.030.17.50.R	5.00	0.30	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.430	GT106.0847.030.22.50.R	5.00	0.30	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.440	GT106.0847.030.27.50.R	5.00	0.30	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.450	GT106.0847.030.32.50.R	5.00	0.30	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.460	GT106.0847.030.37.50.R	5.00	0.30	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.470	GT106.0847.030.42.50.R	5.00	0.30	8	8	2.95	4.70	0.30	42.00	67.00	6.00



Series no. **25501** **25503** **25507**

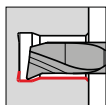
Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.0847.005.12.50.L	5.00	0.05	8	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.0847.005.17.50.L	5.00	0.05	8	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.0847.005.22.50.L	5.00	0.05	8	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.0847.005.27.50.L	5.00	0.05	8	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.0847.005.32.50.L	5.00	0.05	8	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.0847.005.37.50.L	5.00	0.05	8	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.0847.005.42.50.L	5.00	0.05	8	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.110</a>	GT106.0847.010.12.50.L	5.00	0.10	8	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.120</a>	GT106.0847.010.17.50.L	5.00	0.10	8	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.130</a>	GT106.0847.010.22.50.L	5.00	0.10	8	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.140</a>	GT106.0847.010.27.50.L	5.00	0.10	8	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.150</a>	GT106.0847.010.32.50.L	5.00	0.10	8	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.160</a>	GT106.0847.010.37.50.L	5.00	0.10	8	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.170</a>	GT106.0847.010.42.50.L	5.00	0.10	8	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.210</a>	GT106.0847.015.12.50.L	5.00	0.15	8	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.220</a>	GT106.0847.015.17.50.L	5.00	0.15	8	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.230</a>	GT106.0847.015.22.50.L	5.00	0.15	8	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.240</a>	GT106.0847.015.27.50.L	5.00	0.15	8	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.250</a>	GT106.0847.015.32.50.L	5.00	0.15	8	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.260</a>	GT106.0847.015.37.50.L	5.00	0.15	8	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.270</a>	GT106.0847.015.42.50.L	5.00	0.15	8	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.310</a>	GT106.0847.020.12.50.L	5.00	0.20	8	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.320</a>	GT106.0847.020.17.50.L	5.00	0.20	8	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.330</a>	GT106.0847.020.22.50.L	5.00	0.20	8	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.340</a>	GT106.0847.020.27.50.L	5.00	0.20	8	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.350</a>	GT106.0847.020.32.50.L	5.00	0.20	8	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.360</a>	GT106.0847.020.37.50.L	5.00	0.20	8	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.370</a>	GT106.0847.020.42.50.L	5.00	0.20	8	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.410</a>	GT106.0847.030.12.50.L	5.00	0.30	8	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.420</a>	GT106.0847.030.17.50.L	5.00	0.30	8	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.430</a>	GT106.0847.030.22.50.L	5.00	0.30	8	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.440</a>	GT106.0847.030.27.50.L	5.00	0.30	8	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.450</a>	GT106.0847.030.32.50.L	5.00	0.30	8	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.460</a>	GT106.0847.030.37.50.L	5.00	0.30	8	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.470</a>	GT106.0847.030.42.50.L	5.00	0.30	8	8	2.95	4.70	0.30	42.00	67.00	6.00

System 106



Cutting insert for boring out and profiling

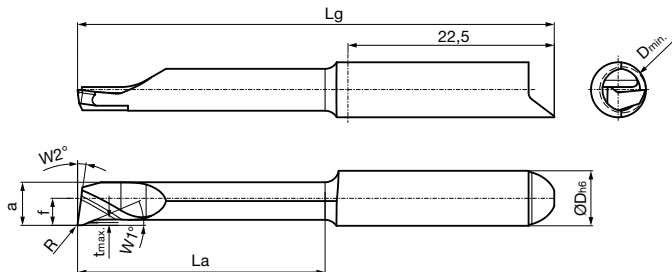


• WIPER-geometry

for tool holders type GB106 see from page 62

Cutting data page 148

System 106



Right hand version shown  
Left hand version mirror image



Series no. **25848** **25850** **25854**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GJ106.2347.005.12.50.R	5.00	0.05	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.020</a>	GJ106.2347.005.17.50.R	5.00	0.05	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.030</a>	GJ106.2347.005.22.50.R	5.00	0.05	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.040</a>	GJ106.2347.005.27.50.R	5.00	0.05	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.050</a>	GJ106.2347.005.32.50.R	5.00	0.05	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.060</a>	GJ106.2347.005.37.50.R	5.00	0.05	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.070</a>	GJ106.2347.005.42.50.R	5.00	0.05	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.110</a>	GJ106.2347.010.12.50.R	5.00	0.10	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.120</a>	GJ106.2347.010.17.50.R	5.00	0.10	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.130</a>	GJ106.2347.010.22.50.R	5.00	0.10	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.140</a>	GJ106.2347.010.27.50.R	5.00	0.10	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.150</a>	GJ106.2347.010.32.50.R	5.00	0.10	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.160</a>	GJ106.2347.010.37.50.R	5.00	0.10	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.170</a>	GJ106.2347.010.42.50.R	5.00	0.10	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.210</a>	GJ106.2347.015.12.50.R	5.00	0.15	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.220</a>	GJ106.2347.015.17.50.R	5.00	0.15	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.230</a>	GJ106.2347.015.22.50.R	5.00	0.15	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.240</a>	GJ106.2347.015.27.50.R	5.00	0.15	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.250</a>	GJ106.2347.015.32.50.R	5.00	0.15	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.260</a>	GJ106.2347.015.37.50.R	5.00	0.15	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.270</a>	GJ106.2347.015.42.50.R	5.00	0.15	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.310</a>	GJ106.2347.020.12.50.R	5.00	0.20	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.320</a>	GJ106.2347.020.17.50.R	5.00	0.20	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.330</a>	GJ106.2347.020.22.50.R	5.00	0.20	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.340</a>	GJ106.2347.020.27.50.R	5.00	0.20	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.350</a>	GJ106.2347.020.32.50.R	5.00	0.20	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.360</a>	GJ106.2347.020.37.50.R	5.00	0.20	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.370</a>	GJ106.2347.020.42.50.R	5.00	0.20	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.410</a>	GJ106.2347.030.12.50.R	5.00	0.30	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.420</a>	GJ106.2347.030.17.50.R	5.00	0.30	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.430</a>	GJ106.2347.030.22.50.R	5.00	0.30	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.440</a>	GJ106.2347.030.27.50.R	5.00	0.30	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.450</a>	GJ106.2347.030.32.50.R	5.00	0.30	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.460</a>	GJ106.2347.030.37.50.R	5.00	0.30	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.470</a>	GJ106.2347.030.42.50.R	5.00	0.30	23	8	2.95	4.70	0.30	42.00	67.00	6.00



Series no. **25849** **25851** **25855**

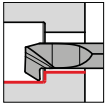
Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GJ106.2347.005.12.50.L	5.00	0.05	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.020</a>	GJ106.2347.005.17.50.L	5.00	0.05	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.030</a>	GJ106.2347.005.22.50.L	5.00	0.05	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.040</a>	GJ106.2347.005.27.50.L	5.00	0.05	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.050</a>	GJ106.2347.005.32.50.L	5.00	0.05	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.060</a>	GJ106.2347.005.37.50.L	5.00	0.05	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.070</a>	GJ106.2347.005.42.50.L	5.00	0.05	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.110</a>	GJ106.2347.010.12.50.L	5.00	0.10	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.120</a>	GJ106.2347.010.17.50.L	5.00	0.10	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.130</a>	GJ106.2347.010.22.50.L	5.00	0.10	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.140</a>	GJ106.2347.010.27.50.L	5.00	0.10	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.150</a>	GJ106.2347.010.32.50.L	5.00	0.10	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.160</a>	GJ106.2347.010.37.50.L	5.00	0.10	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.170</a>	GJ106.2347.010.42.50.L	5.00	0.10	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.210</a>	GJ106.2347.015.12.50.L	5.00	0.15	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.220</a>	GJ106.2347.015.17.50.L	5.00	0.15	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.230</a>	GJ106.2347.015.22.50.L	5.00	0.15	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.240</a>	GJ106.2347.015.27.50.L	5.00	0.15	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.250</a>	GJ106.2347.015.32.50.L	5.00	0.15	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.260</a>	GJ106.2347.015.37.50.L	5.00	0.15	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.270</a>	GJ106.2347.015.42.50.L	5.00	0.15	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.310</a>	GJ106.2347.020.12.50.L	5.00	0.20	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.320</a>	GJ106.2347.020.17.50.L	5.00	0.20	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.330</a>	GJ106.2347.020.22.50.L	5.00	0.20	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.340</a>	GJ106.2347.020.27.50.L	5.00	0.20	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.350</a>	GJ106.2347.020.32.50.L	5.00	0.20	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.360</a>	GJ106.2347.020.37.50.L	5.00	0.20	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.370</a>	GJ106.2347.020.42.50.L	5.00	0.20	23	8	2.95	4.70	0.30	42.00	67.00	6.00
<a href="#">6.410</a>	GJ106.2347.030.12.50.L	5.00	0.30	23	8	2.95	4.70	0.30	12.00	37.00	6.00
<a href="#">6.420</a>	GJ106.2347.030.17.50.L	5.00	0.30	23	8	2.95	4.70	0.30	17.00	42.00	6.00
<a href="#">6.430</a>	GJ106.2347.030.22.50.L	5.00	0.30	23	8	2.95	4.70	0.30	22.00	47.00	6.00
<a href="#">6.440</a>	GJ106.2347.030.27.50.L	5.00	0.30	23	8	2.95	4.70	0.30	27.00	52.00	6.00
<a href="#">6.450</a>	GJ106.2347.030.32.50.L	5.00	0.30	23	8	2.95	4.70	0.30	32.00	57.00	6.00
<a href="#">6.460</a>	GJ106.2347.030.37.50.L	5.00	0.30	23	8	2.95	4.70	0.30	37.00	62.00	6.00
<a href="#">6.470</a>	GJ106.2347.030.42.50.L	5.00	0.30	23	8	2.95	4.70	0.30	42.00	67.00	6.00

System 106



**Cutting insert for back boring and profiling**

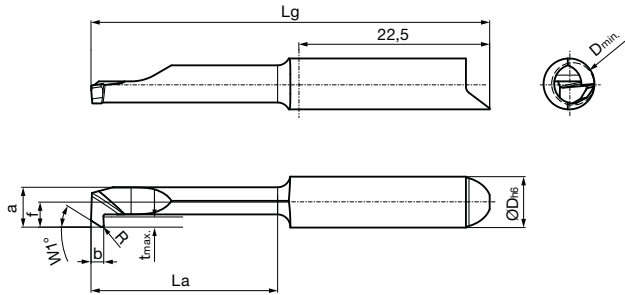


• radial free 32°

for tool holders type GB106 see from page 62

Cutting data page 148

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	nano-A	bright



Right hand version shown  
Left hand version mirror image

Series no.	25856	25858	25862
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.3247.020.12.50.R	5.00	0.20	32	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.3247.020.17.50.R	5.00	0.20	32	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.3247.020.22.50.R	5.00	0.20	32	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.3247.020.27.50.R	5.00	0.20	32	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.3247.020.32.50.R	5.00	0.20	32	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.3247.020.37.50.R	5.00	0.20	32	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.3247.020.42.50.R	5.00	0.20	32	2.95	4.70	1.20	42.00	67.00	6.00

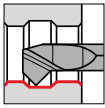
Series no.	25857	25859	25863
Cutting direction	<b>(L)</b>	<b>(L)</b>	<b>(L)</b>

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.3247.020.12.50.L	5.00	0.20	32	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.3247.020.17.50.L	5.00	0.20	32	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.3247.020.22.50.L	5.00	0.20	32	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.3247.020.27.50.L	5.00	0.20	32	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.3247.020.32.50.L	5.00	0.20	32	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.3247.020.37.50.L	5.00	0.20	32	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.3247.020.42.50.L	5.00	0.20	32	2.95	4.70	1.20	42.00	67.00	6.00

System 106



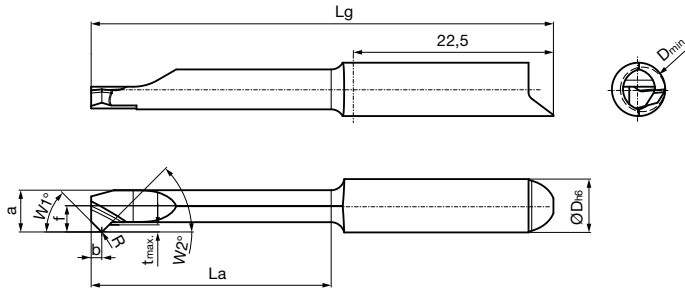
**Cutting insert for boring out and chamfering**



• 45° both sides

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image



Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Surface	S	a	○
	TiN	nano-A	bright

Series no. **25864** **25866** **25870**




Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.4547.010.12.50.R	5.00	0.10	45	45	2.95	4.70	0.80	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.4547.010.17.50.R	5.00	0.10	45	45	2.95	4.70	0.80	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.4547.010.22.50.R	5.00	0.10	45	45	2.95	4.70	0.80	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.4547.010.27.50.R	5.00	0.10	45	45	2.95	4.70	0.80	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.4547.010.32.50.R	5.00	0.10	45	45	2.95	4.70	0.80	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.4547.010.37.50.R	5.00	0.10	45	45	2.95	4.70	0.80	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.4547.010.42.50.R	5.00	0.10	45	45	2.95	4.70	0.80	42.00	67.00	6.00
<a href="#">6.110</a>	GT106.4547.015.12.50.R	5.00	0.15	45	45	2.95	4.70	0.80	12.00	37.00	6.00
<a href="#">6.120</a>	GT106.4547.015.17.50.R	5.00	0.15	45	45	2.95	4.70	0.80	17.00	42.00	6.00
<a href="#">6.130</a>	GT106.4547.015.22.50.R	5.00	0.15	45	45	2.95	4.70	0.80	22.00	47.00	6.00
<a href="#">6.140</a>	GT106.4547.015.27.50.R	5.00	0.15	45	45	2.95	4.70	0.80	27.00	52.00	6.00
<a href="#">6.150</a>	GT106.4547.015.32.50.R	5.00	0.15	45	45	2.95	4.70	0.80	32.00	57.00	6.00
<a href="#">6.160</a>	GT106.4547.015.37.50.R	5.00	0.15	45	45	2.95	4.70	0.80	37.00	62.00	6.00
<a href="#">6.170</a>	GT106.4547.015.42.50.R	5.00	0.15	45	45	2.95	4.70	0.80	42.00	67.00	6.00
<a href="#">6.210</a>	GT106.4547.020.12.50.R	5.00	0.20	45	45	2.95	4.70	0.80	12.00	37.00	6.00
<a href="#">6.220</a>	GT106.4547.020.17.50.R	5.00	0.20	45	45	2.95	4.70	0.80	17.00	42.00	6.00
<a href="#">6.230</a>	GT106.4547.020.22.50.R	5.00	0.20	45	45	2.95	4.70	0.80	22.00	47.00	6.00
<a href="#">6.240</a>	GT106.4547.020.27.50.R	5.00	0.20	45	45	2.95	4.70	0.80	27.00	52.00	6.00
<a href="#">6.250</a>	GT106.4547.020.32.50.R	5.00	0.20	45	45	2.95	4.70	0.80	32.00	57.00	6.00
<a href="#">6.260</a>	GT106.4547.020.37.50.R	5.00	0.20	45	45	2.95	4.70	0.80	37.00	62.00	6.00
<a href="#">6.270</a>	GT106.4547.020.42.50.R	5.00	0.20	45	45	2.95	4.70	0.80	42.00	67.00	6.00
<a href="#">6.310</a>	GT106.4547.030.12.50.R	5.00	0.30	45	45	2.95	4.70	0.80	12.00	37.00	6.00
<a href="#">6.320</a>	GT106.4547.030.17.50.R	5.00	0.30	45	45	2.95	4.70	0.80	17.00	42.00	6.00
<a href="#">6.330</a>	GT106.4547.030.22.50.R	5.00	0.30	45	45	2.95	4.70	0.80	22.00	47.00	6.00
<a href="#">6.340</a>	GT106.4547.030.27.50.R	5.00	0.30	45	45	2.95	4.70	0.80	27.00	52.00	6.00
<a href="#">6.350</a>	GT106.4547.030.32.50.R	5.00	0.30	45	45	2.95	4.70	0.80	32.00	57.00	6.00
<a href="#">6.360</a>	GT106.4547.030.37.50.R	5.00	0.30	45	45	2.95	4.70	0.80	37.00	62.00	6.00
<a href="#">6.370</a>	GT106.4547.030.42.50.R	5.00	0.30	45	45	2.95	4.70	0.80	42.00	67.00	6.00

System 106



Series no. **25865** **25867** **25871**

Cutting direction   

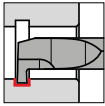
System 106

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.4547.010.12.50.L	5.00	0.10	45	45	2.95	4.70	0.80	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.4547.010.17.50.L	5.00	0.10	45	45	2.95	4.70	0.80	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.4547.010.22.50.L	5.00	0.10	45	45	2.95	4.70	0.80	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.4547.010.27.50.L	5.00	0.10	45	45	2.95	4.70	0.80	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.4547.010.32.50.L	5.00	0.10	45	45	2.95	4.70	0.80	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.4547.010.37.50.L	5.00	0.10	45	45	2.95	4.70	0.80	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.4547.010.42.50.L	5.00	0.10	45	45	2.95	4.70	0.80	42.00	67.00	6.00
<a href="#">6.110</a>	GT106.4547.015.12.50.L	5.00	0.15	45	45	2.95	4.70	0.80	12.00	37.00	6.00
<a href="#">6.120</a>	GT106.4547.015.17.50.L	5.00	0.15	45	45	2.95	4.70	0.80	17.00	42.00	6.00
<a href="#">6.130</a>	GT106.4547.015.22.50.L	5.00	0.15	45	45	2.95	4.70	0.80	22.00	47.00	6.00
<a href="#">6.140</a>	GT106.4547.015.27.50.L	5.00	0.15	45	45	2.95	4.70	0.80	27.00	52.00	6.00
<a href="#">6.150</a>	GT106.4547.015.32.50.L	5.00	0.15	45	45	2.95	4.70	0.80	32.00	57.00	6.00
<a href="#">6.160</a>	GT106.4547.015.37.50.L	5.00	0.15	45	45	2.95	4.70	0.80	37.00	62.00	6.00
<a href="#">6.170</a>	GT106.4547.015.42.50.L	5.00	0.15	45	45	2.95	4.70	0.80	42.00	67.00	6.00
<a href="#">6.210</a>	GT106.4547.020.12.50.L	5.00	0.20	45	45	2.95	4.70	0.80	12.00	37.00	6.00
<a href="#">6.220</a>	GT106.4547.020.17.50.L	5.00	0.20	45	45	2.95	4.70	0.80	17.00	42.00	6.00
<a href="#">6.230</a>	GT106.4547.020.22.50.L	5.00	0.20	45	45	2.95	4.70	0.80	22.00	47.00	6.00
<a href="#">6.240</a>	GT106.4547.020.27.50.L	5.00	0.20	45	45	2.95	4.70	0.80	27.00	52.00	6.00
<a href="#">6.250</a>	GT106.4547.020.32.50.L	5.00	0.20	45	45	2.95	4.70	0.80	32.00	57.00	6.00
<a href="#">6.260</a>	GT106.4547.020.37.50.L	5.00	0.20	45	45	2.95	4.70	0.80	37.00	62.00	6.00
<a href="#">6.270</a>	GT106.4547.020.42.50.L	5.00	0.20	45	45	2.95	4.70	0.80	42.00	67.00	6.00
<a href="#">6.310</a>	GT106.4547.030.12.50.L	5.00	0.30	45	45	2.95	4.70	0.80	12.00	37.00	6.00
<a href="#">6.320</a>	GT106.4547.030.17.50.L	5.00	0.30	45	45	2.95	4.70	0.80	17.00	42.00	6.00
<a href="#">6.330</a>	GT106.4547.030.22.50.L	5.00	0.30	45	45	2.95	4.70	0.80	22.00	47.00	6.00
<a href="#">6.340</a>	GT106.4547.030.27.50.L	5.00	0.30	45	45	2.95	4.70	0.80	27.00	52.00	6.00
<a href="#">6.350</a>	GT106.4547.030.32.50.L	5.00	0.30	45	45	2.95	4.70	0.80	32.00	57.00	6.00
<a href="#">6.360</a>	GT106.4547.030.37.50.L	5.00	0.30	45	45	2.95	4.70	0.80	37.00	62.00	6.00
<a href="#">6.370</a>	GT106.4547.030.42.50.L	5.00	0.30	45	45	2.95	4.70	0.80	42.00	67.00	6.00





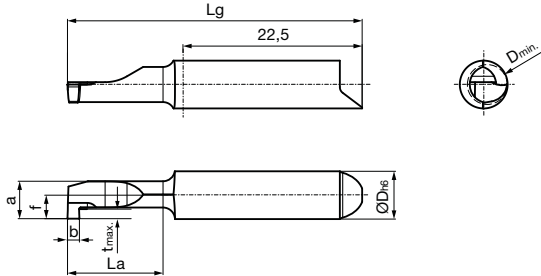
Cutting insert for internal grooving, straight slots



- grooving depth up to 1.2 mm

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GE 106	GE 106	GE 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	nano-A	bright



Series no. **25872** **25874** **25878**

Cutting direction **(R)** **(R)** **(R)**

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GE106.0100.000.12.50.R	5.00	1.00	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.020</a>	GE106.0100.000.17.50.R	5.00	1.00	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.030</a>	GE106.0100.000.22.50.R	5.00	1.00	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.040</a>	GE106.0100.000.27.50.R	5.00	1.00	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.050</a>	GE106.0100.000.32.50.R	5.00	1.00	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.060</a>	GE106.0100.000.37.50.R	5.00	1.00	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.070</a>	GE106.0100.000.42.50.R	5.00	1.00	2.95	4.70	1.20	42.00	67.00	6.00
<a href="#">6.110</a>	GE106.0150.000.12.50.R	5.00	1.50	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.120</a>	GE106.0150.000.17.50.R	5.00	1.50	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.130</a>	GE106.0150.000.22.50.R	5.00	1.50	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.140</a>	GE106.0150.000.27.50.R	5.00	1.50	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.150</a>	GE106.0150.000.32.50.R	5.00	1.50	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.160</a>	GE106.0150.000.37.50.R	5.00	1.50	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.170</a>	GE106.0150.000.42.50.R	5.00	1.50	2.95	4.70	1.20	42.00	67.00	6.00
<a href="#">6.210</a>	GE106.0200.000.12.50.R	5.00	2.00	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.220</a>	GE106.0200.000.17.50.R	5.00	2.00	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.230</a>	GE106.0200.000.22.50.R	5.00	2.00	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.240</a>	GE106.0200.000.27.50.R	5.00	2.00	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.250</a>	GE106.0200.000.32.50.R	5.00	2.00	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.260</a>	GE106.0200.000.37.50.R	5.00	2.00	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.270</a>	GE106.0200.000.42.50.R	5.00	2.00	2.95	4.70	1.20	42.00	67.00	6.00

System 106



Series no. **25873** **25875** **25879**

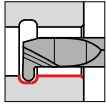
Cutting direction   

System 106

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GE106.0100.000.12.50.L	5.00	1.00	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.020</a>	GE106.0100.000.17.50.L	5.00	1.00	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.030</a>	GE106.0100.000.22.50.L	5.00	1.00	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.040</a>	GE106.0100.000.27.50.L	5.00	1.00	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.050</a>	GE106.0100.000.32.50.L	5.00	1.00	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.060</a>	GE106.0100.000.37.50.L	5.00	1.00	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.070</a>	GE106.0100.000.42.50.L	5.00	1.00	2.95	4.70	1.20	42.00	67.00	6.00
<a href="#">6.110</a>	GE106.0150.000.12.50.L	5.00	1.50	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.120</a>	GE106.0150.000.17.50.L	5.00	1.50	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.130</a>	GE106.0150.000.22.50.L	5.00	1.50	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.140</a>	GE106.0150.000.27.50.L	5.00	1.50	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.150</a>	GE106.0150.000.32.50.L	5.00	1.50	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.160</a>	GE106.0150.000.37.50.L	5.00	1.50	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.170</a>	GE106.0150.000.42.50.L	5.00	1.50	2.95	4.70	1.20	42.00	67.00	6.00
<a href="#">6.210</a>	GE106.0200.000.12.50.L	5.00	2.00	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.220</a>	GE106.0200.000.17.50.L	5.00	2.00	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.230</a>	GE106.0200.000.22.50.L	5.00	2.00	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.240</a>	GE106.0200.000.27.50.L	5.00	2.00	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.250</a>	GE106.0200.000.32.50.L	5.00	2.00	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.260</a>	GE106.0200.000.37.50.L	5.00	2.00	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.270</a>	GE106.0200.000.42.50.L	5.00	2.00	2.95	4.70	1.20	42.00	67.00	6.00



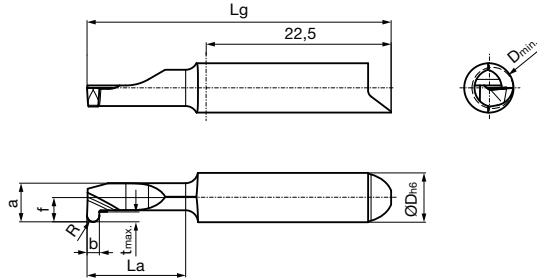
Cutting insert for internal grooving, full radius slots



• full radius R0.5-R1.0

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GE 106	GE 106	GE 106
Surface	<b>S</b> (Yellow)	<b>a</b> (Red)	○ (Bright)
	TiN	nano-A	bright

Series no. **25880**    **25882**    **25886**

Cutting direction **(R)**    **(R)**    **(R)**

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GE106.0100.050.12.50.R	5.00	1.00	0.50	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.020</a>	GE106.0100.050.17.50.R	5.00	1.00	0.50	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.030</a>	GE106.0100.050.22.50.R	5.00	1.00	0.50	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.040</a>	GE106.0100.050.27.50.R	5.00	1.00	0.50	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.050</a>	GE106.0100.050.32.50.R	5.00	1.00	0.50	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.060</a>	GE106.0100.050.37.50.R	5.00	1.00	0.50	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.070</a>	GE106.0100.050.42.50.R	5.00	1.00	0.50	2.95	4.70	1.20	42.00	67.00	6.00
<a href="#">6.110</a>	GE106.0150.075.12.50.R	5.00	1.50	0.75	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.120</a>	GE106.0150.075.17.50.R	5.00	1.50	0.75	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.130</a>	GE106.0150.075.22.50.R	5.00	1.50	0.75	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.140</a>	GE106.0150.075.27.50.R	5.00	1.50	0.75	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.150</a>	GE106.0150.075.32.50.R	5.00	1.50	0.75	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.160</a>	GE106.0150.075.37.50.R	5.00	1.50	0.75	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.170</a>	GE106.0150.075.42.50.R	5.00	1.50	0.75	2.95	4.70	1.20	42.00	67.00	6.00
<a href="#">6.210</a>	GE106.0200.100.12.50.R	5.00	2.00	1.00	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.220</a>	GE106.0200.100.17.50.R	5.00	2.00	1.00	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.230</a>	GE106.0200.100.22.50.R	5.00	2.00	1.00	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.240</a>	GE106.0200.100.27.50.R	5.00	2.00	1.00	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.250</a>	GE106.0200.100.32.50.R	5.00	2.00	1.00	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.260</a>	GE106.0200.100.37.50.R	5.00	2.00	1.00	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.270</a>	GE106.0200.100.42.50.R	5.00	2.00	1.00	2.95	4.70	1.20	42.00	67.00	6.00



Series no. **25881** **25883** **25887**

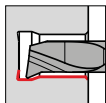
Cutting direction

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GE106.0100.050.12.50.L	5.00	1.00	0.50	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.020</a>	GE106.0100.050.17.50.L	5.00	1.00	0.50	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.030</a>	GE106.0100.050.22.50.L	5.00	1.00	0.50	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.040</a>	GE106.0100.050.27.50.L	5.00	1.00	0.50	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.050</a>	GE106.0100.050.32.50.L	5.00	1.00	0.50	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.060</a>	GE106.0100.050.37.50.L	5.00	1.00	0.50	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.070</a>	GE106.0100.050.42.50.L	5.00	1.00	0.50	2.95	4.70	1.20	42.00	67.00	6.00
<a href="#">6.110</a>	GE106.0150.075.12.50.L	5.00	1.50	0.75	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.120</a>	GE106.0150.075.17.50.L	5.00	1.50	0.75	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.130</a>	GE106.0150.075.22.50.L	5.00	1.50	0.75	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.140</a>	GE106.0150.075.27.50.L	5.00	1.50	0.75	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.150</a>	GE106.0150.075.32.50.L	5.00	1.50	0.75	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.160</a>	GE106.0150.075.37.50.L	5.00	1.50	0.75	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.170</a>	GE106.0150.075.42.50.L	5.00	1.50	0.75	2.95	4.70	1.20	42.00	67.00	6.00
<a href="#">6.210</a>	GE106.0200.100.12.50.L	5.00	2.00	1.00	2.95	4.70	1.20	12.00	37.00	6.00
<a href="#">6.220</a>	GE106.0200.100.17.50.L	5.00	2.00	1.00	2.95	4.70	1.20	17.00	42.00	6.00
<a href="#">6.230</a>	GE106.0200.100.22.50.L	5.00	2.00	1.00	2.95	4.70	1.20	22.00	47.00	6.00
<a href="#">6.240</a>	GE106.0200.100.27.50.L	5.00	2.00	1.00	2.95	4.70	1.20	27.00	52.00	6.00
<a href="#">6.250</a>	GE106.0200.100.32.50.L	5.00	2.00	1.00	2.95	4.70	1.20	32.00	57.00	6.00
<a href="#">6.260</a>	GE106.0200.100.37.50.L	5.00	2.00	1.00	2.95	4.70	1.20	37.00	62.00	6.00
<a href="#">6.270</a>	GE106.0200.100.42.50.L	5.00	2.00	1.00	2.95	4.70	1.20	42.00	67.00	6.00

System 106



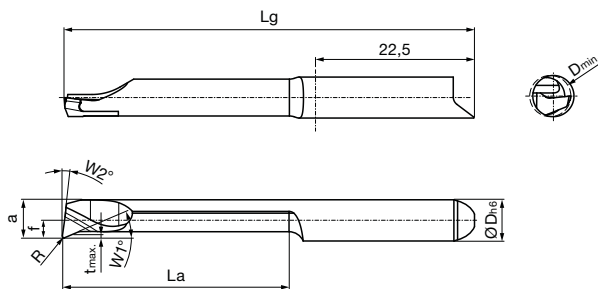
Cutting insert for boring out and profiling



• radial free 23°

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide			
	Type	GT 106	GT 106	GT 106
Surface	<b>S</b>	<b>a</b>	○	
	TiN	nano-A	bright	



Series no.	25700	25702	25706
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.001	GT106.2357.015.27.60.R	6.00	0.15	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.002	GT106.2357.015.32.60.R	6.00	0.15	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.003	GT106.2357.015.37.60.R	6.00	0.15	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.004	GT106.2357.015.42.60.R	6.00	0.15	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.005	GT106.2357.015.47.60.R	6.00	0.15	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.006	GT106.2357.015.52.60.R	6.00	0.15	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.007	GT106.2357.030.27.60.R	6.00	0.30	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.008	GT106.2357.030.32.60.R	6.00	0.30	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.009	GT106.2357.030.37.60.R	6.00	0.30	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.010	GT106.2357.030.42.60.R	6.00	0.30	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.011	GT106.2357.030.47.60.R	6.00	0.30	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.012	GT106.2357.030.52.60.R	6.00	0.30	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.013	GT106.2357.015.12.60.R	6.00	0.15	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.014	GT106.2357.015.17.60.R	6.00	0.15	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.015	GT106.2357.015.22.60.R	6.00	0.15	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.016	GT106.2357.030.12.60.R	6.00	0.30	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.017	GT106.2357.030.17.60.R	6.00	0.30	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.018	GT106.2357.030.22.60.R	6.00	0.30	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.019	GT106.2357.005.12.60.R	6.00	0.05	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.020	GT106.2357.005.17.60.R	6.00	0.05	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.021	GT106.2357.005.22.60.R	6.00	0.05	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.022	GT106.2357.005.27.60.R	6.00	0.05	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.023	GT106.2357.005.32.60.R	6.00	0.05	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.024	GT106.2357.005.37.60.R	6.00	0.05	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.025	GT106.2357.005.42.60.R	6.00	0.05	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.026	GT106.2357.005.47.60.R	6.00	0.05	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.027	GT106.2357.005.52.60.R	6.00	0.05	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.028	GT106.2357.010.12.60.R	6.00	0.10	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.029	GT106.2357.010.17.60.R	6.00	0.10	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.030	GT106.2357.010.22.60.R	6.00	0.10	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.031	GT106.2357.010.27.60.R	6.00	0.10	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.032	GT106.2357.010.32.60.R	6.00	0.10	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.033	GT106.2357.010.37.60.R	6.00	0.10	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.034	GT106.2357.010.42.60.R	6.00	0.10	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.035	GT106.2357.010.47.60.R	6.00	0.10	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.036	GT106.2357.010.52.60.R	6.00	0.10	23	8	2.70	5.70	0.30	52.00	77.00	6.00

System 106

Series no. **25700** **25702** **25706**Cutting direction   

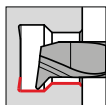
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.037</a>	GT106.2357.020.12.60.R	6.00	0.20	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.038</a>	GT106.2357.020.17.60.R	6.00	0.20	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.039</a>	GT106.2357.020.22.60.R	6.00	0.20	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.2357.020.27.60.R	6.00	0.20	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.041</a>	GT106.2357.020.32.60.R	6.00	0.20	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.042</a>	GT106.2357.020.37.60.R	6.00	0.20	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.043</a>	GT106.2357.020.42.60.R	6.00	0.20	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.044</a>	GT106.2357.020.47.60.R	6.00	0.20	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.045</a>	GT106.2357.020.52.60.R	6.00	0.20	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.046</a>	GT106.2357.025.12.60.R	6.00	0.25	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.047</a>	GT106.2357.025.17.60.R	6.00	0.25	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.048</a>	GT106.2357.025.22.60.R	6.00	0.25	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.049</a>	GT106.2357.025.27.60.R	6.00	0.25	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.2357.025.32.60.R	6.00	0.25	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.051</a>	GT106.2357.025.37.60.R	6.00	0.25	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.052</a>	GT106.2357.025.42.60.R	6.00	0.25	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.053</a>	GT106.2357.025.47.60.R	6.00	0.25	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.054</a>	GT106.2357.025.52.60.R	6.00	0.25	23	8	2.70	5.70	0.30	52.00	77.00	6.00

Series no. **25701** **25703** **25707**  
 Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GT106.2357.015.27.60.L	6.00	0.15	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.002</a>	GT106.2357.015.32.60.L	6.00	0.15	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.003</a>	GT106.2357.015.37.60.L	6.00	0.15	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.004</a>	GT106.2357.015.42.60.L	6.00	0.15	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.005</a>	GT106.2357.015.47.60.L	6.00	0.15	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.006</a>	GT106.2357.015.52.60.L	6.00	0.15	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.007</a>	GT106.2357.030.27.60.L	6.00	0.30	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.008</a>	GT106.2357.030.32.60.L	6.00	0.30	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.009</a>	GT106.2357.030.37.60.L	6.00	0.30	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.010</a>	GT106.2357.030.42.60.L	6.00	0.30	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.011</a>	GT106.2357.030.47.60.L	6.00	0.30	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.012</a>	GT106.2357.030.52.60.L	6.00	0.30	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.013</a>	GT106.2357.015.12.60.L	6.00	0.15	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.014</a>	GT106.2357.015.17.60.L	6.00	0.15	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.015</a>	GT106.2357.015.22.60.L	6.00	0.15	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.016</a>	GT106.2357.030.12.60.L	6.00	0.30	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.017</a>	GT106.2357.030.17.60.L	6.00	0.30	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.018</a>	GT106.2357.030.22.60.L	6.00	0.30	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.019</a>	GT106.2357.005.12.60.L	6.00	0.05	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.2357.005.17.60.L	6.00	0.05	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.021</a>	GT106.2357.005.22.60.L	6.00	0.05	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.022</a>	GT106.2357.005.27.60.L	6.00	0.05	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.023</a>	GT106.2357.005.32.60.L	6.00	0.05	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.024</a>	GT106.2357.005.37.60.L	6.00	0.05	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.025</a>	GT106.2357.005.42.60.L	6.00	0.05	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.026</a>	GT106.2357.005.47.60.L	6.00	0.05	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.027</a>	GT106.2357.005.52.60.L	6.00	0.05	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.028</a>	GT106.2357.010.12.60.L	6.00	0.10	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.029</a>	GT106.2357.010.17.60.L	6.00	0.10	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.2357.010.22.60.L	6.00	0.10	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.031</a>	GT106.2357.010.27.60.L	6.00	0.10	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.032</a>	GT106.2357.010.32.60.L	6.00	0.10	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.033</a>	GT106.2357.010.37.60.L	6.00	0.10	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.034</a>	GT106.2357.010.42.60.L	6.00	0.10	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.035</a>	GT106.2357.010.47.60.L	6.00	0.10	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.036</a>	GT106.2357.010.52.60.L	6.00	0.10	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.037</a>	GT106.2357.020.12.60.L	6.00	0.20	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.038</a>	GT106.2357.020.17.60.L	6.00	0.20	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.039</a>	GT106.2357.020.22.60.L	6.00	0.20	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.2357.020.27.60.L	6.00	0.20	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.041</a>	GT106.2357.020.32.60.L	6.00	0.20	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.042</a>	GT106.2357.020.37.60.L	6.00	0.20	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.043</a>	GT106.2357.020.42.60.L	6.00	0.20	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.044</a>	GT106.2357.020.47.60.L	6.00	0.20	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.045</a>	GT106.2357.020.52.60.L	6.00	0.20	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.046</a>	GT106.2357.025.12.60.L	6.00	0.25	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.047</a>	GT106.2357.025.17.60.L	6.00	0.25	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.048</a>	GT106.2357.025.22.60.L	6.00	0.25	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.049</a>	GT106.2357.025.27.60.L	6.00	0.25	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.2357.025.32.60.L	6.00	0.25	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.051</a>	GT106.2357.025.37.60.L	6.00	0.25	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.052</a>	GT106.2357.025.42.60.L	6.00	0.25	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.053</a>	GT106.2357.025.47.60.L	6.00	0.25	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.054</a>	GT106.2357.025.52.60.L	6.00	0.25	23	8	2.70	5.70	0.30	52.00	77.00	6.00



Cutting insert for boring out and profiling

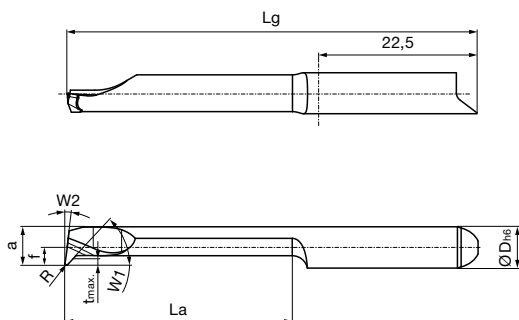


• radial free 47°

for tool holders type GB106 see from page 62

Cutting data page 148

System 106



Tool material	Solid carbide		
	GT 106	GT 106	GT 106
Type			
Surface	Ⓢ	ⓐ	○
	TiN	nano-A	bright

Right hand version shown  
Left hand version mirror image




Series no. **25708** **25710** **25714**




Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.019	GT106.4757.005.12.60.R	6.00	0.05	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.020	GT106.4757.005.17.60.R	6.00	0.05	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.021	GT106.4757.005.22.60.R	6.00	0.05	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.022	GT106.4757.005.27.60.R	6.00	0.05	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.023	GT106.4757.005.32.60.R	6.00	0.05	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.024	GT106.4757.005.37.60.R	6.00	0.05	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.025	GT106.4757.005.42.60.R	6.00	0.05	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.026	GT106.4757.005.47.60.R	6.00	0.05	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.027	GT106.4757.005.52.60.R	6.00	0.05	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.028	GT106.4757.010.12.60.R	6.00	0.10	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.029	GT106.4757.010.17.60.R	6.00	0.10	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.030	GT106.4757.010.22.60.R	6.00	0.10	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.031	GT106.4757.010.27.60.R	6.00	0.10	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.032	GT106.4757.010.32.60.R	6.00	0.10	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.033	GT106.4757.010.37.60.R	6.00	0.10	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.034	GT106.4757.010.42.60.R	6.00	0.10	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.035	GT106.4757.010.47.60.R	6.00	0.10	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.036	GT106.4757.010.52.60.R	6.00	0.10	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.013	GT106.4757.015.12.60.R	6.00	0.15	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.014	GT106.4757.015.17.60.R	6.00	0.15	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.015	GT106.4757.015.22.60.R	6.00	0.15	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.001	GT106.4757.015.27.60.R	6.00	0.15	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.002	GT106.4757.015.32.60.R	6.00	0.15	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.003	GT106.4757.015.37.60.R	6.00	0.15	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.004	GT106.4757.015.42.60.R	6.00	0.15	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.005	GT106.4757.015.47.60.R	6.00	0.15	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.006	GT106.4757.015.52.60.R	6.00	0.15	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.037	GT106.4757.020.12.60.R	6.00	0.20	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.038	GT106.4757.020.17.60.R	6.00	0.20	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.039	GT106.4757.020.22.60.R	6.00	0.20	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.040	GT106.4757.020.27.60.R	6.00	0.20	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.041	GT106.4757.020.32.60.R	6.00	0.20	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.042	GT106.4757.020.37.60.R	6.00	0.20	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.043	GT106.4757.020.42.60.R	6.00	0.20	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.044	GT106.4757.020.47.60.R	6.00	0.20	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.045	GT106.4757.020.52.60.R	6.00	0.20	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.016	GT106.4757.030.12.60.R	6.00	0.30	47	8	2.70	5.70	0.60	12.00	37.00	6.00





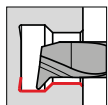
Series no. 25708 25710 25714											
Cutting direction   											
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.017</a>	GT106.4757.030.17.60.R	6.00	0.30	47	8	2.70	5.70	0.60	17.00	42.00	6.00
<a href="#">6.018</a>	GT106.4757.030.22.60.R	6.00	0.30	47	8	2.70	5.70	0.60	22.00	47.00	6.00
<a href="#">6.007</a>	GT106.4757.030.27.60.R	6.00	0.30	47	8	2.70	5.70	0.60	27.00	52.00	6.00
<a href="#">6.008</a>	GT106.4757.030.32.60.R	6.00	0.30	47	8	2.70	5.70	0.60	32.00	57.00	6.00
<a href="#">6.009</a>	GT106.4757.030.37.60.R	6.00	0.30	47	8	2.70	5.70	0.60	37.00	62.00	6.00
<a href="#">6.010</a>	GT106.4757.030.42.60.R	6.00	0.30	47	8	2.70	5.70	0.60	42.00	67.00	6.00
<a href="#">6.011</a>	GT106.4757.030.47.60.R	6.00	0.30	47	8	2.70	5.70	0.60	47.00	72.00	6.00
<a href="#">6.012</a>	GT106.4757.030.52.60.R	6.00	0.30	47	8	2.70	5.70	0.60	52.00	77.00	6.00

Series no. 25709 25711 25715											
Cutting direction   											
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.019</a>	GT106.4757.005.12.60.L	6.00	0.05	47	8	2.70	5.70	0.60	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.4757.005.17.60.L	6.00	0.05	47	8	2.70	5.70	0.60	17.00	42.00	6.00
<a href="#">6.021</a>	GT106.4757.005.22.60.L	6.00	0.05	47	8	2.70	5.70	0.60	22.00	47.00	6.00
<a href="#">6.022</a>	GT106.4757.005.27.60.L	6.00	0.05	47	8	2.70	5.70	0.60	27.00	52.00	6.00
<a href="#">6.023</a>	GT106.4757.005.32.60.L	6.00	0.05	47	8	2.70	5.70	0.60	32.00	57.00	6.00
<a href="#">6.024</a>	GT106.4757.005.37.60.L	6.00	0.05	47	8	2.70	5.70	0.60	37.00	62.00	6.00
<a href="#">6.025</a>	GT106.4757.005.42.60.L	6.00	0.05	47	8	2.70	5.70	0.60	42.00	67.00	6.00
<a href="#">6.026</a>	GT106.4757.005.47.60.L	6.00	0.05	47	8	2.70	5.70	0.60	47.00	72.00	6.00
<a href="#">6.027</a>	GT106.4757.005.52.60.L	6.00	0.05	47	8	2.70	5.70	0.60	52.00	77.00	6.00
<a href="#">6.028</a>	GT106.4757.010.12.60.L	6.00	0.10	47	8	2.70	5.70	0.60	12.00	37.00	6.00
<a href="#">6.029</a>	GT106.4757.010.17.60.L	6.00	0.10	47	8	2.70	5.70	0.60	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.4757.010.22.60.L	6.00	0.10	47	8	2.70	5.70	0.60	22.00	47.00	6.00
<a href="#">6.031</a>	GT106.4757.010.27.60.L	6.00	0.10	47	8	2.70	5.70	0.60	27.00	52.00	6.00
<a href="#">6.032</a>	GT106.4757.010.32.60.L	6.00	0.10	47	8	2.70	5.70	0.60	32.00	57.00	6.00
<a href="#">6.033</a>	GT106.4757.010.37.60.L	6.00	0.10	47	8	2.70	5.70	0.60	37.00	62.00	6.00
<a href="#">6.034</a>	GT106.4757.010.42.60.L	6.00	0.10	47	8	2.70	5.70	0.60	42.00	67.00	6.00
<a href="#">6.035</a>	GT106.4757.010.47.60.L	6.00	0.10	47	8	2.70	5.70	0.60	47.00	72.00	6.00
<a href="#">6.036</a>	GT106.4757.010.52.60.L	6.00	0.10	47	8	2.70	5.70	0.60	52.00	77.00	6.00
<a href="#">6.013</a>	GT106.4757.015.12.60.L	6.00	0.15	47	8	2.70	5.70	0.60	12.00	37.00	6.00
<a href="#">6.014</a>	GT106.4757.015.17.60.L	6.00	0.15	47	8	2.70	5.70	0.60	17.00	42.00	6.00
<a href="#">6.015</a>	GT106.4757.015.22.60.L	6.00	0.15	47	8	2.70	5.70	0.60	22.00	47.00	6.00
<a href="#">6.001</a>	GT106.4757.015.27.60.L	6.00	0.15	47	8	2.70	5.70	0.60	27.00	52.00	6.00
<a href="#">6.002</a>	GT106.4757.015.32.60.L	6.00	0.15	47	8	2.70	5.70	0.60	32.00	57.00	6.00
<a href="#">6.003</a>	GT106.4757.015.37.60.L	6.00	0.15	47	8	2.70	5.70	0.60	37.00	62.00	6.00
<a href="#">6.004</a>	GT106.4757.015.42.60.L	6.00	0.15	47	8	2.70	5.70	0.60	42.00	67.00	6.00
<a href="#">6.005</a>	GT106.4757.015.47.60.L	6.00	0.15	47	8	2.70	5.70	0.60	47.00	72.00	6.00
<a href="#">6.006</a>	GT106.4757.015.52.60.L	6.00	0.15	47	8	2.70	5.70	0.60	52.00	77.00	6.00
<a href="#">6.037</a>	GT106.4757.020.12.60.L	6.00	0.20	47	8	2.70	5.70	0.60	12.00	37.00	6.00
<a href="#">6.038</a>	GT106.4757.020.17.60.L	6.00	0.20	47	8	2.70	5.70	0.60	17.00	42.00	6.00
<a href="#">6.039</a>	GT106.4757.020.22.60.L	6.00	0.20	47	8	2.70	5.70	0.60	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.4757.020.27.60.L	6.00	0.20	47	8	2.70	5.70	0.60	27.00	52.00	6.00
<a href="#">6.041</a>	GT106.4757.020.32.60.L	6.00	0.20	47	8	2.70	5.70	0.60	32.00	57.00	6.00
<a href="#">6.042</a>	GT106.4757.020.37.60.L	6.00	0.20	47	8	2.70	5.70	0.60	37.00	62.00	6.00
<a href="#">6.043</a>	GT106.4757.020.42.60.L	6.00	0.20	47	8	2.70	5.70	0.60	42.00	67.00	6.00
<a href="#">6.044</a>	GT106.4757.020.47.60.L	6.00	0.20	47	8	2.70	5.70	0.60	47.00	72.00	6.00
<a href="#">6.045</a>	GT106.4757.020.52.60.L	6.00	0.20	47	8	2.70	5.70	0.60	52.00	77.00	6.00
<a href="#">6.016</a>	GT106.4757.030.12.60.L	6.00	0.30	47	8	2.70	5.70	0.60	12.00	37.00	6.00
<a href="#">6.017</a>	GT106.4757.030.17.60.L	6.00	0.30	47	8	2.70	5.70	0.60	17.00	42.00	6.00
<a href="#">6.018</a>	GT106.4757.030.22.60.L	6.00	0.30	47	8	2.70	5.70	0.60	22.00	47.00	6.00
<a href="#">6.007</a>	GT106.4757.030.27.60.L	6.00	0.30	47	8	2.70	5.70	0.60	27.00	52.00	6.00
<a href="#">6.008</a>	GT106.4757.030.32.60.L	6.00	0.30	47	8	2.70	5.70	0.60	32.00	57.00	6.00
<a href="#">6.009</a>	GT106.4757.030.37.60.L	6.00	0.30	47	8	2.70	5.70	0.60	37.00	62.00	6.00
<a href="#">6.010</a>	GT106.4757.030.42.60.L	6.00	0.30	47	8	2.70	5.70	0.60	42.00	67.00	6.00
<a href="#">6.011</a>	GT106.4757.030.47.60.L	6.00	0.30	47	8	2.70	5.70	0.60	47.00	72.00	6.00
<a href="#">6.012</a>	GT106.4757.030.52.60.L	6.00	0.30	47	8	2.70	5.70	0.60	52.00	77.00	6.00

System 106



**Cutting insert for boring out and profiling**

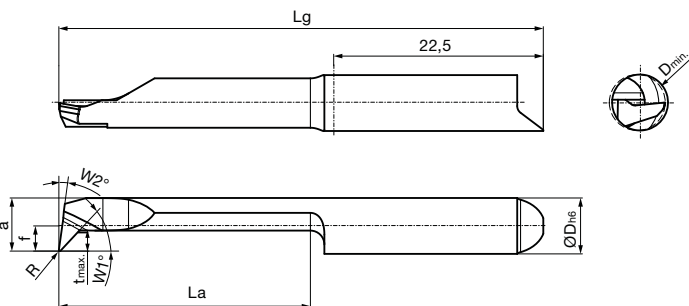


- radial free 47°, tmax 2

for tool holders type GB106 see from page 62

Cutting data page 148

System 106



Right hand version shown  
Left hand version mirror image

Series no. **25516** **25518** **25522**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.4757.005.12.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.4757.005.17.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.4757.005.22.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.4757.005.27.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.4757.005.32.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.4757.005.37.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.4757.005.42.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.080</a>	GT106.4757.005.47.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	47.00	72.00	6.00
<a href="#">6.090</a>	GT106.4757.005.52.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	52.00	77.00	6.00
<a href="#">6.110</a>	GT106.4757.010.12.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.120</a>	GT106.4757.010.17.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.130</a>	GT106.4757.010.22.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.140</a>	GT106.4757.010.27.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.150</a>	GT106.4757.010.32.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.160</a>	GT106.4757.010.37.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.170</a>	GT106.4757.010.42.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.180</a>	GT106.4757.010.47.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	47.00	72.00	6.00
<a href="#">6.190</a>	GT106.4757.010.52.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	52.00	77.00	6.00
<a href="#">6.210</a>	GT106.4757.015.12.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.220</a>	GT106.4757.015.17.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.230</a>	GT106.4757.015.22.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.240</a>	GT106.4757.015.27.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.250</a>	GT106.4757.015.32.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.260</a>	GT106.4757.015.37.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.270</a>	GT106.4757.015.42.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.280</a>	GT106.4757.015.47.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	47.00	72.00	6.00
<a href="#">6.290</a>	GT106.4757.015.52.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	52.00	77.00	6.00
<a href="#">6.310</a>	GT106.4757.020.12.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.320</a>	GT106.4757.020.17.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.330</a>	GT106.4757.020.22.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.340</a>	GT106.4757.020.27.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.350</a>	GT106.4757.020.32.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.360</a>	GT106.4757.020.37.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.370</a>	GT106.4757.020.42.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.380</a>	GT106.4757.020.47.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	47.00	72.00	6.00
<a href="#">6.390</a>	GT106.4757.020.52.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	52.00	77.00	6.00
<a href="#">6.410</a>	GT106.4757.030.12.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	12.00	37.00	6.00

Series no. **25516** **25518** **25522**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.420</a>	GT106.4757.030.17.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.430</a>	GT106.4757.030.22.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.440</a>	GT106.4757.030.27.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.450</a>	GT106.4757.030.32.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.460</a>	GT106.4757.030.37.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.470</a>	GT106.4757.030.42.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.480</a>	GT106.4757.030.47.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	47.00	72.00	6.00
<a href="#">6.490</a>	GT106.4757.030.52.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	52.00	77.00	6.00

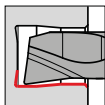
Series no. **25517** **25519** **25523**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.4757.005.12.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.4757.005.17.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.4757.005.22.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.4757.005.27.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.4757.005.32.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.4757.005.37.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.4757.005.42.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.080</a>	GT106.4757.005.47.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	47.00	72.00	6.00
<a href="#">6.090</a>	GT106.4757.005.52.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	52.00	77.00	6.00
<a href="#">6.110</a>	GT106.4757.010.12.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.120</a>	GT106.4757.010.17.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.130</a>	GT106.4757.010.22.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.140</a>	GT106.4757.010.27.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.150</a>	GT106.4757.010.32.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.160</a>	GT106.4757.010.37.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.170</a>	GT106.4757.010.42.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.180</a>	GT106.4757.010.47.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	47.00	72.00	6.00
<a href="#">6.190</a>	GT106.4757.010.52.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	52.00	77.00	6.00
<a href="#">6.210</a>	GT106.4757.015.12.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.220</a>	GT106.4757.015.17.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.230</a>	GT106.4757.015.22.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.240</a>	GT106.4757.015.27.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.250</a>	GT106.4757.015.32.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.260</a>	GT106.4757.015.37.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.270</a>	GT106.4757.015.42.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.280</a>	GT106.4757.015.47.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	47.00	72.00	6.00
<a href="#">6.290</a>	GT106.4757.015.52.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	52.00	77.00	6.00
<a href="#">6.310</a>	GT106.4757.020.12.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.320</a>	GT106.4757.020.17.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.330</a>	GT106.4757.020.22.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.340</a>	GT106.4757.020.27.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.350</a>	GT106.4757.020.32.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.360</a>	GT106.4757.020.37.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.370</a>	GT106.4757.020.42.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.380</a>	GT106.4757.020.47.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	47.00	72.00	6.00
<a href="#">6.390</a>	GT106.4757.020.52.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	52.00	77.00	6.00
<a href="#">6.410</a>	GT106.4757.030.12.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.420</a>	GT106.4757.030.17.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.430</a>	GT106.4757.030.22.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.440</a>	GT106.4757.030.27.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.450</a>	GT106.4757.030.32.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.460</a>	GT106.4757.030.37.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.470</a>	GT106.4757.030.42.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.480</a>	GT106.4757.030.47.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	47.00	72.00	6.00
<a href="#">6.490</a>	GT106.4757.030.52.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	52.00	77.00	6.00

System 106



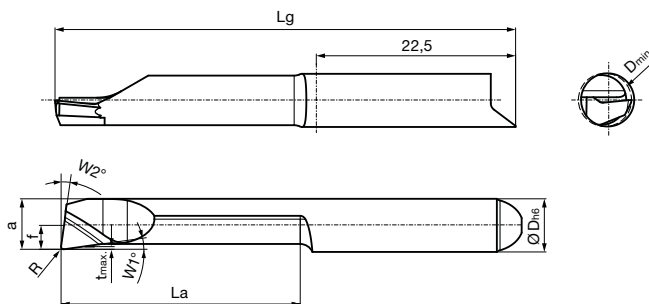
Cutting insert for boring out and profiling



• radial free 8°

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Surface	S	a	
	TiN	nano-A	bright



Series no.	25508	25510	25514
Cutting direction	(R)	(R)	(R)

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.0857.005.12.60.R	6.00	0.05	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.020	GT106.0857.005.17.60.R	6.00	0.05	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.030	GT106.0857.005.22.60.R	6.00	0.05	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.040	GT106.0857.005.27.60.R	6.00	0.05	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.050	GT106.0857.005.32.60.R	6.00	0.05	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.060	GT106.0857.005.37.60.R	6.00	0.05	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.070	GT106.0857.005.42.60.R	6.00	0.05	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.110	GT106.0857.010.12.60.R	6.00	0.10	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.120	GT106.0857.010.17.60.R	6.00	0.10	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.130	GT106.0857.010.22.60.R	6.00	0.10	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.140	GT106.0857.010.27.60.R	6.00	0.10	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.150	GT106.0857.010.32.60.R	6.00	0.10	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.160	GT106.0857.010.37.60.R	6.00	0.10	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.170	GT106.0857.010.42.60.R	6.00	0.10	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.210	GT106.0857.015.12.60.R	6.00	0.15	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.220	GT106.0857.015.17.60.R	6.00	0.15	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.230	GT106.0857.015.22.60.R	6.00	0.15	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.240	GT106.0857.015.27.60.R	6.00	0.15	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.250	GT106.0857.015.32.60.R	6.00	0.15	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.260	GT106.0857.015.37.60.R	6.00	0.15	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.270	GT106.0857.015.42.60.R	6.00	0.15	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.310	GT106.0857.020.12.60.R	6.00	0.20	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.320	GT106.0857.020.17.60.R	6.00	0.20	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.330	GT106.0857.020.22.60.R	6.00	0.20	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.340	GT106.0857.020.27.60.R	6.00	0.20	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.350	GT106.0857.020.32.60.R	6.00	0.20	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.360	GT106.0857.020.37.60.R	6.00	0.20	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.370	GT106.0857.020.42.60.R	6.00	0.20	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.410	GT106.0857.030.12.60.R	6.00	0.30	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.420	GT106.0857.030.17.60.R	6.00	0.30	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.430	GT106.0857.030.22.60.R	6.00	0.30	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.440	GT106.0857.030.27.60.R	6.00	0.30	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.450	GT106.0857.030.32.60.R	6.00	0.30	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.460	GT106.0857.030.37.60.R	6.00	0.30	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.470	GT106.0857.030.42.60.R	6.00	0.30	8	8	2.70	5.70	0.30	42.00	67.00	6.00

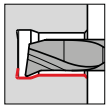
Series no. **25509** **25511** **25515**

Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GT106.0857.005.12.60.L	6.00	0.05	8	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.0857.005.17.60.L	6.00	0.05	8	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.0857.005.22.60.L	6.00	0.05	8	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.040</a>	GT106.0857.005.27.60.L	6.00	0.05	8	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.050</a>	GT106.0857.005.32.60.L	6.00	0.05	8	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.060</a>	GT106.0857.005.37.60.L	6.00	0.05	8	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.070</a>	GT106.0857.005.42.60.L	6.00	0.05	8	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.110</a>	GT106.0857.010.12.60.L	6.00	0.10	8	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.120</a>	GT106.0857.010.17.60.L	6.00	0.10	8	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.130</a>	GT106.0857.010.22.60.L	6.00	0.10	8	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.140</a>	GT106.0857.010.27.60.L	6.00	0.10	8	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.150</a>	GT106.0857.010.32.60.L	6.00	0.10	8	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.160</a>	GT106.0857.010.37.60.L	6.00	0.10	8	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.170</a>	GT106.0857.010.42.60.L	6.00	0.10	8	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.210</a>	GT106.0857.015.12.60.L	6.00	0.15	8	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.220</a>	GT106.0857.015.17.60.L	6.00	0.15	8	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.230</a>	GT106.0857.015.22.60.L	6.00	0.15	8	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.240</a>	GT106.0857.015.27.60.L	6.00	0.15	8	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.250</a>	GT106.0857.015.32.60.L	6.00	0.15	8	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.260</a>	GT106.0857.015.37.60.L	6.00	0.15	8	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.270</a>	GT106.0857.015.42.60.L	6.00	0.15	8	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.310</a>	GT106.0857.020.12.60.L	6.00	0.20	8	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.320</a>	GT106.0857.020.17.60.L	6.00	0.20	8	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.330</a>	GT106.0857.020.22.60.L	6.00	0.20	8	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.340</a>	GT106.0857.020.27.60.L	6.00	0.20	8	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.350</a>	GT106.0857.020.32.60.L	6.00	0.20	8	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.360</a>	GT106.0857.020.37.60.L	6.00	0.20	8	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.370</a>	GT106.0857.020.42.60.L	6.00	0.20	8	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.410</a>	GT106.0857.030.12.60.L	6.00	0.30	8	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.420</a>	GT106.0857.030.17.60.L	6.00	0.30	8	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.430</a>	GT106.0857.030.22.60.L	6.00	0.30	8	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.440</a>	GT106.0857.030.27.60.L	6.00	0.30	8	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.450</a>	GT106.0857.030.32.60.L	6.00	0.30	8	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.460</a>	GT106.0857.030.37.60.L	6.00	0.30	8	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.470</a>	GT106.0857.030.42.60.L	6.00	0.30	8	8	2.70	5.70	0.30	42.00	67.00	6.00



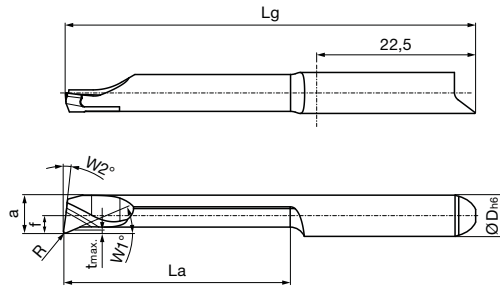
Cutting insert for boring out and profiling



• WIPER-geometry

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Series no.	<b>25716</b>	<b>25718</b>	<b>25722</b>
Cutting direction			

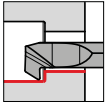
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.019</a>	GJ106.2357.005.12.60.R	6.00	0.05	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.020</a>	GJ106.2357.005.17.60.R	6.00	0.05	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.021</a>	GJ106.2357.005.22.60.R	6.00	0.05	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.022</a>	GJ106.2357.005.27.60.R	6.00	0.05	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.023</a>	GJ106.2357.005.32.60.R	6.00	0.05	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.024</a>	GJ106.2357.005.37.60.R	6.00	0.05	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.025</a>	GJ106.2357.005.42.60.R	6.00	0.05	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.026</a>	GJ106.2357.005.47.60.R	6.00	0.05	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.027</a>	GJ106.2357.005.52.60.R	6.00	0.05	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.013</a>	GJ106.2357.015.12.60.R	6.00	0.15	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.014</a>	GJ106.2357.015.17.60.R	6.00	0.15	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.015</a>	GJ106.2357.015.22.60.R	6.00	0.15	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.001</a>	GJ106.2357.015.27.60.R	6.00	0.15	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.002</a>	GJ106.2357.015.32.60.R	6.00	0.15	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.003</a>	GJ106.2357.015.37.60.R	6.00	0.15	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.004</a>	GJ106.2357.015.42.60.R	6.00	0.15	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.005</a>	GJ106.2357.015.47.60.R	6.00	0.15	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.006</a>	GJ106.2357.015.52.60.R	6.00	0.15	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.028</a>	GJ106.2357.020.12.60.R	6.00	0.20	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.029</a>	GJ106.2357.020.17.60.R	6.00	0.20	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.030</a>	GJ106.2357.020.22.60.R	6.00	0.20	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.031</a>	GJ106.2357.020.27.60.R	6.00	0.20	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.032</a>	GJ106.2357.020.32.60.R	6.00	0.20	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.033</a>	GJ106.2357.020.37.60.R	6.00	0.20	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.034</a>	GJ106.2357.020.42.60.R	6.00	0.20	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.035</a>	GJ106.2357.020.47.60.R	6.00	0.20	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.036</a>	GJ106.2357.020.52.60.R	6.00	0.20	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.016</a>	GJ106.2357.030.12.60.R	6.00	0.30	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.017</a>	GJ106.2357.030.17.60.R	6.00	0.30	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.018</a>	GJ106.2357.030.22.60.R	6.00	0.30	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.007</a>	GJ106.2357.030.27.60.R	6.00	0.30	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.008</a>	GJ106.2357.030.32.60.R	6.00	0.30	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.009</a>	GJ106.2357.030.37.60.R	6.00	0.30	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.010</a>	GJ106.2357.030.42.60.R	6.00	0.30	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.011</a>	GJ106.2357.030.47.60.R	6.00	0.30	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.012</a>	GJ106.2357.030.52.60.R	6.00	0.30	23	8	2.70	5.70	0.30	52.00	77.00	6.00

Series no. **25717** **25719** **25723**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.019</a>	GJ106.2357.005.12.60.L	6.00	0.05	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.020</a>	GJ106.2357.005.17.60.L	6.00	0.05	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.021</a>	GJ106.2357.005.22.60.L	6.00	0.05	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.022</a>	GJ106.2357.005.27.60.L	6.00	0.05	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.023</a>	GJ106.2357.005.32.60.L	6.00	0.05	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.024</a>	GJ106.2357.005.37.60.L	6.00	0.05	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.025</a>	GJ106.2357.005.42.60.L	6.00	0.05	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.026</a>	GJ106.2357.005.47.60.L	6.00	0.05	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.027</a>	GJ106.2357.005.52.60.L	6.00	0.05	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.013</a>	GJ106.2357.015.12.60.L	6.00	0.15	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.014</a>	GJ106.2357.015.17.60.L	6.00	0.15	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.015</a>	GJ106.2357.015.22.60.L	6.00	0.15	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.001</a>	GJ106.2357.015.27.60.L	6.00	0.15	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.002</a>	GJ106.2357.015.32.60.L	6.00	0.15	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.003</a>	GJ106.2357.015.37.60.L	6.00	0.15	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.004</a>	GJ106.2357.015.42.60.L	6.00	0.15	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.005</a>	GJ106.2357.015.47.60.L	6.00	0.15	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.006</a>	GJ106.2357.015.52.60.L	6.00	0.15	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.028</a>	GJ106.2357.020.12.60.L	6.00	0.20	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.029</a>	GJ106.2357.020.17.60.L	6.00	0.20	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.030</a>	GJ106.2357.020.22.60.L	6.00	0.20	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.031</a>	GJ106.2357.020.27.60.L	6.00	0.20	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.032</a>	GJ106.2357.020.32.60.L	6.00	0.20	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.033</a>	GJ106.2357.020.37.60.L	6.00	0.20	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.034</a>	GJ106.2357.020.42.60.L	6.00	0.20	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.035</a>	GJ106.2357.020.47.60.L	6.00	0.20	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.036</a>	GJ106.2357.020.52.60.L	6.00	0.20	23	8	2.70	5.70	0.30	52.00	77.00	6.00
<a href="#">6.016</a>	GJ106.2357.030.12.60.L	6.00	0.30	23	8	2.70	5.70	0.30	12.00	37.00	6.00
<a href="#">6.017</a>	GJ106.2357.030.17.60.L	6.00	0.30	23	8	2.70	5.70	0.30	17.00	42.00	6.00
<a href="#">6.018</a>	GJ106.2357.030.22.60.L	6.00	0.30	23	8	2.70	5.70	0.30	22.00	47.00	6.00
<a href="#">6.007</a>	GJ106.2357.030.27.60.L	6.00	0.30	23	8	2.70	5.70	0.30	27.00	52.00	6.00
<a href="#">6.008</a>	GJ106.2357.030.32.60.L	6.00	0.30	23	8	2.70	5.70	0.30	32.00	57.00	6.00
<a href="#">6.009</a>	GJ106.2357.030.37.60.L	6.00	0.30	23	8	2.70	5.70	0.30	37.00	62.00	6.00
<a href="#">6.010</a>	GJ106.2357.030.42.60.L	6.00	0.30	23	8	2.70	5.70	0.30	42.00	67.00	6.00
<a href="#">6.011</a>	GJ106.2357.030.47.60.L	6.00	0.30	23	8	2.70	5.70	0.30	47.00	72.00	6.00
<a href="#">6.012</a>	GJ106.2357.030.52.60.L	6.00	0.30	23	8	2.70	5.70	0.30	52.00	77.00	6.00



**Cutting insert for back boring and profiling**



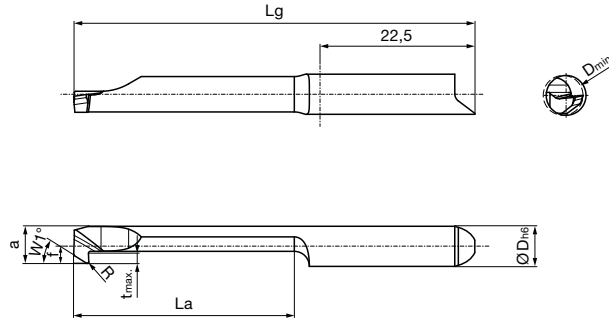
• radial free 32°

for tool holders type GB106 see from page 62

Tool material **Solid carbide**

Type	GT 106	GT 106	GT 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	nano-A	bright

Cutting data page 148



Right hand version shown  
Left hand version mirror image



Series no.	<b>25732</b>	<b>25734</b>	<b>25738</b>
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
<a href="#">6.013</a>	GT106.3257.020.12.60.R	6.00	0.20	32	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.014</a>	GT106.3257.020.17.60.R	6.00	0.20	32	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.001</a>	GT106.3257.020.22.60.R	6.00	0.20	32	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.002</a>	GT106.3257.020.32.60.R	6.00	0.20	32	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.003</a>	GT106.3257.020.42.60.R	6.00	0.20	32	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.004</a>	GT106.3257.020.52.60.R	6.00	0.20	32	2.70	5.70	2.00	52.00	77.00	6.00

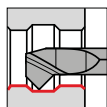
Series no.	<b>25733</b>	<b>25735</b>	<b>25739</b>
Cutting direction	<b>(L)</b>	<b>(L)</b>	<b>(L)</b>

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
<a href="#">6.013</a>	GT106.3257.020.12.60.L	6.00	0.20	32	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.014</a>	GT106.3257.020.17.60.L	6.00	0.20	32	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.001</a>	GT106.3257.020.22.60.L	6.00	0.20	32	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.002</a>	GT106.3257.020.32.60.L	6.00	0.20	32	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.003</a>	GT106.3257.020.42.60.L	6.00	0.20	32	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.004</a>	GT106.3257.020.52.60.L	6.00	0.20	32	2.70	5.70	2.00	52.00	77.00	6.00





Cutting insert for boring out and chamfering

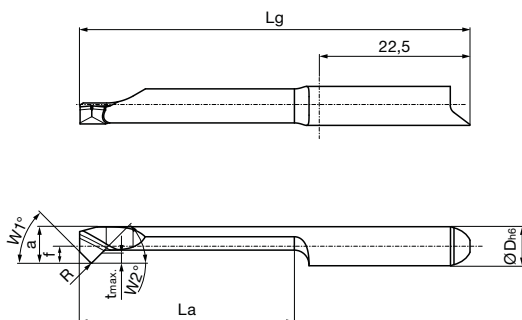


• 45° both sides

for tool holders type GB106 see from page 62

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	nano-A	bright

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Series no.	<b>25740</b>	<b>25742</b>	<b>25746</b>
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

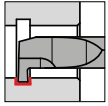
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.019	GT106.4557.010.12.60.R	6.00	0.10	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.020	GT106.4557.010.17.60.R	6.00	0.10	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.021	GT106.4557.010.22.60.R	6.00	0.10	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.022	GT106.4557.010.27.60.R	6.00	0.10	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.023	GT106.4557.010.32.60.R	6.00	0.10	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.024	GT106.4557.010.37.60.R	6.00	0.10	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.025	GT106.4557.010.42.60.R	6.00	0.10	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.026	GT106.4557.010.47.60.R	6.00	0.10	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.027	GT106.4557.010.52.60.R	6.00	0.10	45	45	2.70	5.70	1.00	52.00	77.00	6.00
6.013	GT106.4557.015.12.60.R	6.00	0.15	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.014	GT106.4557.015.17.60.R	6.00	0.15	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.015	GT106.4557.015.22.60.R	6.00	0.15	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.001	GT106.4557.015.27.60.R	6.00	0.15	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.002	GT106.4557.015.32.60.R	6.00	0.15	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.003	GT106.4557.015.37.60.R	6.00	0.15	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.004	GT106.4557.015.42.60.R	6.00	0.15	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.005	GT106.4557.015.47.60.R	6.00	0.15	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.006	GT106.4557.015.52.60.R	6.00	0.15	45	45	2.70	5.70	1.00	52.00	77.00	6.00
6.028	GT106.4557.020.12.60.R	6.00	0.20	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.029	GT106.4557.020.17.60.R	6.00	0.20	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.030	GT106.4557.020.22.60.R	6.00	0.20	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.031	GT106.4557.020.27.60.R	6.00	0.20	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.032	GT106.4557.020.32.60.R	6.00	0.20	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.033	GT106.4557.020.37.60.R	6.00	0.20	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.034	GT106.4557.020.42.60.R	6.00	0.20	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.035	GT106.4557.020.47.60.R	6.00	0.20	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.036	GT106.4557.020.52.60.R	6.00	0.20	45	45	2.70	5.70	1.00	52.00	77.00	6.00
6.016	GT106.4557.030.12.60.R	6.00	0.30	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.017	GT106.4557.030.17.60.R	6.00	0.30	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.018	GT106.4557.030.22.60.R	6.00	0.30	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.007	GT106.4557.030.27.60.R	6.00	0.30	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.008	GT106.4557.030.32.60.R	6.00	0.30	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.009	GT106.4557.030.37.60.R	6.00	0.30	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.010	GT106.4557.030.42.60.R	6.00	0.30	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.011	GT106.4557.030.47.60.R	6.00	0.30	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.012	GT106.4557.030.52.60.R	6.00	0.30	45	45	2.70	5.70	1.00	52.00	77.00	6.00

Series no. **25741** **25743** **25747**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
<a href="#">6.019</a>	GT106.4557.010.12.60.L	6.00	0.10	45	45	2.70	5.70	1.00	12.00	37.00	6.00
<a href="#">6.020</a>	GT106.4557.010.17.60.L	6.00	0.10	45	45	2.70	5.70	1.00	17.00	42.00	6.00
<a href="#">6.021</a>	GT106.4557.010.22.60.L	6.00	0.10	45	45	2.70	5.70	1.00	22.00	47.00	6.00
<a href="#">6.022</a>	GT106.4557.010.27.60.L	6.00	0.10	45	45	2.70	5.70	1.00	27.00	52.00	6.00
<a href="#">6.023</a>	GT106.4557.010.32.60.L	6.00	0.10	45	45	2.70	5.70	1.00	32.00	57.00	6.00
<a href="#">6.024</a>	GT106.4557.010.37.60.L	6.00	0.10	45	45	2.70	5.70	1.00	37.00	62.00	6.00
<a href="#">6.025</a>	GT106.4557.010.42.60.L	6.00	0.10	45	45	2.70	5.70	1.00	42.00	67.00	6.00
<a href="#">6.026</a>	GT106.4557.010.47.60.L	6.00	0.10	45	45	2.70	5.70	1.00	47.00	72.00	6.00
<a href="#">6.027</a>	GT106.4557.010.52.60.L	6.00	0.10	45	45	2.70	5.70	1.00	52.00	77.00	6.00
<a href="#">6.013</a>	GT106.4557.015.12.60.L	6.00	0.15	45	45	2.70	5.70	1.00	12.00	37.00	6.00
<a href="#">6.014</a>	GT106.4557.015.17.60.L	6.00	0.15	45	45	2.70	5.70	1.00	17.00	42.00	6.00
<a href="#">6.015</a>	GT106.4557.015.22.60.L	6.00	0.15	45	45	2.70	5.70	1.00	22.00	47.00	6.00
<a href="#">6.001</a>	GT106.4557.015.27.60.L	6.00	0.15	45	45	2.70	5.70	1.00	27.00	52.00	6.00
<a href="#">6.002</a>	GT106.4557.015.32.60.L	6.00	0.15	45	45	2.70	5.70	1.00	32.00	57.00	6.00
<a href="#">6.003</a>	GT106.4557.015.37.60.L	6.00	0.15	45	45	2.70	5.70	1.00	37.00	62.00	6.00
<a href="#">6.004</a>	GT106.4557.015.42.60.L	6.00	0.15	45	45	2.70	5.70	1.00	42.00	67.00	6.00
<a href="#">6.005</a>	GT106.4557.015.47.60.L	6.00	0.15	45	45	2.70	5.70	1.00	47.00	72.00	6.00
<a href="#">6.006</a>	GT106.4557.015.52.60.L	6.00	0.15	45	45	2.70	5.70	1.00	52.00	77.00	6.00
<a href="#">6.028</a>	GT106.4557.020.12.60.L	6.00	0.20	45	45	2.70	5.70	1.00	12.00	37.00	6.00
<a href="#">6.029</a>	GT106.4557.020.17.60.L	6.00	0.20	45	45	2.70	5.70	1.00	17.00	42.00	6.00
<a href="#">6.030</a>	GT106.4557.020.22.60.L	6.00	0.20	45	45	2.70	5.70	1.00	22.00	47.00	6.00
<a href="#">6.031</a>	GT106.4557.020.27.60.L	6.00	0.20	45	45	2.70	5.70	1.00	27.00	52.00	6.00
<a href="#">6.032</a>	GT106.4557.020.32.60.L	6.00	0.20	45	45	2.70	5.70	1.00	32.00	57.00	6.00
<a href="#">6.033</a>	GT106.4557.020.37.60.L	6.00	0.20	45	45	2.70	5.70	1.00	37.00	62.00	6.00
<a href="#">6.034</a>	GT106.4557.020.42.60.L	6.00	0.20	45	45	2.70	5.70	1.00	42.00	67.00	6.00
<a href="#">6.035</a>	GT106.4557.020.47.60.L	6.00	0.20	45	45	2.70	5.70	1.00	47.00	72.00	6.00
<a href="#">6.036</a>	GT106.4557.020.52.60.L	6.00	0.20	45	45	2.70	5.70	1.00	52.00	77.00	6.00
<a href="#">6.016</a>	GT106.4557.030.12.60.L	6.00	0.30	45	45	2.70	5.70	1.00	12.00	37.00	6.00
<a href="#">6.017</a>	GT106.4557.030.17.60.L	6.00	0.30	45	45	2.70	5.70	1.00	17.00	42.00	6.00
<a href="#">6.018</a>	GT106.4557.030.22.60.L	6.00	0.30	45	45	2.70	5.70	1.00	22.00	47.00	6.00
<a href="#">6.007</a>	GT106.4557.030.27.60.L	6.00	0.30	45	45	2.70	5.70	1.00	27.00	52.00	6.00
<a href="#">6.008</a>	GT106.4557.030.32.60.L	6.00	0.30	45	45	2.70	5.70	1.00	32.00	57.00	6.00
<a href="#">6.009</a>	GT106.4557.030.37.60.L	6.00	0.30	45	45	2.70	5.70	1.00	37.00	62.00	6.00
<a href="#">6.010</a>	GT106.4557.030.42.60.L	6.00	0.30	45	45	2.70	5.70	1.00	42.00	67.00	6.00
<a href="#">6.011</a>	GT106.4557.030.47.60.L	6.00	0.30	45	45	2.70	5.70	1.00	47.00	72.00	6.00
<a href="#">6.012</a>	GT106.4557.030.52.60.L	6.00	0.30	45	45	2.70	5.70	1.00	52.00	77.00	6.00



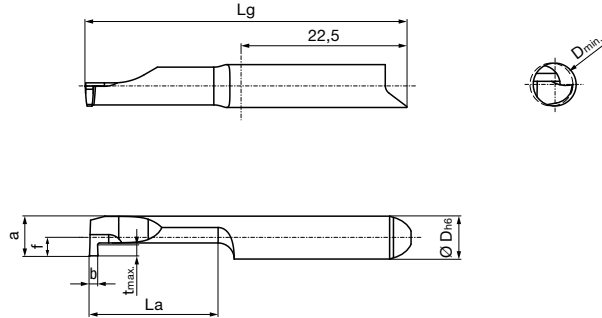
**Cutting insert for internal grooving, straight slots**



• grooving depth up to 2 mm

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GE 106	GE 106	GE 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	nano-A	bright



Series no.	<b>25748</b>	<b>25750</b>	<b>25754</b>
Cutting direction	<b>R</b>	<b>R</b>	<b>R</b>

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GE106.0100.000.12.60.R	6.00	1.00	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.002</a>	GE106.0100.000.17.60.R	6.00	1.00	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.003</a>	GE106.0100.000.22.60.R	6.00	1.00	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.004</a>	GE106.0100.000.27.60.R	6.00	1.00	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.005</a>	GE106.0100.000.32.60.R	6.00	1.00	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.006</a>	GE106.0100.000.37.60.R	6.00	1.00	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.007</a>	GE106.0100.000.42.60.R	6.00	1.00	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.008</a>	GE106.0150.000.12.60.R	6.00	1.50	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.009</a>	GE106.0150.000.17.60.R	6.00	1.50	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.010</a>	GE106.0150.000.22.60.R	6.00	1.50	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.011</a>	GE106.0150.000.27.60.R	6.00	1.50	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.012</a>	GE106.0150.000.32.60.R	6.00	1.50	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.013</a>	GE106.0150.000.37.60.R	6.00	1.50	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.014</a>	GE106.0150.000.42.60.R	6.00	1.50	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.015</a>	GE106.0200.000.12.60.R	6.00	2.00	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.016</a>	GE106.0200.000.17.60.R	6.00	2.00	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.017</a>	GE106.0200.000.22.60.R	6.00	2.00	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.018</a>	GE106.0200.000.27.60.R	6.00	2.00	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.019</a>	GE106.0200.000.32.60.R	6.00	2.00	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.020</a>	GE106.0200.000.37.60.R	6.00	2.00	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.021</a>	GE106.0200.000.42.60.R	6.00	2.00	2.70	5.70	2.00	42.00	67.00	6.00

Series no.	<b>25749</b>	<b>25751</b>	<b>25755</b>
Cutting direction	<b>L</b>	<b>L</b>	<b>L</b>

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GE106.0100.000.12.60.L	6.00	1.00	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.002</a>	GE106.0100.000.17.60.L	6.00	1.00	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.003</a>	GE106.0100.000.22.60.L	6.00	1.00	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.004</a>	GE106.0100.000.27.60.L	6.00	1.00	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.005</a>	GE106.0100.000.32.60.L	6.00	1.00	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.006</a>	GE106.0100.000.37.60.L	6.00	1.00	2.70	5.70	2.00	37.00	62.00	6.00

System 106



Series no. **25749** **25751** **25755**

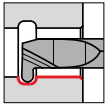
Cutting direction   

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.007</a>	GE106.0100.000.42.60.L	6.00	1.00	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.008</a>	GE106.0150.000.12.60.L	6.00	1.50	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.009</a>	GE106.0150.000.17.60.L	6.00	1.50	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.010</a>	GE106.0150.000.22.60.L	6.00	1.50	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.011</a>	GE106.0150.000.27.60.L	6.00	1.50	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.012</a>	GE106.0150.000.32.60.L	6.00	1.50	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.013</a>	GE106.0150.000.37.60.L	6.00	1.50	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.014</a>	GE106.0150.000.42.60.L	6.00	1.50	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.015</a>	GE106.0200.000.12.60.L	6.00	2.00	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.016</a>	GE106.0200.000.17.60.L	6.00	2.00	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.017</a>	GE106.0200.000.22.60.L	6.00	2.00	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.018</a>	GE106.0200.000.27.60.L	6.00	2.00	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.019</a>	GE106.0200.000.32.60.L	6.00	2.00	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.020</a>	GE106.0200.000.37.60.L	6.00	2.00	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.021</a>	GE106.0200.000.42.60.L	6.00	2.00	2.70	5.70	2.00	42.00	67.00	6.00

System 106



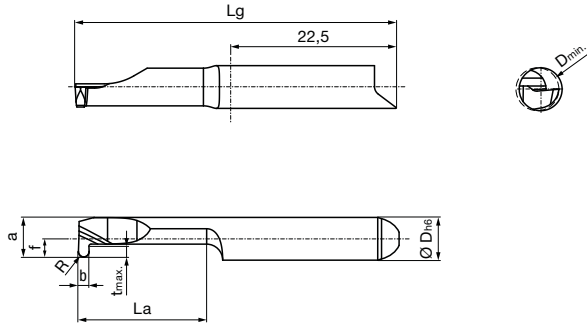
Cutting insert for internal grooving, full radius slots



• full radius R0.5-R1.0

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GE 106	GE 106	GE 106
Surface			
	TiN	nano-A	bright



Series no.	<b>25756</b>	<b>25758</b>	<b>25762</b>
Cutting direction			

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GE106.0100.050.12.60.R	6.00	1.00	0.50	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.002</a>	GE106.0100.050.17.60.R	6.00	1.00	0.50	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.003</a>	GE106.0100.050.22.60.R	6.00	1.00	0.50	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.004</a>	GE106.0100.050.27.60.R	6.00	1.00	0.50	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.005</a>	GE106.0100.050.32.60.R	6.00	1.00	0.50	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.006</a>	GE106.0100.050.37.60.R	6.00	1.00	0.50	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.007</a>	GE106.0100.050.42.60.R	6.00	1.00	0.50	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.008</a>	GE106.0150.075.12.60.R	6.00	1.50	0.75	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.009</a>	GE106.0150.075.17.60.R	6.00	1.50	0.75	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.010</a>	GE106.0150.075.22.60.R	6.00	1.50	0.75	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.011</a>	GE106.0150.075.27.60.R	6.00	1.50	0.75	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.012</a>	GE106.0150.075.32.60.R	6.00	1.50	0.75	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.013</a>	GE106.0150.075.37.60.R	6.00	1.50	0.75	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.014</a>	GE106.0150.075.42.60.R	6.00	1.50	0.75	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.015</a>	GE106.0200.100.12.60.R	6.00	2.00	1.00	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.016</a>	GE106.0200.100.17.60.R	6.00	2.00	1.00	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.017</a>	GE106.0200.100.22.60.R	6.00	2.00	1.00	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.018</a>	GE106.0200.100.27.60.R	6.00	2.00	1.00	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.019</a>	GE106.0200.100.32.60.R	6.00	2.00	1.00	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.020</a>	GE106.0200.100.37.60.R	6.00	2.00	1.00	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.021</a>	GE106.0200.100.42.60.R	6.00	2.00	1.00	2.70	5.70	2.00	42.00	67.00	6.00

Series no.	<b>25757</b>	<b>25759</b>	<b>25763</b>
Cutting direction			

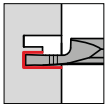
Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GE106.0100.050.12.60.L	6.00	1.00	0.50	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.002</a>	GE106.0100.050.17.60.L	6.00	1.00	0.50	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.003</a>	GE106.0100.050.22.60.L	6.00	1.00	0.50	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.004</a>	GE106.0100.050.27.60.L	6.00	1.00	0.50	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.005</a>	GE106.0100.050.32.60.L	6.00	1.00	0.50	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.006</a>	GE106.0100.050.37.60.L	6.00	1.00	0.50	2.70	5.70	2.00	37.00	62.00	6.00

Series no. **25757** **25759** **25763**Cutting direction   

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.007</a>	GE106.0100.050.42.60.L	6.00	1.00	0.50	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.008</a>	GE106.0150.075.12.60.L	6.00	1.50	0.75	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.009</a>	GE106.0150.075.17.60.L	6.00	1.50	0.75	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.010</a>	GE106.0150.075.22.60.L	6.00	1.50	0.75	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.011</a>	GE106.0150.075.27.60.L	6.00	1.50	0.75	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.012</a>	GE106.0150.075.32.60.L	6.00	1.50	0.75	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.013</a>	GE106.0150.075.37.60.L	6.00	1.50	0.75	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.014</a>	GE106.0150.075.42.60.L	6.00	1.50	0.75	2.70	5.70	2.00	42.00	67.00	6.00
<a href="#">6.015</a>	GE106.0200.100.12.60.L	6.00	2.00	1.00	2.70	5.70	2.00	12.00	37.00	6.00
<a href="#">6.016</a>	GE106.0200.100.17.60.L	6.00	2.00	1.00	2.70	5.70	2.00	17.00	42.00	6.00
<a href="#">6.017</a>	GE106.0200.100.22.60.L	6.00	2.00	1.00	2.70	5.70	2.00	22.00	47.00	6.00
<a href="#">6.018</a>	GE106.0200.100.27.60.L	6.00	2.00	1.00	2.70	5.70	2.00	27.00	52.00	6.00
<a href="#">6.019</a>	GE106.0200.100.32.60.L	6.00	2.00	1.00	2.70	5.70	2.00	32.00	57.00	6.00
<a href="#">6.020</a>	GE106.0200.100.37.60.L	6.00	2.00	1.00	2.70	5.70	2.00	37.00	62.00	6.00
<a href="#">6.021</a>	GE106.0200.100.42.60.L	6.00	2.00	1.00	2.70	5.70	2.00	42.00	67.00	6.00



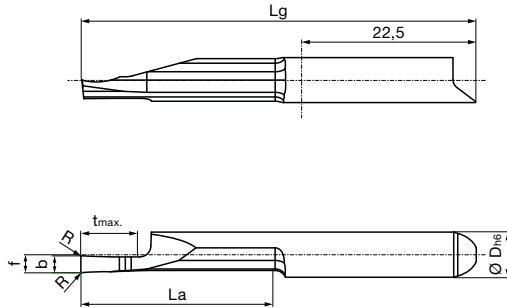
Cutting insert for axial grooving bores, straight slots



- grooving depth up to 8 mm

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GA 106	GA 106	GA 106
Surface	Ⓢ	ⓐ	Ⓞ
	TiN	nano-A	bright

Series no.	25780	25782	25786
Cutting direction	Ⓡ	Ⓡ	Ⓡ

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GA106.0150.010.17.60.R	6.00	1.50	0.10	2.60	5.00	17.00	42.00	6.00
<a href="#">6.002</a>	GA106.0150.010.22.60.R	6.00	1.50	0.10	2.60	5.00	22.00	47.00	6.00
<a href="#">6.003</a>	GA106.0200.015.17.60.R	6.00	2.00	0.15	2.60	8.00	17.00	42.00	6.00
<a href="#">6.004</a>	GA106.0200.015.22.60.R	6.00	2.00	0.15	2.60	8.00	22.00	47.00	6.00

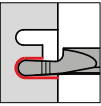
Series no.	25781	25783	25787
Cutting direction	Ⓛ	Ⓛ	Ⓛ

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GA106.0150.010.17.60.L	6.00	1.50	0.10	2.60	5.00	17.00	42.00	6.00
<a href="#">6.002</a>	GA106.0150.010.22.60.L	6.00	1.50	0.10	2.60	5.00	22.00	47.00	6.00
<a href="#">6.003</a>	GA106.0200.015.17.60.L	6.00	2.00	0.15	2.60	8.00	17.00	42.00	6.00
<a href="#">6.004</a>	GA106.0200.015.22.60.L	6.00	2.00	0.15	2.60	8.00	22.00	47.00	6.00

System 106



**Cutting insert for axial grooving bores, full radius slots**

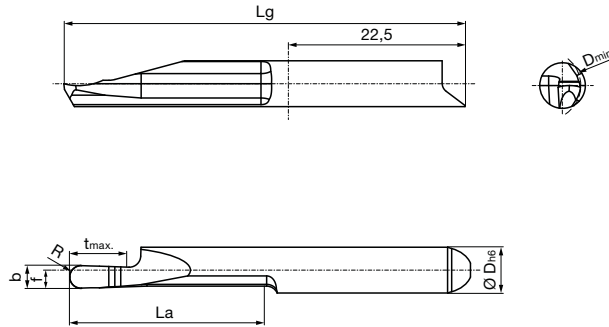


- grooving depth up to 8 mm

for tool holders type GB106 see from page 62

Tool material	Solid carbide		
Type	GA 106	GA 106	GA 106
Surface			
	TiN	nano-A	bright

Cutting data page 148



Right hand version shown  
Left hand version mirror image



Series no.	25788	25790	25794
Cutting direction			

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GA106.0150.075.17.60.R	6.00	1.50	0.75	2.60	5.00	17.00	42.00	6.00
<a href="#">6.002</a>	GA106.0150.075.22.60.R	6.00	1.50	0.75	2.60	5.00	22.00	47.00	6.00
<a href="#">6.003</a>	GA106.0200.100.17.60.R	6.00	2.00	1.00	2.60	8.00	17.00	42.00	6.00
<a href="#">6.004</a>	GA106.0200.100.22.60.R	6.00	2.00	1.00	2.60	8.00	22.00	47.00	6.00

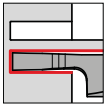
Series no.	25789	25791	25795
Cutting direction			

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GA106.0150.075.17.60.L	6.00	1.50	0.75	2.60	5.00	17.00	42.00	6.00
<a href="#">6.002</a>	GA106.0150.075.22.60.L	6.00	1.50	0.75	2.60	5.00	22.00	47.00	6.00
<a href="#">6.003</a>	GA106.0200.100.17.60.L	6.00	2.00	1.00	2.60	8.00	17.00	42.00	6.00
<a href="#">6.004</a>	GA106.0200.100.22.60.L	6.00	2.00	1.00	2.60	8.00	22.00	47.00	6.00





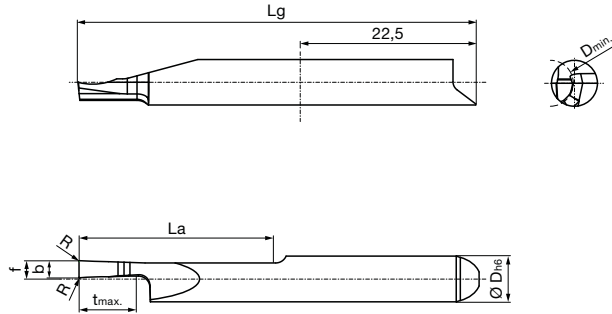
Cutting insert for axial grooving studs, straight slots



- grooving depth up to 8 mm

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GA 106	GA 106	GA 106
Surface	S	a	○
	TiN	nano-A	bright



Series no.	<b>25796</b>	<b>25798</b>	<b>25802</b>
Cutting direction			

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GA106.Z150.010.17.60.R	6.00	1.50	0.10	2.60	5.00	17.00	42.00	6.00
<a href="#">6.002</a>	GA106.Z150.010.22.60.R	6.00	1.50	0.10	2.60	5.00	22.00	47.00	6.00
<a href="#">6.003</a>	GA106.Z200.015.17.60.R	6.00	2.00	0.15	2.60	8.00	17.00	42.00	6.00
<a href="#">6.004</a>	GA106.Z200.015.22.60.R	6.00	2.00	0.15	2.60	8.00	22.00	47.00	6.00

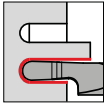
Series no.	<b>25797</b>	<b>25799</b>	<b>25803</b>
Cutting direction			

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GA106.Z150.010.17.60.L	6.00	1.50	0.10	2.60	5.00	17.00	42.00	6.00
<a href="#">6.002</a>	GA106.Z150.010.22.60.L	6.00	1.50	0.10	2.60	5.00	22.00	47.00	6.00
<a href="#">6.003</a>	GA106.Z200.015.17.60.L	6.00	2.00	0.15	2.60	8.00	17.00	42.00	6.00
<a href="#">6.004</a>	GA106.Z200.015.22.60.L	6.00	2.00	0.15	2.60	8.00	22.00	47.00	6.00

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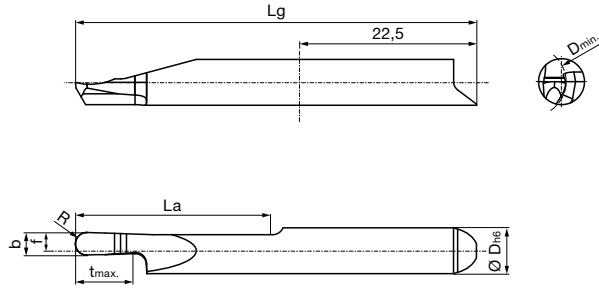
**Cutting insert for axial grooving studs, full radius slots**



• grooving depth up to 8 mm

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GA 106	GA 106	GA 106
Surface			
	TiN	nano-A	bright



Series no.	25804	25806	25810
Cutting direction			

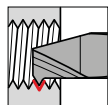
Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GA106.Z150.075.17.60.R	6.00	1.50	0.75	2.60	5.00	17.00	42.00	6.00
<a href="#">6.002</a>	GA106.Z150.075.22.60.R	6.00	1.50	0.75	2.60	5.00	22.00	47.00	6.00
<a href="#">6.003</a>	GA106.Z200.100.17.60.R	6.00	2.00	1.00	2.60	8.00	17.00	42.00	6.00
<a href="#">6.004</a>	GA106.Z200.100.22.60.R	6.00	2.00	1.00	2.60	8.00	22.00	47.00	6.00

Series no.	25805	25807	25811
Cutting direction			

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GA106.Z150.075.17.60.L	6.00	1.50	0.75	2.60	5.00	17.00	42.00	6.00
<a href="#">6.002</a>	GA106.Z150.075.22.60.L	6.00	1.50	0.75	2.60	5.00	22.00	47.00	6.00
<a href="#">6.003</a>	GA106.Z200.100.17.60.L	6.00	2.00	1.00	2.60	8.00	17.00	42.00	6.00
<a href="#">6.004</a>	GA106.Z200.100.22.60.L	6.00	2.00	1.00	2.60	8.00	22.00	47.00	6.00



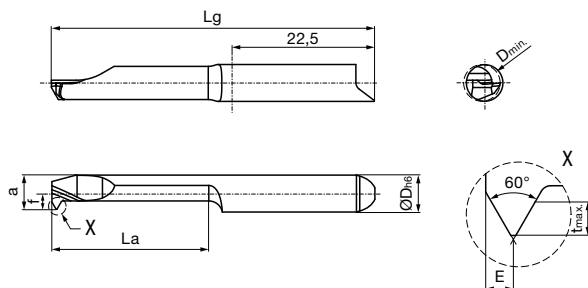
Cutting insert for internal threading, partial profile - metric standard threads



• pitch P = 1.25-1.75

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GG 106	GG 106	GG 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	nano-A	bright



Series no.	<b>25764</b>	<b>25766</b>	<b>25770</b>
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>




Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.TM08.125.12.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	12.00	37.00	6.00
6.001	GG106.TM08.125.17.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	17.00	42.00	6.00
6.002	GG106.TM08.125.22.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	22.00	47.00	6.00
6.003	GG106.TM08.125.27.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	27.00	52.00	6.00
6.011	GG106.TM08.125.32.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	32.00	57.00	6.00
6.012	GG106.TM08.125.37.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	37.00	62.00	6.00
6.013	GG106.TM08.125.42.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	42.00	67.00	6.00
6.014	GG106.TM10.150.12.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	12.00	37.00	6.00
6.004	GG106.TM10.150.17.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	17.00	42.00	6.00
6.005	GG106.TM10.150.22.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	22.00	47.00	6.00
6.006	GG106.TM10.150.27.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	27.00	52.00	6.00
6.015	GG106.TM10.150.32.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	32.00	57.00	6.00
6.016	GG106.TM10.150.37.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	37.00	62.00	6.00
6.017	GG106.TM10.150.42.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	42.00	67.00	6.00
6.018	GG106.TM12.175.12.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	12.00	37.00	6.00
6.007	GG106.TM12.175.17.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	17.00	42.00	6.00
6.008	GG106.TM12.175.22.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	22.00	47.00	6.00
6.009	GG106.TM12.175.27.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	27.00	52.00	6.00
6.019	GG106.TM12.175.32.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	32.00	57.00	6.00
6.020	GG106.TM12.175.37.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	37.00	62.00	6.00
6.021	GG106.TM12.175.42.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	42.00	67.00	6.00

Series no.	<b>25765</b>	<b>25767</b>	<b>25771</b>
Cutting direction	<b>(L)</b>	<b>(L)</b>	<b>(L)</b>

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.TM08.125.12.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	12.00	37.00	6.00
6.001	GG106.TM08.125.17.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	17.00	42.00	6.00
6.002	GG106.TM08.125.22.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	22.00	47.00	6.00
6.003	GG106.TM08.125.27.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	27.00	52.00	6.00
6.011	GG106.TM08.125.32.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	32.00	57.00	6.00
6.012	GG106.TM08.125.37.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	37.00	62.00	6.00



Series no. **25765** **25767** **25771**

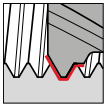
Cutting direction   

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.013</a>	GG106.TM08.125.42.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	42.00	67.00	6.00
<a href="#">6.014</a>	GG106.TM10.150.12.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	12.00	37.00	6.00
<a href="#">6.004</a>	GG106.TM10.150.17.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	17.00	42.00	6.00
<a href="#">6.005</a>	GG106.TM10.150.22.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	22.00	47.00	6.00
<a href="#">6.006</a>	GG106.TM10.150.27.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	27.00	52.00	6.00
<a href="#">6.015</a>	GG106.TM10.150.32.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	32.00	57.00	6.00
<a href="#">6.016</a>	GG106.TM10.150.37.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	37.00	62.00	6.00
<a href="#">6.017</a>	GG106.TM10.150.42.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	42.00	67.00	6.00
<a href="#">6.018</a>	GG106.TM12.175.12.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	12.00	37.00	6.00
<a href="#">6.007</a>	GG106.TM12.175.17.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	17.00	42.00	6.00
<a href="#">6.008</a>	GG106.TM12.175.22.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	22.00	47.00	6.00
<a href="#">6.009</a>	GG106.TM12.175.27.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	27.00	52.00	6.00
<a href="#">6.019</a>	GG106.TM12.175.32.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	32.00	57.00	6.00
<a href="#">6.020</a>	GG106.TM12.175.37.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	37.00	62.00	6.00
<a href="#">6.021</a>	GG106.TM12.175.42.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	42.00	67.00	6.00

System 106



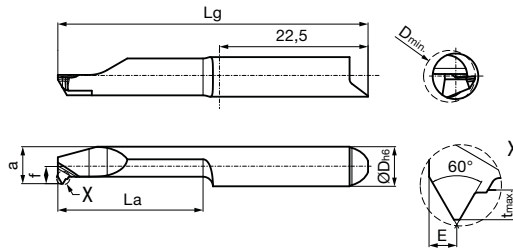
Cutting insert for internal threading, full profile - metric standard threads



• pitch P = 1-1.75

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GG 106	GG 106	GG 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	nano-A	bright

Series no.	<b>25772</b>	<b>25774</b>	<b>25778</b>
Cutting direction	<b>R</b>	<b>R</b>	<b>R</b>

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GG106.VM06.100.12.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	12.00	37.00	6.00
<a href="#">6.020</a>	GG106.VM06.100.17.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	17.00	42.00	6.00
<a href="#">6.030</a>	GG106.VM06.100.22.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	22.00	47.00	6.00
<a href="#">6.040</a>	GG106.VM06.100.27.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	27.00	52.00	6.00
<a href="#">6.050</a>	GG106.VM06.100.32.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	32.00	57.00	6.00
<a href="#">6.060</a>	GG106.VM06.100.37.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	37.00	62.00	6.00
<a href="#">6.070</a>	GG106.VM06.100.42.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	42.00	67.00	6.00
<a href="#">6.110</a>	GG106.VM08.125.12.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	12.00	37.00	6.00
<a href="#">6.120</a>	GG106.VM08.125.17.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	17.00	42.00	6.00
<a href="#">6.130</a>	GG106.VM08.125.22.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	22.00	47.00	6.00
<a href="#">6.140</a>	GG106.VM08.125.27.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	27.00	52.00	6.00
<a href="#">6.150</a>	GG106.VM08.125.32.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	32.00	57.00	6.00
<a href="#">6.160</a>	GG106.VM08.125.37.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	37.00	62.00	6.00
<a href="#">6.170</a>	GG106.VM08.125.42.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	42.00	67.00	6.00
<a href="#">6.210</a>	GG106.VM10.150.12.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	12.00	37.00	6.00
<a href="#">6.220</a>	GG106.VM10.150.17.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	17.00	42.00	6.00
<a href="#">6.230</a>	GG106.VM10.150.22.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	22.00	47.00	6.00
<a href="#">6.240</a>	GG106.VM10.150.27.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	27.00	52.00	6.00
<a href="#">6.250</a>	GG106.VM10.150.32.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	32.00	57.00	6.00
<a href="#">6.260</a>	GG106.VM10.150.37.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	37.00	62.00	6.00
<a href="#">6.270</a>	GG106.VM10.150.42.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	42.00	67.00	6.00
<a href="#">6.310</a>	GG106.VM12.175.12.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	12.00	37.00	6.00
<a href="#">6.320</a>	GG106.VM12.175.17.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	17.00	42.00	6.00
<a href="#">6.330</a>	GG106.VM12.175.22.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	22.00	47.00	6.00
<a href="#">6.340</a>	GG106.VM12.175.27.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	27.00	52.00	6.00
<a href="#">6.350</a>	GG106.VM12.175.32.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	32.00	57.00	6.00
<a href="#">6.360</a>	GG106.VM12.175.37.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	37.00	62.00	6.00
<a href="#">6.370</a>	GG106.VM12.175.42.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	42.00	67.00	6.00

System 106



Series no. **25773** **25775** **25779**

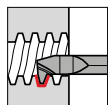
Cutting direction   

System 106

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GG106.VM06.100.12.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	12.00	37.00	6.00
<a href="#">6.020</a>	GG106.VM06.100.17.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	17.00	42.00	6.00
<a href="#">6.030</a>	GG106.VM06.100.22.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	22.00	47.00	6.00
<a href="#">6.040</a>	GG106.VM06.100.27.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	27.00	52.00	6.00
<a href="#">6.050</a>	GG106.VM06.100.32.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	32.00	57.00	6.00
<a href="#">6.060</a>	GG106.VM06.100.37.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	37.00	62.00	6.00
<a href="#">6.070</a>	GG106.VM06.100.42.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	42.00	67.00	6.00
<a href="#">6.110</a>	GG106.VM08.125.12.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	12.00	37.00	6.00
<a href="#">6.120</a>	GG106.VM08.125.17.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	17.00	42.00	6.00
<a href="#">6.130</a>	GG106.VM08.125.22.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	22.00	47.00	6.00
<a href="#">6.140</a>	GG106.VM08.125.27.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	27.00	52.00	6.00
<a href="#">6.150</a>	GG106.VM08.125.32.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	32.00	57.00	6.00
<a href="#">6.160</a>	GG106.VM08.125.37.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	37.00	62.00	6.00
<a href="#">6.170</a>	GG106.VM08.125.42.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	42.00	67.00	6.00
<a href="#">6.210</a>	GG106.VM10.150.12.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	12.00	37.00	6.00
<a href="#">6.220</a>	GG106.VM10.150.17.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	17.00	42.00	6.00
<a href="#">6.230</a>	GG106.VM10.150.22.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	22.00	47.00	6.00
<a href="#">6.240</a>	GG106.VM10.150.27.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	27.00	52.00	6.00
<a href="#">6.250</a>	GG106.VM10.150.32.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	32.00	57.00	6.00
<a href="#">6.260</a>	GG106.VM10.150.37.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	37.00	62.00	6.00
<a href="#">6.270</a>	GG106.VM10.150.42.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	42.00	67.00	6.00
<a href="#">6.310</a>	GG106.VM12.175.12.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	12.00	37.00	6.00
<a href="#">6.320</a>	GG106.VM12.175.17.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	17.00	42.00	6.00
<a href="#">6.330</a>	GG106.VM12.175.22.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	22.00	47.00	6.00
<a href="#">6.340</a>	GG106.VM12.175.27.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	27.00	52.00	6.00
<a href="#">6.350</a>	GG106.VM12.175.32.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	32.00	57.00	6.00
<a href="#">6.360</a>	GG106.VM12.175.37.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	37.00	62.00	6.00
<a href="#">6.370</a>	GG106.VM12.175.42.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	42.00	67.00	6.00



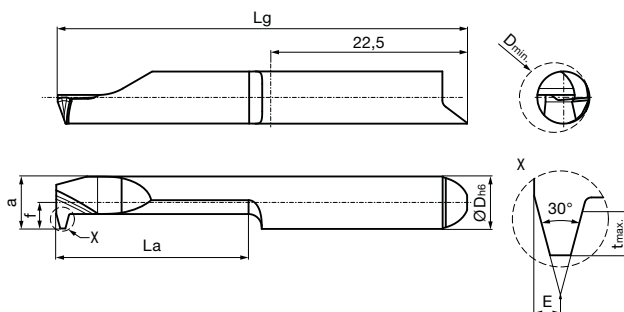
Cutting insert for internal threading, partial profile - trapezoidal thread



• pitch P = 1.5-3.0

for tool holders type GB106 see from page 62

Cutting data page 148



Right hand version shown  
Left hand version mirror image



Series no.	<b>25824</b>	<b>25826</b>	<b>25830</b>
Cutting direction			

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GG106.TT08.150.22.65.R	Tr8	1.50	6.50	2.95	0.60	5.95	0.90	22.00	47.00	6.00
<a href="#">6.002</a>	GG106.TT08.200.22.60.R	Tr8	2.00	6.00	2.70	0.75	5.70	1.25	22.00	47.00	6.00
<a href="#">6.003</a>	GG106.TT10.200.22.80.R	Tr10	2.00	8.00	2.95	0.75	5.95	1.25	22.00	47.00	6.00
<a href="#">6.005</a>	GG106.TT10.300.22.70.R	Tr10	3.00	7.00	2.95	1.10	5.95	1.75	22.00	47.00	6.00
<a href="#">6.004</a>	GG106.TT10.200.32.80.R	Tr10	2.00	8.00	2.95	0.75	5.95	1.25	32.00	57.00	6.00
<a href="#">6.006</a>	GG106.TT10.300.32.70.R	Tr10	3.00	7.00	2.95	1.10	5.95	1.75	32.00	57.00	6.00

Series no.	<b>25825</b>	<b>25827</b>	<b>25831</b>
Cutting direction			

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GG106.TT08.150.22.65.L	Tr8	1.50	6.50	2.95	0.60	5.95	0.90	22.00	47.00	6.00
<a href="#">6.002</a>	GG106.TT08.200.22.60.L	Tr8	2.00	6.00	2.70	0.75	5.70	1.25	22.00	47.00	6.00
<a href="#">6.003</a>	GG106.TT10.200.22.80.L	Tr10	2.00	8.00	2.95	0.75	5.95	1.25	22.00	47.00	6.00
<a href="#">6.005</a>	GG106.TT10.300.22.70.L	Tr10	3.00	7.00	2.95	1.10	5.95	1.75	22.00	47.00	6.00
<a href="#">6.004</a>	GG106.TT10.200.32.80.L	Tr10	2.00	8.00	2.95	0.75	5.95	1.25	32.00	57.00	6.00
<a href="#">6.006</a>	GG106.TT10.300.32.70.L	Tr10	3.00	7.00	2.95	1.10	5.95	1.75	32.00	57.00	6.00

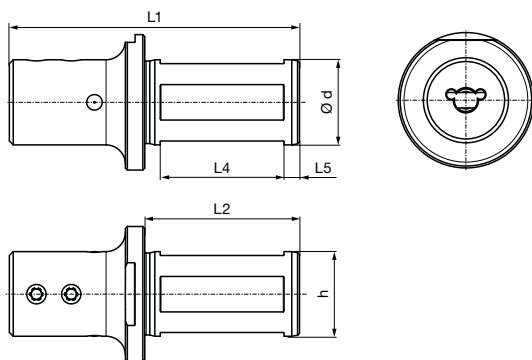


**Round shank holder, 4 clamping surfaces**

- for inserts type 106
- with internal coolant delivery

Type GB 106

System 106



Series no. **25302**

Code no.	Description	d	d	h	L1	L2	L4	L5
		mm	inch	mm	mm	mm	mm	mm
<a href="#">6.010</a>	GB106.0750.300.00.22.S.IK		3/4	17.05	76.20	40.00	32.00	4.00
<a href="#">6.001</a>	GB106.0020.075.00.22.S.IK	20.00		18.00	75.00	40.00	32.00	4.00
<a href="#">6.002</a>	GB106.0022.075.00.22.S.IK	22.00		20.00	75.00	40.00	32.00	4.00
<a href="#">6.003</a>	GB106.0025.075.00.22.S.IK	25.00		23.00	75.00	40.00	32.00	4.00
<a href="#">6.011</a>	GB106.1000.300.00.22.S.IK		1"	23.40	76.20	40.00	32.00	4.00

**Spare parts**

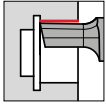
Series no.	Clamping screw	Tightening torque
25900		Nm
Code <a href="#">6.000</a>	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle





**Cutting insert for broaching longitudinal slots**

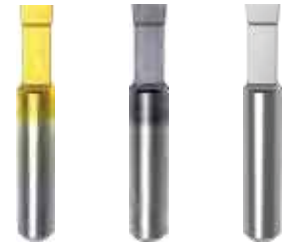
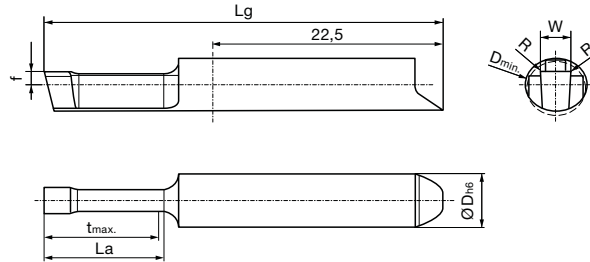


• tolerance class C11, P9, JS9

for tool holders type GB106 Series No. 25302 see page 118

Tool material	Solid carbide		
Type	GN 106	GN 106	GN 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	nano-A	bright

Cutting data page 148



Series no. **25812** **25813** **25815**

Code no.	Description	for slot width	D min	W	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GN106.0198.010.12.06.N	2 P9	6.00	1.98	0.10	1.50	11.50	12.00	37.00	6.00
<a href="#">6.002</a>	GN106.0298.010.12.06.N	3 P9	6.00	2.98	0.10	1.50	11.50	12.00	37.00	6.00
<a href="#">6.003</a>	GN106.0398.010.12.06.N	4 P9	6.00	3.98	0.10	1.50	11.50	12.00	37.00	6.00
<a href="#">6.004</a>	GN106.0498.020.12.07.N	5 P9	7.00	4.98	0.20	1.50	11.50	12.00	37.00	6.00

Series no. **25816** **25817** **25819**

Code no.	Description	for slot width	D min	W	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GN106.0200.010.12.06.N	2 JS9	6.00	2.00	0.10	1.50	11.50	12.00	37.00	6.00
<a href="#">6.002</a>	GN106.0300.010.12.06.N	3 JS9	6.00	3.00	0.10	1.50	11.50	12.00	37.00	6.00
<a href="#">6.003</a>	GN106.0400.010.12.06.N	4 JS9	6.00	4.00	0.10	1.50	11.50	12.00	37.00	6.00
<a href="#">6.004</a>	GN106.0500.020.12.07.N	5 JS9	7.00	5.00	0.20	1.50	11.50	12.00	37.00	6.00

Series no. **25820** **25821** **25823**

Code no.	Description	for slot width	D min	W	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm
<a href="#">6.001</a>	GN106.0211.035.12.06.N	2 C11	6.00	2.11	0.35	1.50	11.50	12.00	37.00	6.00
<a href="#">6.002</a>	GN106.0311.035.12.06.N	3 C11	6.00	3.11	0.35	1.50	11.50	12.00	37.00	6.00
<a href="#">6.003</a>	GN106.0413.050.12.06.N	4 C11	6.00	4.13	0.50	1.50	11.50	12.00	37.00	6.00
<a href="#">6.004</a>	GN106.0513.050.12.07.N	5 C11	7.00	5.13	0.50	1.50	11.50	12.00	37.00	6.00

# 305





# SYSTEM 305

## GROOVING AND PARTING OFF



Square shank holder straight  
with and without IC  
from page 122



Square shank holder, 90°  
offset with and without IC  
from page 127



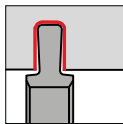
Square shank holder, 45°  
offset with and without IC  
from page 131



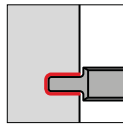
Round shank holder  
with and without IC  
from page 133

Tool holder

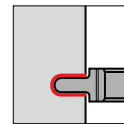
System 305



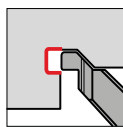
Radial grooving  
straight slots  
from page 137



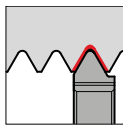
Axial grooving,  
straight slots  
page 140



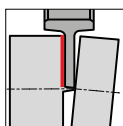
Axial grooving,  
full radius slots  
page 141



Grooving axial recesses  
page 142



External thread turning  
from page 143



Parting off  
from page 145

Indexable inserts

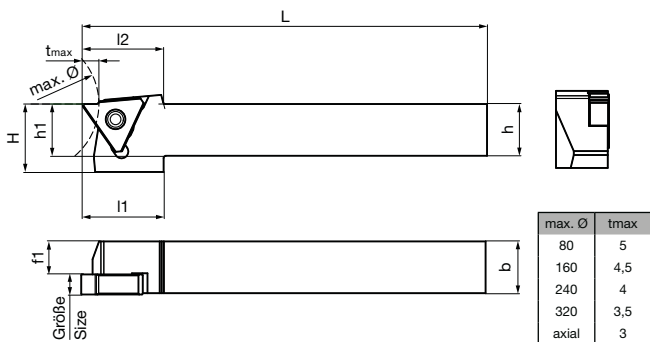


**Square shank holder straight, external machining, without IC**

- grooving depth up to 5 mm
- without internal coolant delivery

Type GH 305

for indexable inserts type 305 see from page 137



Right hand version shown  
Left hand version mirror image

Series no. **25350**

version right-hand

Code no.	Description	t max	h=b	h=b	L	h1	H	l1	l2	f1	Size
		mm	mm	inch	mm	mm	mm	mm	mm	mm	
<a href="#">12.013</a>	GH305.1010.125.00.04.R	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	04
<a href="#">12.014</a>	GH305.1212.125.00.04.R	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	04
<a href="#">12.021</a>	GH305.0625.500.00.04.R	5.00		5/8	127.00	15.87	20.87	25.40	25.40	12.07	04
<a href="#">12.001</a>	GH305.1616.125.00.04.R	5.00	16.00		125.00	16.00	21.00	25.00	25.00	12.20	04
<a href="#">12.022</a>	GH305.0750.500.00.04.R	5.00		3/4	127.00	19.05	24.05	25.40	25.40	15.25	04
<a href="#">12.002</a>	GH305.2020.125.00.04.R	5.00	20.00		125.00	20.00	25.00	25.00	25.00	16.20	04
<a href="#">12.003</a>	GH305.2525.150.00.04.R	5.00	25.00		150.00	25.00	30.00	25.00	25.00	21.20	04
<a href="#">12.023</a>	GH305.1000.600.00.04.R	5.00		1"	152.40	25.40	30.40	25.40	25.40	21.60	04
<a href="#">12.015</a>	GH305.1010.125.00.06.R	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	06
<a href="#">12.016</a>	GH305.1212.125.00.06.R	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	06
<a href="#">12.024</a>	GH305.0625.500.00.06.R	5.00		5/8	127.00	15.87	20.87	25.40	25.40	10.07	06
<a href="#">12.004</a>	GH305.1616.125.00.06.R	5.00	16.00		125.00	16.00	21.00	25.00	25.00	10.20	06
<a href="#">12.025</a>	GH305.0750.500.00.06.R	5.00		3/4	127.00	19.05	24.05	25.40	25.40	13.25	06
<a href="#">12.005</a>	GH305.2020.125.00.06.R	5.00	20.00		125.00	20.00	25.00	25.00	25.00	14.20	06
<a href="#">12.006</a>	GH305.2525.150.00.06.R	5.00	25.00		150.00	25.00	30.00	25.00	25.00	19.20	06
<a href="#">12.026</a>	GH305.1000.600.00.06.R	5.00		1"	152.40	25.40	30.40	25.40	25.40	19.60	06
<a href="#">12.017</a>	GH305.1010.125.00.08.R	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	08
<a href="#">12.018</a>	GH305.1212.125.00.08.R	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	08
<a href="#">12.027</a>	GH305.0625.500.00.08.R	5.00		5/8	127.00	15.87	20.87	25.40	25.40	8.07	08
<a href="#">12.007</a>	GH305.1616.125.00.08.R	5.00	16.00		125.00	16.00	21.00	25.00	25.00	8.20	08
<a href="#">12.028</a>	GH305.0750.500.00.08.R	5.00		3/4	127.00	19.05	24.05	25.40	25.40	11.25	08
<a href="#">12.008</a>	GH305.2020.125.00.08.R	5.00	20.00		125.00	20.00	25.00	25.00	25.00	12.20	08
<a href="#">12.009</a>	GH305.2525.150.00.08.R	5.00	25.00		150.00	25.00	30.00	25.00	25.00	17.20	08
<a href="#">12.029</a>	GH305.1000.600.00.08.R	5.00		1"	152.40	25.40	30.40	25.40	25.40	17.60	08
<a href="#">12.019</a>	GH305.1010.125.00.12.R	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	12
<a href="#">12.020</a>	GH305.1212.125.00.12.R	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	12
<a href="#">12.030</a>	GH305.0625.500.00.12.R	5.00		5/8	127.00	15.87	20.87	24.40	25.40	8.27	12
<a href="#">12.010</a>	GH305.1616.125.00.12.R	5.00	16.00		125.00	16.00	21.00	24.00	25.00	8.60	12
<a href="#">12.031</a>	GH305.0750.500.00.12.R	5.00		3/4	127.00	19.05	24.05	25.40	25.40	7.25	12
<a href="#">12.011</a>	GH305.2020.125.00.12.R	5.00	20.00		125.00	20.00	25.00	25.00	25.00	8.20	12
<a href="#">12.012</a>	GH305.2525.150.00.12.R	5.00	25.00		150.00	25.00	30.00	25.00	25.00	13.20	12
<a href="#">12.032</a>	GH305.1000.600.00.12.R	5.00		1"	152.40	25.40	30.40	25.40	25.40	13.60	12

Series no. **25351**

version left-hand

Code no.	Description	t max	h=b	h=b	L	h1	H	l1	l2	f1	Size
		mm	mm	inch	mm	mm	mm	mm	mm	mm	
<a href="#">12.013</a>	GH305.1010.125.00.04.L	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	04
<a href="#">12.014</a>	GH305.1212.125.00.04.L	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	04
<a href="#">12.021</a>	GH305.0625.500.00.04.L	5.00		5/8	127.00	15.87	20.87	25.40	25.40	12.07	04
<a href="#">12.001</a>	GH305.1616.125.00.04.L	5.00	16.00		125.00	16.00	21.00	25.00	25.00	12.20	04
<a href="#">12.022</a>	GH305.0750.500.00.04.L	5.00		3/4	127.00	19.05	24.05	25.40	25.40	15.25	04
<a href="#">12.002</a>	GH305.2020.125.00.04.L	5.00	20.00		125.00	20.00	25.00	25.00	25.00	16.20	04
<a href="#">12.003</a>	GH305.2525.150.00.04.L	5.00	25.00		150.00	25.00	30.00	25.00	25.00	21.20	04
<a href="#">12.023</a>	GH305.1000.600.00.04.L	5.00		1"	152.40	25.40	30.40	25.40	25.40	21.60	04
<a href="#">12.015</a>	GH305.1010.125.00.06.L	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	06
<a href="#">12.016</a>	GH305.1212.125.00.06.L	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	06
<a href="#">12.024</a>	GH305.0625.500.00.06.L	5.00		5/8	127.00	15.87	20.87	25.40	25.40	10.07	06
<a href="#">12.004</a>	GH305.1616.125.00.06.L	5.00	16.00		125.00	16.00	21.00	25.00	25.00	10.20	06
<a href="#">12.025</a>	GH305.0750.500.00.06.L	5.00		3/4	127.00	19.05	24.05	25.40	25.40	13.25	06
<a href="#">12.005</a>	GH305.2020.125.00.06.L	5.00	20.00		125.00	20.00	25.00	25.00	25.00	14.20	06
<a href="#">12.006</a>	GH305.2525.150.00.06.L	5.00	25.00		150.00	25.00	30.00	25.00	25.00	19.20	06
<a href="#">12.026</a>	GH305.1000.600.00.06.L	5.00		1"	152.40	25.40	30.40	25.40	25.40	19.60	06
<a href="#">12.017</a>	GH305.1010.125.00.08.L	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	08
<a href="#">12.018</a>	GH305.1212.125.00.08.L	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	08
<a href="#">12.027</a>	GH305.0625.500.00.08.L	5.00		5/8	127.00	15.87	20.87	25.40	25.40	8.07	08
<a href="#">12.007</a>	GH305.1616.125.00.08.L	5.00	16.00		125.00	16.00	21.00	25.00	25.00	8.20	08
<a href="#">12.028</a>	GH305.0750.500.00.08.L	5.00		3/4	127.00	19.05	24.05	25.40	25.40	11.25	08
<a href="#">12.008</a>	GH305.2020.125.00.08.L	5.00	20.00		125.00	20.00	25.00	25.00	25.00	12.20	08
<a href="#">12.009</a>	GH305.2525.150.00.08.L	5.00	25.00		150.00	25.00	30.00	25.00	25.00	17.20	08
<a href="#">12.029</a>	GH305.1000.600.00.08.L	5.00		1"	152.40	25.40	30.40	25.40	25.40	17.60	08
<a href="#">12.019</a>	GH305.1010.125.00.12.L	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	12
<a href="#">12.020</a>	GH305.1212.125.00.12.L	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	12
<a href="#">12.030</a>	GH305.0625.500.00.12.L	5.00		5/8	127.00	15.87	20.87	24.40	25.40	8.27	12
<a href="#">12.010</a>	GH305.1616.125.00.12.L	5.00	16.00		125.00	16.00	21.00	24.00	25.00	8.60	12
<a href="#">12.031</a>	GH305.0750.500.00.12.L	5.00		3/4	127.00	19.05	24.05	25.40	25.40	7.25	12
<a href="#">12.011</a>	GH305.2020.125.00.12.L	5.00	20.00		125.00	20.00	25.00	25.00	25.00	8.20	12
<a href="#">12.012</a>	GH305.2525.150.00.12.L	5.00	25.00		150.00	25.00	30.00	25.00	25.00	13.20	12
<a href="#">12.032</a>	GH305.1000.600.00.12.L	5.00		1"	152.40	25.40	30.40	25.40	25.40	13.60	12

System 305

**Spare parts**

Series no.	Clamping screw	Tightening torque
25901		Nm
Code <a href="#">4.000</a>	M4x15x42x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

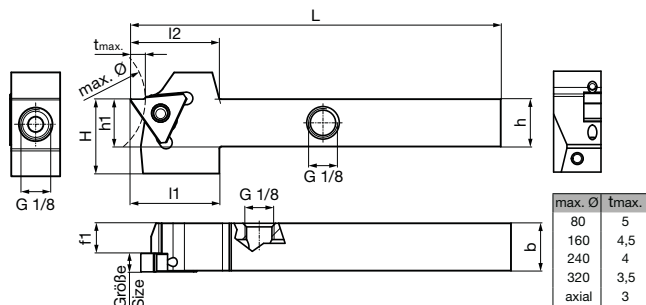


**Square shank holder straight, external machining, with IC**

- grooving depth up to 5 mm
- with internal coolant delivery from above and below

Type GH 305

for indexable inserts type 305 see from page 137



Right hand version shown  
Left hand version mirror image

Series no. **25352**

version right-hand

Code no.	Description	t max	h=b	h=b	L	h1	H	l1	l2	f1	Size
		mm	mm	inch							
<a href="#">12.014</a>	GH305.1212.125.00.04.R.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	8.20	04
<a href="#">12.021</a>	GH305.0625.500.00.04.R.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	12.07	04
<a href="#">12.001</a>	GH305.1616.125.00.04.R.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	12.20	04
<a href="#">12.022</a>	GH305.0750.500.00.04.R.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	15.25	04
<a href="#">12.002</a>	GH305.2020.125.00.04.R.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	16.20	04
<a href="#">12.003</a>	GH305.2525.150.00.04.R.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	21.20	04
<a href="#">12.023</a>	GH305.1000.600.00.04.R.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	21.60	04
<a href="#">12.016</a>	GH305.1212.125.00.06.R.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	6.20	06
<a href="#">12.024</a>	GH305.0625.500.00.06.R.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	10.07	06
<a href="#">12.004</a>	GH305.1616.125.00.06.R.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	10.20	06
<a href="#">12.025</a>	GH305.0750.500.00.06.R.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	13.25	06
<a href="#">12.005</a>	GH305.2020.125.00.06.R.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	14.20	06
<a href="#">12.006</a>	GH305.2525.150.00.06.R.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	19.20	06
<a href="#">12.026</a>	GH305.1000.600.00.06.R.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	19.60	06
<a href="#">12.018</a>	GH305.1212.125.00.08.R.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	4.20	08
<a href="#">12.027</a>	GH305.0625.500.00.08.R.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	8.07	08
<a href="#">12.007</a>	GH305.1616.125.00.08.R.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	8.20	08
<a href="#">12.028</a>	GH305.0750.500.00.08.R.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	11.25	08
<a href="#">12.008</a>	GH305.2020.125.00.08.R.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	12.20	08
<a href="#">12.009</a>	GH305.2525.150.00.08.R.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	17.20	08
<a href="#">12.029</a>	GH305.1000.600.00.08.R.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	17.60	08
<a href="#">12.020</a>	GH305.1212.125.00.12.R.IK	5.00	12.00		125.00	12.00	25.00	30.00	30.00	0.20	12
<a href="#">12.030</a>	GH305.0625.500.00.12.R.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	4.07	12
<a href="#">12.010</a>	GH305.1616.125.00.12.R.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	4.20	12
<a href="#">12.031</a>	GH305.0750.500.00.12.R.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	7.25	12
<a href="#">12.011</a>	GH305.2020.125.00.12.R.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	8.20	12
<a href="#">12.012</a>	GH305.2525.150.00.12.R.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	13.20	12
<a href="#">12.032</a>	GH305.1000.600.00.12.R.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	13.60	12

Series no. **25353**

version left-hand

Code no.	Description	t max	h=b	h=b	L	h1	H	l1	l2	f1	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
<a href="#">12.014</a>	GH305.1212.125.00.04.L.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	8.20	04
<a href="#">12.021</a>	GH305.0625.500.00.04.L.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	12.07	04
<a href="#">12.001</a>	GH305.1616.125.00.04.L.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	12.20	04
<a href="#">12.022</a>	GH305.0750.500.00.04.L.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	15.25	04
<a href="#">12.002</a>	GH305.2020.125.00.04.L.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	16.20	04
<a href="#">12.003</a>	GH305.2525.150.00.04.L.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	21.20	04
<a href="#">12.023</a>	GH305.1000.600.00.04.L.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	21.60	04
<a href="#">12.016</a>	GH305.1212.125.00.06.L.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	6.20	06
<a href="#">12.024</a>	GH305.0625.500.00.06.L.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	10.07	06
<a href="#">12.004</a>	GH305.1616.125.00.04.L.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	10.20	06
<a href="#">12.025</a>	GH305.0750.500.00.06.L.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	13.25	06
<a href="#">12.005</a>	GH305.2020.125.00.06.L.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	14.20	06
<a href="#">12.006</a>	GH305.2525.150.00.06.L.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	19.20	06
<a href="#">12.026</a>	GH305.1000.600.00.06.L.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	19.60	06
<a href="#">12.018</a>	GH305.1212.125.00.08.L.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	4.20	08
<a href="#">12.027</a>	GH305.0625.500.00.08.L.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	8.07	08
<a href="#">12.007</a>	GH305.1616.125.00.08.L.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	8.20	08
<a href="#">12.028</a>	GH305.0750.500.00.08.L.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	11.25	08
<a href="#">12.008</a>	GH305.2020.125.00.08.L.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	12.20	08
<a href="#">12.009</a>	GH305.2525.150.00.08.L.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	17.20	08
<a href="#">12.029</a>	GH305.1000.600.00.08.L.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	17.60	08
<a href="#">12.020</a>	GH305.1212.125.00.12.L.IK	5.00	12.00		125.00	12.00	25.00	30.00	30.00	0.20	12
<a href="#">12.030</a>	GH305.0625.500.00.12.L.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	4.07	12
<a href="#">12.010</a>	GH305.1616.125.00.12.L.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	4.20	12
<a href="#">12.031</a>	GH305.0750.500.00.12.L.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	7.25	12
<a href="#">12.011</a>	GH305.2020.125.00.12.L.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	8.20	12
<a href="#">12.012</a>	GH305.2525.150.00.12.L.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	13.20	12
<a href="#">12.032</a>	GH305.1000.600.00.12.L.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	13.60	12

## Spare parts

Series no.	Clamping screw	Tightening torque
25901		Nm
Code <a href="#">4.000</a>	M4x15x42x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

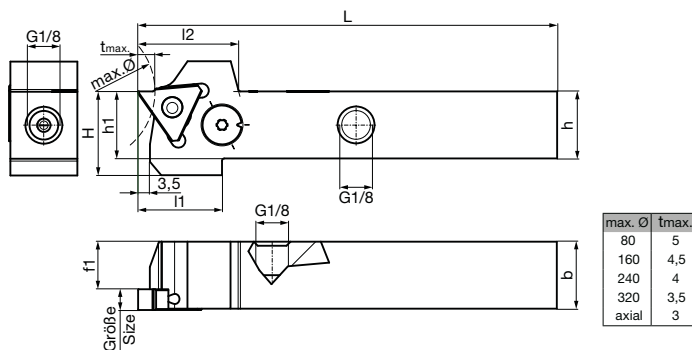


**Square shank holder straight, external machining, IC adjustable**

- grooving depth up to 5 mm
- with internal coolant delivery

Type GH 305

for indexable inserts type 305 see from page 137



Right hand version shown  
Left hand version mirror image

Series no. **25372**

version right-hand

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f1	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
<a href="#">12.002</a>	GH305.2020.125.00.04.R.IK.EST	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	16.20	04
<a href="#">12.003</a>	GH305.2525.150.00.04.R.IK.EST	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	21.20	04
<a href="#">12.005</a>	GH305.2020.125.00.06.R.IK.EST	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	14.20	06
<a href="#">12.006</a>	GH305.2525.150.00.06.R.IK.EST	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	19.20	06

Series no. **25373**

version left-hand

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f1	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
<a href="#">12.002</a>	GH305.2020.125.00.04.L.IK.EST	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	16.20	04
<a href="#">12.003</a>	GH305.2525.150.00.04.L.IK.EST	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	21.20	04
<a href="#">12.005</a>	GH305.2020.125.00.06.L.IK.EST	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	14.20	06
<a href="#">12.006</a>	GH305.2525.150.00.06.L.IK.EST	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	19.20	06

**Spare parts**

Series no.	Clamping screw	Tightening torque
25901		Nm
Code <a href="#">4.000</a>	M4x15x42x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



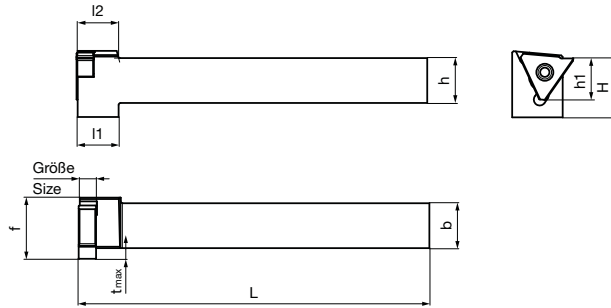


**Square shank holder 90° offset, external machining, without IC**

- grooving depth up to 3.5 mm
- without internal coolant delivery

Type GH 305

for indexable inserts type 305 see from page 137



System 305

Right hand version shown  
Left hand version mirror image

Series no. **25356**

version right-hand

Code no.	Description	t max	h=b	h=b	L	h1	H	l1	l2	f	Size
		mm	mm	inch		mm	mm				
<a href="#">12.013</a>	GH305.1010.125.90.04.R	3.50	10.00		125.00	10.00	19.00	14.60	14.60	13.80	04
<a href="#">12.014</a>	GH305.1212.125.90.04.R	3.50	12.00		125.00	12.00	21.00	14.60	14.60	15.80	04
<a href="#">12.021</a>	GH305.0625.500.90.04.R	3.50		5/8	127.00	15.87	20.87	14.84	14.84	19.67	04
<a href="#">12.001</a>	GH305.1616.125.90.04.R	3.50	16.00		125.00	16.00	21.00	14.60	14.60	19.80	04
<a href="#">12.022</a>	GH305.0750.500.90.04.R	3.50		3/4	127.00	19.05	24.05	14.84	14.84	22.85	04
<a href="#">12.002</a>	GH305.2020.125.90.04.R	3.50	20.00		125.00	20.00	25.00	14.60	14.60	23.80	04
<a href="#">12.003</a>	GH305.2525.150.90.04.R	3.50	25.00		150.00	25.00	30.00	14.60	14.60	28.80	04
<a href="#">12.023</a>	GH305.1000.600.90.04.R	3.50		1"	152.40	25.40	30.40	14.84	14.84	29.20	04
<a href="#">12.015</a>	GH305.1010.125.90.06.R	3.50	10.00		125.00	10.00	19.00	14.60	14.60	13.80	06
<a href="#">12.016</a>	GH305.1212.125.90.06.R	3.50	12.00		125.00	12.00	21.00	14.60	14.60	15.80	06
<a href="#">12.024</a>	GH305.0625.500.90.06.R	3.50		5/8	127.00	15.87	20.87	14.84	14.84	19.67	06
<a href="#">12.004</a>	GH305.1616.125.90.06.R	3.50	16.00		125.00	16.00	21.00	14.60	14.60	19.80	06
<a href="#">12.025</a>	GH305.0750.500.90.06.R	3.50		3/4	127.00	19.05	24.05	14.84	14.84	22.85	06
<a href="#">12.005</a>	GH305.2020.125.90.06.R	3.50	20.00		125.00	20.00	25.00	14.60	14.60	23.80	06
<a href="#">12.006</a>	GH305.2525.150.90.06.R	3.50	25.00		150.00	25.00	30.00	14.60	14.60	28.80	06
<a href="#">12.026</a>	GH305.1000.600.90.06.R	3.50		1"	152.40	25.40	30.40	14.84	14.84	29.20	06
<a href="#">12.017</a>	GH305.1010.125.90.08.R	3.50	10.00		125.00	10.00	19.00	16.60	16.60	13.80	08
<a href="#">12.018</a>	GH305.1212.125.90.08.R	3.50	12.00		125.00	12.00	21.00	16.60	16.60	15.80	08
<a href="#">12.027</a>	GH305.0625.500.90.08.R	3.50		5/8	127.00	15.87	20.87	16.84	16.84	19.67	08
<a href="#">12.007</a>	GH305.1616.125.90.08.R	3.50	16.00		125.00	16.00	21.00	16.60	16.60	19.80	08
<a href="#">12.028</a>	GH305.0750.500.90.08.R	3.50		3/4	127.00	19.05	24.05	16.84	16.84	22.85	08
<a href="#">12.008</a>	GH305.2020.125.90.08.R	3.50	20.00		125.00	20.00	25.00	16.60	16.60	23.80	08
<a href="#">12.009</a>	GH305.2525.150.90.08.R	3.50	25.00		150.00	25.00	30.00	16.60	16.60	28.80	08
<a href="#">12.029</a>	GH305.1000.600.90.08.R	3.50		1"	152.40	25.40	30.40	16.84	16.84	29.20	08
<a href="#">12.019</a>	GH305.1010.125.90.12.R	3.50	10.00		125.00	10.00	19.00	16.60	20.60	13.80	12
<a href="#">12.020</a>	GH305.1212.125.90.12.R	3.50	12.00		125.00	12.00	21.00	20.60	20.60	15.80	12
<a href="#">12.030</a>	GH305.0625.500.90.12.R	3.50		5/8	127.00	15.87	20.87	20.84	20.84	19.67	12
<a href="#">12.010</a>	GH305.1616.125.90.12.R	3.50	16.00		125.00	16.00	21.00	20.60	20.60	19.80	12
<a href="#">12.031</a>	GH305.0750.500.90.12.R	3.50		3/4	127.00	19.05	24.05	20.84	20.84	22.85	12
<a href="#">12.011</a>	GH305.2020.125.90.12.R	3.50	20.00		125.00	20.00	25.00	20.60	20.60	23.80	12
<a href="#">12.012</a>	GH305.2525.150.90.12.R	3.50	25.00		150.00	25.00	30.00	20.60	20.60	28.80	12
<a href="#">12.032</a>	GH305.1000.600.90.12.R	3.50		1"	152.40	25.40	30.40	20.84	20.84	29.20	12

Series no. **25357**

version left-hand

Code no.	Description	t max	h=b	h=b	L	h1	H	l1	l2	f	Size
		mm	mm	inch	mm	mm	mm	mm	mm	mm	
<a href="#">12.013</a>	GH305.1010.125.90.04.L	3.50	10.00		125.00	10.00	19.00	14.60	14.60	13.80	04
<a href="#">12.014</a>	GH305.1212.125.90.04.L	3.50	12.00		125.00	12.00	21.00	14.60	14.60	15.80	04
<a href="#">12.021</a>	GH305.0625.500.90.04.L	3.50		5/8	127.00	15.87	20.87	14.84	14.84	19.67	04
<a href="#">12.001</a>	GH305.1616.125.90.04.L	3.50	16.00		125.00	16.00	21.00	14.60	14.60	19.80	04
<a href="#">12.022</a>	GH305.0750.500.90.04.L	3.50		3/4	127.00	19.05	24.05	14.84	14.84	22.85	04
<a href="#">12.002</a>	GH305.2020.125.90.04.L	3.50	20.00		125.00	20.00	25.00	14.60	14.60	23.80	04
<a href="#">12.003</a>	GH305.2525.150.90.04.L	3.50	25.00		150.00	25.00	30.00	14.60	14.60	28.80	04
<a href="#">12.023</a>	GH305.1000.600.90.04.L	3.50		1"	152.40	25.40	30.40	14.84	14.84	29.20	04
<a href="#">12.015</a>	GH305.1010.125.90.06.L	3.50	10.00		125.00	10.00	19.00	14.60	14.60	13.80	06
<a href="#">12.016</a>	GH305.1212.125.90.06.L	3.50	12.00		125.00	12.00	21.00	14.60	14.60	15.80	06
<a href="#">12.024</a>	GH305.0625.500.90.06.L	3.50		5/8	127.00	15.87	20.87	14.84	14.84	19.67	06
<a href="#">12.004</a>	GH305.1616.125.90.06.L	3.50	16.00		125.00	16.00	21.00	14.60	14.60	19.80	06
<a href="#">12.025</a>	GH305.0750.500.90.06.L	3.50		3/4	127.00	19.05	24.05	14.84	14.84	22.85	06
<a href="#">12.005</a>	GH305.2020.125.90.06.L	3.50	20.00		125.00	20.00	25.00	14.60	14.60	23.80	06
<a href="#">12.006</a>	GH305.2525.150.90.06.L	3.50	25.00		150.00	25.00	30.00	14.60	14.60	28.80	06
<a href="#">12.026</a>	GH305.1000.600.90.06.L	3.50		1"	152.40	25.40	30.40	14.84	14.84	29.20	06
<a href="#">12.017</a>	GH305.1010.125.90.08.L	3.50	10.00		125.00	10.00	19.00	16.60	16.60	13.80	08
<a href="#">12.018</a>	GH305.1212.125.90.08.L	3.50	12.00		125.00	12.00	21.00	16.60	16.60	15.80	08
<a href="#">12.027</a>	GH305.0625.500.90.08.L	3.50		5/8	127.00	15.87	20.87	16.84	16.84	19.67	08
<a href="#">12.007</a>	GH305.1616.125.90.08.L	3.50	16.00		125.00	16.00	21.00	16.60	16.60	19.80	08
<a href="#">12.028</a>	GH305.0750.500.90.08.L	3.50		3/4	127.00	19.05	24.05	16.84	16.84	22.85	08
<a href="#">12.008</a>	GH305.2020.125.90.08.L	3.50	20.00		125.00	20.00	25.00	16.60	16.60	23.80	08
<a href="#">12.009</a>	GH305.2525.150.90.08.L	3.50	25.00		150.00	25.00	30.00	16.60	16.60	28.80	08
<a href="#">12.029</a>	GH305.1000.600.90.08.L	3.50		1"	152.40	25.40	30.40	16.84	16.84	29.20	08
<a href="#">12.019</a>	GH305.1010.125.90.12.L	3.50	10.00		125.00	10.00	19.00	16.60	20.60	13.80	12
<a href="#">12.020</a>	GH305.1212.125.90.12.L	3.50	12.00		125.00	12.00	21.00	20.60	20.60	15.80	12
<a href="#">12.030</a>	GH305.0625.500.90.12.L	3.50		5/8	127.00	15.87	20.87	20.84	20.84	19.67	12
<a href="#">12.010</a>	GH305.1616.125.90.12.L	3.50	16.00		125.00	16.00	21.00	20.60	20.60	19.80	12
<a href="#">12.031</a>	GH305.0750.500.90.12.L	3.50		3/4	127.00	19.05	24.05	20.84	20.84	22.85	12
<a href="#">12.011</a>	GH305.2020.125.90.12.L	3.50	20.00		125.00	20.00	25.00	20.60	20.60	23.80	12
<a href="#">12.012</a>	GH305.2525.150.90.12.L	3.50	25.00		150.00	25.00	30.00	20.60	20.60	28.80	12
<a href="#">12.032</a>	GH305.1000.600.90.12.L	3.50		1"	152.40	25.40	30.40	20.84	20.84	29.20	12

**Spare parts**

Series no.	Clamping screw	Tightening torque
25901		Nm
Code <a href="#">4.000</a>	M4x15x42x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

System 305

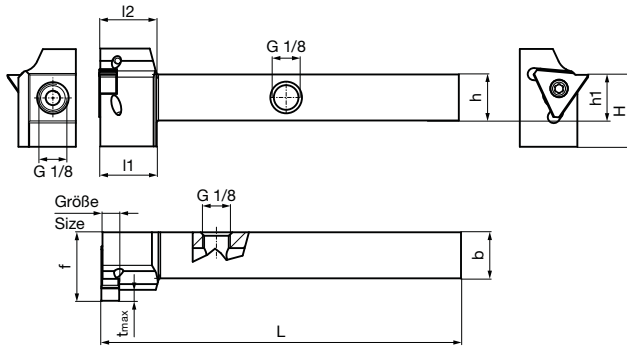


**Square shank holder 90° offset, external machining, with IC**

- grooving depth up to 3.5 mm
- with internal coolant delivery from above and below

Type GH 305

for indexable inserts type 305 see from page 137



System 305

Right hand version shown  
Left hand version mirror image

Series no. 25358

version right-hand

Code no.	Description	t max	h=b	h=b	L	h1	H	l1	l2	f	Size
		mm	mm	inch							
<a href="#">12.014</a>	GH305.1212.125.90.04.R.IK	3.50	12.00		125.00	12.00	21.00	21.60	21.60	23.80	04
<a href="#">12.021</a>	GH305.0625.500.90.04.R.IK	3.50		5/8	127.00	15.87	24.87	19.92	19.92	24.12	04
<a href="#">12.001</a>	GH305.1616.125.90.04.R.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	04
<a href="#">12.022</a>	GH305.0750.500.90.04.R.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	04
<a href="#">12.002</a>	GH305.2020.125.90.04.R.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	04
<a href="#">12.003</a>	GH305.2525.150.90.04.R.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	04
<a href="#">12.023</a>	GH305.1000.600.90.04.R.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	04
<a href="#">12.016</a>	GH305.1212.125.90.06.R.IK	3.50	12.00		125.00	12.00	21.00	21.60	21.60	23.80	06
<a href="#">12.024</a>	GH305.0625.500.90.06.R.IK	3.50		5/8	127.00	15.87	24.87	19.92	19.92	24.12	06
<a href="#">12.004</a>	GH305.1616.125.90.06.R.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	06
<a href="#">12.025</a>	GH305.0750.500.90.06.R.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	06
<a href="#">12.005</a>	GH305.2020.125.90.06.R.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	06
<a href="#">12.006</a>	GH305.2525.150.90.06.R.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	06
<a href="#">12.026</a>	GH305.1000.600.90.06.R.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	06
<a href="#">12.018</a>	GH305.1212.125.90.08.R.IK	3.50	12.00		125.00	12.00	21.00	23.60	23.60	23.80	08
<a href="#">12.027</a>	GH305.0625.500.90.08.R.IK	3.50		5/8	127.00	15.87	24.87	21.92	21.92	24.12	08
<a href="#">12.007</a>	GH305.1616.125.90.08.R.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	08
<a href="#">12.028</a>	GH305.0750.500.90.08.R.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	08
<a href="#">12.008</a>	GH305.2020.125.90.08.R.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	08
<a href="#">12.009</a>	GH305.2525.150.90.08.R.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	08
<a href="#">12.029</a>	GH305.1000.600.90.08.R.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	08
<a href="#">12.020</a>	GH305.1212.125.90.12.R.IK	3.50	12.00		125.00	12.00	21.00	27.60	27.60	23.80	12
<a href="#">12.030</a>	GH305.0625.500.90.12.R.IK	3.50		5/8	127.00	15.87	24.87	25.92	25.92	24.12	12
<a href="#">12.010</a>	GH305.1616.125.90.12.R.IK	3.50	16.00		125.00	16.00	25.00	27.60	27.60	23.80	12
<a href="#">12.031</a>	GH305.0750.500.90.12.R.IK	3.50		3/4	127.00	19.05	24.05	25.92	25.92	24.12	12
<a href="#">12.011</a>	GH305.2020.125.90.12.R.IK	3.50	20.00		125.00	20.00	25.00	27.60	27.60	23.80	12
<a href="#">12.012</a>	GH305.2525.150.90.12.R.IK	3.50	25.00		150.00	25.00	30.00	27.60	27.60	28.80	12
<a href="#">12.032</a>	GH305.1000.600.90.12.R.IK	3.50		1"	152.40	25.40	30.40	25.92	25.92	29.20	12



Code no.	Description	t max	h=b	h=b	L	h1	H	l1	l2	f	Size
		mm	mm	inch	mm	mm	mm	mm	mm	mm	
<a href="#">12.014</a>	GH305.1212.125.90.04.L.IK	3.50	12.00		125.00	12.00	21.00	21.60	21.60	23.80	04
<a href="#">12.021</a>	GH305.0625.500.90.04.L.IK	3.50		5/8	127.00	15.87	24.87	19.92	19.92	24.12	04
<a href="#">12.001</a>	GH305.1616.125.90.04.L.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	04
<a href="#">12.022</a>	GH305.0750.500.90.04.L.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	04
<a href="#">12.002</a>	GH305.2020.125.90.04.L.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	04
<a href="#">12.003</a>	GH305.2525.150.90.04.L.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	04
<a href="#">12.023</a>	GH305.1000.600.90.04.L.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	04
<a href="#">12.016</a>	GH305.1212.125.90.06.L.IK	3.50	12.00		125.00	12.00	21.00	21.60	21.60	23.80	06
<a href="#">12.024</a>	GH305.0625.500.90.06.L.IK	3.50		5/8	127.00	15.87	24.87	19.92	19.92	24.12	06
<a href="#">12.004</a>	GH305.1616.125.90.06.L.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	06
<a href="#">12.025</a>	GH305.0750.500.90.06.L.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	06
<a href="#">12.005</a>	GH305.2020.125.90.06.L.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	06
<a href="#">12.006</a>	GH305.2525.150.90.06.L.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	06
<a href="#">12.026</a>	GH305.1000.600.90.06.L.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	06
<a href="#">12.018</a>	GH305.1212.125.90.08.L.IK	3.50	12.00		125.00	12.00	21.00	23.60	23.60	23.80	08
<a href="#">12.027</a>	GH305.0625.500.90.08.L.IK	3.50		5/8	127.00	15.87	24.87	21.92	21.92	24.12	08
<a href="#">12.007</a>	GH305.1616.125.90.08.L.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	08
<a href="#">12.028</a>	GH305.0750.500.90.08.L.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	08
<a href="#">12.008</a>	GH305.2020.125.90.08.L.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	08
<a href="#">12.009</a>	GH305.2525.150.90.08.L.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	08
<a href="#">12.029</a>	GH305.1000.600.90.08.L.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	08
<a href="#">12.020</a>	GH305.1212.125.90.12.L.IK	3.50	12.00		125.00	12.00	21.00	27.60	27.60	23.80	12
<a href="#">12.030</a>	GH305.0625.500.90.12.L.IK	3.50		5/8	127.00	15.87	24.87	25.92	25.92	24.12	12
<a href="#">12.010</a>	GH305.1616.125.90.12.L.IK	3.50	16.00		125.00	16.00	25.00	27.60	27.60	23.80	12
<a href="#">12.031</a>	GH305.0750.500.90.12.L.IK	3.50		3/4	127.00	19.05	24.05	25.92	25.92	24.12	12
<a href="#">12.011</a>	GH305.2020.125.90.12.L.IK	3.50	20.00		125.00	20.00	25.00	27.60	27.60	23.80	12
<a href="#">12.012</a>	GH305.2525.150.90.12.L.IK	3.50	25.00		150.00	25.00	30.00	27.60	27.60	28.80	12
<a href="#">12.032</a>	GH305.1000.600.90.12.L.IK	3.50		1"	152.40	25.40	30.40	25.92	25.92	29.20	12

**Spare parts**

Series no.	Clamping screw	Tightening torque
25901		Nm
Code <a href="#">4.000</a>	M4x15x42x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

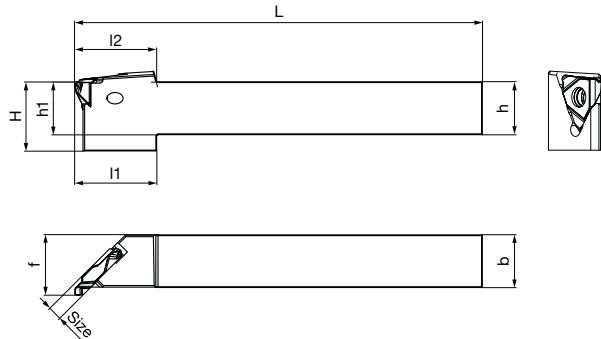


**Square shank holder 45° offset, external machining, without IC**

- grooving depth up to 2 mm
- without internal coolant delivery

Type GH 305

for indexable inserts type 305 see page 137



System 305

Right hand version shown  
Left hand version mirror image

Series no. **25362**

version right-hand

Code no.	Description	h=b	h=b	L	h1	H	l1	l2	f	Size
		mm	inch	mm	mm	mm	mm	mm	mm	
<a href="#">12.004</a>	GH305.1010.125.45.04.R	10.00		125.00	10.00	21.00	25.66	25.66	12.56	04
<a href="#">12.005</a>	GH305.1212.125.45.04.R	12.00		125.00	12.00	21.00	25.66	25.66	14.56	04
<a href="#">12.021</a>	GH305.0625.500.45.04.R		5/8	127.00	15.87	20.87	26.06	26.06	18.44	04
<a href="#">12.001</a>	GH305.1616.125.45.04.R	16.00		125.00	16.00	21.00	25.66	25.66	18.56	04
<a href="#">12.022</a>	GH305.0750.500.45.04.R		3/4	127.00	19.05	24.05	26.06	26.06	21.61	04
<a href="#">12.002</a>	GH305.2020.125.45.04.R	20.00		125.00	20.00	25.00	25.66	25.66	22.56	04
<a href="#">12.003</a>	GH305.2525.150.45.04.R	25.00		150.00	25.00	30.00	30.66	30.66	27.56	04
<a href="#">12.023</a>	GH305.1000.600.45.04.R		1"	152.40	25.40	30.40	31.14	31.14	27.96	04

Series no. **25363**

version left-hand

Code no.	Description	h=b	h=b	L	h1	H	l1	l2	f	Size
		mm	inch	mm	mm	mm	mm	mm	mm	
<a href="#">12.004</a>	GH305.1010.125.45.04.L	10.00		125.00	10.00	21.00	25.66	25.66	12.56	04
<a href="#">12.005</a>	GH305.1212.125.45.04.L	12.00		125.00	12.00	21.00	25.66	25.66	14.56	04
<a href="#">12.021</a>	GH305.0625.500.45.04.L		5/8	127.00	15.87	20.87	26.06	26.06	18.44	04
<a href="#">12.001</a>	GH305.1616.125.45.04.L	16.00		125.00	16.00	21.00	25.66	25.66	18.56	04
<a href="#">12.022</a>	GH305.0750.500.45.04.L		3/4	127.00	19.05	24.05	26.06	26.06	21.61	04
<a href="#">12.002</a>	GH305.2020.125.45.04.L	20.00		125.00	20.00	25.00	25.66	25.66	22.56	04
<a href="#">12.003</a>	GH305.2525.150.45.04.L	25.00		150.00	25.00	30.00	30.66	30.66	27.56	04
<a href="#">12.023</a>	GH305.1000.600.45.04.L		1"	152.40	25.40	30.40	31.14	31.14	27.96	04

**Spare parts**

Series no.	Clamping screw	Tightening torque
25902		Nm
Code <a href="#">4.001</a>	M4x0.5x7x42x15IP	3-3.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

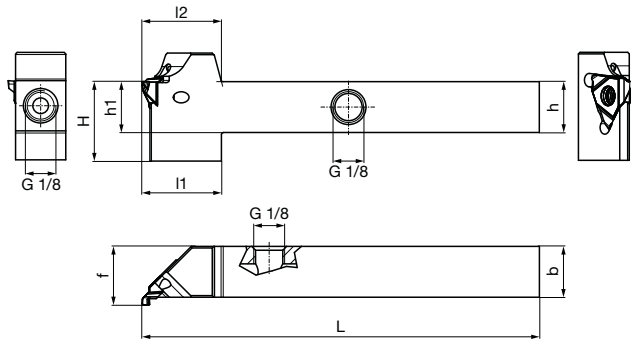


**Square shank holder 45° offset, external machining, with IC**

- grooving depth up to 2 mm
- with internal coolant delivery from above

Type GH 305

for indexable inserts type 305 see page 137



Right hand version shown  
Left hand version mirror image

Series no. **25364**

version right-hand

Code no.	Description	h=b	h=b	L	h1	H	l1	l2	f	Size
		mm	inch							
<a href="#">12.005</a>	GH305.1212.125.45.04.R.IK	12.00		125.00	12.00	25.00	25.66	25.66	14.56	04
<a href="#">12.021</a>	GH305.0625.500.45.04.R.IK		5/8	127.00	15.87	24.87	26.06	26.06	18.44	04
<a href="#">12.001</a>	GH305.1616.125.45.04.R.IK	16.00		125.00	16.00	25.00	25.66	25.66	18.56	04
<a href="#">12.022</a>	GH305.0750.500.45.04.R.IK		3/4	127.00	19.05	24.05	26.06	26.06	21.61	04
<a href="#">12.002</a>	GH305.2020.125.45.04.R.IK	20.00		125.00	20.00	25.00	25.66	25.66	22.56	04
<a href="#">12.003</a>	GH305.2525.150.45.04.R.IK	25.00		150.00	25.00	30.00	30.66	30.66	27.56	04
<a href="#">12.023</a>	GH305.1000.600.45.04.R.IK		1"	152.40	25.40	30.40	31.14	31.14	27.96	04

Series no. **25365**

version left-hand

Code no.	Description	h=b	h=b	L	h1	H	l1	l2	f	Size
		mm	inch							
<a href="#">12.005</a>	GH305.1212.125.45.04.L.IK	12.00		125.00	12.00	25.00	25.66	25.66	14.56	04
<a href="#">12.021</a>	GH305.0625.500.45.04.L.IK		5/8	127.00	15.87	24.87	26.06	26.06	18.44	04
<a href="#">12.001</a>	GH305.1616.125.45.04.L.IK	16.00		125.00	16.00	25.00	25.66	25.66	18.56	04
<a href="#">12.022</a>	GH305.0750.500.45.04.L.IK		3/4	127.00	19.05	24.05	26.06	26.06	21.61	04
<a href="#">12.002</a>	GH305.2020.125.45.04.L.IK	20.00		125.00	20.00	25.00	25.66	25.66	22.56	04
<a href="#">12.003</a>	GH305.2525.150.45.04.L.IK	25.00		150.00	25.00	30.00	30.66	30.66	27.56	04
<a href="#">12.023</a>	GH305.1000.600.45.04.L.IK		1"	152.40	25.40	30.40	31.14	31.14	27.96	04

**Spare parts**

Series no.	Clamping screw	Tightening torque
25902		Nm
Code <a href="#">4.001</a>	M4x0.5x7x42x15IP	3-3.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle

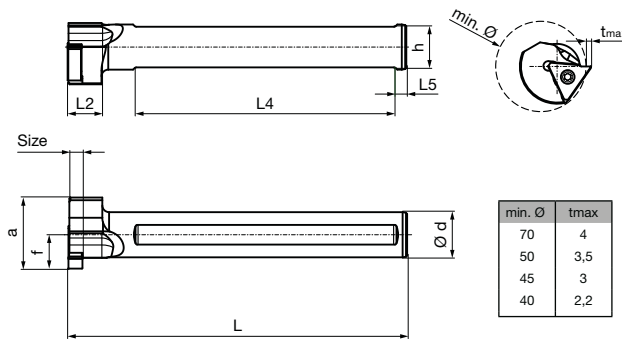


**Round shank holder, internal machining, without IC**

- grooving depth up to 4 mm
- without internal coolant delivery

Type GB 305

for indexable inserts type 305 see from page 137



System 305

Right hand version shown  
Left hand version mirror image

Series no. **25368**

version right-hand

Code no.	Description	d	d	L	L2	L4	L5	h	f	a	Size
		mm	inch	mm	mm	mm	mm	mm	mm	mm	
<a href="#">12.021</a>	GB305.0750.600.90.04.R		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	04
<a href="#">12.001</a>	GB305.0020.150.90.04.R	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	04
<a href="#">12.002</a>	GB305.0025.170.90.04.R	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	04
<a href="#">12.022</a>	GB305.1000.670.90.04.R		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	04
<a href="#">12.023</a>	GB305.1250.800.90.04.R		1-1/4	205.20	14.60	162.56	5.08	29.74	21.08	39.37	04
<a href="#">12.003</a>	GB305.0032.200.90.04.R	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	04
<a href="#">12.024</a>	GB305.0750.600.90.06.R		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	06
<a href="#">12.004</a>	GB305.0020.150.90.06.R	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	06
<a href="#">12.005</a>	GB305.0025.170.90.06.R	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	06
<a href="#">12.025</a>	GB305.1000.670.90.06.R		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	06
<a href="#">12.026</a>	GB305.1250.800.90.06.R		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	06
<a href="#">12.006</a>	GB305.0032.200.90.06.R	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	06
<a href="#">12.027</a>	GB305.0750.600.90.08.R		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	08
<a href="#">12.007</a>	GB305.0020.150.90.08.R	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	08
<a href="#">12.008</a>	GB305.0025.170.90.08.R	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	08
<a href="#">12.028</a>	GB305.1000.670.90.08.R		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	08
<a href="#">12.029</a>	GB305.1250.800.90.08.R		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	08
<a href="#">12.009</a>	GB305.0032.200.90.08.R	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	08
<a href="#">12.030</a>	GB305.0750.600.90.12.R		3/4	152.40	19.60	116.84	5.08	17.04	14.48	30.48	12
<a href="#">12.010</a>	GB305.0020.150.90.12.R	20.00		150.00	19.60	115.00	5.00	18.00	15.00	31.50	12
<a href="#">12.011</a>	GB305.0025.170.90.12.R	25.00		170.00	19.60	130.00	5.00	23.00	17.50	34.50	12
<a href="#">12.031</a>	GB305.1000.670.90.12.R		1"	170.18	19.60	129.54	5.08	23.39	17.78	34.54	12
<a href="#">12.032</a>	GB305.1250.800.90.12.R		1-1/4	203.20	19.60	162.56	5.08	29.74	21.08	39.37	12
<a href="#">12.012</a>	GB305.0032.200.90.12.R	32.00		200.00	19.60	160.00	5.00	30.00	21.00	39.25	12

Series no. **25369**

version left-hand

Code no.	Description	d	d	L	L2	L4	L5	h	f	a	Size
		mm	inch	mm	mm	mm	mm	mm	mm	mm	
<a href="#">12.021</a>	GB305.0750.600.90.04.L		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	04
<a href="#">12.001</a>	GB305.0020.150.90.04.L	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	04
<a href="#">12.002</a>	GB305.0025.170.90.04.L	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	04
<a href="#">12.022</a>	GB305.1000.670.90.04.L		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	04
<a href="#">12.023</a>	GB305.1250.800.90.04.L		1-1/4	205.20	14.60	162.56	5.08	29.74	21.08	39.37	04
<a href="#">12.003</a>	GB305.0032.200.90.04.L	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	04

Series no. **25369**

version left-hand

Code no.	Description	d	d	L	L2	L4	L5	h	f	a	Size
		mm	inch	mm	mm	mm	mm	mm	mm	mm	
<a href="#">12.024</a>	GB305.0750.600.90.06.L		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	06
<a href="#">12.004</a>	GB305.0020.150.90.06.L	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	06
<a href="#">12.005</a>	GB305.0025.170.90.06.L	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	06
<a href="#">12.025</a>	GB305.1000.670.90.06.L		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	06
<a href="#">12.026</a>	GB305.1250.800.90.06.L		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	06
<a href="#">12.006</a>	GB305.0032.200.90.06.L	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	06
<a href="#">12.027</a>	GB305.0750.600.90.08.L		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	08
<a href="#">12.007</a>	GB305.0020.150.90.08.L	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	08
<a href="#">12.008</a>	GB305.0025.170.90.08.L	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	08
<a href="#">12.028</a>	GB305.1000.670.90.08.L		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	08
<a href="#">12.029</a>	GB305.1250.800.90.08.L		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	08
<a href="#">12.009</a>	GB305.0032.200.90.08.L	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	08
<a href="#">12.030</a>	GB305.0750.600.90.12.L		3/4	152.40	19.60	116.84	5.08	17.04	14.48	30.48	12
<a href="#">12.010</a>	GB305.0020.150.90.12.L	20.00		150.00	19.60	115.00	5.00	18.00	15.00	31.50	12
<a href="#">12.011</a>	GB305.0025.170.90.12.L	25.00		170.00	19.60	130.00	5.00	23.00	17.50	34.50	12
<a href="#">12.031</a>	GB305.1000.670.90.12.L		1"	170.18	19.60	129.54	5.08	23.39	17.78	34.54	12
<a href="#">12.032</a>	GB305.1250.800.90.12.L		1-1/4	203.20	19.60	162.56	5.08	29.74	21.08	39.37	12
<a href="#">12.012</a>	GB305.0032.200.90.12.L	32.00		200.00	19.60	160.00	5.00	30.00	21.00	39.25	12

**Spare parts**

Series no.	Clamping screw	Tightening torque
25901		Nm
Code <a href="#">4.000</a>	M4x15x42x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



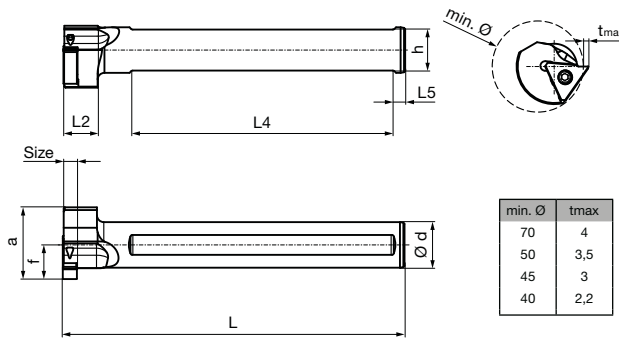


**Round shank holder, internal machining, with IC**

- grooving depth up to 4 mm
- with internal coolant delivery from above

Type GB 305

for indexable inserts type 305 see from page 137



System 305

Right hand version shown  
Left hand version mirror image

Series no. 25370

version right-hand

Code no.	Description	d		L	L2	L4	L5	h	f	a	Size
		mm	inch								
<a href="#">12.021</a>	GB305.0750.600.90.04.R.IK		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	04
<a href="#">12.001</a>	GB305.0020.150.90.04.R.IK	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	04
<a href="#">12.002</a>	GB305.0025.170.90.04.R.IK	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	04
<a href="#">12.022</a>	GB305.1000.670.90.04.R.IK		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	04
<a href="#">12.023</a>	GB305.1250.800.90.04.R.IK		1-1/4	205.20	14.60	162.56	5.08	29.74	21.08	39.37	04
<a href="#">12.003</a>	GB305.0032.200.90.04.R.IK	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	04
<a href="#">12.024</a>	GB305.0750.600.90.06.R.IK		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	06
<a href="#">12.004</a>	GB305.0020.150.90.06.R.IK	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	06
<a href="#">12.005</a>	GB305.0025.170.90.06.R.IK	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	06
<a href="#">12.025</a>	GB305.1000.670.90.06.R.IK		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	06
<a href="#">12.026</a>	GB305.1250.800.90.06.R.IK		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	06
<a href="#">12.006</a>	GB305.0032.200.90.06.R.IK	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	06
<a href="#">12.027</a>	GB305.0750.600.90.12.R.IK		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	08
<a href="#">12.007</a>	GB305.0020.150.90.08.R.IK	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	08
<a href="#">12.008</a>	GB305.0025.170.90.08.R.IK	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	08
<a href="#">12.028</a>	GB305.1000.670.90.08.R.IK		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	08
<a href="#">12.029</a>	GB305.1250.800.90.08.R.IK		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	08
<a href="#">12.009</a>	GB305.0032.200.90.08.R.IK	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	08
<a href="#">12.030</a>	GB305.0750.600.90.06.R.IK		3/4	152.40	19.60	116.84	5.08	17.04	14.48	30.48	12
<a href="#">12.010</a>	GB305.0020.150.90.12.R.IK	20.00		150.00	19.60	115.00	5.00	18.00	15.00	31.50	12
<a href="#">12.011</a>	GB305.0025.170.90.12.R.IK	25.00		170.00	19.60	130.00	5.00	23.00	17.50	34.50	12
<a href="#">12.031</a>	GB305.1000.670.90.12.R.IK		1"	170.18	19.60	129.54	5.08	23.39	17.78	34.54	12
<a href="#">12.032</a>	GB305.1250.800.90.12.R.IK		1-1/4	203.20	19.60	162.56	5.08	29.74	21.08	39.37	12
<a href="#">12.012</a>	GB305.0032.200.90.12.R.IK	32.00		200.00	19.60	160.00	5.00	30.00	21.00	39.25	12

Series no. **25371**

version left-hand

Code no.	Description	d	d	L	L2	L4	L5	h	f	a	Size
		mm	inch	mm	mm	mm	mm	mm	mm	mm	
<a href="#">12.021</a>	GB305.0750.600.90.04.L.IK		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	04
<a href="#">12.001</a>	GB305.0020.150.90.04.L.IK	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	04
<a href="#">12.002</a>	GB305.0025.170.90.04.L.IK	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	04
<a href="#">12.022</a>	GB305.1000.670.90.04.L.IK		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	04
<a href="#">12.023</a>	GB305.1250.800.90.04.L.IK		1-1/4	205.20	14.60	162.56	5.08	29.74	21.08	39.37	04
<a href="#">12.003</a>	GB305.0032.200.90.04.L.IK	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	04
<a href="#">12.024</a>	GB305.0750.600.90.06.L.IK		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	06
<a href="#">12.004</a>	GB305.0020.150.90.06.L.IK	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	06
<a href="#">12.005</a>	GB305.0025.170.90.06.L.IK	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	06
<a href="#">12.025</a>	GB305.1000.670.90.06.L.IK		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	06
<a href="#">12.026</a>	GB305.1250.800.90.06.L.IK		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	06
<a href="#">12.006</a>	GB305.0032.200.90.06.L.IK	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	06
<a href="#">12.027</a>	GB305.0750.600.90.12.L.IK		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	08
<a href="#">12.007</a>	GB305.0020.150.90.08.L.IK	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	08
<a href="#">12.008</a>	GB305.0025.170.90.08.L.IK	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	08
<a href="#">12.028</a>	GB305.1000.670.90.08.L.IK		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	08
<a href="#">12.029</a>	GB305.1250.800.90.08.L.IK		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	08
<a href="#">12.009</a>	GB305.0032.200.90.08.L.IK	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	08
<a href="#">12.030</a>	GB305.0750.600.90.06.L.IK		3/4	152.40	19.60	116.84	5.08	17.04	14.48	30.48	12
<a href="#">12.010</a>	GB305.0020.150.90.12.L.IK	20.00		150.00	19.60	115.00	5.00	18.00	15.00	31.50	12
<a href="#">12.011</a>	GB305.0025.170.90.12.L.IK	25.00		170.00	19.60	130.00	5.00	23.00	17.50	34.50	12
<a href="#">12.031</a>	GB305.1000.670.90.12.L.IK		1"	170.18	19.60	129.54	5.08	23.39	17.78	34.54	12
<a href="#">12.032</a>	GB305.1250.800.90.12.L.IK		1-1/4	203.20	19.60	162.56	5.08	29.74	21.08	39.37	12
<a href="#">12.012</a>	GB305.0032.200.90.12.L.IK	32.00		200.00	19.60	160.00	5.00	30.00	21.00	39.25	12

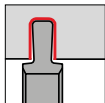
**Spare parts**

Series no.	Clamping screw	Tightening torque
25901		Nm
Code <a href="#">4.000</a>	M4x15x42x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code <a href="#">15.000</a>	T15IP T-handle



**Indexable insert for radial grooving external and internal**

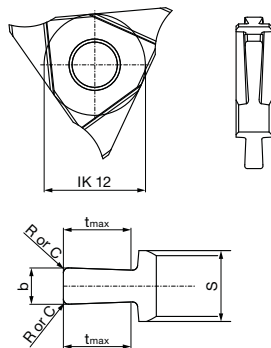


- Snap ring grooves to DIN471/472, NW = 0.5-5.15
- Indexable insert applicable in right and left holders
- Geometry .BA ground
- Pay attention to insert seat size 04 / 06

for tool holders type GH305/GB305 see from page 122

Tool material	Solid carbide		
Type	GE 305	GE 305	GE 305
Surface	<b>F</b>	<b>C</b>	○
	FIRE	TiCN	bright

Cutting data page 149

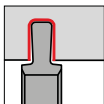


Series no. **25601** **25602** **25603**

Code no.	Description	NW	b ± 0.02	R	C	t max	s	Size
		mm	mm	mm	mm	mm	mm	
<a href="#">12.001</a>	GE305.0050.000.BA.04.N	0.50	0.55			1.50	4.20	04
<a href="#">12.002</a>	GE305.0060.000.BA.04.N	0.60	0.65			1.50	4.20	04
<a href="#">12.003</a>	GE305.0070.000.BA.04.N	0.70	0.75			1.50	4.20	04
<a href="#">12.004</a>	GE305.0080.000.BA.04.N	0.80	0.85			1.50	4.20	04
<a href="#">12.005</a>	GE305.0090.000.BA.04.N	0.90	0.95			1.50	4.20	04
<a href="#">12.006</a>	GE305.0100.000.BA.04.N	1.00	1.05		0.05	3.00	4.20	04
<a href="#">12.007</a>	GE305.0110.000.BA.04.N	1.10	1.22		0.05	3.00	4.20	04
<a href="#">12.008</a>	GE305.0130.000.BA.04.N	1.30	1.42		0.05	3.00	4.20	04
<a href="#">12.009</a>	GE305.0160.000.BA.04.N	1.60	1.72		0.05	4.00	4.20	04
<a href="#">12.010</a>	GE305.0185.015.BA.04.N	1.85	1.97	0.15		4.00	4.20	04
<a href="#">12.011</a>	GE305.0215.015.BA.04.N	2.15	2.27	0.15		5.00	4.20	04
<a href="#">12.012</a>	GE305.0265.015.BA.04.N	2.65	2.77	0.15		5.00	4.20	04
<a href="#">12.013</a>	GE305.0315.015.BA.04.N	3.15	3.27	0.15		5.00	4.20	04
<a href="#">12.014</a>	GE305.0415.015.BA.06.N	4.15	4.27	0.15		5.00	6.20	06
<a href="#">12.015</a>	GE305.0515.015.BA.06.N	5.15	5.27	0.15		5.00	6.20	06



## Indexable insert for radial grooving and copying external and internal

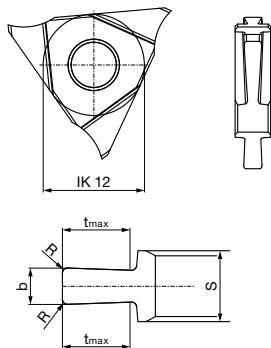


- grooving depth up to 5 mm
- Indexable insert applicable in right and left holders
- Geometry .BA ground

for tool holders type GH305/GB305 size 04 see from page 122

Tool material	Solid carbide		
Type	GE 305	GE 305	GE 305
Surface	<b>F</b>	<b>C</b>	○
	FIRE	TiCN	bright

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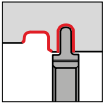


Series no. **25605** **25606** **25607**

Code no.	Description	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	
<a href="#">12.001</a>	GE305.0100.010.BA.04.N	1.00	0.10	3.00	4.20	04
<a href="#">12.002</a>	GE305.0150.020.BA.04.N	1.50	0.20	3.00	4.20	04
<a href="#">12.003</a>	GE305.0200.020.BA.04.N	2.00	0.20	4.00	4.20	04
<a href="#">12.004</a>	GE305.0250.030.BA.04.N	2.50	0.30	5.00	4.20	04
<a href="#">12.005</a>	GE305.0300.030.BA.04.N	3.00	0.30	5.00	4.20	04
<a href="#">12.006</a>	GE305.0350.030.BA.04.N	3.50	0.30	5.00	4.20	04
<a href="#">12.007</a>	GE305.0400.020.BA.04.N	4.00	0.20	5.00	4.20	04
<a href="#">12.008</a>	GE305.0400.040.BA.04.N	4.00	0.40	5.00	4.20	04



**Indexable insert for radial grooving and copying external and internal**

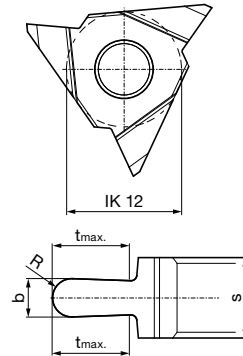


- grooving depth up to 5 mm
- Indexable insert applicable in right and left holders
- Geometry .AA ground

for tool holders type GH305/GB305 size 04 see from page 122

Tool material	Solid carbide		
Type	GE 305	GE 305	GE 305
Surface	<b>F</b>	<b>C</b>	○
	FIRE	TiCN	bright

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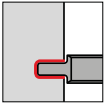
System 305

Series no. **25613** **25614** **25615**

Code no.	Description	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	
<a href="#">12.001</a>	GE305.0050.025.AA.04.N	0.50	0.25	1.50	4.20	04
<a href="#">12.002</a>	GE305.0100.050.AA.04.N	1.00	0.50	3.00	4.20	04
<a href="#">12.003</a>	GE305.0110.055.AA.04.N	1.10	0.55	3.00	4.20	04
<a href="#">12.004</a>	GE305.0120.060.AA.04.N	1.20	0.60	3.00	4.20	04
<a href="#">12.005</a>	GE305.0140.070.AA.04.N	1.40	0.70	3.00	4.20	04
<a href="#">12.006</a>	GE305.0150.075.AA.04.N	1.50	0.75	3.00	4.20	04
<a href="#">12.007</a>	GE305.0160.080.AA.04.N	1.60	0.80	4.00	4.20	04
<a href="#">12.008</a>	GE305.0180.090.AA.04.N	1.80	0.90	4.00	4.20	04
<a href="#">12.009</a>	GE305.0200.100.AA.04.N	2.00	1.00	4.00	4.20	04
<a href="#">12.010</a>	GE305.0220.110.AA.04.N	2.20	1.10	5.00	4.20	04
<a href="#">12.011</a>	GE305.0250.125.AA.04.N	2.50	1.25	5.00	4.20	04
<a href="#">12.012</a>	GE305.0280.140.AA.04.N	2.80	1.40	5.00	4.20	04
<a href="#">12.013</a>	GE305.0300.150.AA.04.N	3.00	1.50	5.00	4.20	04
<a href="#">12.014</a>	GE305.0360.180.AA.04.N	3.60	1.80	5.00	4.20	04
<a href="#">12.015</a>	GE305.0400.200.AA.04.N	4.00	2.00	5.00	4.20	04



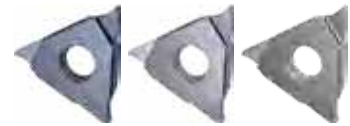
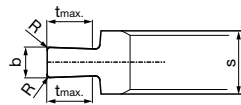
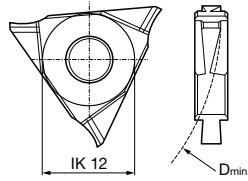
## Indexable insert for axial grooving, straight slots



- grooving depth up to 3 mm
- right index. inserts in rh, left index. inserts in lh tool holders
- Geometry .BA ground

for tool holders type GH305 size 04 see from page 122

Cutting data page 149



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GA 305	GA 305	GA 305
Surface	<b>F</b>	<b>C</b>	○
	FIRE	TiCN	bright

System 305

Series no.	25626	25628	25630
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

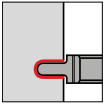
Code no.	Description	D min	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	mm	
<a href="#">12.001</a>	GA305.0150.020.BA.04.R	15.00	1.50	0.20	2.00	4.20	04
<a href="#">12.002</a>	GA305.0200.020.BA.04.R	30.00	2.00	0.20	3.00	4.20	04
<a href="#">12.003</a>	GA305.0250.020.BA.04.R	30.00	2.50	0.20	3.00	4.20	04
<a href="#">12.004</a>	GA305.0300.020.BA.04.R	30.00	3.00	0.20	3.00	4.20	04

Series no.	25627	25629	25631
Cutting direction	<b>(L)</b>	<b>(L)</b>	<b>(L)</b>

Code no.	Description	D min	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	mm	
<a href="#">12.001</a>	GA305.0150.020.BA.04.L	15.00	1.50	0.20	2.00	4.20	04
<a href="#">12.002</a>	GA305.0200.020.BA.04.L	30.00	2.00	0.20	3.00	4.20	04
<a href="#">12.003</a>	GA305.0250.020.BA.04.L	30.00	2.50	0.20	3.00	4.20	04
<a href="#">12.004</a>	GA305.0300.020.BA.04.L	30.00	3.00	0.20	3.00	4.20	04



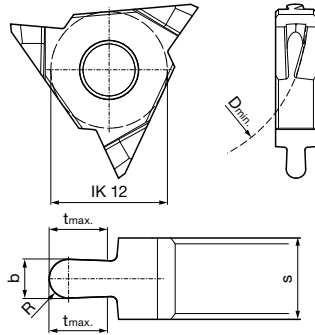
**Indexable insert for axial grooving, full radius slots**



- grooving depth up to 3 mm
- right index. inserts in rh, left index. inserts in lh tool holders
- Geometry .AA ground

for tool holders type GH305 size 04 see from page 122

Cutting data page 149



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GA 305	GA 305	GA 305
Surface	<b>F</b>	<b>C</b>	○
	FIRE	TiCN	bright

Series no.	<b>25634</b>	<b>25636</b>	<b>25638</b>
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

Code no.	Description	D min	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	mm	
<a href="#">12.001</a>	GA305.0150.075.AA.04.R	15.00	1.50	0.75	2.00	4.20	04
<a href="#">12.002</a>	GA305.0200.100.AA.04.R	30.00	2.00	1.00	3.00	4.20	04
<a href="#">12.003</a>	GA305.0300.150.AA.04.R	30.00	3.00	1.50	3.00	4.20	04
<a href="#">12.004</a>	GA305.0400.200.AA.04.R	30.00	4.00	2.00	3.00	4.20	04

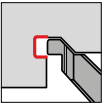
Series no.	<b>25635</b>	<b>25637</b>	<b>25639</b>
Cutting direction	<b>(L)</b>	<b>(L)</b>	<b>(L)</b>

Code no.	Description	D min	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	mm	
<a href="#">12.001</a>	GA305.0150.075.AA.04.L	15.00	1.50	0.75	2.00	4.20	04
<a href="#">12.002</a>	GA305.0200.100.AA.04.L	30.00	2.00	1.00	3.00	4.20	04
<a href="#">12.003</a>	GA305.0300.150.AA.04.L	30.00	3.00	1.50	3.00	4.20	04
<a href="#">12.004</a>	GA305.0400.200.AA.04.L	30.00	4.00	2.00	3.00	4.20	04

System 305



**Indexable insert for grooving axial external recesses**

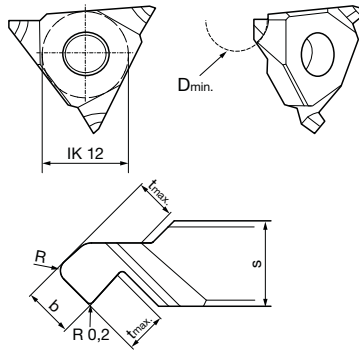


- grooving depth up to 2 mm
- right index. inserts in rh, left index. inserts in lh tool holders
- Geometry .AA ground
- for axial external recesses to ISO 9974-2

for tool holders type GH305, 45° depressed centre, see page 131

Tool material	Solid carbide		
Type	GA 305	GA 305	GA 305
Surface	<b>F</b>	<b>C</b>	○
	FIRE	TiCN	bright

Cutting data page 149



Right hand version shown  
Left hand version mirror image

Series no.	<b>25618</b>	<b>25620</b>	<b>25622</b>
Cutting direction			

Code no.	Description	D min	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	mm	
<a href="#">12.001</a>	GA305.0150.040.AA.04.R	8.00	1.50	0.40	1.60	4.20	04
<a href="#">12.002</a>	GA305.0200.050.AA.04.R	12.00	2.00	0.50	1.90	4.20	04
<a href="#">12.003</a>	GA305.0240.060.AA.04.R	20.00	2.40	0.60	2.00	4.20	04

Series no.	<b>25619</b>	<b>25621</b>	<b>25623</b>
Cutting direction			

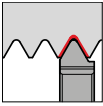
Code no.	Description	D min	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	mm	
<a href="#">12.001</a>	GA305.0150.040.AA.04.L	8.00	1.50	0.40	1.60	4.20	04
<a href="#">12.002</a>	GA305.0200.050.AA.04.L	12.00	2.00	0.50	1.90	4.20	04
<a href="#">12.003</a>	GA305.0240.060.AA.04.L	20.00	2.40	0.60	2.00	4.20	04

System 305





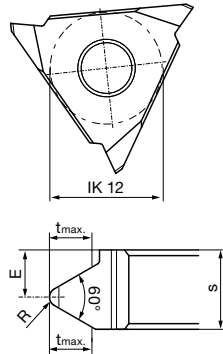
**Indexable insert for thread turning, partial profile**



- grooving depth up to 3.5 mm
- ground top rake
- Geometry .AA ground

for tool holders type GH305 size 04 see from page 122

Cutting data page 149



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GG 305	GG 305	GG 305
Surface	<b>F</b>	<b>C</b>	○
	FIRE	TiCN	bright

Series no.	<b>25654</b>	<b>25656</b>	<b>25658</b>
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

Code no.	Description	P	E	R	t max	s	Size
			mm	mm	mm	mm	
<a href="#">12.010</a>	GG305.TM00.100.AA.04.R	1.00	3.60	0.14	0.70	4.20	04
<a href="#">12.020</a>	GG305.TM00.125.AA.04.R	1.25	3.50	0.17	0.85	4.20	04
<a href="#">12.030</a>	GG305.TM00.150.AA.04.R	1.50	3.40	0.21	1.00	4.20	04
<a href="#">12.040</a>	GG305.TM00.175.AA.04.R	1.75	3.20	0.25	1.20	4.20	04
<a href="#">12.050</a>	GG305.TM00.200.AA.04.R	2.00	3.10	0.28	1.35	4.20	04
<a href="#">12.060</a>	GG305.TM00.250.AA.04.R	2.50	2.90	0.36	1.65	4.20	04
<a href="#">12.070</a>	GG305.TM00.300.AA.04.R	3.00	2.60	0.43	2.60	4.20	04
<a href="#">12.080</a>	GG305.TM00.600.AA.06.R	3.0-6.0	3.50	0.43	3.50	6.20	06
<a href="#">12.090</a>	GG305.TM00.350.AA.04.R	3.50	2.50	0.50	2.50	4.20	04

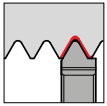
Series no.	<b>25655</b>	<b>25657</b>	<b>25659</b>
Cutting direction	<b>(L)</b>	<b>(L)</b>	<b>(L)</b>

Code no.	Description	P	E	R	t max	s	Size
			mm	mm	mm	mm	
<a href="#">12.010</a>	GG305.TM00.100.AA.04.L	1.00	3.60	0.14	0.70	4.20	04
<a href="#">12.020</a>	GG305.TM00.125.AA.04.L	1.25	3.50	0.17	0.85	4.20	04
<a href="#">12.030</a>	GG305.TM00.150.AA.04.L	1.50	3.40	0.21	1.00	4.20	04
<a href="#">12.040</a>	GG305.TM00.175.AA.04.L	1.75	3.20	0.25	1.20	4.20	04
<a href="#">12.050</a>	GG305.TM00.200.AA.04.L	2.00	3.10	0.28	1.35	4.20	04
<a href="#">12.060</a>	GG305.TM00.250.AA.04.L	2.50	2.90	0.36	1.65	4.20	04
<a href="#">12.070</a>	GG305.TM00.300.AA.04.L	3.00	2.60	0.43	2.60	4.20	04
<a href="#">12.080</a>	GG305.TM00.600.AA.06.L	3.0-6.0	3.50	0.43	3.50	6.20	06
<a href="#">12.090</a>	GG305.TM00.350.AA.04.L	3.50	2.50	0.50	2.50	4.20	04

System 305



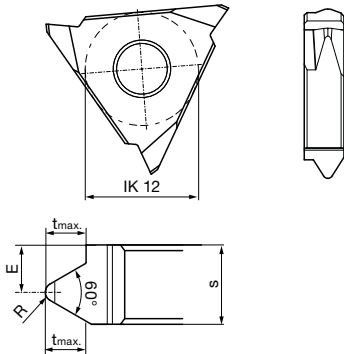
**Indexable insert for thread turning, full profile**



- grooving depth up to 3.9 mm
- ground top rake
- Geometry .AA ground

for tool holders type GH305 size 04 see from page 122

Cutting data page 149



Right hand version shown  
Left hand version mirror image



Series no.	<b>25662</b>	<b>25664</b>	<b>25666</b>
Cutting direction			

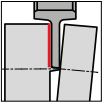
Code no.	Description	P	E	R	t max	s	Size
		mm	mm	mm	mm	mm	
<a href="#">12.010</a>	GG305.VM00.100.AA.04.R	1.00	3.60	0.14	0.70	4.20	04
<a href="#">12.020</a>	GG305.VM00.125.AA.04.R	1.25	3.40	0.17	1.00	4.20	04
<a href="#">12.030</a>	GG305.VM00.150.AA.04.R	1.50	3.30	0.21	1.15	4.20	04
<a href="#">12.040</a>	GG305.VM00.175.AA.04.R	1.75	3.20	0.25	1.30	4.20	04
<a href="#">12.050</a>	GG305.VM00.200.AA.04.R	2.00	3.10	0.28	1.45	4.20	04
<a href="#">12.060</a>	GG305.VM00.250.AA.04.R	2.50	2.90	0.36	1.75	4.20	04
<a href="#">12.070</a>	GG305.VM00.300.AA.04.R	3.00	2.70	0.43	2.10	4.20	04
<a href="#">12.080</a>	GG305.VM00.350.AA.04.R	3.50	2.40	0.50	2.40	4.20	04
<a href="#">12.090</a>	GG305.VM00.400.AA.06.R	4.00	4.20	0.57	2.70	6.20	06
<a href="#">12.100</a>	GG305.VM00.500.AA.06.R	5.00	3.80	0.72	3.30	6.20	06
<a href="#">12.110</a>	GG305.VM00.600.AA.08.R	6.00	5.20	0.86	3.90	8.20	08

Series no.	<b>25663</b>	<b>25665</b>	<b>25667</b>
Cutting direction			

Code no.	Description	P	E	R	t max	s	Size
		mm	mm	mm	mm	mm	
<a href="#">12.010</a>	GG305.VM00.100.AA.04.L	1.00	3.60	0.14	0.70	4.20	04
<a href="#">12.020</a>	GG305.VM00.125.AA.04.L	1.25	3.40	0.17	1.00	4.20	04
<a href="#">12.030</a>	GG305.VM00.150.AA.04.L	1.50	3.30	0.21	1.15	4.20	04
<a href="#">12.040</a>	GG305.VM00.175.AA.04.L	1.75	3.20	0.25	1.30	4.20	04
<a href="#">12.050</a>	GG305.VM00.200.AA.04.L	2.00	3.10	0.28	1.45	4.20	04
<a href="#">12.060</a>	GG305.VM00.250.AA.04.L	2.50	2.90	0.36	1.75	4.20	04
<a href="#">12.070</a>	GG305.VM00.300.AA.04.L	3.00	2.70	0.43	2.10	4.20	04
<a href="#">12.080</a>	GG305.VM00.350.AA.04.L	3.50	2.40	0.50	2.40	4.20	04
<a href="#">12.090</a>	GG305.VM00.400.AA.06.L	4.00	4.20	0.57	2.70	6.20	06
<a href="#">12.100</a>	GG305.VM00.500.AA.06.L	5.00	3.80	0.72	3.30	6.20	06
<a href="#">12.110</a>	GG305.VM00.600.AA.08.L	6.00	5.20	0.86	3.90	8.20	08



**Indexable insert for parting off**

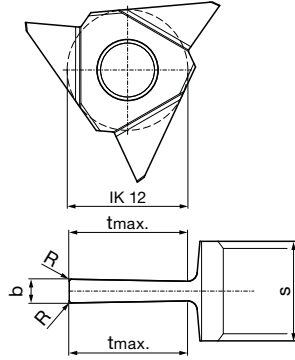


- grooving depth up to 5 mm
- Indexable insert applicable in right and left holders
- Geometry .AA ground
- without front cutting angle

for tool holders type GH305 size 04 see from page 122

Cutting data page 149

Tool material	Solid carbide		
Type	GZ 305	GZ 305	GZ 305
Surface	<b>F</b>	<b>C</b>	○
	FIRE	TiCN	bright



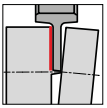
Series no. **25641** **25642** **25643**

Code no.	Description	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	
<a href="#">12.001</a>	GZ305.0100.000.AA.04.N	1.00	0.10	5.00	4.20	04
<a href="#">12.002</a>	GZ305.0150.000.AA.04.N	1.50	0.10	5.00	4.20	04

System 305



**Indexable insert for parting off**

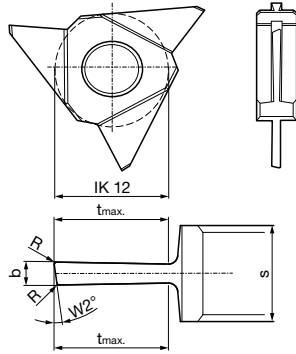


- **grooving depth up to 5 mm**
- Indexable insert applicable in right and left holders
- Geometry .AA ground
- with front cutting angle

for tool holders type GH305 size 04 see from page 122

Tool material	Solid carbide		
Type	GZ 305	GZ 305	GZ 305
Surface	<b>F</b>	<b>C</b>	○
	FIRE	TiCN	bright

Cutting data page 149



Right hand version shown  
Left hand version mirror image

Series no. **25646** **25648** **25650**  
version right-hand right-hand right-hand

Code no.	Description	b ± 0.02	R	W2	t max	s	Size
		mm	mm	°	mm	mm	
<a href="#">12.001</a>	GZ305.0100.080.AA.04.R	1.00	0.10	8.00	5.00	4.20	04
<a href="#">12.002</a>	GZ305.0150.080.AA.04.R	1.50	0.10	8.00	5.00	4.20	04

Series no. **25647** **25649** **25651**  
version left-hand left-hand left-hand

Code no.	Description	b ± 0.02	R	W2	t max	s	Size
		mm	mm	°	mm	mm	
<a href="#">12.001</a>	GZ305.0100.080.AA.04.L	1.00	0.10	8.00	5.00	4.20	04
<a href="#">12.002</a>	GZ305.0150.080.AA.04.L	1.50	0.10	8.00	5.00	4.20	04

System 305



# **TECHNICAL SECTION & ACCESSORIES**





SYSTEM 104/106

Machining	Feed range f (IPR)	Point radius R (mm)	Cutting depth ap (in)	General formulas
	0.0008 - 0.0031	R 0.05 (0.002in) R 0.10 (0.004in) R 0.15 (0.006in) R 0.20 (0.008in) R 0.25 (0.010in) R 0.30 (0.012in)	0.0008 - 0.0028 0.0020 - 0.0059 0.0031 - 0.0079 0.0047 - 0.0098 0.0051 - 0.0110 0.0067 - 0.0138	Cutting speed (SFM) RPM x Dia. / 3.82 = SFM
	0.0004 - 0.0012			Revolutions per minute (RPM) SFM x 3.82 / Dia. = RPM
	0.0004 - 0.0020		Rule of thumb: ap ~ r	Feed rate (IPM) IPR x RPM = IPM



Guide values for feed and cutting depths

ISO	Material	Material examples/ material number	Tensile strength (N/mm <sup>2</sup> )	Brinell hardness (HB)	Cutting speed SFM (surface feet / min)				
					TiN	TiAlN nanoA	Bright		
P	Carbon steel	C <= 0.15 %	11SMn30+C / 1.0715 C15 / 1.0401	500 600	150 180	65-525	165-655	50-295	
		C ≥ 0.15 - 0.45 %	S235JR (ST37-2) / 1.0037 Ck22 / 1.1151	400 600	120 180				
		C > 0.45 %	S355JO (St52-3) / 1.0553 C60 / 1.0601	600 900	180 270				
	Low-alloyed steel (alloy content ≤5%)	annealed	16MnCr5 / 1.7131 18CrNi8 / 1.5920	650 650	200 200	65-525	165-590	50-230	
		heat-treatable	25CrMoV4 / 1.7218 42CrMo4V / 1.7225	900 1100	270 320				
	High-alloyed steel (alloy content >5%)	annealed	X37CrMoV5-1 / 1.2343 X153CrMoV12 / 1.2379	750 850	220 250	80-295	130-460	-	
		heat-treatable	55NiCrMoV7 / 1.2714	1200	350				
	Cast steel	un-alloyed, low-alloyed	GS52 / 1.0552	600	180	65-395	100-590	-	
		high-alloyed	GX40CrNiSi22-10 / 1.4826	750	220	-	100-295	-	
	M	Stainless steel	martensitic, ferritic, tempered	X14CrMoS17 / 1.4104	800	240	65-230	100-295	-
X4CrNiMo16-5-1 / 1.4418				1000	300				
austenitic, Ni > 8%			X5CrNi18-10 / 1.4301 X2CrNiMo17-12-2 / 1.4404	650	200	65-300	100-360	-	
austenitic, ferritic (Duplex)			X2CrNiMoCuN25-6-3 / 1.4507 X2CrNiMoN25-7-4 / 1.4410	850	250	-	100-330	-	
K	Grey cast iron	low tensile strength	EN-GJL-200 (GG20) / 0.6020		180	100-490	100-590	100-295	
		high tensile strength	EN-GJL-400 (GG40) / 0.6040		260	100-395	100-490	100-230	
	Spheroidal graphite iron	low tensile strength	EN-GJS-400-15 (GGG40) / 0.7040		160	100-425	100-525	-	
		high tensile strength	EN-GJS-700-2 (GGG70) / 0.7070		260	100-360	100-460	-	
	Malleable cast iron	low tensile strength	EN-GJMW-350-4 (GTW35) / 0.8035		125	100-425	100-525	-	
		high tensile strength	EN-GJMB-550-4 (GTS55) / 0.8155		250	100-360	100-460	-	
N	Al-alloys	non-heat-treatable <12% Si	EN-AW-2017 (AlCuMg1) / 3.1325		60	100-1805	100-1805	100-820	
		heat-treatable <12% Si	EN-AW-6082 (AlMgSi1) / 3.2315		100	100-1310	100-1310	100-590	
	Al-cast-alloys	non-heat-treatable <12% Si	AlSi9Cu3 / 3.2163		80	100-1805	100-1805	100-820	
		heat-treatable <12% Si	AlSi10Mg / 3.2383		100	100-1310	100-1310	100-590	
	Copper alloys	brass, lead alloy	CuZn39Pb2 (MS58) / 2.0380	400	120	100-1310	100-1310	100-590	
		bronze	CuSn6 / 2.1020	500	150	100-240	100-240	100-590	
	S	Heat resistant alloys, super alloys	NiFe-base, annealed	NiCr15Fe (Alloy600) / 2.4816	700		-	50-230	
			NiFe-base, hardened		950		-	50-165	
NiCo-base, annealed			NiMo16Cr15W (Alloy C-276) / 2.4819	800		-	50-165		
NiCo-base, cast				1100		-	30-130	-	
NiCo-base, hardened			NiCr19NbMo (Alloy718) / 2.4668	1200		-	30-115		
Titanium-alloys		annealed	Ti6Al4V / 3.7164	900		-	15-165		
		hardened		1200		-	30-115		
H	Hardened steels	Heat-treatable steel			> 52 HRC	-	65-130	-	
		Heat-treatable/case hardened steel			> 59 HRC	-	30-100	-	
		Heat-treatable/case hardened steel			> 62 HRC	-	(CBN)	-	

The specified values must be adapted to the machine and machining conditions.



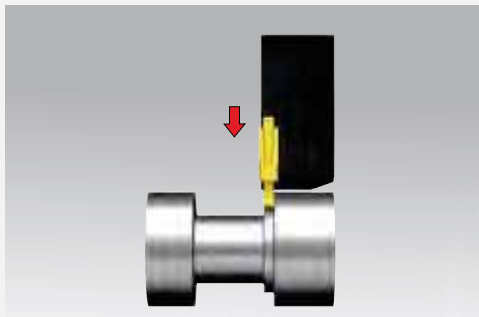
SYSTEM 305

 <p><b>Geometry .BA ground round chip breaker</b></p>	<p><b>Feed rate f (IPR)</b></p> <p>↓ 0.0012 - 0.0059</p> <p>↔ 0.0008 - 0.0047 ap = 0.0039 - 0.0197 in</p>	 <p><b>Geometry .AA ground flat chip breaker</b></p>	<p><b>Feed rate f (IPR)</b></p> <p>↓ 0.0012 - 0.0059</p> <p>↔ 0.0008 - 0.0047 ap = 0.0039 - 0.0197 in</p>	<p><b>General formulas</b></p> <p>Cutting speed (SFM) RPM x Dia. / 3.82 = SFM</p> <p>Revolutions per minute (RPM) SFM x 3.82 / Dia. = RPM</p> <p>Feed rate (IPM) IPR x RPM = IPM</p>
	<p>↓ = radial feed direction      ↔ = axial feed direction</p>			

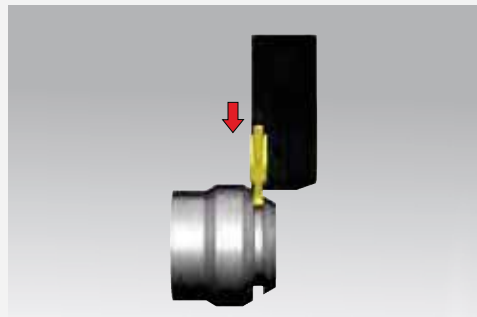
ISO	Material	Material examples/ material number	Tensile strength (N/mm <sup>2</sup> )	Brinell hardness (HB)	Cutting speed (surface feet / min)		
					FIREX/nanoFIREX <sup>®</sup>	TiCN <sup>®</sup>	
P	Carbon steel	C <= 0.15 %	11SMn30+C / 1.0715 C15 / 1.0401	500 600	150 180	490-720	425-655
		C ≥ 0.15 - 0.45 %	S235JR (ST37-2) / 1.0037 Ck22 / 1.1151	400 600	120 180		
		C > 0.45 %	S355JO (St52-3) / 1.0553 C60 / 1.0601	600 900	180 270		
	Low-alloyed steel (alloy content ≤5%)	annealed	16MnCr5 / 1.7131 18CrNi8 / 1.5920	650 650	200 200	395-560	295-490
		heat-treatable	25CrMoV4 / 1.7218 42CrMo4V / 1.7225	900 1100	270 320		
	High-alloyed steel (alloy content >5%)	annealed	X37CrMoV5-1 / 1.2343 X153CrMoV12 / 1.2379	750 850	220 250	425-590	-
		heat-treatable	55NiCrMoV7 / 1.2714	1200	350		
	Cast steel	un-alloyed, low-alloyed	GS52 / 1.0552	600	180	425-590	-
		high-alloyed	GX40CrNiSi22-10 / 1.4826	750	220	330-460	-
	M	Stainless steel	martensitic, ferritic, tempered	X14CrMoS17 / 1.4104 X4CrNiMo16-5-1 / 1.4418	800 1000	240 300	295-525
austenitic, Ni > 8%			X5CrNi18-10 / 1.4301 X2CrNiMo17-12-2 / 1.4404	650	200		
austenitic, ferritic (Duplex)			X2CrNiMoCuN25-6-3 / 1.4507 X2CrNiMoN25-7-4 / 1.4410	850	250	230-330	165-395
Grey cast iron			low tensile strength	EN-GJL-200 (GG20) / 0.6020		180	295-490
K	Spheroidal graphite iron	high tensile strength	EN-GJL-400 (GG40) / 0.6040		260	230-360	-
		low tensile strength	EN-GJS-400-15 (GGG40) / 0.7040		160	295-490	230-330
	Malleable cast iron	high tensile strength	EN-GJS-700-2 (GGG70) / 0.7070		260	230-360	165-295
		low tensile strength	EN-GJMW-350-4 (GTW35) / 0.8035		125	230-460	165-330
N	Al-alloys	high tensile strength	EN-GJMB-550-4 (GTS55) / 0.8155		250	165-295	165-230
		non-heat-treatable <12% Si	EN-AW-2017 (AlCuMg1) / 3.1325		60	-	1640-2625
	Al-cast-alloys	heat-treatable <12% Si	EN-AW-6082 (AlMgSi1) / 3.2315		100	-	655-1310
		non-heat-treatable <12% Si	AlSi9Cu3 / 3.2163		80	-	1640-2625
	Copper alloys	heat-treatable <12% Si	AlSi10Mg / 3.2383		100	-	655-1310
		brass, lead alloy	CuZn39Pb2 (MS58) / 2.0380	400	120	-	435-820
S	Heat resistant alloys, super alloys	bronze	CuSn6 / 2.1020	500	150	-	330-590
		NiFe-base, annealed	NiCr15Fe (Alloy600) / 2.4816	700		-	100-230
		NiFe-base, hardened		950		-	400-165
		NiCo-base, annealed	NiMo16Cr15W (Alloy C-276) / 2.4819	800		-	100-195
		NiCo-base, cast		1100		-	100-130
	Titanium-alloys	NiCo-base, hardened	NiCr19NbMo (Alloy718) / 2.4668	1200		-	65-100
		annealed	Ti6Al4V / 3.7164	900		-	100-165
		hardened		1200		-	65-100
H	Hardened steels	Heat-treatable steel			> 52 HRC	66-131	-
		Heat-treatable/case hardened steel			> 59 HRC	33-98	-
		Heat-treatable/case hardened steel			> 62 HRC	(CBN)	-

The specified values must be adapted to the machine and machining conditions.

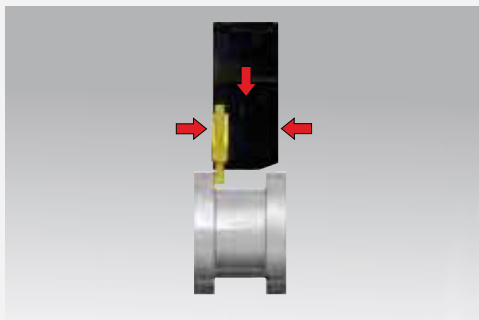
## General machining hints



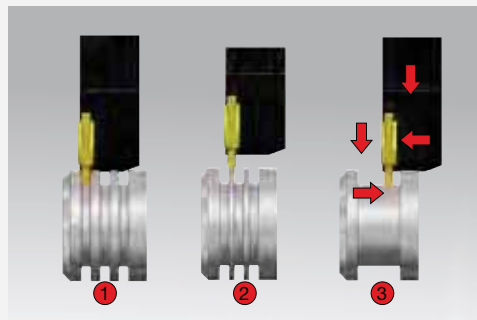
Width of machining should be min. 70% of the width of the cutting edge



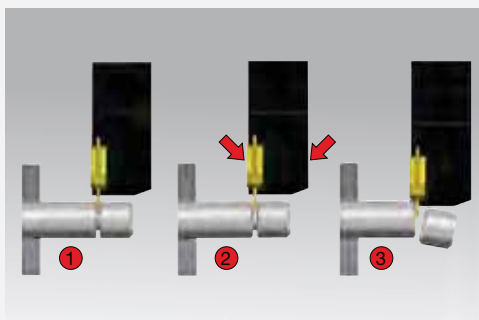
Reduce feed by 20 – 50% when grooving on angled faces



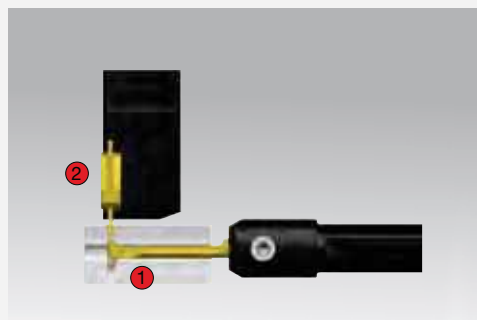
Recessing  
 - radial in-feed  
 - turning in axial direction  
 - leave axial and radial stock for finishing



Process tip for recessing:  
 1 – pre-grooving "comb"  
 2 – removing remaining webs  
 max width of webs: insert width  $b - (2xr)$   
 3 - finishing



Process tip for parting:  
 1 – pre-grooving  
 2 – chamfering  
 3 - parting



Process tip for parting into a central bore:  
 1 – pre-grooving with tool type GV104  
 2 – parting with tool type GZ305





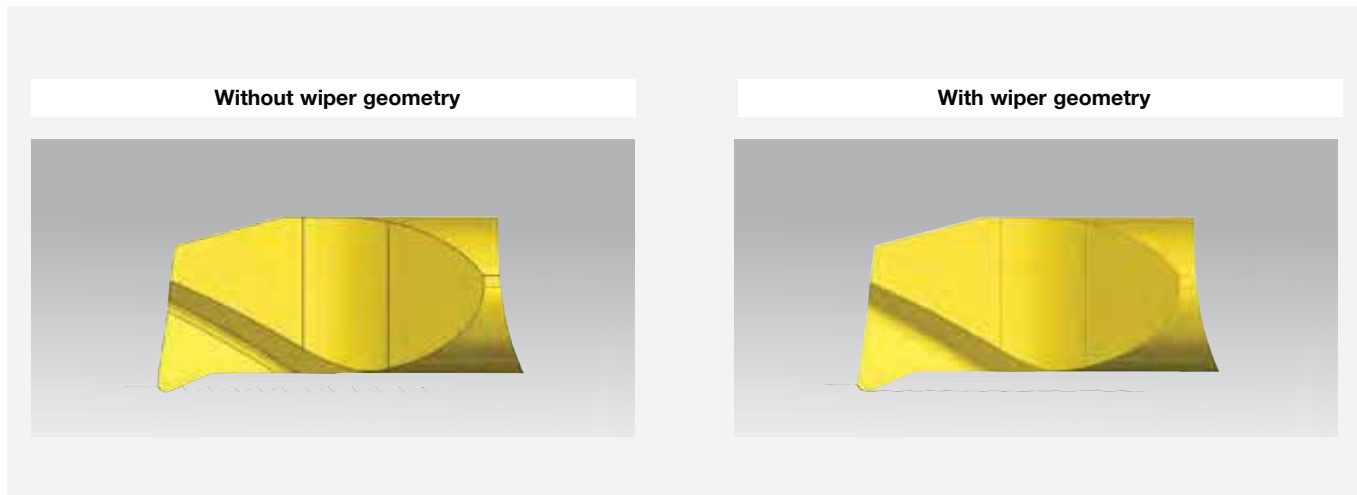
# Troubleshooting

Subject		Solution											
		Feed	Feed at centre	Cutting speed	RH/LH edge orientation	Corner radius	Wiper	Width of groove	Tool clamping	Workpiece clamping	Tool overhang	Centre height of cutting edge	Coolant
Related to wear	Edge chipping	↓	↓			↑			🔍	🔍	🔍	🔍	
	Build up edge			↑									👍
	Flank wear	🔍	↓	↓		↑					🔍		👍
	Plastic deformation	↓	↑	↓		↑							👍
Related to the component	Vibrations	↑		↓		↓		↓	🔍	🔍	↓	🔍	
	Burrs		↓		👍	↓						🔍	👍
	Surface	↓	↓	↑		↑	👍	↑	🔍	🔍	↓	🔍	👍
	Long chips (no chip breakage)	↑		↑									👍
	(too) short chips, compressed chips	↓											

- ↓ decrease values (large impact)
- ↑ increase values (large impact)
- ↓ decrease values (low impact)
- ↑ increase values (low impact)
- 🔍 check
- 👍 apply



# Application hints for the cutting insert GJ104/106 with wiper geometry



### The wiper geometry offers multiple options

- You retain the feed rate of the cutting insert without wiper geometry and achieve a considerably better surface finish.
- You increase the feed rate taking the entire process (material, chip formation, stability) into consideration and achieve the following improvements:
  - reduced machining time
  - therefore reduced engagement of the tool, improving tool life
  - improved chip formation/chip breakage
  - thicker chip enables better heat dissipation

### Please note the following carefully!

The cutting insert/holder must be positioned axially parallel to optimize the wiper. This is the only way the wiper geometry can achieve its desired effect to improve the surface finish.

### General formulas to determine the surface finish quality

$R_{th} = f^2 / 8 \cdot r$	$r = f^2 / 8 \cdot R_{th}$	$f = \sqrt{8 \cdot r \cdot R_{th}}$
----------------------------	----------------------------	-------------------------------------

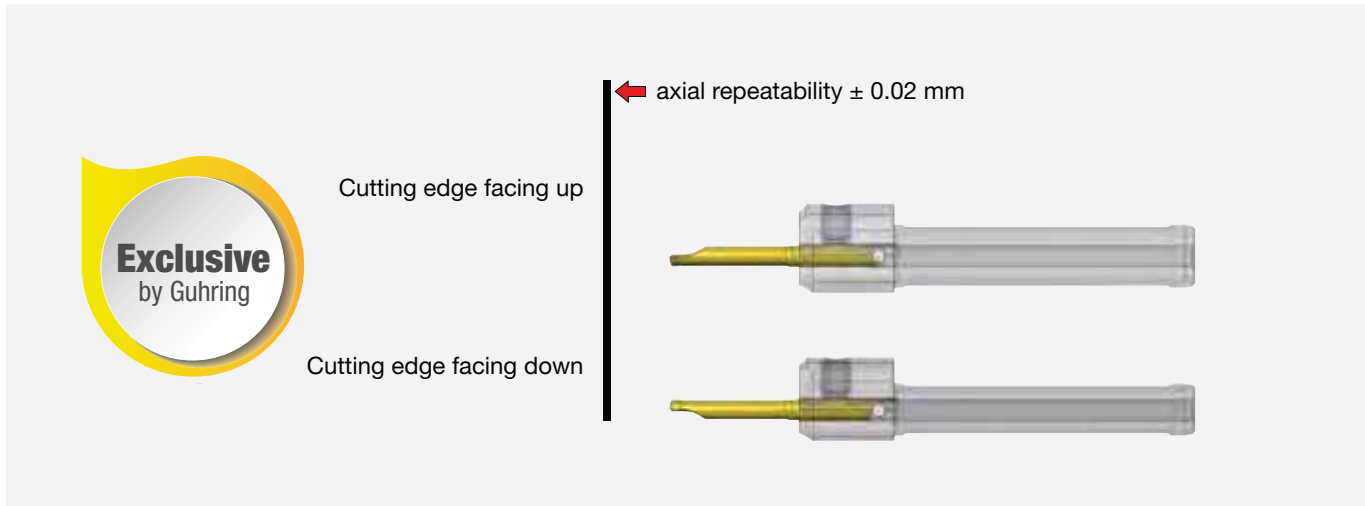
### Application example

Application: Boring out Ø 4 mm		Tool selection		Customer benefit
Component:	Sleeve	System:	104	Rz 5-8 µm was achieved with a cutting insert without wiper. With a wiper cutting insert Rz values could be improved to 2-4 µm. In the 2nd step vc was increased to 130 m/min. This resulted in an improved surface finish.
Material:	42CrMo4	Holder:	GB104.0016.075.00.15.N.IK	
	1.7225	Insert:	GJ104.2337.020.17.40.R	
Machine:	Spinner		TiAlN nanoA	
Cooling:	20 bar			
Operat. step:	Finishing			
vc:	90 m/min			
f:	0.08 mm			
ap:	0.15			
Groov. depth:	-			



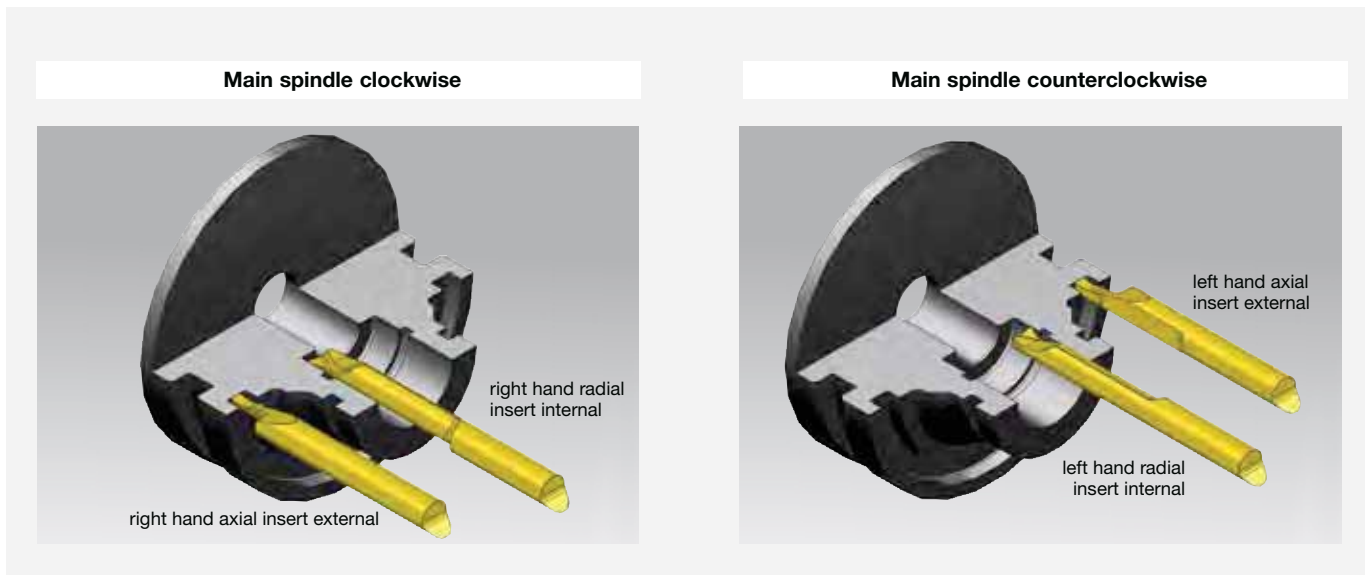
# System 104/106

## Positioning and clamping



Guhring's system 104/106 is unique in terms of insert positioning and clamping: The position between cutting edge facing up and cutting edge facing down can be changed by keeping the same length position without loosening the holder.

## Definition of the cutting edge position





# Internal threading System GG 104 and GG 106

Pitch/P		Recommended number of cuts with internal threading						
		Steel materials (tensile strength in N/mm <sup>2</sup> )			Stainless steel	Cast iron	Heat-resistant alloys	Aluminium
mm	Gg/“	400-700	700-1150	> 1150				
0.3		3	4	5	5	3	5	3
0.5	48	5	6	8	8	5	8	5
0.8	32	7	8	9	9	7	9	7
1	24	8	9	10	10	8	10	8
1.25	20	10	11	12	12	10	12	10
1.5	16	12	13	15	15	12	15	12
1.75	14	14	15	18	18	14	18	14
2	12	16	17	20	20	16	20	16
3	8	22	24	30	30	22	30	22

## Feed direction internal threading

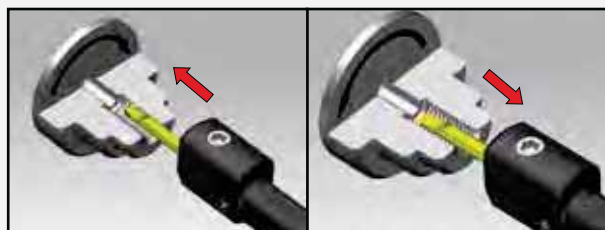
### Right-hand thread



Insert: Right-hand design  
Direction of rotation: Clockwise  
M3 turning from outside in

Insert: Left-hand design  
Direction of rotation: Counter-clockwise  
M4 turning from inside out

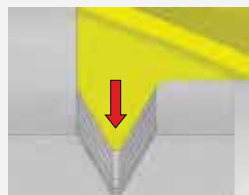
### Left-hand thread



Insert: Left-hand design  
Direction of rotation: Counterclockwise  
M4 turning from outside in

Insert: Right-hand design  
Direction of rotation: Clockwise  
M3 turning from inside out

## Feed process



### Radial feed

- Both cutting edges engaged at the same time
- High cutting pressure and thermal load
- Especially suitable for the machining of short-chipping materials
- For the production of threads with a small pitch and small thread depth as well as multiple start depths to prevent pitch errors



### One-sided flank in-feed

- Only one cutting edge engaged
- Lower cutting pressure and thermal load
- Especially suitable for the machining of long-chipping materials
- Achieve a higher surface finish quality at the respective thread flank



### Reciprocal flank in-feed

- Both cutting edges alternately engaged
- Lower cutting pressure and thermal load
- Especially suitable for the machining of long-chipping materials
- Achieve a higher surface finish quality at the flanks



# Internal threading System GG 104 and GG 106

Pre-drill diameters for metric threads						
Standard pitch thread				Fine pitch thread		
Nominal Ø	Pitch mm	Pre-drill Ø* full profile mm	Pre-drill Ø partial profile mm	Nominal Ø	Pitch mm	Pre-drill Ø partial profile mm
M 2	0.40	1.50	1.60	M 2	0.20	1.80
M 2.5	0.45	1.85	2.05	M 2.5	0.35	2.15
M 3	0.50	2.40	2.50	M 3	0.35	2.65
M 4	0.7	3.10	3.30	M 3.5	0.35	3.15
M 4.5	0.75		3.75	M 4	0.50	3.50
M 5	0.80	4.00	4.20	M 4.5	0.50	4.00
M 6	1.00		5.00	M 5	0.50	4.50
M 8	1.25		6.80	M 5.5	0.50	5.00
M 10	1.5		8.5	M 6	0.75	5.25
M 12	1.75		10.25			

\*max. allowance (ap) in core diameter = 0.2 mm

## Application example

Application: Internal thread		Tool selection		Customer benefit
Component:	Threaded sleeve	System:	106	Guhring's cutting insert leads to considerably less manual re-working. The customer saves time and money.
Material:	TiAl 6 V 4	Holder:	GB106.0016.090.00.22.N.IK	
	3.7165	Insert:	GG106.TM08.125.22.68.R	
Machine:	Mazak Nexus 200			
Cooling:	12 bar			
Operat.step:	Threading			
vc:	25 m/min			
f:	Pitch			
ap:				
Groov. depth:				



# Broaching System GN 104 and GN 106

## General hints

Please align the tool accurately.

The alignment surface on the tool holder GB104/106 provides a significant benefit.

## Application instructions

- For blind holes there must be an undercut or cross hole at the bottom of the broach profile to allow chip evacuation.
- As a general rule the delivery of coolant (soluble or neat oil) helps the broaching process. It promotes chip evacuation, increases tool life, and improves surface finish.
- On the return stroke the tool must travel completely out of the hole.
- Pay attention to the feed  $\varnothing$  when programming the first stroke (load on the cutting corners).

### Calculating the feed diameter $\varnothing d1$ for the first stroke

Example: Hole  $\varnothing$ : 8 mm  
 Groove width: 5 mm  
 Safety distance between cutting corners and workpiece  $\varnothing$ : 0.15 mm

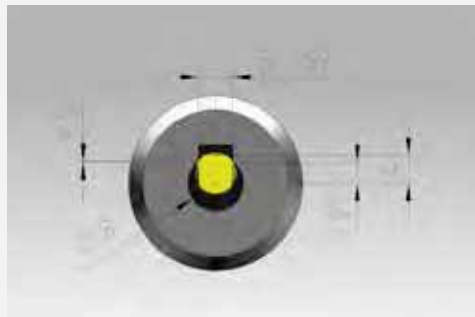
$r = \text{radius workpiece (hole } \varnothing 8/2) = 4$   
 $b = \text{Cutting edge} / 2 (5/2) = 2.5$

Feed radius =  $\sqrt{r^2 - b^2} - \text{safety distance}$

Feed radius =  $\sqrt{4^2 - 2.5^2} - 0.15 = 2.97$

**Feed diameter  $\varnothing d1 = 2.97 \times 2 = \varnothing 5.94$**

**The feed diameter for the first stroke in the machining example above is  $\varnothing 5.94$**



## Feed and feed rate

- The feed per stroke is dependent on the tensile strength of the material to be machined.
- The feed rate when broaching corresponds to the cutting speed and is controlled by the Z-axis of the machine.
- Achievable speeds are partly limited by the machine conditions.

	Tensile strength (N/mm <sup>2</sup> )					
	300	400	600	800	1000	1200
Feed rate (mm/min)	10000	8000	7000	6000	5000	4000
Feed per stroke (mm)	0.1	0.08	0.07	0.06	0.05	0.04

\* Values are for guidance only. The machine condition, rigidity of component clamping as well as the workpiece material influence the cutting parameters.



# Broaching System GN 104 and GN 106

## Sequence of machining

### Broaching square profile:

- The broaching inserts generate a 90° corner
- The component must be repositioned 4 times each 90° to complete the square profile



### Broaching hexagon profile:

- The broaching inserts generate a 60° corner
- The component must be repositioned 6 times each 60° to complete the hexagon profile



### Broaching Torx profile:

- The broaching inserts generate one section of the torx profile
- The component must be repositioned 6 times each 60° to complete the torx profile



## Application example

Application: Hexagon broaching		Tool selection		Customer benefit
Component:	Sleeve	System:	106 Special tool	The current process required a high amount of manual rework. Also the tool life was low. With the Guhring tool the customer achieves a very good surface with high tool life. Also there is no more manual rework required.
Material:	X 10 CrNiS 18 9	Holder:	GB106.0025.075.00.22.S.IK	
	1.4305	Insert:	Special insert	
Machine:	Spinner TC 65		TiAlN nanoA	
Cooling:	20 bar			
Operat. step:	Semifinishing & finishing			
vc:	-			
f:	3200 mm			
ap:	0,06			
Groov. depth:	SW 9.3 (special)			



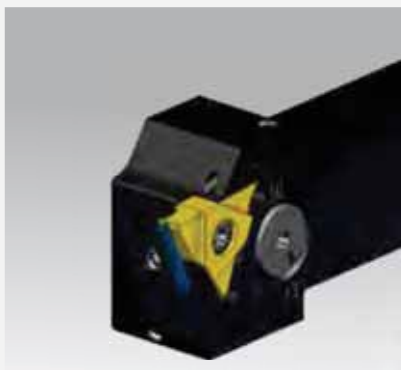
# Application hints for holder GH305...EST with adjustable coolant supply



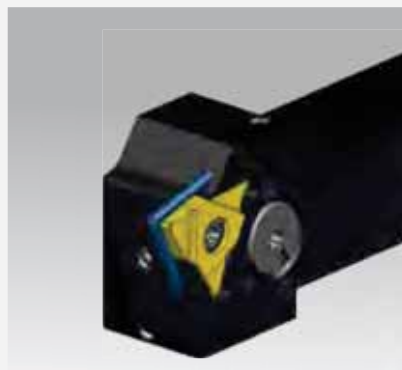
The adjustable valve directs the coolant to the cutting edge as follows:



Coolant supply directed to the rake face



Coolant supply directed to the clearance face



Coolant supply directed to both spots

The GH305 . . . EST is Guhring's patent pending grooving holder with internal coolant.

### What makes it worth the effort?

- You can optimally provide your process with coolant even at low coolant pressure:
  - first choice is the coolant supply to the rake face
  - if chips interfere or prevent coolant delivery, the temperature can be effectively controlled by cooling the clearance face.
- With high coolant pressure we recommend cooling from both coolant holes:
  - cooling the rake face can positively influence chip fracture
  - cooling the clearance face provides additional temperature reduction of cutting edge

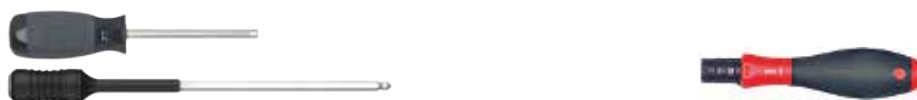
### Application example

Application: External grooving radial		Tool selection		Customer benefit
Component:	Piston	System:	305	Guhring's precision ground insert offers more tool life than the just sintered product of the competitor. Additionally the customer reported better chip formation as well as improved surface quality.
Material:	17 CrNiM0 6	Holder:	GH305.2020.125.00.04.R.IK.EST	
	1.6587	Insert:	GE305.0200.020.BA.04.N	
Machine:	Mazak Quick Turn Smart 200			
Cooling:	20 bar			
Operat. step:	groov. 58 HRC, 0.8mm case d.			
vc:	40 m/min			
f:	0.06 mm			
ap:				
Groov. depth:	3 mm			





**Torque wrenches**



Series no. **4915**

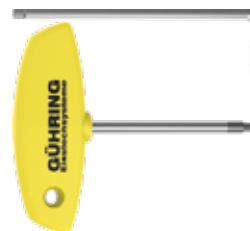
Size		l1 mm	Code no.
1/4	2-8	200.000	<a href="#">8.000</a>



Series no. **4960**

Size		l1 mm	Code no.
6,6 NM		175.000	<a href="#">15.000</a>

Key with T-handle code no. 15.000  
Allen key code no. 15.001



Series no. **25904**

Size		l1 mm	Code no.
15IP		65.000	<a href="#">15.000</a>
15IP		97.000	<a href="#">15.001</a>

**Clamping screws**



Series no. **25900**

Size	d1	l1 mm	Code no.
15IP	M6	7.500	<a href="#">6.000</a>



Series no. **25901**

Size	d1	l1 mm	Code no.
15IP	M4	15.000	<a href="#">4.000</a>
15IP	M4	22.000	<a href="#">4.001</a>



Series no. **25902**

Size	d1	l1 mm	Code no.
15IP	M4	15.000	<a href="#">4.000</a>
15IP	M4	7.000	<a href="#">4.001</a>

**Activation screws**



Series no. **25905**

Size	d1	l1 mm	Code no.
SW 4	G1/8	5.000	<a href="#">5.000</a>

# SPECIAL SOLUTIONS made to measure

## SYSTEM 104



**Face grooving and copying  
dovetail grooving**

Insert: GA 104



**Internal threading**

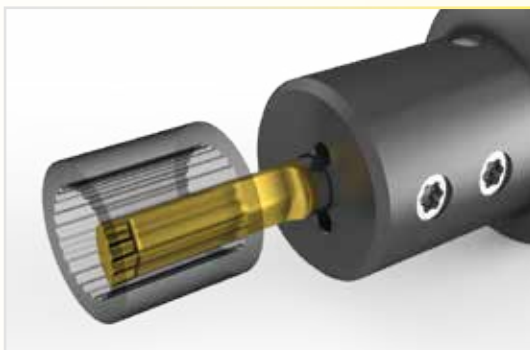
Insert: GG 104

## SYSTEM 106



**Copying a radius at the bottom  
of a bore on a turning center**

Insert: GT 106



**Broaching an internal spline,  
rough and finish cutter in one tool**

Insert: GN 106

# SYSTEM 305



**Broaching an internal longitudinal  
grooves from hole  $\varnothing$  30 mm,**

**i.e. for profile forms or tooth profiles**

Clamping holder and indexable insert type 305



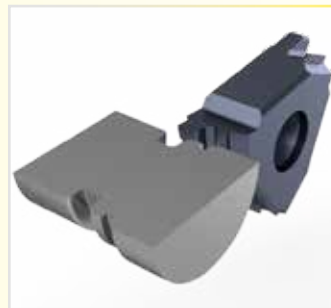
**External/internal circular milling  
of form recesses**

Milling body and indexable insert type 305



**Indexable insert type 305, basic width 4.2 mm**

Grooving with external edge chamfering,  
form width up to 4.2 mm, form depth up to 4 mm



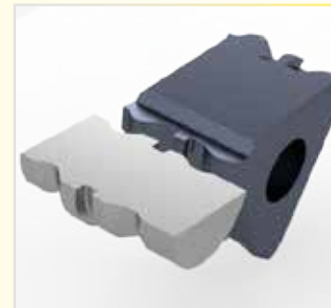
**Indexable insert type 305, basic width 6.2 mm**

Two grooves in one operation,  
form width up to 6.2 mm, form depth up to 4 mm



**Indexable insert type 305, basic width 8.2 mm**

Profile form insert, external contour,  
form width up to 8.2 mm, form depth up to 4 mm



**Indexable insert type 305, basic width 12.2 mm**

Profile form insert, external contour,  
form width up to 12.2 mm, form depth up to 4 mm



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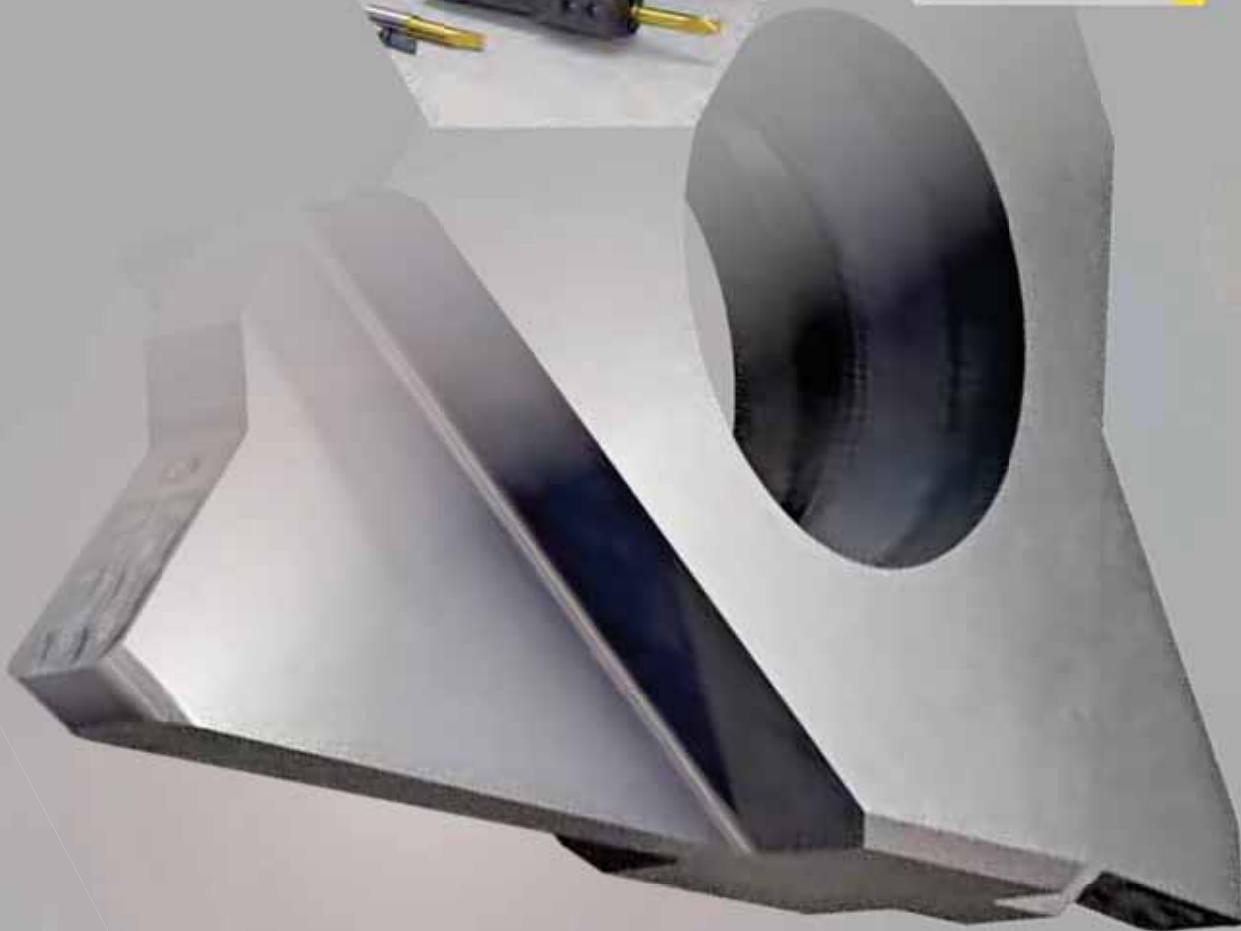
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