

GUHRING

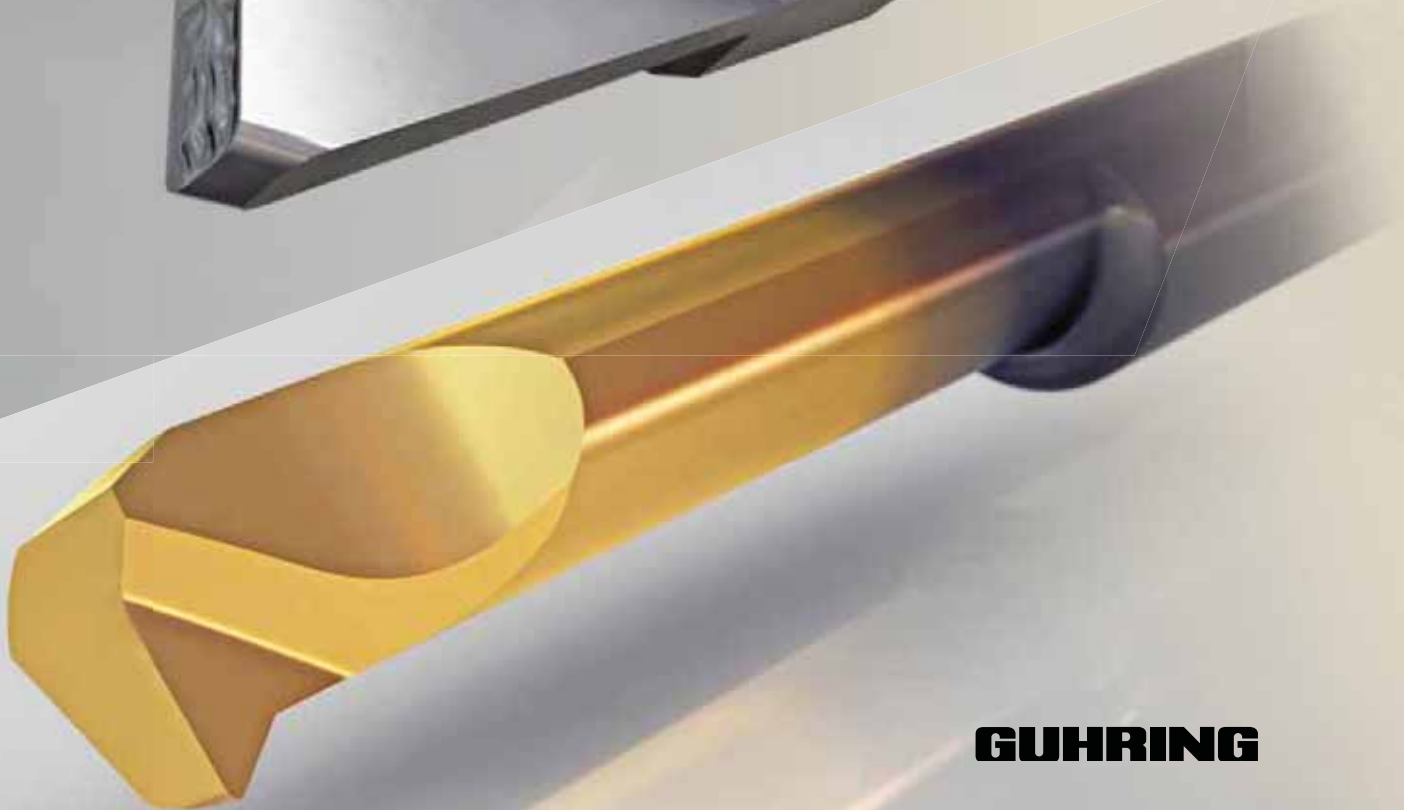
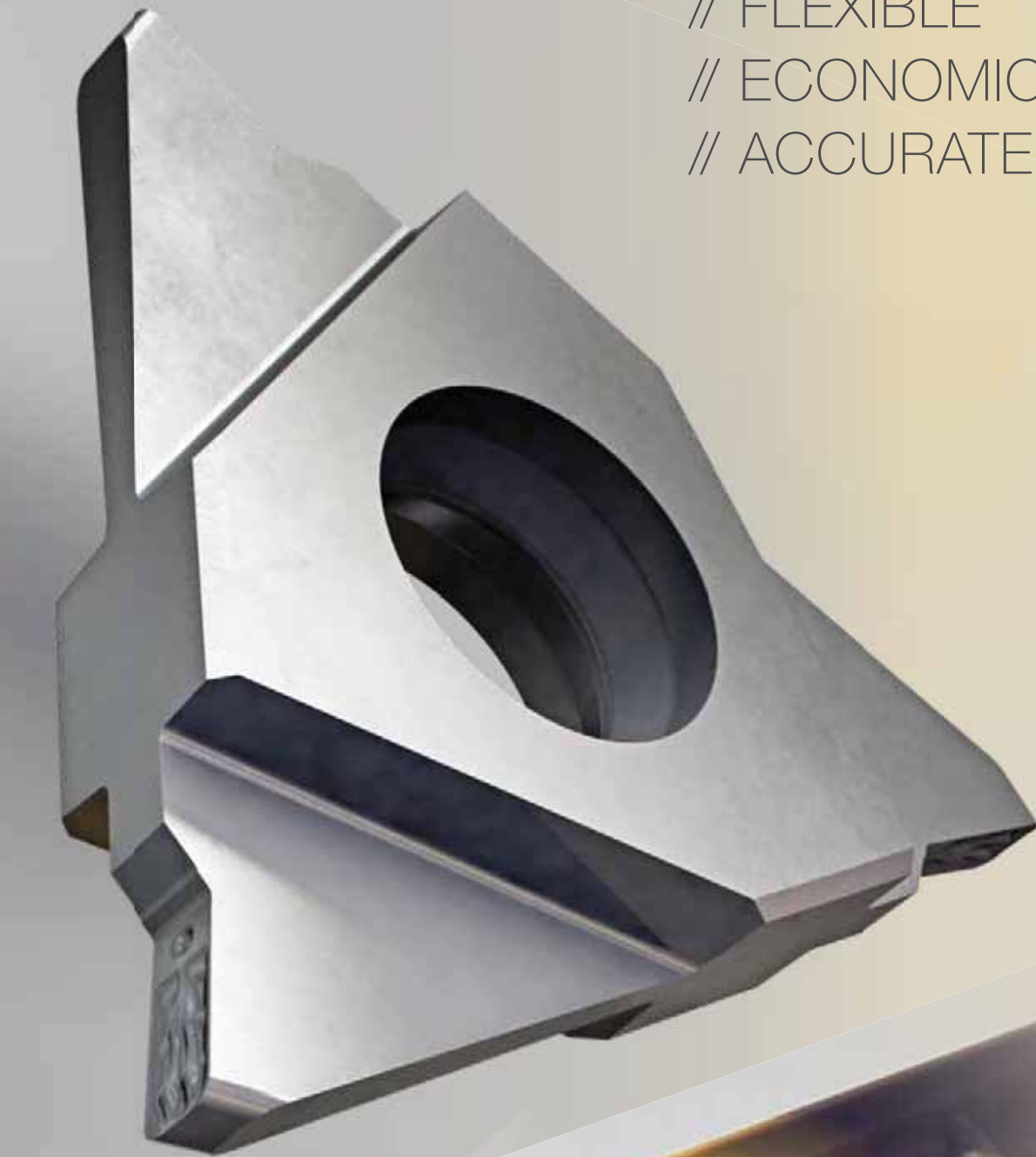
GROOVING SYSTEMS



NEW

Boring
Grooving
Threading
Broaching
Special tools

// FLEXIBLE
// ECONOMICAL
// ACCURATE



GUHRING

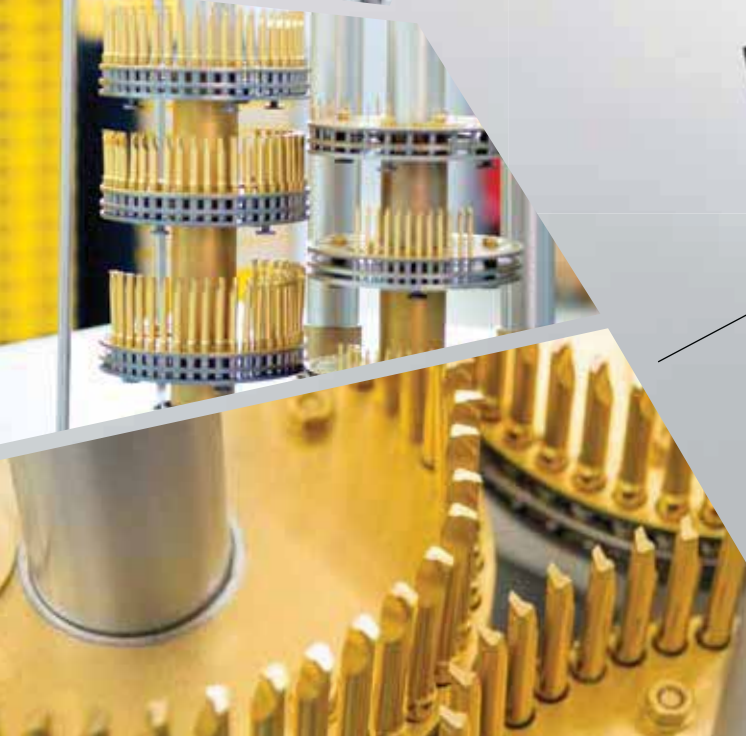
GROOVING SYSTEMS

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



WE KEEP ON GROWING

| PROGRAM EXPANSION | MORE SIZES | NEW APPLICATIONS

This rapid development is made possible by the huge manufacturing depth at Guhring, which is also evident in the grooving tool product line. Carbide manufactured in-house and specially developed machines and coatings from our own R&D are typical of Guhring products. This is no longer exclusive to rotating tools, but now also applies to stationary tools.

108

The new System 108 is the logical next development of the range of micro-precision tools. With a shank diameter of 8 mm and a minimum machining diameter of 7 mm, System 108 is a valuable addition to the existing tool portfolio. The shank diameter of 8 mm provides maximum stability and therefore high processing safety. The start-up range offers over 700 different series for boring and profiling up to a maximum depth of 2.5 mm, internal grooving up to a maximum depth of 3 mm and back boring.

System 108 will also be continuously expanded to meet the needs of its users.



106

In the tried and tested System 106, a larger selection of broaching tools is now available. These are now available for internal hexagon processing of spanner sizes 4 to 10.

Where internal hole machining with micro-precision tools is concerned, the 106 tool system is already one of the most comprehensive ranges on the market.



110

Similarly, System 110 also opens up new and exciting opportunities. With a shank diameter of 10 mm, this special tool ensures maximum stability. We have blanks in stock measuring up to 112 mm in length to be able to provide the best possible solution for challenging applications. In addition, the standard range includes the most conventional round shank holders.

Gühring specializes in industry-specific tool and process solutions. We are also able to design custom-made special tools for grooving. As well as our comprehensive standard portfolio, we focus on tailored systems aimed specifically at our customers. This is based in particular on Gühring's substantial tool expertise and extensive consulting experience.



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

8000

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

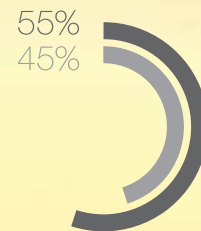


90000

Standard tools

2000

Tool types



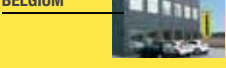
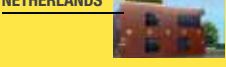
■ Standard tools
■ Special tools

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.

48 SUBSIDIARIES

70 PRODUCTION AND SERVICE CENTERS



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

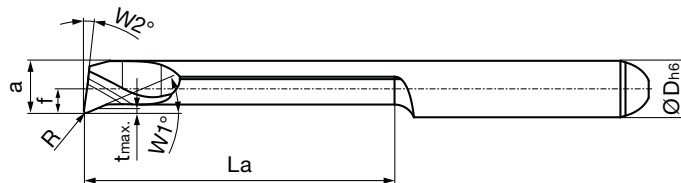


<p>GERMANY BERLIN</p> 	<p>FRANCE</p> 	<p>DENMARK</p> 	<p>RUSSIA</p> 
<p>GERMANY REGENSBURG</p> 	<p>RUMANIA</p> 	<p>VIETNAM</p> 	<p>AUSTRALIA</p> 
<p>GERMANY ZORBAU</p> 	<p>HUNGARY</p> 	<p>THAILAND</p> 	<p>INDONESIA</p> 
<p>SPAIN</p> 	<p>AUSTRIA</p> 	<p>INDIA</p> 	<p>TAIWAN</p> 
<p>ITALY UBIEMME</p> 	<p>POLAND</p> 	<p>CHINA</p> 	<p>JAPAN</p> 
<p>ITALY MISSAGLIA</p> 	<p>CZECH REPUBLIC</p> 	<p>TURKEY</p> 	<p>KOREA</p> 

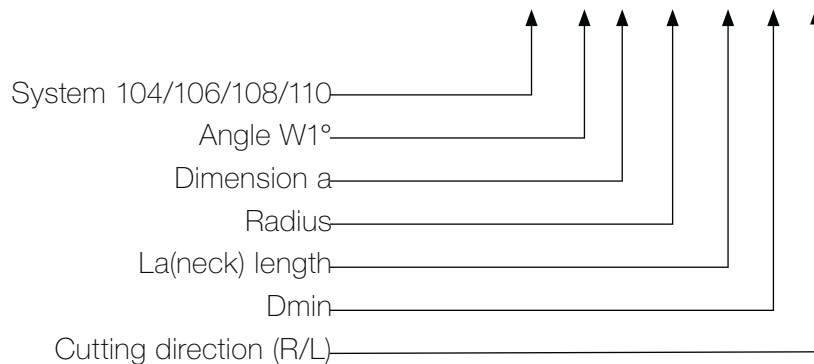
GROOVING SYSTEMS

Explanation of the series description

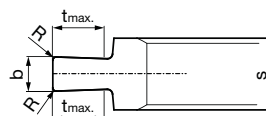
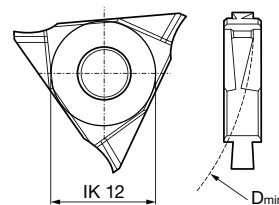
Series description System 104/106/108/110



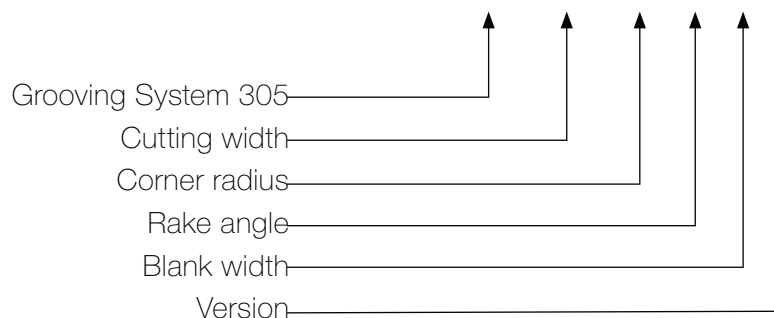
Tool description: Example: GT104.2326.010.22.30.R



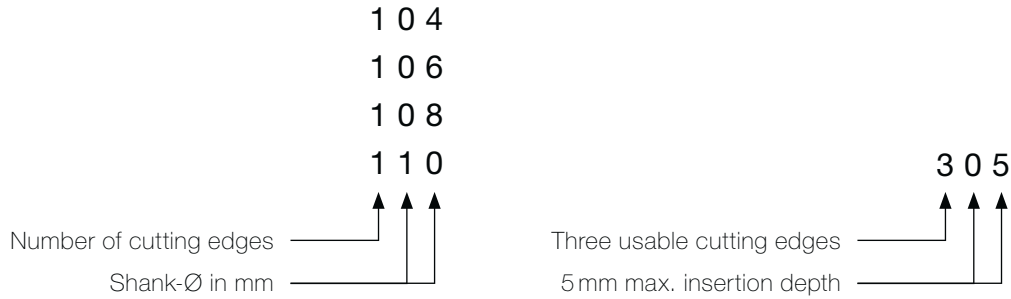
Series description System 305



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



Explanation of the system



When ordering please always state the
Series no. and the Code No. i.e.:
Item 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 Series no. 25164 25166 25170

• pitch P = 0.4-0.8

Tool material **Solid carbide**

Type	GG 104	GG 104	GG 104
Surface	Ⓢ	Ⓜ	○
	TiN	nanoA	uncoated

for tool holders type GH104/GB104 see from page 16

Cutting data page 148

Right hand version shown
Left hand version mirror image

Cutting direction (R) (R) (R)

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

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Micro-precision tools from Ø 0.7 mm

Tool holder	18
Cutting inserts	32

Broaching from Ø 1.5 mm

Tool holder	63
Cutting inserts	64



SYSTEM 106

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Micro-precision tools from Ø 5 mm

Tool holder	70
Cutting inserts	83

Broaching from Ø 6 mm

Tool holder	128
Cutting inserts	129



SYSTEM 108

page

Micro-precision tools from Ø 7 mm

Tool holder	134
Cutting inserts	146

Broaching from Ø 9 mm

Tool holder	170
Cutting inserts	171



SYSTEM 110

page

Micro-precision tools for special solutions

Tool holder	177
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SYSTEM 305

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Grooving and parting off

Tool holder	184
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Technical information & Accessories from page 213

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104





SYSTEM 104

MICRO-PRECISION TOOLS



Round shank holder

from page 18



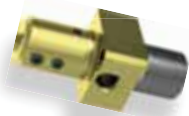
Square shank holder

from page 25



Modular holder

from page 27



Star holder

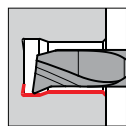
page 30



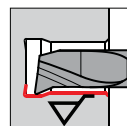
Round shank holder

Broaching
page 63

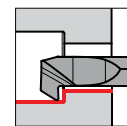
Tool holder



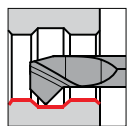
Boring out
and profiling, Type GT
from page 32



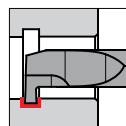
Boring out,
with Wiper, Type GJ
page 45



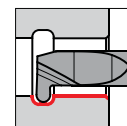
Back boring
and profiling, Type GT
from page 46



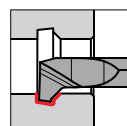
Boring out
and chamfering, Type GT
page 48



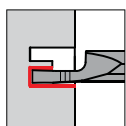
Internal grooving,
straight slots, Type GE
page 49



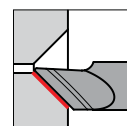
Internal grooving,
full radius slots, Type GE
page 51



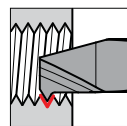
Internal pre-grooving
and chamfering, Type GV
page 52



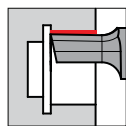
Axial grooving bores,
Type GA
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Axial chamfering
bores, Type GA
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Internal threading,
Type GG
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Broaching,
Type GN
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Cutting inserts from hole-Ø 0.7 mm

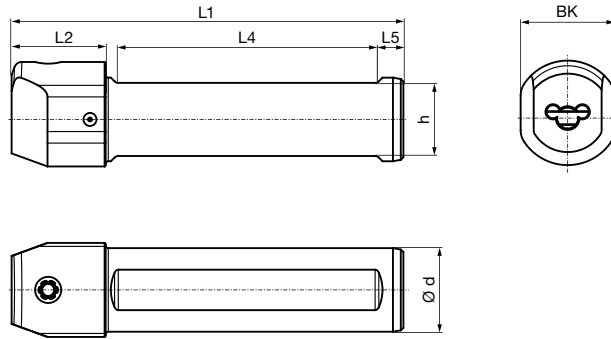


Round shank holder, clamping screw top

Series no. **25000**

- for inserts type 104
- with internal coolant delivery

Type GB 104



version left and right

Code no.	Description	d	d	h	L1	L2	L4	L5	BK
		mm	inch	mm	mm	mm	mm	mm	mm
4.001	GB104.0010.075.00.15.N.IK	10.00		9.00	75.00	18.00	50.00	5.00	12.0
4.002	GB104.0012.075.00.15.N.IK	12.00		11.00	75.00	18.00	50.00	5.00	14.0
4.015	GB104.0500.354.00.15.N.IK		1/2	11.00	89.92	17.78	54.86	5.08	13.9
4.016	GB104.0625.354.00.15.N.IK		5/8	14.00	89.92	17.78	54.86	5.08	17.7
4.003	GB104.0016.075.00.15.N.IK	16.00		14.00	75.00	18.00	50.00	5.00	18.0
4.017	GB104.0750.380.00.15.N.IK		3/4	17.04	96.52	17.78	69.85	5.08	
4.004	GB104.0020.090.00.15.N.IK	20.00		18.00	90.00		55.00	5.00	
4.005	GB104.0022.090.00.15.N.IK	22.00		20.00	90.00		55.00	5.00	
4.006	GB104.0025.100.00.15.N.IK	25.00		23.00	100.00		55.00	5.00	
4.018	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

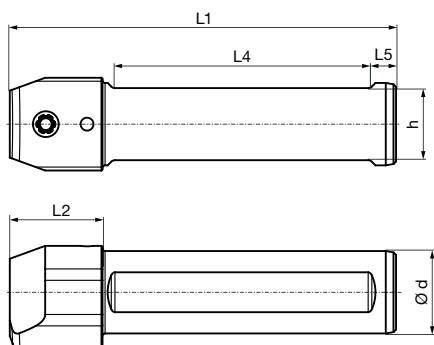


Round shank holder, clamping screw lateral

Series no. **25001**

- for inserts type 104
- with internal coolant delivery

Type GB 104



version left and right

Code no.	Description	d	d	h	L1	L2	L4	L5
		mm	inch	mm	mm	mm	mm	mm
4.001	GB104.0010.075.00.15.N.IK.90	10.00		9.00	75.00	18.00	50.00	5.00
4.002	GB104.0012.075.00.15.N.IK.90	12.00		11.00	75.00	18.00	50.00	5.00
4.015	GB104.0500.354.00.15.N.IK.90		1/2	11.00	89.92	17.78	54.86	5.08
4.016	GB104.0625.354.00.15.N.IK.90		5/8	14.00	89.92	17.78	54.86	5.08
4.003	GB104.0016.075.00.15.N.IK.90	16.00		14.00	75.00	18.00	50.00	5.00
4.017	GB104.0750.380.00.15.N.IK.90		3/4	17.04	96.52	17.78	69.85	5.08
4.004	GB104.0020.090.00.15.N.IK.90	20.00		18.00	90.00		55.00	5.00
4.005	GB104.0022.090.00.15.N.IK.90	22.00		20.00	90.00		55.00	5.00
4.006	GB104.0025.100.00.15.N.IK.90	25.00		23.00	100.00		55.00	5.00
4.018	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

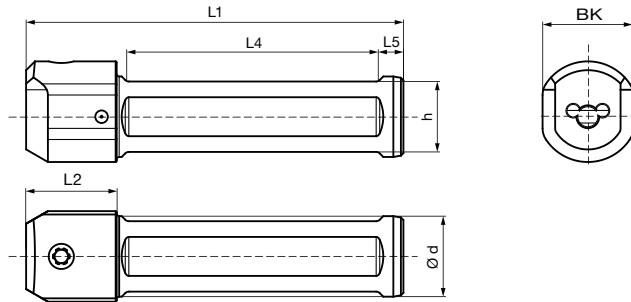


Round shank holder, clamping screw above, four clamping surfaces

Series no. **25018**

- for inserts type 104
- with internal coolant delivery

Type GB 104



version left and right

Code no.	Description	d	h	L1	L2	L4	L5	BK
		mm	mm	mm	mm	mm	mm	mm
4.010	GB104.0016.075.00.15.N.IK.VSP	16.00	14.00	75.00	18.00	50.00	5.00	18.0
4.020	GB104.0020.090.00.15.N.IK.VSP	20.00	18.00	90.00		55.00	5.00	
4.030	GB104.0022.090.00.15.N.IK.VSP	22.00	20.00	90.00		55.00	5.00	
4.040	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

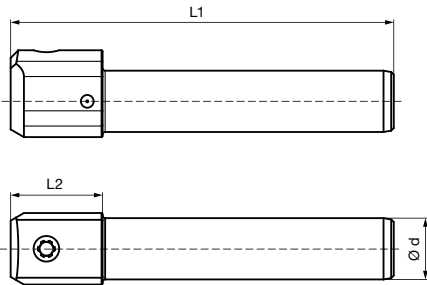


Round shank holder, clamping screw above, without clamping surfaces

Series no. **25017**

- for inserts type 104
- with internal coolant delivery

Type GB 104



version left and right

Code no.	Description	d	L1	L2	BK
		mm	mm	mm	mm
4.010	GB104.0010.075.00.15.N.IK.RND	10.00	75.00	18.00	12.0
4.020	GB104.0012.075.00.15.N.IK.RND	12.00	75.00	18.00	14.0
4.030	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

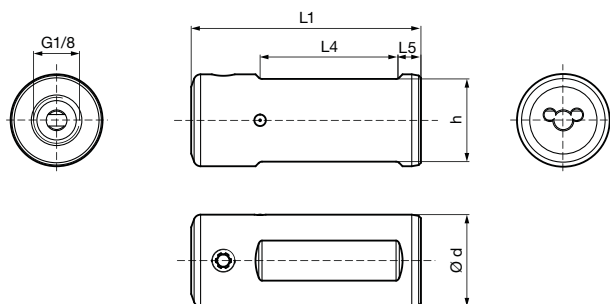


Round shank holder, clamping screw above, for Citizen machine

Series no. 25021

- for inserts type 104
- with internal coolant delivery

Type GB 104



version left and right

Code no.	Description	d	d	h	L1	L4	L5
		mm	inch	mm	mm	mm	mm
4.110	GB104.0750.040.00.15.N.IK.CIT		3/4	17.04	40.00	20.32	5.08
4.120	GB104.0750.050.00.15.N.IK.CIT		3/4	17.04	50.00	31.75	5.08
4.130	GB104.0750.070.00.15.N.IK.CIT		3/4	17.04	70.00	44.45	5.08
4.140	GB104.0750.100.00.15.N.IK.CIT		3/4	17.04	100.00	76.20	5.08
4.010	GB104.0020.050.00.15.N.IK.CIT	20.00		18.00	50.00	30.00	5.00
4.020	GB104.0020.030.00.15.N.IK.CIT	20.00		18.00	30.00	13.00	5.00
4.150	GB104.1000.060.00.15.N.IK.CIT		1"	23.39	60.00	38.10	5.08
4.160	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

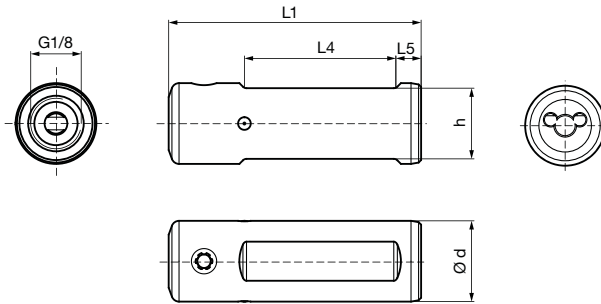


Round shank holder, clamping screw above, for Star machine

Series no. **25022**

- for inserts type 104
- with internal coolant delivery

Type GB 104



version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
4.010	GB104.0016.030.00.15.N.IK.STA	16.00	14.00	30.00	13.00	5.00
4.020	GB104.0016.050.00.15.N.IK.STA	16.00	14.00	50.00	30.00	5.00
4.030	GB104.0016.070.00.15.N.IK.STA	16.00	14.00	70.00	50.00	5.00
4.040	GB104.0022.038.00.15.N.IK.STA	22.00	20.00	38.00	18.00	5.00
4.050	GB104.0022.050.00.15.N.IK.STA	22.00	20.00	50.00	30.00	5.00
4.060	GB104.0022.070.00.15.N.IK.STA	22.00	20.00	70.00	50.00	5.00
4.070	GB104.0022.100.00.15.N.IK.STA	22.00	20.00	100.00	80.00	5.00
4.080	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 6.000	M6x7.5x15P	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

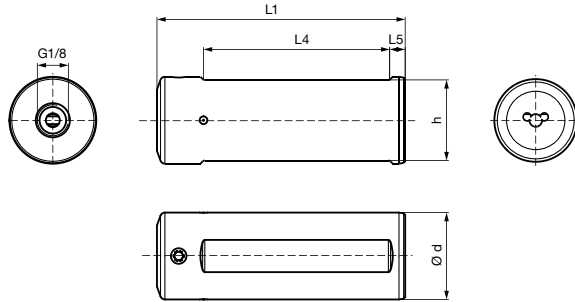


Round shank holder, clamping screw above, for Tornos machine

Series no. **25023**

- for inserts type 104
- with internal coolant delivery

Type GB 104



version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
4.010	GB104.0018.310.00.15.N.IK.TOR	18.00	16.00	310.00	290.00	5.00
4.020	GB104.0020.170.00.15.N.IK.TOR	20.00	18.00	170.00	150.00	5.00
4.030	GB104.0020.185.00.15.N.IK.TOR	20.00	18.00	185.00	165.00	5.00
4.040	GB104.0025.100.00.15.N.IK.TOR	25.00	23.00	100.00	80.00	5.00
4.050	GB104.0025.150.00.15.N.IK.TOR	25.00	23.00	150.00	130.00	5.00
4.060	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

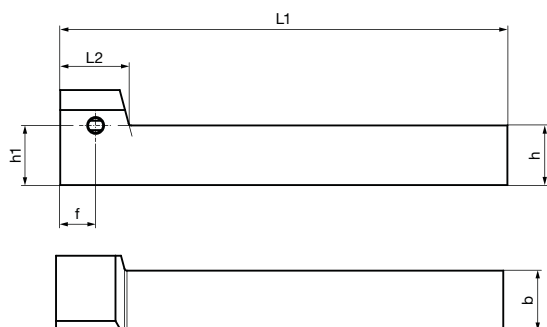


Square shank holder, 90° offset

Series no. **25002**

- for inserts type 104
- without internal coolant delivery

Type GH 104



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	b	b	h	h1	f	L1	L2
		mm	inch	mm	mm	mm	mm	mm
4.001	GH104.0808.090.90.15.R	8.00		8.00	8.00	9.50	90.00	18.50
4.010	GH104.0375.350.90.15.R		3/8	9.52	9.52	7.62	88.90	16.51
4.002	GH104.1010.090.90.15.R	10.00		10.00	10.00	9.50	90.00	18.50
4.003	GH104.1212.090.90.15.R	12.00		12.00	12.00	9.50	90.00	18.50
4.011	GH104.0500.350.90.15.R		1/2	12.70	12.70	7.62	88.90	16.51
4.012	GH104.0625.400.90.15.R		5/8	15.87	15.87	7.62	101.60	16.51
4.004	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
4.001	GH104.0808.090.90.15.L	8.00		8.00	8.00	9.50	90.00	18.50
4.010	GH104.0375.350.90.15.L		3/8	9.52	9.52	7.62	88.90	16.51
4.002	GH104.1010.090.90.15.L	10.00		10.00	10.00	9.50	90.00	18.50
4.003	GH104.1212.090.90.15.L	12.00		12.00	12.00	9.50	90.00	18.50
4.011	GH104.0500.350.90.15.L		1/2	12.70	12.70	7.62	88.90	16.51
4.012	GH104.0625.400.90.15.L		5/8	15.87	15.87	7.62	101.60	16.51
4.004	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

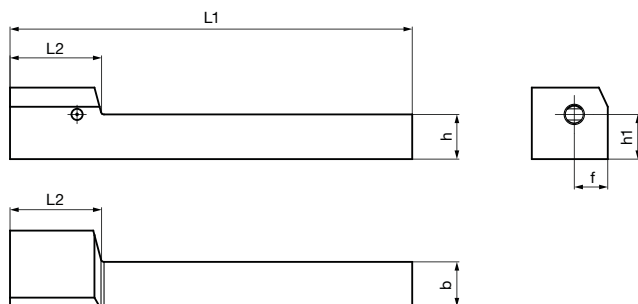


Square shank holder, straight 0°

Series no. **25019**

- for inserts type 104
- without internal coolant delivery

Type GH 104



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	b	b	h	h1	f	L1	L2
		mm	inch	mm	mm	mm	mm	mm
4.010	GH104.0808.090.00.15.R	8.00		8.00	8.00	7.50	90.00	20.50
4.100	GH104.0375.350.00.15.R		3/8	9.52	9.52	7.62	88.90	20.00
4.020	GH104.1010.090.00.15.R	10.00		10.00	10.00	7.50	90.00	20.50
4.030	GH104.1212.090.00.15.R	12.00		12.00	12.00	7.50	90.00	20.50
4.110	GH104.0500.350.00.15.R		1/2	12.70	12.70	7.62	88.90	20.00
4.120	GH104.0625.400.00.15.R		5/8	15.87	15.87	7.62	101.60	20.00
4.040	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
4.010	GH104.0808.090.00.15.L	8.00		8.00	8.00	7.50	90.00	20.50
4.100	GH104.0375.350.00.15.L		3/8	9.52	9.52	7.62	88.90	20.00
4.020	GH104.1010.090.00.15.L	10.00		10.00	10.00	7.50	90.00	20.50
4.030	GH104.1212.090.00.15.L	12.00		12.00	12.00	7.50	90.00	20.50
4.110	GH104.0500.350.00.15.L		1/2	12.70	12.70	7.62	88.90	20.00
4.120	GH104.0625.400.00.15.L		5/8	15.87	15.87	7.62	101.60	20.00
4.040	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

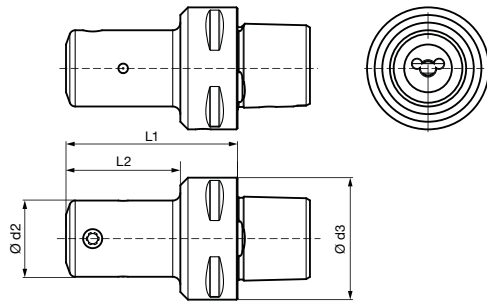


Polygon shank holder, to ISO 26623, straight 0°

Series no. **25010**

- for inserts type 104
- with internal coolant delivery

Type GH 104



version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
4.001	GH104.PO32.045.00.15.N.IK	20.00	PSC 32	45.00	30.00
4.002	GH104.PO40.050.00.15.N.IK	20.00	PSC 40	50.00	30.00
4.003	GH104.PO50.050.00.15.N.IK	20.00	PSC 50	50.00	30.00
4.004	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

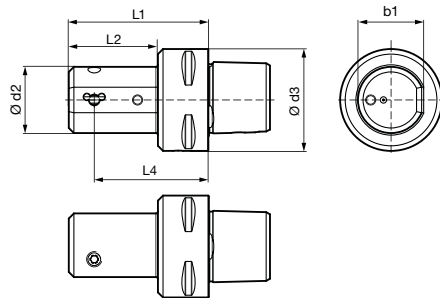


Polygon shank holder, to ISO 26623, off-set 90°

Series no. **25012**

- for inserts type 104
- with internal coolant delivery

Type GH 104



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	d2	d3	L1	L2	L4	b1
		mm		mm	mm	mm	mm
4.001	GH104.PO32.045.90.15.R.IK	26.00	PSC 32	55.00	40.00	45.00	25.00
4.002	GH104.PO40.050.90.15.R.IK	26.00	PSC 40	55.00	35.00	45.00	25.00
4.003	GH104.PO50.050.90.15.R.IK	26.00	PSC 50	55.00	35.00	45.00	25.00
4.004	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
4.001	GH104.PO32.045.90.15.L.IK	26.00	PSC 32	55.00	40.00	45.00	25.00
4.002	GH104.PO40.050.90.15.L.IK	26.00	PSC 40	55.00	35.00	45.00	25.00
4.003	GH104.PO50.050.90.15.L.IK	26.00	PSC 50	55.00	35.00	45.00	25.00
4.004	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

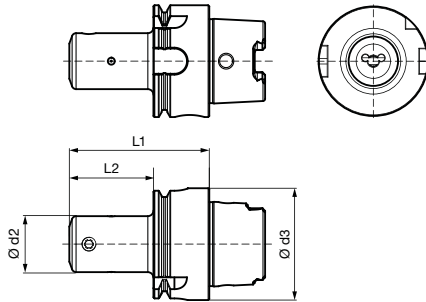


HSK-T holder, to ISO 12164-3, straight 0°

Series no. **25016**

- for inserts type 104
- with internal coolant delivery

Type GH 104



version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
4.001	GH104.HS40.050.00.15.N.IK	20.00	HSK-T 40	50.00	30.00
4.002	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

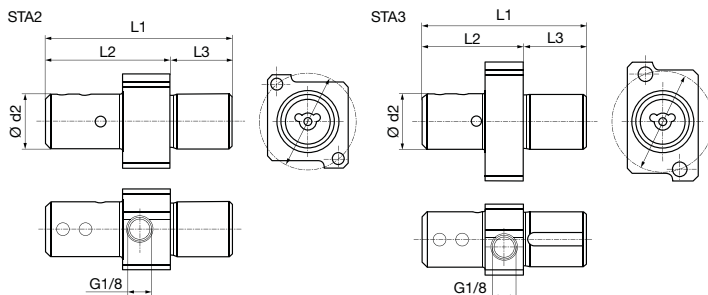


Star holders for backworking

Series no. **25024**

- for inserts type 104
- with internal coolant delivery

Type GB 104



version left and right

Code no.	Description	d	L1	L2	x	y
		mm	mm	mm		
4.010	GB104.0022.075.00.15.N.IK.STA2	22	75	50	25	30
4.020	GB104.0022.065.00.15.N.IK.STA3	22	65	40	13.66	37.6

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M4 x 30	4-4.5

Series no.	Connecting screw	Holder Designation
25912		
Code 4.000	M4x30 (STA2)	GB104.022.....IK.STA2
Code 5.000	M5x30 (STA3)	GB104.022.....IK.STA3

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

Pionex

FROM
GUHRING

NEW GENERATION THREADING TOOLS

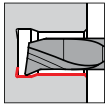
- High-performance machining
- higher cutting speeds
- outstanding tool life
- universal application in a wide variety of materials





Cutting insert for boring out and profiling

Series no. 25050 25052 25056



• radial free 23°

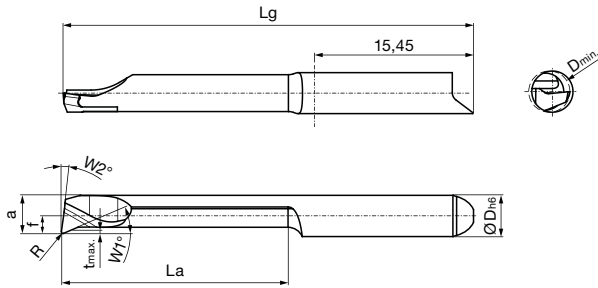
Tool material **Solid carbide**

Type GT 104 GT 104 GT 104

Coating **S** **a**
 TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214






Right hand version shown
Left hand version mirror image



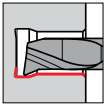
Code no.	Description	Cutting direction									
		D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.2306.005.03.07.R	0.70	0.05	23	8	1.95	0.60	0.05	3.00	25.00	4.00
4.002	GT104.2309.005.04.10.R	1.00	0.05	23	8	1.95	0.90	0.10	4.00	25.00	4.00
4.003	GT104.2309.005.07.10.R	1.00	0.05	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
4.049	GT104.2337.010.12.40.R	4.00	0.10	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
4.052	GT104.2337.020.12.40.R	4.00	0.20	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



Cutting insert for boring out and profiling											
		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
4.050	GT104.2337.010.17.40.R	4.00	0.10	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
4.053	GT104.2337.020.17.40.R	4.00	0.20	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
4.051	GT104.2337.010.22.40.R	4.00	0.10	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.041	GT104.2337.015.22.40.R	4.00	0.15	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.054	GT104.2337.020.22.40.R	4.00	0.20	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.046	GT104.2337.025.22.40.R	4.00	0.25	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.037	GT104.2337.005.27.40.R	4.00	0.05	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.042	GT104.2337.015.27.40.R	4.00	0.15	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.047	GT104.2337.025.27.40.R	4.00	0.25	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.038	GT104.2337.005.32.40.R	4.00	0.05	23	8	1.70	3.70	0.30	32.00	50.00	4.00
4.043	GT104.2337.015.32.40.R	4.00	0.15	23	8	1.70	3.70	0.30	32.00	50.00	4.00
4.048	GT104.2337.025.32.40.R	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

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



• radial free 23°

Tool material **Solid carbide**

Type GT 104 GT 104 GT 104

Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

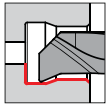
Cutting data page 214

Code no.	Description	D min mm	R mm	W1 °	W2 °	Cutting direction		t max mm	La mm	Lg mm	D h6 mm
						f mm	a mm				
4.001	GT104.2306.005.03.07.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	4.00	0.05	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.049	GT104.2337.010.12.40.L	4.00	0.10	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.039	GT104.2337.015.12.40.L	4.00	0.15	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.052	GT104.2337.020.12.40.L	4.00	0.20	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.044	GT104.2337.025.12.40.L	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.L	4.00	0.05	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.050	GT104.2337.010.17.40.L	4.00	0.10	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.040	GT104.2337.015.17.40.L	4.00	0.15	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.053	GT104.2337.020.17.40.L	4.00	0.20	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.045	GT104.2337.025.17.40.L	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.L	4.00	0.05	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.051	GT104.2337.010.22.40.L	4.00	0.10	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.041	GT104.2337.015.22.40.L	4.00	0.15	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.054	GT104.2337.020.22.40.L	4.00	0.20	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.046	GT104.2337.025.22.40.L	4.00	0.25	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.037	GT104.2337.005.27.40.L	4.00	0.05	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.042	GT104.2337.015.27.40.L	4.00	0.15	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.047	GT104.2337.025.27.40.L	4.00	0.25	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.038	GT104.2337.005.32.40.L	4.00	0.05	23	8	1.70	3.70	0.30	32.00	50.00	4.00
4.043	GT104.2337.015.32.40.L	4.00	0.15	23	8	1.70	3.70	0.30	32.00	50.00	4.00
4.048	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

Series no. 25058 25060 25064



• face flat 90°

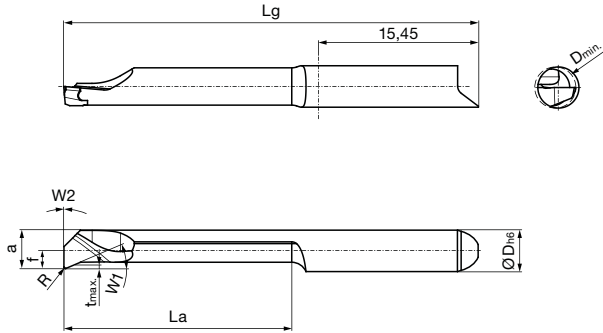
Tool material **Solid carbide**

Type GT 104 GT 104 GT 104

Coating **S** **a** ○
TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18




Cutting data page 214



Right hand version shown
Left hand version mirror image

Code no.	Description	Cutting direction									
		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
4.049	GT104.9037.010.12.40.R	4.00	0.10	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
4.050	GT104.9037.010.17.40.R	4.00	0.10	23	0	1.70	3.70	0.30	17.00	35.00	4.00

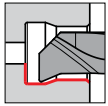


Cutting insert for boring out and profiling												Series no.		
												25058	25060	25064
												Cutting direction		
														
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6			
		mm	mm	°	°	mm	mm	mm	mm	mm	mm			
4.040	GT104.9037.015.17.40.R	4.00	0.15	23	0	1.70	3.70	0.30	17.00	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			
4.036	GT104.9037.005.22.40.R	4.00	0.05	23	0	1.70	3.70	0.30	22.00	40.00	4.00			
4.051	GT104.9037.010.22.40.R	4.00	0.10	23	0	1.70	3.70	0.30	22.00	40.00	4.00			
4.041	GT104.9037.015.22.40.R	4.00	0.15	23	0	1.70	3.70	0.30	22.00	40.00	4.00			
4.046	GT104.9037.025.22.40.R	4.00	0.25	23	0	1.70	3.70	0.30	22.00	40.00	4.00			
4.037	GT104.9037.005.27.40.R	4.00	0.05	23	0	1.70	3.70	0.30	27.00	45.00	4.00			
4.042	GT104.9037.015.27.40.R	4.00	0.15	23	0	1.70	3.70	0.30	27.00	45.00	4.00			
4.047	GT104.9037.025.27.40.R	4.00	0.25	23	0	1.70	3.70	0.30	27.00	45.00	4.00			
4.038	GT104.9037.005.32.40.R	4.00	0.05	23	0	1.70	3.70	0.30	32.00	50.00	4.00			
4.043	GT104.9037.015.32.40.R	4.00	0.15	23	0	1.70	3.70	0.30	32.00	50.00	4.00			
4.048	GT104.9037.025.32.40.R	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

Series no. **25059** **25061** **25065**



• face flat 90°

Tool material **Solid carbide**

Type GT 104 GT 104 GT 104

Coating **S** **a** ○
TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

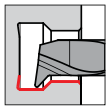
Cutting data page 214

		Series no.			Cutting direction							
		25059			25061			25065				
		L			L			L				
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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	4.00	0.05	23	0	1.70	3.70	0.30	12.00	30.00	4.00	
4.049	GT104.9037.010.12.40.L	4.00	0.10	23	0	1.70	3.70	0.30	12.00	30.00	4.00	
4.039	GT104.9037.015.12.40.L	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.L	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.L	4.00	0.05	23	0	1.70	3.70	0.30	17.00	35.00	4.00	
4.050	GT104.9037.010.17.40.L	4.00	0.10	23	0	1.70	3.70	0.30	17.00	35.00	4.00	
4.040	GT104.9037.015.17.40.L	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.L	4.00	0.25	23	0	1.70	3.70	0.30	17.00	35.00	4.00	
4.036	GT104.9037.005.22.40.L	4.00	0.05	23	0	1.70	3.70	0.30	22.00	40.00	4.00	
4.051	GT104.9037.010.22.40.L	4.00	0.10	23	0	1.70	3.70	0.30	22.00	40.00	4.00	
4.041	GT104.9037.015.22.40.L	4.00	0.15	23	0	1.70	3.70	0.30	22.00	40.00	4.00	
4.046	GT104.9037.025.22.40.L	4.00	0.25	23	0	1.70	3.70	0.30	22.00	40.00	4.00	
4.037	GT104.9037.005.27.40.L	4.00	0.05	23	0	1.70	3.70	0.30	27.00	45.00	4.00	
4.042	GT104.9037.015.27.40.L	4.00	0.15	23	0	1.70	3.70	0.30	27.00	45.00	4.00	
4.047	GT104.9037.025.27.40.L	4.00	0.25	23	0	1.70	3.70	0.30	27.00	45.00	4.00	
4.038	GT104.9037.005.32.40.L	4.00	0.05	23	0	1.70	3.70	0.30	32.00	50.00	4.00	
4.043	GT104.9037.015.32.40.L	4.00	0.15	23	0	1.70	3.70	0.30	32.00	50.00	4.00	
4.048	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

Series no. 25066 25068 25072



• radial free 47°

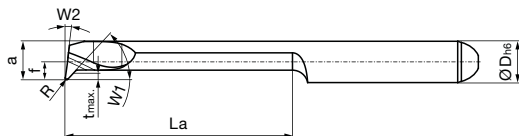
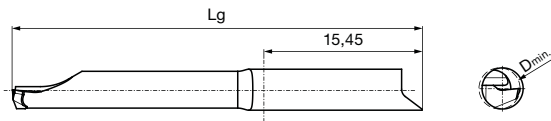
Tool material **Solid carbide**

Type GT 104 GT 104 GT 104

Coating **S** **a** ○
TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image



Code no.	Description	Cutting direction									
		D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	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
4.040	GT104.4737.010.12.40.R	4.00	0.10	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
4.043	GT104.4737.020.12.40.R	4.00	0.20	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
4.041	GT104.4737.010.17.40.R	4.00	0.10	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
4.044	GT104.4737.020.17.40.R	4.00	0.20	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
4.042	GT104.4737.010.22.40.R	4.00	0.10	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
4.045	GT104.4737.020.22.40.R	4.00	0.20	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



Cutting insert for boring out and profiling

Series no.

25066

25068

25072

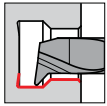
Cutting direction



Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
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

Cutting insert for boring out and profiling

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



• radial free 47°

Tool material **Solid carbide**

Type GT 104 GT 104 GT 104

Coating **S** **a** ○
TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214

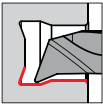
Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.4717.005.04.20.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	4.00	0.05	47	8	1.70	3.70	0.60	12.00	30.00	4.00
4.040	GT104.4737.010.12.40.L	4.00	0.10	47	8	1.70	3.70	0.60	12.00	30.00	4.00
4.030	GT104.4737.015.12.40.L	4.00	0.15	47	8	1.70	3.70	0.60	12.00	30.00	4.00
4.043	GT104.4737.020.12.40.L	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.L	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.L	4.00	0.05	47	8	1.70	3.70	0.60	17.00	35.00	4.00
4.041	GT104.4737.010.17.40.L	4.00	0.10	47	8	1.70	3.70	0.60	17.00	35.00	4.00
4.031	GT104.4737.015.17.40.L	4.00	0.15	47	8	1.70	3.70	0.60	17.00	35.00	4.00
4.044	GT104.4737.020.17.40.L	4.00	0.20	47	8	1.70	3.70	0.60	17.00	35.00	4.00
4.036	GT104.4737.025.17.40.L	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.L	4.00	0.05	47	8	1.70	3.70	0.60	22.00	40.00	4.00
4.042	GT104.4737.010.22.40.L	4.00	0.10	47	8	1.70	3.70	0.60	22.00	40.00	4.00
4.032	GT104.4737.015.22.40.L	4.00	0.15	47	8	1.70	3.70	0.60	22.00	40.00	4.00
4.045	GT104.4737.020.22.40.L	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.L	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.L	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.L	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.L	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.L	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.L	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.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

Series no. 25074 25076 25080

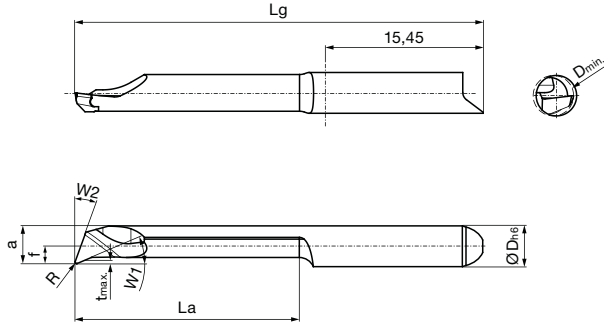


• face free 20°

for tool holders type GH104/GB104 see from page 18

Tool material	Solid carbide		
Type	GT 104	GT 104	GT 104
Coating	S	a	○
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image



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
4.001	GT104.2026.005.07.30.R	3.00	0.05	23	20	1.95	2.60	0.20	7.00	25.00	4.00
4.005	GT104.2026.010.07.30.R	3.00	0.10	23	20	1.95	2.60	0.20	7.00	25.00	4.00
4.009	GT104.2026.020.07.30.R	3.00	0.20	23	20	1.95	2.60	0.20	7.00	25.00	4.00
4.002	GT104.2026.005.12.30.R	3.00	0.05	23	20	1.95	2.60	0.20	12.00	30.00	4.00
4.006	GT104.2026.010.12.30.R	3.00	0.10	23	20	1.95	2.60	0.20	12.00	30.00	4.00
4.010	GT104.2026.020.12.30.R	3.00	0.20	23	20	1.95	2.60	0.20	12.00	30.00	4.00
4.003	GT104.2026.005.17.30.R	3.00	0.05	23	20	1.95	2.60	0.20	17.00	35.00	4.00
4.007	GT104.2026.010.17.30.R	3.00	0.10	23	20	1.95	2.60	0.20	17.00	35.00	4.00
4.011	GT104.2026.020.17.30.R	3.00	0.20	23	20	1.95	2.60	0.20	17.00	35.00	4.00
4.004	GT104.2026.005.22.30.R	3.00	0.05	23	20	1.95	2.60	0.20	22.00	40.00	4.00
4.008	GT104.2026.010.22.30.R	3.00	0.10	23	20	1.95	2.60	0.20	22.00	40.00	4.00
4.012	GT104.2026.020.22.30.R	3.00	0.20	23	20	1.95	2.60	0.20	22.00	40.00	4.00
4.013	GT104.2037.005.12.40.R	4.00	0.05	23	20	1.70	3.70	0.30	12.00	30.00	4.00
4.018	GT104.2037.015.12.40.R	4.00	0.15	23	20	1.70	3.70	0.30	12.00	30.00	4.00
4.023	GT104.2037.025.12.40.R	4.00	0.25	23	20	1.70	3.70	0.30	12.00	30.00	4.00
4.014	GT104.2037.005.17.40.R	4.00	0.05	23	20	1.70	3.70	0.30	17.00	35.00	4.00
4.019	GT104.2037.015.17.40.R	4.00	0.15	23	20	1.70	3.70	0.30	17.00	35.00	4.00
4.024	GT104.2037.025.17.40.R	4.00	0.25	23	20	1.70	3.70	0.30	17.00	35.00	4.00
4.015	GT104.2037.005.22.40.R	4.00	0.05	23	20	1.70	3.70	0.30	22.00	40.00	4.00
4.020	GT104.2037.015.22.40.R	4.00	0.15	23	20	1.70	3.70	0.30	22.00	40.00	4.00
4.025	GT104.2037.025.22.40.R	4.00	0.25	23	20	1.70	3.70	0.30	22.00	40.00	4.00
4.016	GT104.2037.005.27.40.R	4.00	0.05	23	20	1.70	3.70	0.30	27.00	45.00	4.00
4.021	GT104.2037.015.27.40.R	4.00	0.15	23	20	1.70	3.70	0.30	27.00	45.00	4.00
4.026	GT104.2037.025.27.40.R	4.00	0.25	23	20	1.70	3.70	0.30	27.00	45.00	4.00
4.017	GT104.2037.005.32.40.R	4.00	0.05	23	20	1.70	3.70	0.30	32.00	50.00	4.00
4.022	GT104.2037.015.32.40.R	4.00	0.15	23	20	1.70	3.70	0.30	32.00	50.00	4.00
4.027	GT104.2037.025.32.40.R	4.00	0.25	23	20	1.70	3.70	0.30	32.00	50.00	4.00

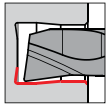
Series no. **25075** **25077** **25081**Cutting direction   

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

Series no. **25082** **25084** **25088**



• radial free 8°

Tool material **Solid carbide**

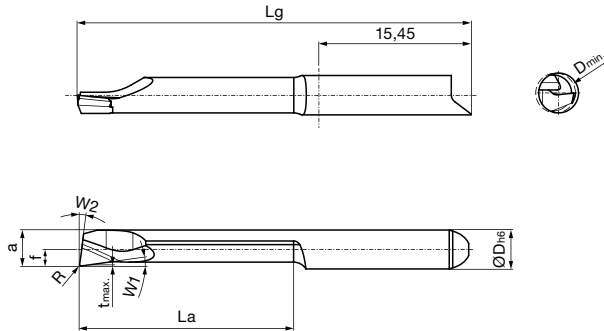
Type GT 104 GT 104 GT 104

Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image

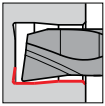
Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.0827.005.07.30.R	3.00	0.05	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.005	GT104.0827.010.07.30.R	3.00	0.10	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.009	GT104.0827.020.07.30.R	3.00	0.20	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.002	GT104.0827.005.12.30.R	3.00	0.05	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.006	GT104.0827.010.12.30.R	3.00	0.10	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.010	GT104.0827.020.12.30.R	3.00	0.20	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.003	GT104.0827.005.17.30.R	3.00	0.05	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.007	GT104.0827.010.17.30.R	3.00	0.10	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.011	GT104.0827.020.17.30.R	3.00	0.20	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.004	GT104.0827.005.22.30.R	3.00	0.05	8	8	1.95	2.70	0.15	22.00	40.00	4.00
4.008	GT104.0827.010.22.30.R	3.00	0.10	8	8	1.95	2.70	0.15	22.00	40.00	4.00
4.012	GT104.0827.020.22.30.R	3.00	0.20	8	8	1.95	2.70	0.15	22.00	40.00	4.00
4.013	GT104.0837.005.12.40.R	4.00	0.05	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.018	GT104.0837.015.12.40.R	4.00	0.15	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.023	GT104.0837.025.12.40.R	4.00	0.25	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.014	GT104.0837.005.17.40.R	4.00	0.05	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.028	GT104.0837.010.12.40.R	4.00	0.10	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.019	GT104.0837.015.17.40.R	4.00	0.15	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.024	GT104.0837.025.17.40.R	4.00	0.25	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.015	GT104.0837.005.22.40.R	4.00	0.05	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.029	GT104.0837.010.17.40.R	4.00	0.10	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.020	GT104.0837.015.22.40.R	4.00	0.15	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.025	GT104.0837.025.22.40.R	4.00	0.25	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.016	GT104.0837.005.27.40.R	4.00	0.05	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.030	GT104.0837.010.22.40.R	4.00	0.10	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.021	GT104.0837.015.27.40.R	4.00	0.15	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.026	GT104.0837.025.27.40.R	4.00	0.25	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.017	GT104.0837.005.32.40.R	4.00	0.05	8	8	1.70	3.70	0.15	32.00	50.00	4.00
4.022	GT104.0837.015.32.40.R	4.00	0.15	8	8	1.70	3.70	0.15	32.00	50.00	4.00
4.027	GT104.0837.025.32.40.R	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

Series no. **25083** **25085** **25089**



for tool holders type GH104/GB104 see from page 18

Tool material	Solid carbide		
Type	GT 104	GT 104	GT 104
Coating			
	TiN	nano-A	uncoated

Cutting data page 214

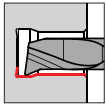
Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.0827.005.07.30.L	3.00	0.05	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.005	GT104.0827.010.07.30.L	3.00	0.10	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.009	GT104.0827.020.07.30.L	3.00	0.20	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.002	GT104.0827.005.12.30.L	3.00	0.05	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.006	GT104.0827.010.12.30.L	3.00	0.10	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.010	GT104.0827.020.12.30.L	3.00	0.20	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.003	GT104.0827.005.17.30.L	3.00	0.05	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.007	GT104.0827.010.17.30.L	3.00	0.10	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.011	GT104.0827.020.17.30.L	3.00	0.20	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.004	GT104.0827.005.22.30.L	3.00	0.05	8	8	1.95	2.70	0.15	22.00	40.00	4.00
4.008	GT104.0827.010.22.30.L	3.00	0.10	8	8	1.95	2.70	0.15	22.00	40.00	4.00
4.012	GT104.0827.020.22.30.L	3.00	0.20	8	8	1.95	2.70	0.15	22.00	40.00	4.00
4.013	GT104.0837.005.12.40.L	4.00	0.05	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.028	GT104.0837.010.12.40.L	4.00	0.10	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.018	GT104.0837.015.12.40.L	4.00	0.15	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.023	GT104.0837.025.12.40.L	4.00	0.25	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.014	GT104.0837.005.17.40.L	4.00	0.05	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.029	GT104.0837.010.17.40.L	4.00	0.10	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.019	GT104.0837.015.17.40.L	4.00	0.15	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.024	GT104.0837.025.17.40.L	4.00	0.25	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.015	GT104.0837.005.22.40.L	4.00	0.05	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.030	GT104.0837.010.22.40.L	4.00	0.10	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.020	GT104.0837.015.22.40.L	4.00	0.15	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.025	GT104.0837.025.22.40.L	4.00	0.25	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.016	GT104.0837.005.27.40.L	4.00	0.05	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.021	GT104.0837.015.27.40.L	4.00	0.15	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.026	GT104.0837.025.27.40.L	4.00	0.25	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.017	GT104.0837.005.32.40.L	4.00	0.05	8	8	1.70	3.70	0.15	32.00	50.00	4.00
4.022	GT104.0837.015.32.40.L	4.00	0.15	8	8	1.70	3.70	0.15	32.00	50.00	4.00
4.027	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

Series no. **25090** **25092** **25096**



• WIPER-geometry

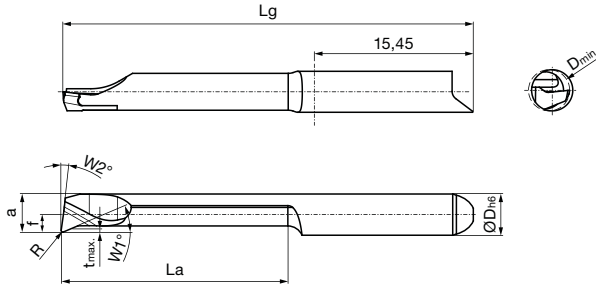
Tool material **Solid carbide**

Type GJ 104 GJ 104 GJ 104

Coating **S** **a** ○
TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
4.001	GJ104.2319.010.04.20.R	2.00	0.10	23	8	1.95	1.90	0.15	4.00	25.00	4.00
4.002	GJ104.2319.010.07.20.R	2.00	0.10	23	8	1.95	1.90	0.15	7.00	25.00	4.00
4.003	GJ104.2319.010.12.20.R	2.00	0.10	23	8	1.95	1.90	0.15	12.00	30.00	4.00
4.004	GJ104.2319.010.17.20.R	2.00	0.10	23	8	1.95	1.90	0.15	17.00	35.00	4.00
4.005	GJ104.2326.015.07.30.R	3.00	0.15	23	8	1.95	2.60	0.20	7.00	25.00	4.00
4.006	GJ104.2326.015.12.30.R	3.00	0.15	23	8	1.95	2.60	0.20	12.00	30.00	4.00
4.007	GJ104.2326.015.17.30.R	3.00	0.15	23	8	1.95	2.60	0.20	17.00	35.00	4.00
4.008	GJ104.2326.015.22.30.R	3.00	0.15	23	8	1.95	2.60	0.20	22.00	40.00	4.00
4.009	GJ104.2337.020.12.40.R	4.00	0.20	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.010	GJ104.2337.020.17.40.R	4.00	0.20	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.011	GJ104.2337.020.22.40.R	4.00	0.20	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.012	GJ104.2337.020.27.40.R	4.00	0.20	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.013	GJ104.2337.020.32.40.R	4.00	0.20	23	8	1.70	3.70	0.30	32.00	50.00	4.00

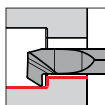
Series no. **25091** **25093** **25097**

Cutting direction **(L)** **(L)** **(L)**

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	GJ104.2319.010.04.20.L	2.00	0.10	23	8	1.95	1.90	0.15	4.00	25.00	4.00
4.002	GJ104.2319.010.07.20.L	2.00	0.10	23	8	1.95	1.90	0.15	7.00	25.00	4.00
4.003	GJ104.2319.010.12.20.L	2.00	0.10	23	8	1.95	1.90	0.15	12.00	30.00	4.00
4.004	GJ104.2319.010.17.20.L	2.00	0.10	23	8	1.95	1.90	0.15	17.00	35.00	4.00
4.005	GJ104.2326.015.07.30.L	3.00	0.15	23	8	1.95	2.60	0.20	7.00	25.00	4.00
4.006	GJ104.2326.015.12.30.L	3.00	0.15	23	8	1.95	2.60	0.20	12.00	30.00	4.00
4.007	GJ104.2326.015.17.30.L	3.00	0.15	23	8	1.95	2.60	0.20	17.00	35.00	4.00
4.008	GJ104.2326.015.22.30.L	3.00	0.15	23	8	1.95	2.60	0.20	22.00	40.00	4.00
4.009	GJ104.2337.020.12.40.L	4.00	0.20	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.010	GJ104.2337.020.17.40.L	4.00	0.20	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.011	GJ104.2337.020.22.40.L	4.00	0.20	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.012	GJ104.2337.020.27.40.L	4.00	0.20	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.013	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

Series no. 25106 25108 25112

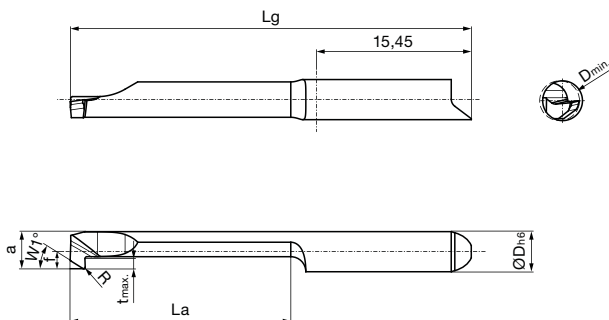


• radial free 32°

Tool material	Solid carbide		
Type	GT 104	GT 104	GT 104
Coating	S	a	○
	TiN	nano-A	uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
4.001	GT104.3217.010.04.20.R	2.00	0.10	32	1.95	1.70	0.30	4.00	25.00	4.00
4.002	GT104.3217.010.07.20.R	2.00	0.10	32	1.95	1.70	0.30	7.00	25.00	4.00
4.003	GT104.3217.010.12.20.R	2.00	0.10	32	1.95	1.70	0.30	12.00	30.00	4.00
4.004	GT104.3217.010.17.20.R	2.00	0.10	32	1.95	1.70	0.70	17.00	35.00	4.00
4.005	GT104.3226.005.07.30.R	3.00	0.05	32	1.95	2.60	0.70	7.00	25.00	4.00
4.009	GT104.3226.010.07.30.R	3.00	0.10	32	1.95	2.60	0.70	7.00	25.00	4.00
4.006	GT104.3226.005.12.30.R	3.00	0.05	32	1.95	2.60	0.70	12.00	30.00	4.00
4.010	GT104.3226.010.12.30.R	3.00	0.10	32	1.95	2.60	0.70	12.00	30.00	4.00
4.007	GT104.3226.005.17.30.R	3.00	0.05	32	1.95	2.60	0.70	17.00	35.00	4.00
4.011	GT104.3226.010.17.30.R	3.00	0.10	32	1.95	2.60	0.70	17.00	35.00	4.00
4.008	GT104.3226.005.22.30.R	3.00	0.05	32	1.95	2.60	0.70	22.00	40.00	4.00
4.012	GT104.3226.010.22.30.R	3.00	0.10	32	1.95	2.60	0.70	22.00	40.00	4.00
4.013	GT104.3237.010.12.40.R	4.00	0.10	32	1.70	3.70	1.00	12.00	30.00	4.00
4.018	GT104.3237.015.12.40.R	4.00	0.15	32	1.70	3.70	1.00	12.00	30.00	4.00
4.014	GT104.3237.010.17.40.R	4.00	0.10	32	1.70	3.70	1.00	17.00	35.00	4.00
4.019	GT104.3237.015.17.40.R	4.00	0.15	32	1.70	3.70	1.00	17.00	35.00	4.00
4.015	GT104.3237.010.22.40.R	4.00	0.10	32	1.70	3.70	1.00	22.00	40.00	4.00
4.020	GT104.3237.015.22.40.R	4.00	0.15	32	1.70	3.70	1.00	22.00	40.00	4.00
4.016	GT104.3237.010.27.40.R	4.00	0.10	32	1.70	3.70	1.00	27.00	45.00	4.00
4.021	GT104.3237.015.27.40.R	4.00	0.15	32	1.70	3.70	1.00	27.00	45.00	4.00
4.017	GT104.3237.010.32.40.R	4.00	0.10	32	1.70	3.70	1.00	32.00	50.00	4.00
4.022	GT104.3237.015.32.40.R	4.00	0.15	32	1.70	3.70	1.00	32.00	50.00	4.00

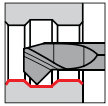


		Series no.		25107	25109	25113					
		Cutting direction									
Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6	
		mm	mm	°	mm	mm	mm	mm	mm	mm	
4.001	GT104.3217.010.04.20.L	2.00	0.10	32	1.95	1.70	0.30	4.00	25.00	4.00	
4.002	GT104.3217.010.07.20.L	2.00	0.10	32	1.95	1.70	0.30	7.00	25.00	4.00	
4.003	GT104.3217.010.12.20.L	2.00	0.10	32	1.95	1.70	0.30	12.00	30.00	4.00	
4.004	GT104.3217.010.17.20.L	2.00	0.10	32	1.95	1.70	0.70	17.00	35.00	4.00	
4.005	GT104.3226.005.07.30.L	3.00	0.05	32	1.95	2.60	0.70	7.00	25.00	4.00	
4.009	GT104.3226.010.07.30.L	3.00	0.10	32	1.95	2.60	0.70	7.00	25.00	4.00	
4.006	GT104.3226.005.12.30.L	3.00	0.05	32	1.95	2.60	0.70	12.00	30.00	4.00	
4.010	GT104.3226.010.12.30.L	3.00	0.10	32	1.95	2.60	0.70	12.00	30.00	4.00	
4.007	GT104.3226.005.17.30.L	3.00	0.05	32	1.95	2.60	0.70	17.00	35.00	4.00	
4.011	GT104.3226.010.17.30.L	3.00	0.10	32	1.95	2.60	0.70	17.00	35.00	4.00	
4.008	GT104.3226.005.22.30.L	3.00	0.05	32	1.95	2.60	0.70	22.00	40.00	4.00	
4.012	GT104.3226.010.22.30.L	3.00	0.10	32	1.95	2.60	0.70	22.00	40.00	4.00	
4.013	GT104.3237.010.12.40.L	4.00	0.10	32	1.7	3.70	1.00	12.00	30.00	4.00	
4.018	GT104.3237.015.12.40.L	4.00	0.15	32	1.7	3.70	1.00	12.00	30.00	4.00	
4.014	GT104.3237.010.17.40.L	4.00	0.10	32	1.7	3.70	1.00	17.00	35.00	4.00	
4.019	GT104.3237.015.17.40.L	4.00	0.15	32	1.7	3.70	1.00	17.00	35.00	4.00	
4.015	GT104.3237.010.22.40.L	4.00	0.10	32	1.7	3.70	1.00	22.00	40.00	4.00	
4.020	GT104.3237.015.22.40.L	4.00	0.15	32	1.7	3.70	1.00	22.00	40.00	4.00	
4.016	GT104.3237.010.27.40.L	4.00	0.10	32	1.7	3.70	1.00	27.00	45.00	4.00	
4.021	GT104.3237.015.27.40.L	4.00	0.15	32	1.7	3.70	1.00	27.00	45.00	4.00	
4.017	GT104.3237.010.32.40.L	4.00	0.10	32	1.7	3.70	1.00	32.00	50.00	4.00	
4.022	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

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



• 45° both sides

Tool material **Solid carbide**

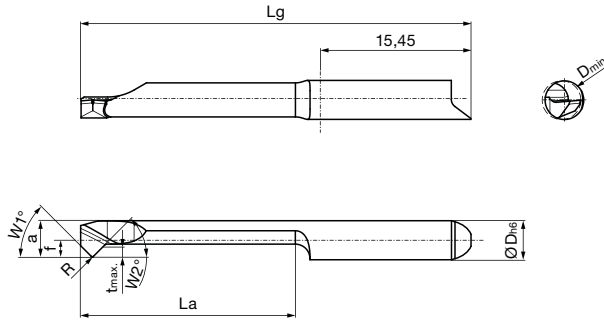
Type GT 104 GT 104 GT 104

Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
4.001	GT104.4518.010.04.20.R	2.00	0.10	45	45	1.95	1.80	0.50	4.00	25.00	4.00
4.002	GT104.4518.010.07.20.R	2.00	0.10	45	45	1.95	1.80	0.50	7.00	25.00	4.00
4.003	GT104.4518.010.12.20.R	2.00	0.10	45	45	1.95	1.80	0.50	12.00	30.00	4.00
4.004	GT104.4518.010.17.20.R	2.00	0.10	45	45	1.95	1.80	0.50	17.00	35.00	4.00
4.005	GT104.4527.010.07.30.R	3.00	0.10	45	45	1.95	2.70	0.70	7.00	25.00	4.00
4.006	GT104.4527.010.12.30.R	3.00	0.10	45	45	1.95	2.70	0.70	12.00	30.00	4.00
4.007	GT104.4527.010.17.30.R	3.00	0.10	45	45	1.95	2.70	0.70	17.00	35.00	4.00
4.008	GT104.4527.010.22.30.R	3.00	0.10	45	45	1.95	2.70	0.70	22.00	40.00	4.00
4.009	GT104.4537.015.12.40.R	4.00	0.15	45	45	1.70	3.70	1.00	12.00	30.00	4.00
4.010	GT104.4537.015.17.40.R	4.00	0.15	45	45	1.70	3.70	1.00	17.00	35.00	4.00
4.011	GT104.4537.015.22.40.R	4.00	0.15	45	45	1.70	3.70	1.00	22.00	40.00	4.00
4.012	GT104.4537.015.27.40.R	4.00	0.15	45	45	1.70	3.70	1.00	27.00	45.00	4.00
4.013	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**

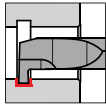
Cutting direction

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

Series no. 25124 25126 25130

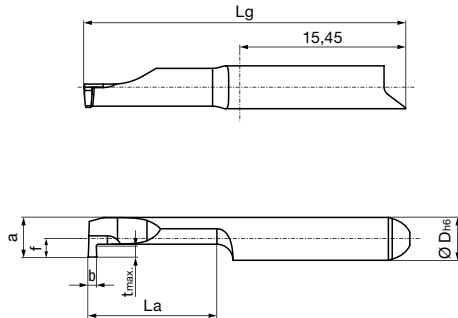


- grooving depth up to 1 mm

for tool holders type GH104/GB104 see from page 18

Tool material	Solid carbide		
Type	GE 104	GE 104	GE 104
Coating			
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image



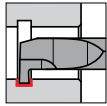
Cutting direction

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



Cutting insert for internal grooving, straight slots

Series no. **25125** **25127** **25131**



for tool holders type GH104/GB104 see from page 18

Tool material	Solid carbide		
Type	GE 104	GE 104	GE 104
Coating			
	TiN	nano-A	uncoated

Cutting data page 214

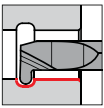
Cutting direction

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

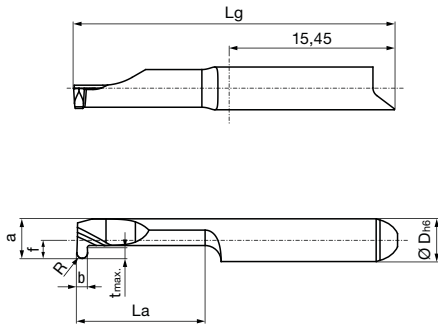
Series no. **25132** **25134** **25138**



• full radius R0.4-R0.58

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
4.001	GE104.0080.040.07.30.R	3.00	0.80	0.40	1.95	2.70	0.70	7.00	25.00	4.00
4.002	GE104.0080.040.12.30.R	3.00	0.80	0.40	1.95	2.70	0.70	12.00	30.00	4.00
4.003	GE104.0080.040.17.30.R	3.00	0.80	0.40	1.95	2.70	0.70	17.00	35.00	4.00
4.004	GE104.0080.040.22.30.R	3.00	0.80	0.40	1.95	2.70	0.70	22.00	40.00	4.00
4.005	GE104.0100.050.12.40.R	4.00	1.00	0.50	1.70	3.70	1.00	12.00	30.00	4.00
4.006	GE104.0100.050.17.40.R	4.00	1.00	0.50	1.70	3.70	1.00	17.00	35.00	4.00
4.007	GE104.0100.050.22.40.R	4.00	1.00	0.50	1.70	3.70	1.00	22.00	40.00	4.00
4.008	GE104.0100.050.27.40.R	4.00	1.00	0.50	1.70	3.70	1.00	27.00	45.00	4.00
4.009	GE104.0100.050.32.40.R	4.00	1.00	0.50	1.70	3.70	1.00	32.00	50.00	4.00
4.010	GE104.0117.058.12.40.R	4.00	1.17	0.58	1.70	3.70	1.00	12.00	30.00	4.00
4.011	GE104.0117.058.17.40.R	4.00	1.17	0.58	1.70	3.70	1.00	17.00	35.00	4.00
4.012	GE104.0117.058.22.40.R	4.00	1.17	0.58	1.70	3.70	1.00	22.00	40.00	4.00
4.013	GE104.0117.058.27.40.R	4.00	1.17	0.58	1.70	3.70	1.00	27.00	45.00	4.00
4.014	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. **25133** **25135** **25139**

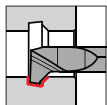
Cutting direction

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

Series no. **25140** **25142** **25146**



• 45° chamfer

Tool material **Solid carbide**

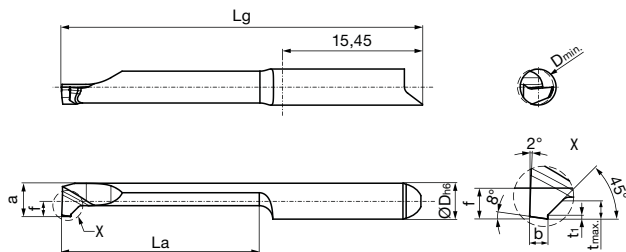
Type GV 104 GV 104 GV 104

Coating **S** **a**

TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image



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**

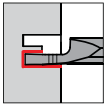
Cutting direction

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

Series no. 25188 25190 25194



• grooving depth up to 5 mm

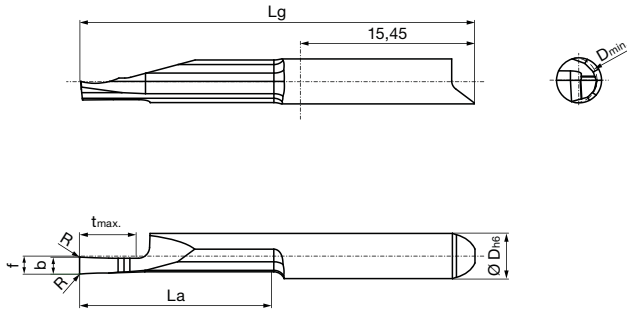
for tool holders type GH104/GB104 see from page 18

Tool material **Solid carbide**

Type GA 104 GA 104 GA 104

Coating **S** **a** ○
TiN nano-A uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image



Cutting direction

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

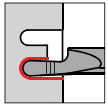
Cutting direction

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

Series no. **25196** **25198** **25202**



• grooving depth up to 5 mm

Tool material **Solid carbide**

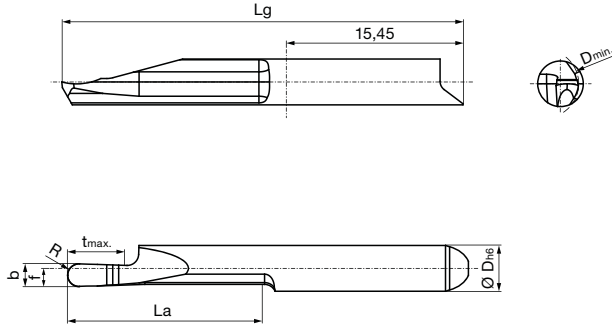
Type GA 104 GA 104 GA 104

Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image



Cutting direction

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

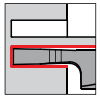
Cutting direction

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

Series no. **25204** **25206** **25210**



• grooving depth up to 5 mm

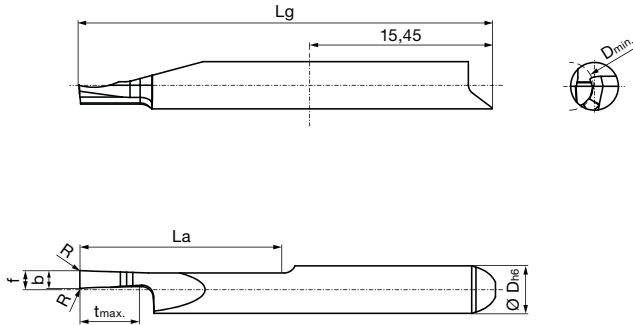
for tool holders type GH104/GB104 see from page 18

Tool material **Solid carbide**

Type GA 104 GA 104 GA 104

Coating **S** **a** ○
TiN nano-A uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image



Cutting direction

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

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

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



• grooving depth up to 5 mm

Tool material **Solid carbide**

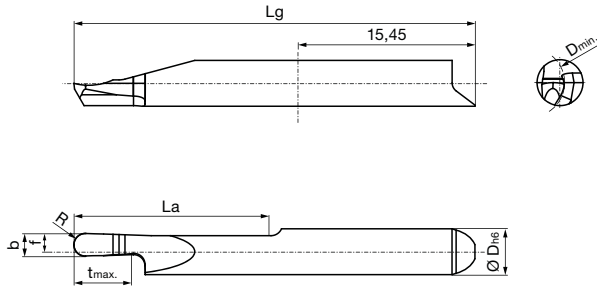
Type GA 104 GA 104 GA 104

Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction

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

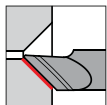
Cutting direction

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

Series no. **25220** **25222** **25226**

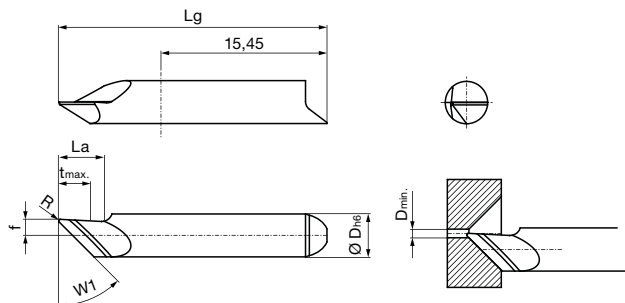


• 45°/60°/75° chamfer angle

for tool holders type GH104/GB104 see from page 18

Tool material	Solid carbide		
Type	GA 104	GA 104	GA 104
Coating			
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image



Cutting direction

Code no.	Description	D min	R	W1	f	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm
4.001	GA104.F045.015.04.08.R	0.80	0.15	45.00	1.50	3.00	4.00	25.00	4.00
4.002	GA104.F060.015.04.08.R	0.80	0.15	60.00	0.50	3.50	4.00	25.00	4.00
4.003	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**

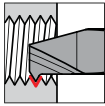
Cutting direction

Code no.	Description	D min	R	W1	f	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm
4.001	GA104.F045.015.04.08.L	0.80	0.15	45.00	1.50	3.00	4.00	25.00	4.00
4.002	GA104.F060.015.04.08.L	0.80	0.15	60.00	0.50	3.50	4.00	25.00	4.00
4.003	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

Series no. **25148** **25150** **25154**

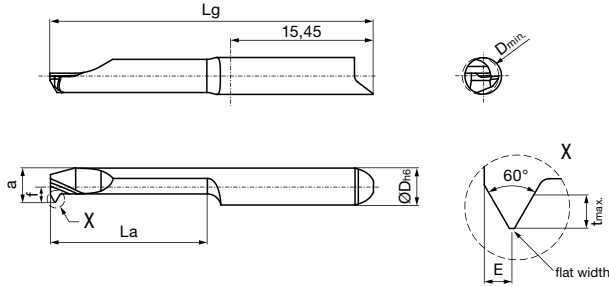


- pitch P = 0.4-1.0
- Dh6 = 4.00 mm

Tool material	Solid carbide		
Type	GG 104	GG 104	GG 104
Coating	TiN	nano-A	uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image



Cutting direction

Code no.	Description	G	P	TPI	D min	f	flat width	t max	a	E	La	Lg
					mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TM02.040.04.15.R	M2/M2.5	0.40-0.45	56-64	1.50	1.95	0.040	0.25	1.40	0.25	4.00	25.00
4.002	GG104.TM02.040.07.15.R	M2/M2.5	0.40-0.45	56-64	1.50	1.95	0.040	0.25	1.40	0.25	7.00	25.00
4.003	GG104.TM02.040.12.15.R	M2/M2.5	0.40-0.45	56-64	1.50	1.95	0.040	0.25	1.40	0.25	12.00	30.00
4.004	GG104.TM03.050.04.25.R	M3	0.50	48-56	2.50	1.95	0.053	0.30	2.20	0.30	4.00	25.00
4.005	GG104.TM03.050.07.25.R	M3	0.50	48-56	2.50	1.95	0.053	0.30	2.20	0.30	7.00	25.00
4.006	GG104.TM03.050.12.25.R	M3	0.50	48-56	2.50	1.95	0.053	0.30	2.20	0.30	12.00	30.00
4.007	GG104.TM04.070.07.33.R	M4	0.70	36	3.30	1.95	0.078	0.40	3.00	0.40	7.00	25.00
4.008	GG104.TM04.070.12.33.R	M4	0.70	36	3.30	1.95	0.078	0.40	3.00	0.40	12.00	30.00
4.009	GG104.TM04.070.17.33.R	M4	0.70	36	3.30	1.95	0.078	0.40	3.00	0.40	17.00	35.00
4.010	GG104.TM05.080.12.40.R	M5/M6	0.80-1.00	24-32	4.00	1.70	0.090	0.60	3.70	0.50	12.00	30.00
4.011	GG104.TM05.080.17.40.R	M5/M6	0.80-1.00	24-32	4.00	1.70	0.090	0.60	3.70	0.50	17.00	35.00
4.012	GG104.TM05.080.22.40.R	M5/M6	0.80-1.00	24-32	4.00	1.70	0.090	0.60	3.70	0.50	22.00	40.00

Series no. **25149** **25151** **25155**

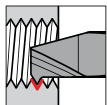
Cutting direction

Code no.	Description	G	P	TPI	D min	f	flat width	t max	a	E	La	Lg
					mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TM02.040.04.15.L	M2/M2.5	0.40-0.45	56-64	1.50	1.95	0.040	0.25	1.40	0.25	4.00	25.00
4.002	GG104.TM02.040.07.15.L	M2/M2.5	0.40-0.45	56-64	1.50	1.95	0.040	0.25	1.40	0.25	7.00	25.00
4.003	GG104.TM02.040.12.15.L	M2/M2.5	0.40-0.45	56-64	1.50	1.95	0.040	0.25	1.40	0.25	12.00	30.00
4.004	GG104.TM03.050.04.25.L	M3	0.50	48-56	2.50	1.95	0.053	0.30	2.20	0.30	4.00	25.00
4.005	GG104.TM03.050.07.25.L	M3	0.50	48-56	2.50	1.95	0.053	0.30	2.20	0.30	7.00	25.00
4.006	GG104.TM03.050.12.25.L	M3	0.50	48-56	2.50	1.95	0.053	0.30	2.20	0.30	12.00	30.00
4.007	GG104.TM04.070.07.33.L	M4	0.70	36	3.30	1.95	0.078	0.40	3.00	0.40	7.00	25.00
4.008	GG104.TM04.070.12.33.L	M4	0.70	36	3.30	1.95	0.078	0.40	3.00	0.40	12.00	30.00
4.009	GG104.TM04.070.17.33.L	M4	0.70	36	3.30	1.95	0.078	0.40	3.00	0.40	17.00	35.00
4.010	GG104.TM05.080.12.40.L	M5/M6	0.80-1.00	24-32	4.00	1.70	0.090	0.60	3.70	0.50	12.00	30.00
4.011	GG104.TM05.080.17.40.L	M5/M6	0.80-1.00	24-32	4.00	1.70	0.090	0.60	3.70	0.50	17.00	35.00
4.012	GG104.TM05.080.22.40.L	M5/M6	0.80-1.00	24-32	4.00	1.70	0.090	0.60	3.70	0.50	22.00	40.00



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

Series no. **25156** **25158** **25162**

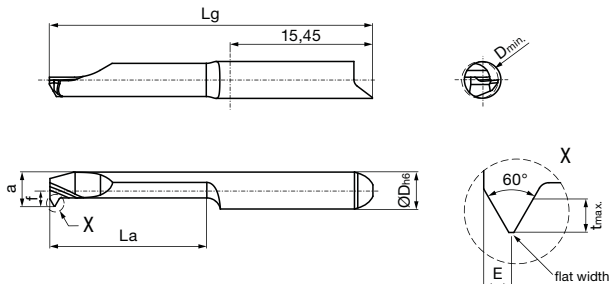


- pitch P = 0.2-0.5
- Dh6 = 4.00 mm

for tool holders type GH104/GB104 see from page 18

Tool material	Solid carbide		
Type	GG 104	GG 104	GG 104
Coating			
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image



Cutting direction

Code no.	Description	G	P	TPI	D min	f	flat width	t max	a	E	La	Lg
					mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TM02.020.04.17.R	M2/M3	0.20-0.30	-	1.70	1.95	0.015	0.20	1.55	0.20	4.00	25.00
4.002	GG104.TM02.020.07.17.R	M2/M3	0.20-0.30	-	1.70	1.95	0.015	0.20	1.55	0.20	7.00	25.00
4.003	GG104.TM02.020.12.17.R	M2/M3	0.20-0.30	-	1.70	1.95	0.015	0.20	1.55	0.20	12.00	30.00
4.004	GG104.TM04.035.07.35.R	M4/M5	0.35-0.50	48-72	3.50	1.95	0.034	0.30	3.20	0.35	7.00	25.00
4.005	GG104.TM04.035.12.35.R	M4/M5	0.35-0.50	48-72	3.50	1.95	0.034	0.30	3.20	0.35	12.00	30.00
4.006	GG104.TM04.035.17.35.R	M4/M5	0.35-0.50	48-72	3.50	1.95	0.034	0.30	3.20	0.35	17.00	35.00

Series no. **25157** **25159** **25163**

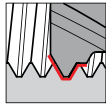
Cutting direction

Code no.	Description	G	P	TPI	D min	f	flat width	t max	a	E	La	Lg
					mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TM02.020.04.17.L	M2/M3	0.20-0.30	-	1.70	1.95	0.015	0.20	1.55	0.20	4.00	25.00
4.002	GG104.TM02.020.07.17.L	M2/M3	0.20-0.30	-	1.70	1.95	0.015	0.20	1.55	0.20	7.00	25.00
4.003	GG104.TM02.020.12.17.L	M2/M3	0.20-0.30	-	1.70	1.95	0.015	0.20	1.55	0.20	12.00	30.00
4.004	GG104.TM04.035.07.35.L	M4/M5	0.35-0.50	48-72	3.50	1.95	0.034	0.30	3.20	0.35	7.00	25.00
4.005	GG104.TM04.035.12.35.L	M4/M5	0.35-0.50	48-72	3.50	1.95	0.034	0.30	3.20	0.35	12.00	30.00
4.006	GG104.TM04.035.17.35.L	M4/M5	0.35-0.50	48-72	3.50	1.95	0.034	0.30	3.20	0.35	17.00	35.00



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

Series no. 25164 25166 25170

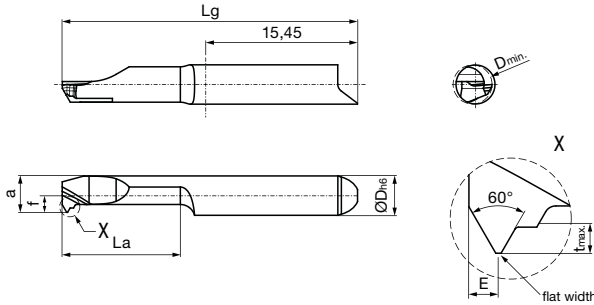


- pitch P = 0.4-0.8
- Dh6 = 4.00 mm

Tool material	Solid carbide		
Type	GG 104	GG 104	GG 104
Coating			
	TiN	nano-A	uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image



Cutting direction

Code no.	Description	G	P	D min	f	E	a	flat width	t max	La	Lg
			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	0.040	0.25	4.00	25.00
4.002	GG104.VM02.040.07.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.040	0.25	7.00	25.00
4.003	GG104.VM02.040.12.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.040	0.25	12.00	30.00
4.004	GG104.VM03.050.04.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.053	0.35	4.00	25.00
4.005	GG104.VM03.050.07.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.053	0.35	7.00	25.00
4.006	GG104.VM03.050.12.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.053	0.35	12.00	30.00
4.007	GG104.VM04.070.07.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.078	0.45	7.00	25.00
4.008	GG104.VM04.070.12.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.078	0.45	12.00	30.00
4.009	GG104.VM04.070.17.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.078	0.45	17.00	35.00
4.010	GG104.VM04.070.22.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.078	0.45	22.00	40.00
4.011	GG104.VM05.080.12.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.090	0.50	12.00	30.00
4.012	GG104.VM05.080.17.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.090	0.50	17.00	35.00
4.013	GG104.VM05.080.22.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.090	0.50	22.00	40.00
4.014	GG104.VM05.080.27.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.090	0.50	27.00	45.00

Series no. 25165 25167 25171

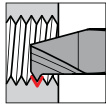
Cutting direction

Code no.	Description	G	P	D min	f	E	a	flat width	t max	La	Lg
			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	0.040	0.25	4.00	25.00
4.002	GG104.VM02.040.07.15.L	M2	0.40	1.50	1.95	0.20	1.35	0.040	0.25	7.00	25.00
4.003	GG104.VM02.040.12.15.L	M2	0.40	1.50	1.95	0.20	1.35	0.040	0.25	12.00	30.00
4.004	GG104.VM03.050.04.24.L	M3	0.50	2.40	1.95	0.30	1.95	0.053	0.35	4.00	25.00
4.005	GG104.VM03.050.07.24.L	M3	0.50	2.40	1.95	0.30	1.95	0.053	0.35	7.00	25.00
4.006	GG104.VM03.050.12.24.L	M3	0.50	2.40	1.95	0.30	1.95	0.053	0.35	12.00	30.00
4.007	GG104.VM04.070.07.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.078	0.45	7.00	25.00
4.008	GG104.VM04.070.12.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.078	0.45	12.00	30.00
4.009	GG104.VM04.070.17.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.078	0.45	17.00	35.00
4.010	GG104.VM04.070.22.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.078	0.45	22.00	40.00
4.011	GG104.VM05.080.12.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.090	0.50	12.00	30.00
4.012	GG104.VM05.080.17.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.090	0.50	17.00	35.00
4.013	GG104.VM05.080.22.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.090	0.50	22.00	40.00
4.014	GG104.VM05.080.27.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.090	0.50	27.00	45.00



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

Series no. **25172** **25174** **25178**



- pitch 32-40 thread/inch
- Dh6 = 4.00 mm

Tool material **Solid carbide**

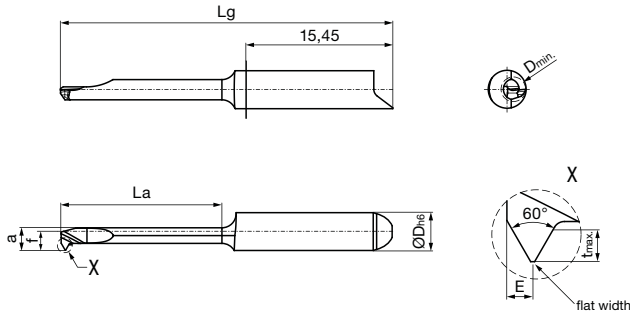
Type GG 104 GG 104 GG 104

Coating **S** **a**

TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction

Code no.	Description	P	D min	f	flat width	t max	a	E	La	Lg
		Thread/inch	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TU32.040.17.26.R	32-40	2.60	1.95	0.069	0.55	2.35	0.45	17.00	35.00

Series no. **25173** **25175** **25179**

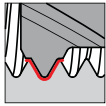
Cutting direction

Code no.	Description	P	D min	f	flat width	t max	a	E	La	Lg
		Thread/inch	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TU32.040.17.26.L	32-40	2.60	1.95	0.069	0.55	2.35	0.45	17.00	35.00



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

Series no. 25180 25182 25186



• pitch 24-28 thread/inch

Tool material **Solid carbide**

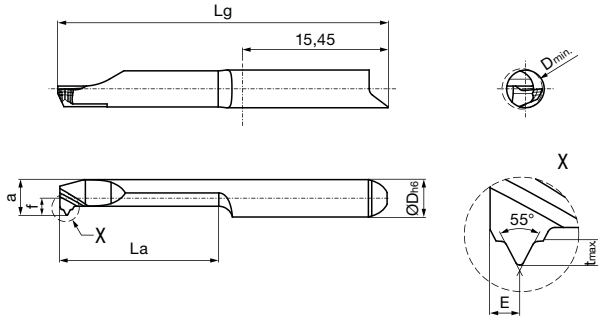
Type GG 104 GG 104 GG 104

Coating **S** **a**

TiN nano-A uncoated

for tool holders type GH104/GB104 see from page 18

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
4.003	GG104.VW24.106.17.33.R	24	3.30	1.95	0.75	3.00	0.80	17.00	35.00	4.00
4.002	GG104.VW26.098.17.49.R	26	4.90	1.95	0.70	3.95	0.80	17.00	35.00	4.00
4.001	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
4.003	GG104.VW24.106.17.33.L	24	3.30	1.95	0.75	3.00	0.80	17.00	35.00	4.00
4.002	GG104.VW26.098.17.49.L	26	4.90	1.95	0.70	3.95	0.80	17.00	35.00	4.00
4.001	GG104.VW28.091.17.43.L	28	4.30	1.80	0.65	3.80	0.75	17.00	35.00	4.00

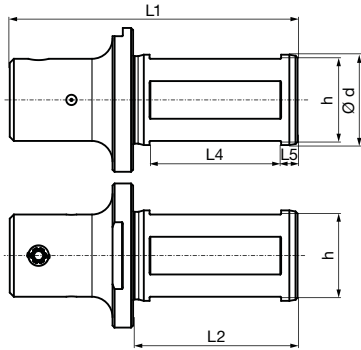


Round shank holder, 4 clamping surfaces

Series no. **25006**

- for inserts type 104
- with internal coolant delivery

Type GB 104



Cutting direction

left and right

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
4.001	GB104.0020.070.00.15.S.IK	20.00		18.00	70.00	40.00	32.00	4.00
4.002	GB104.0022.070.00.15.S.IK	22.00		20.00	70.00	40.00	32.00	4.00
4.003	GB104.0025.070.00.15.S.IK	25.00		23.00	70.00	40.00	32.00	4.00
4.011	GB104.1000.275.00.15.S.IK		1"	23.40	69.85	40.00	32.00	4.00

Spare parts

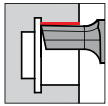
Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



Cutting insert for internal hexagon

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



• SW 1.5-4.0

Tool material **Solid carbide**

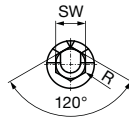
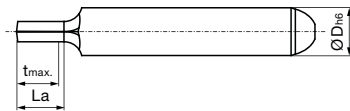
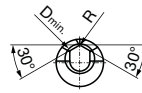
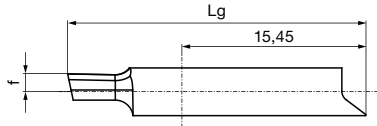
Type GN 104 GN 104 GN 104

Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GB104 Art. No. 25006 see page 63

Cutting data page 214

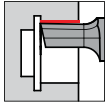


Code no.	Description	SW	D min	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm
4.001	GN104.SW15.005.04.15.N	1.50-2.00	1.50	0.05	1.50	3.50	4.00	25.00	4.00
4.002	GN104.SW20.005.04.20.N	2.00-2.50	2.00	0.05	1.50	3.50	4.00	25.00	4.00
4.003	GN104.SW25.005.04.25.N	2.50-2.90	2.50	0.05	1.50	3.50	4.00	25.00	4.00
4.004	GN104.SW29.005.05.29.N	2.90-3.50	2.90	0.05	1.50	4.50	5.00	25.00	4.00
4.005	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

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



• SW 1.5-4.0

Tool material **Solid carbide**

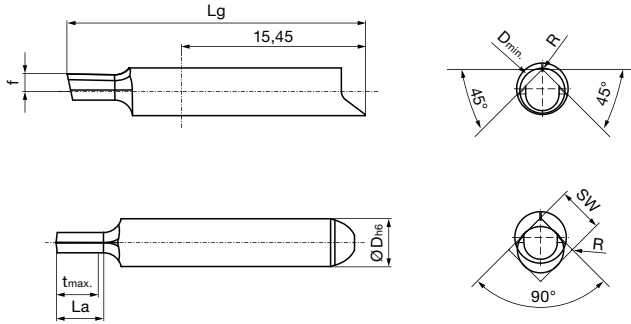
Type GN 104 GN 104 GN 104

Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GB104 Art. No. 25006 see page 63

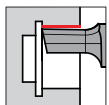
Cutting data page 214



Code no.	Description	SW	D min	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm
4.001	GN104.4545.005.04.15.N	1.50-2.00	1.50	0.05	1.50	3.50	4.00	25.00	4.00
4.002	GN104.4545.005.04.20.N	2.00-2.50	2.00	0.05	1.50	3.50	4.00	25.00	4.00
4.003	GN104.4545.005.04.25.N	2.50-2.90	2.50	0.05	1.50	3.50	4.00	25.00	4.00
4.004	GN104.4545.005.05.29.N	2.90-3.50	2.90	0.05	1.50	4.50	5.00	25.00	4.00
4.005	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

Series no. 25236 25237 25239

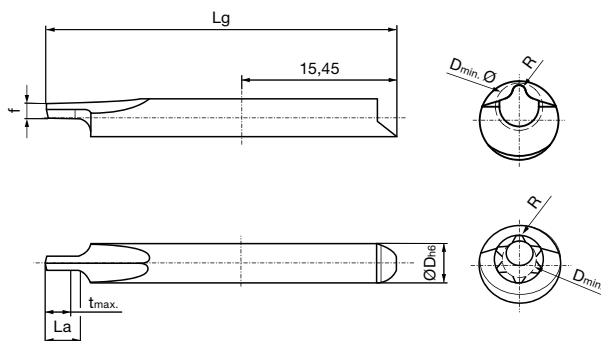


• Torx 8-30

for tool holders type GB104 Art. No. 25006 see page 63

Tool material	Solid carbide		
Type	GN 104	GN 104	GN 104
Coating			
	TiN	nano-A	uncoated

Cutting data page 214



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

MICRO-PRECISION TOOLS

Guhring's micro-precision tools range from micro-precision drills with a radius of 0.05 mm to special solutions in larger sizes and from HSS to solid carbide. The micro-precision tool range comprises 75 types in over 2,400 sizes and therefore offers stocked tool solutions for a variety of applications. Specially adapted geometries, substrates and surfaces guarantee optimum performance and processing safety for drilling, milling, reaming and threading in micro applications.



106





SYSTEM 106

MICRO-PRECISION TOOLS

System 106



Round shank holder
from page 70



Square shank holder
from page 77



Modular holder
from page 79

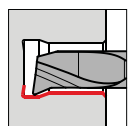


Star holders
Backworking
page 82

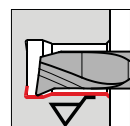


Round shank holder
Broaching
page 128

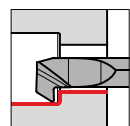
Tool holder



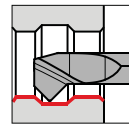
Boring out
and profiling, Type GT
from page 83



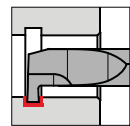
Boring out,
with Wiper, Type GJ
page 100



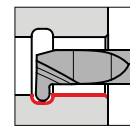
Back boring
and profiling, Type GT
page 104



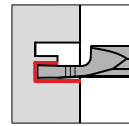
Boring out
and chamfering, Type GT
page 106



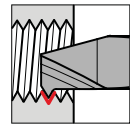
Internal grooving,
straight slots, Type GE
from page 110



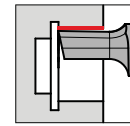
Internal grooving,
full radius slots, Type GE
from page 114



Axial grooving bores,
Type GA
from page 118



Internal threading,
Type GG
from page 123



Broaching,
Type GN
page 129

Cutting inserts from hole-Ø 5 mm

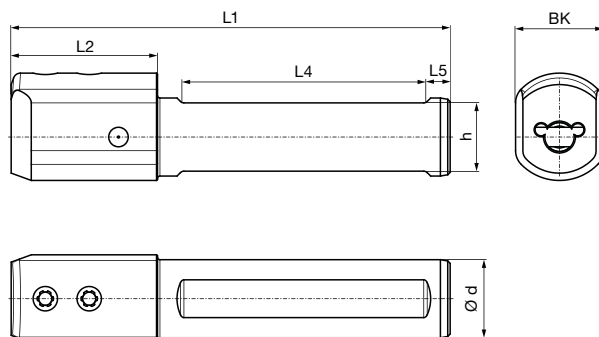


Round shank holder, clamping screw top

Series no. 25300

- for inserts type 106
- with internal coolant delivery

Type GB 106



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

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

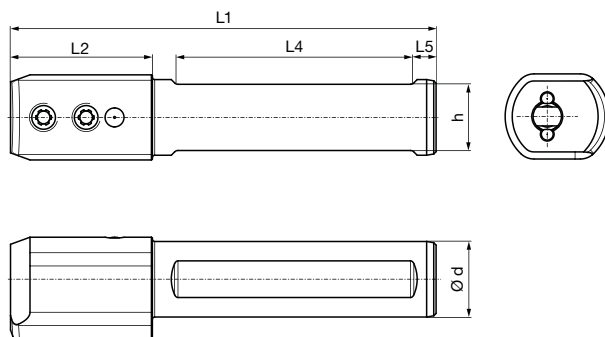


Round shank holder, clamping screw lateral

Series no. **25301**

- for inserts type 106
- with internal coolant delivery

Type **GB 106**



System 106

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

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



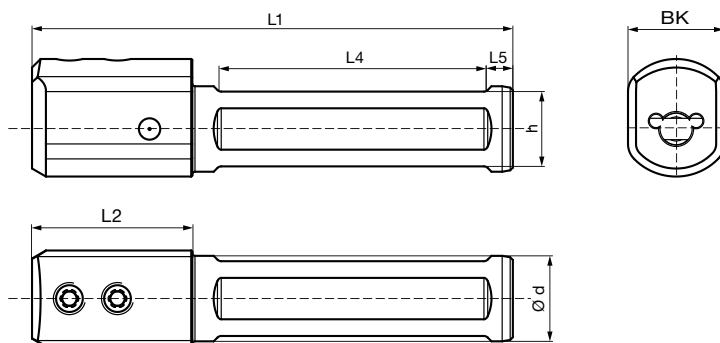
Round shank holder, clamping screw above, four clamping surfaces

Series no. **25320**

- for inserts type 106
- with internal coolant delivery

Type GB 106

System 106



version left and right

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

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

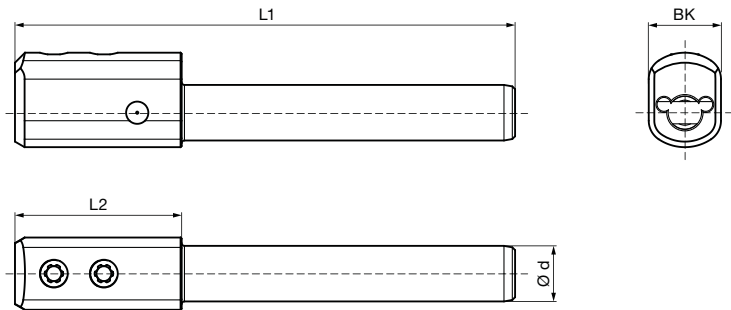


Round shank holder, clamping screw above, without clamping surfaces

Series no. **25319**

- for inserts type 106
- with internal coolant delivery

Type **GB 106**



System 106

version left and right

Code no.	Description	d	L1	L2	BK
		mm	mm	mm	mm
6.010	GB106.0010.090.00.22.N.IK.RND	10.00	90.00	30.00	13.0
6.020	GB106.0012.090.00.22.N.IK.RND	12.00	90.00	30.00	14.0
6.030	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 6.000	M6x7.5x15IP	4-4.5

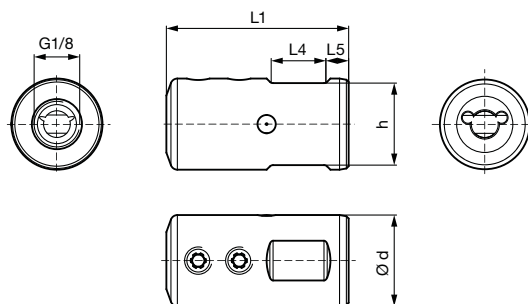
Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

Round shank holder, clamping screw above, for Citizen machine

Series no. 25316

- for inserts type 106
- with internal coolant delivery

Type GB 106



version left and right

Code no.	Description	d	d	h	L1	L4	L5
		mm	inch	mm	mm	mm	mm
6.110	GB106.0750.040.00.22.N.IK.CIT		3/4	17.05	40.00	12.70	5.08
6.120	GB106.0750.050.00.22.N.IK.CIT		3/4	17.05	50.00	22.86	5.08
6.130	GB106.0750.070.00.22.N.IK.CIT		3/4	17.05	70.00	44.45	5.08
6.140	GB106.0750.100.00.22.N.IK.CIT		3/4	17.05	100.00	73.66	5.08
6.010	GB106.0020.040.00.22.N.IK.CIT	20.00		18.00	40.00	12.00	5.00
6.020	GB106.0020.050.00.22.N.IK.CIT	20.00		18.00	50.00	22.00	5.00
6.150	GB106.1000.060.00.22.N.IK.CIT		1"	23.40	60.00	31.75	5.08
6.160	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

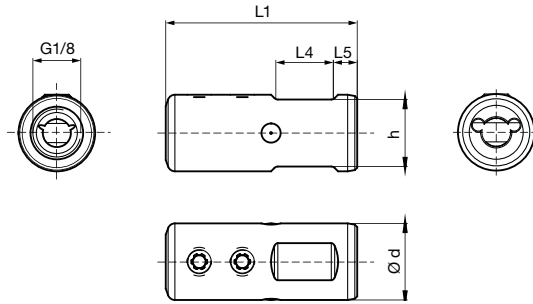


Round shank holder, clamping screw above, for Star machine

Series no. **25317**

- for inserts type 106
- with internal coolant delivery

Type **GB 106**



version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
6.010	GB106.0016.040.00.22.N.IK.STA	16.00	14.00	40.00	12.00	5.00
6.020	GB106.0016.050.00.22.N.IK.STA	16.00	14.00	50.00	22.00	5.00
6.030	GB106.0016.070.00.22.N.IK.STA	16.00	14.00	70.00	42.00	5.00
6.040	GB106.0022.038.00.22.N.IK.STA	22.00	20.00	38.00	10.00	5.00
6.050	GB106.0022.050.00.22.N.IK.STA	22.00	20.00	50.00	20.00	5.00
6.060	GB106.0022.070.00.22.N.IK.STA	22.00	20.00	70.00	40.00	5.00
6.070	GB106.0022.100.00.22.N.IK.STA	22.00	20.00	100.00	70.00	5.00
6.080	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

System 106



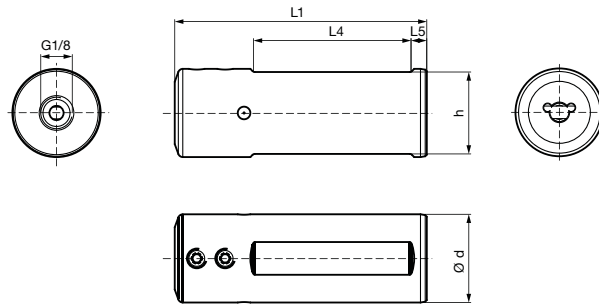
Round shank holder, clamping screw above, for Tornos machine

Series no. **25318**

- for inserts type 106
- with internal coolant delivery

Type GB 106

System 106



version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
6.010	GB106.0018.310.00.22.N.IK.TOR	18.00	16.00	310.00	280.00	5.00
6.020	GB106.0020.170.00.22.N.IK.TOR	20.00	18.00	170.00	140.00	5.00
6.030	GB106.0020.185.00.22.N.IK.TOR	20.00	18.00	185.00	155.00	5.00
6.040	GB106.0025.100.00.22.N.IK.TOR	25.00	23.00	100.00	70.00	5.00
6.050	GB106.0025.150.00.22.N.IK.TOR	25.00	23.00	150.00	120.00	5.00
6.060	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

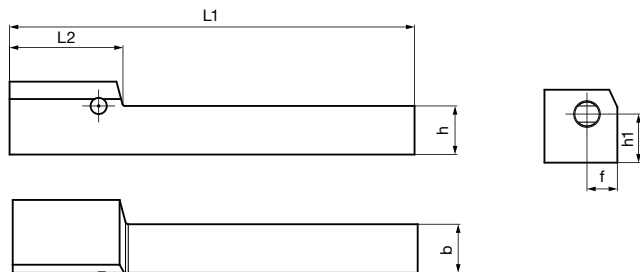


Square shank holder, straight 0°

Series no. **25314**

- for inserts type 106
- without internal coolant delivery

Type **GH 106**



Right hand version shown
Left hand version mirror image

version **right-hand**

Code no.	Description	b	b	h	h1	f	L1	L2
		mm	inch	mm	mm	mm	mm	mm
6.110	GH106.0375.350.00.22.R		3/8	9.52	9.52	7.62	88.90	27.94
6.010	GH106.1010.100.00.22.R	10.00		10.00	10.00	7.50	100.00	28.00
6.020	GH106.1212.100.00.22.R	12.00		12.00	12.00	7.50	100.00	28.00
6.120	GH106.0500.350.00.22.R		1/2	12.70	12.70	7.62	88.90	27.94
6.130	GH106.0625.400.00.22.R		5/8	15.87	15.87	7.62	101.60	27.94
6.030	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
6.110	GH106.0375.350.00.22.L		3/8	9.52	9.52	7.62	88.90	27.94
6.010	GH106.1010.100.00.22.L	10.00		10.00	10.00	7.50	100.00	28.00
6.020	GH106.1212.100.00.22.L	12.00		12.00	12.00	7.50	100.00	28.00
6.120	GH106.0500.350.00.22.L		1/2	12.70	12.70	7.62	88.90	27.94
6.130	GH106.0625.400.00.22.L		5/8	15.87	15.87	7.62	101.60	27.94
6.030	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



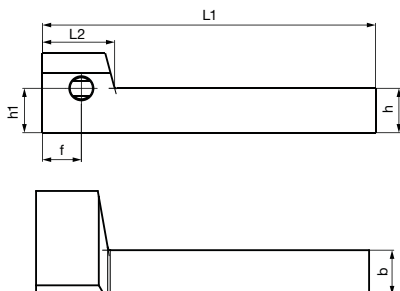
Square shank holder, 90° offset

Series no. **25304**

- for inserts type 106
- without internal coolant delivery

Type GH 106

System 106



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	b	b	h	h1	f	L1	L2
		mm	inch	mm	mm	mm	mm	mm
6.010	GH106.0375.350.90.22.R		3/8	9.52	9.52	22.00	88.90	19.50
6.001	GH106.1010.090.90.22.R	10.00		10.00	10.00	22.00	90.00	19.50
6.002	GH106.1212.090.90.22.R	12.00		12.00	12.00	22.00	90.00	19.50
6.011	GH106.0500.350.90.22.R		1/2	12.70	12.70	22.00	88.90	19.50
6.012	GH106.0625.400.90.22.R		5/8	15.87	15.87	22.00	101.60	19.50
6.003	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	b	h	h1	f	L1	L2
		mm	inch	mm	mm	mm	mm	mm
6.010	GH106.0375.350.90.22.L		3/8	9.52	9.52	22.00	88.90	19.50
6.001	GH106.1010.090.90.22.L	10.00		10.00	10.00	22.00	90.00	19.50
6.002	GH106.1212.090.90.22.L	12.00		12.00	12.00	22.00	90.00	19.50
6.011	GH106.0500.350.90.22.L		1/2	12.70	12.70	22.00	88.90	19.50
6.012	GH106.0625.400.90.22.L		5/8	15.87	15.87	22.00	101.60	19.50
6.003	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
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

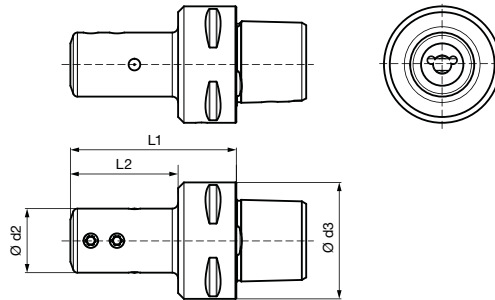


Polygon shank holder, to ISO 26623, straight 0°

Series no. **25307**

- for inserts type 106
- with internal coolant delivery

Type **GH 106**



version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
6.001	GH106.PO32.052.00.22.N.IK	22.00	PSC 32	52.00	37.00
6.002	GH106.PO40.057.00.22.N.IK	22.00	PSC 40	57.00	37.00
6.003	GH106.PO50.057.00.22.N.IK	22.00	PSC 50	57.00	37.00
6.004	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



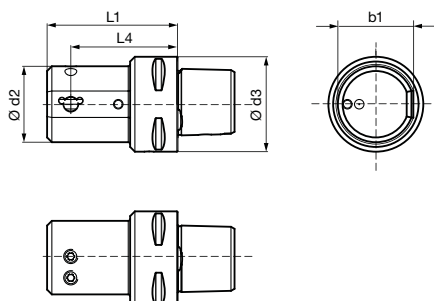
Polygon shank holder, to ISO 26623, off-set 90°

Series no. **25308**

- for inserts type 106
- with internal coolant delivery

Type GH 106

System 106



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	d2	d3	L1	L4	b1
		mm		mm	mm	mm
6.001	GH106.PO32.045.90.22.R.IK	32.00	PSC 32	55.00	45.00	31.00
6.002	GH106.PO40.045.90.22.R.IK	32.00	PSC 40	55.00	45.00	31.00
6.003	GH106.PO50.050.90.22.R.IK	32.00	PSC 50	60.00	50.00	31.00
6.004	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
6.001	GH106.PO32.045.90.22.L.IK	32.00	PSC 32	55.00	45.00	31.00
6.002	GH106.PO40.045.90.22.L.IK	32.00	PSC 40	55.00	45.00	31.00
6.003	GH106.PO50.050.90.22.L.IK	32.00	PSC 50	60.00	50.00	31.00
6.004	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 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

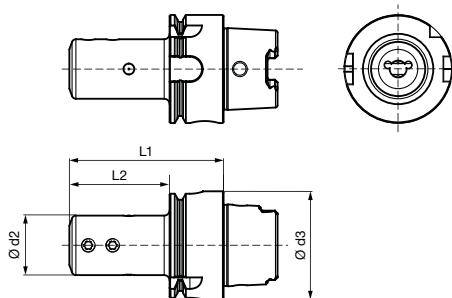


HSK-T holder, to ISO 12164-3, straight 0°

Series no. **25311**

- for inserts type 106
- with internal coolant delivery

Type **GH 106**



version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
6.001	GH106.HS40.057.00.22.N.IK	22.00	HSK-T 40	57.00	37.00
6.002	GH106.HS63.063.00.22.N.IK	22.00	HSK-T 63	63.00	37.00

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

System 106



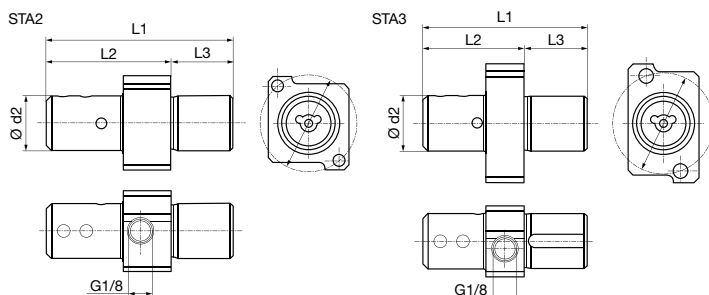
Star holders for backworking

Series no. **25321**

- for inserts type 106
- with internal coolant delivery

Type GB 106

System 106



version left and right

Code no.	Description	d	L1	L2	x	y
		mm	mm	mm		
6.010	GB106.0022.075.00.22.N.IK.STA2	22.00	75.00	50.00	25.00	30.00
6.020	GB106.0022.065.00.22.N.IK.STA3	22.00	65.00	40.00	13.66	37.60

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

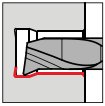
Series no.	Connecting screw	Holder Designation
25912		
Code 4.000	M4x30 (STA2)	GB106.022.....IK.STA2
Code 5.000	M5x30 (STA3)	GB106.022.....IK.STA3

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



Cutting insert for boring out and profiling

Series no. **25832** **25834** **25838**



• radial free 23°

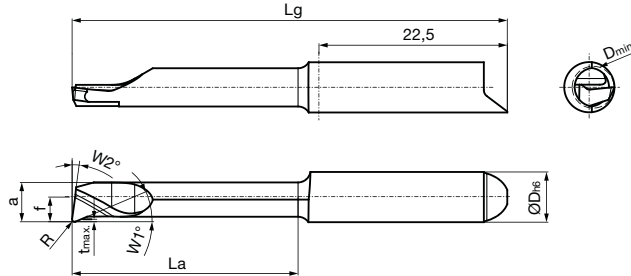
Tool material **Solid carbide**

Type GT 106 GT 106 GT 106

Coating **S** **a** ○
TiN nano-A uncoated

for tool holders type GB106/GH106 see from page 70

Cutting data page 214



Right hand version shown
Left hand version mirror image

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	GT106.2347.005.12.50.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

System 106

Series no. **25833** **25835** **25839**Cutting direction   

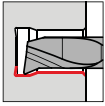
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.2347.005.12.50.L	5.00	0.05	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GT106.2347.005.17.50.L	5.00	0.05	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GT106.2347.005.22.50.L	5.00	0.05	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.040	GT106.2347.005.27.50.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.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

Series no. 25700 25702 25706

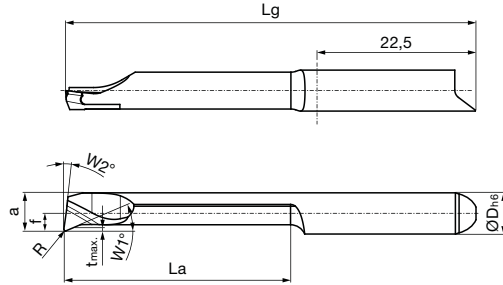


• radial free 23°

for tool holders type GB106/GH106 see from page 70

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Coating	S	a	○
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
6.001	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



Cutting insert for boring out and profiling

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
6.037	GT106.2357.020.12.60.R	6.00	0.20	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.038	GT106.2357.020.17.60.R	6.00	0.20	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.039	GT106.2357.020.22.60.R	6.00	0.20	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.040	GT106.2357.020.27.60.R	6.00	0.20	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.041	GT106.2357.020.32.60.R	6.00	0.20	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.042	GT106.2357.020.37.60.R	6.00	0.20	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.043	GT106.2357.020.42.60.R	6.00	0.20	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.044	GT106.2357.020.47.60.R	6.00	0.20	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.045	GT106.2357.020.52.60.R	6.00	0.20	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.046	GT106.2357.025.12.60.R	6.00	0.25	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.047	GT106.2357.025.17.60.R	6.00	0.25	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.048	GT106.2357.025.22.60.R	6.00	0.25	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.049	GT106.2357.025.27.60.R	6.00	0.25	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.050	GT106.2357.025.32.60.R	6.00	0.25	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.051	GT106.2357.025.37.60.R	6.00	0.25	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.052	GT106.2357.025.42.60.R	6.00	0.25	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.053	GT106.2357.025.47.60.R	6.00	0.25	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.054	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**

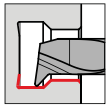
Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.001	GT106.2357.015.27.60.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	6.00	0.10	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.037	GT106.2357.020.12.60.L	6.00	0.20	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.038	GT106.2357.020.17.60.L	6.00	0.20	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.039	GT106.2357.020.22.60.L	6.00	0.20	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.040	GT106.2357.020.27.60.L	6.00	0.20	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.041	GT106.2357.020.32.60.L	6.00	0.20	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.042	GT106.2357.020.37.60.L	6.00	0.20	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.043	GT106.2357.020.42.60.L	6.00	0.20	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.044	GT106.2357.020.47.60.L	6.00	0.20	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.045	GT106.2357.020.52.60.L	6.00	0.20	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.046	GT106.2357.025.12.60.L	6.00	0.25	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.047	GT106.2357.025.17.60.L	6.00	0.25	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.048	GT106.2357.025.22.60.L	6.00	0.25	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.049	GT106.2357.025.27.60.L	6.00	0.25	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.050	GT106.2357.025.32.60.L	6.00	0.25	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.051	GT106.2357.025.37.60.L	6.00	0.25	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.052	GT106.2357.025.42.60.L	6.00	0.25	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.053	GT106.2357.025.47.60.L	6.00	0.25	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.054	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

Series no. **25840** **25842** **25846**



• radial free 47°, tmax 0.6

Tool material **Solid carbide**

Type GT 106 GT 106 GT 106

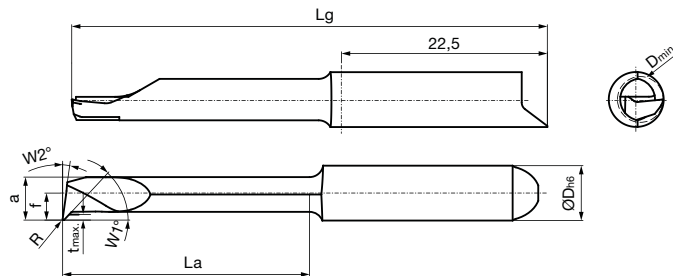
Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GB106/GH106 see from page 70

Cutting data page 214


System 106



Right hand version shown
Left hand version mirror image

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	GT106.4747.005.12.50.R	5.00	0.05	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.020	GT106.4747.005.17.50.R	5.00	0.05	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.030	GT106.4747.005.22.50.R	5.00	0.05	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.040	GT106.4747.005.27.50.R	5.00	0.05	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.050	GT106.4747.005.32.50.R	5.00	0.05	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.060	GT106.4747.005.37.50.R	5.00	0.05	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.070	GT106.4747.005.42.50.R	5.00	0.05	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.110	GT106.4747.010.12.50.R	5.00	0.10	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.120	GT106.4747.010.17.50.R	5.00	0.10	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.130	GT106.4747.010.22.50.R	5.00	0.10	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.140	GT106.4747.010.27.50.R	5.00	0.10	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.150	GT106.4747.010.32.50.R	5.00	0.10	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.160	GT106.4747.010.37.50.R	5.00	0.10	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.170	GT106.4747.010.42.50.R	5.00	0.10	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.210	GT106.4747.015.12.50.R	5.00	0.15	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.220	GT106.4747.015.17.50.R	5.00	0.15	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.230	GT106.4747.015.22.50.R	5.00	0.15	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.240	GT106.4747.015.27.50.R	5.00	0.15	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.250	GT106.4747.015.32.50.R	5.00	0.15	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.260	GT106.4747.015.37.50.R	5.00	0.15	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.270	GT106.4747.015.42.50.R	5.00	0.15	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.310	GT106.4747.020.12.50.R	5.00	0.20	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.320	GT106.4747.020.17.50.R	5.00	0.20	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.330	GT106.4747.020.22.50.R	5.00	0.20	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.340	GT106.4747.020.27.50.R	5.00	0.20	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.350	GT106.4747.020.32.50.R	5.00	0.20	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.360	GT106.4747.020.37.50.R	5.00	0.20	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.370	GT106.4747.020.42.50.R	5.00	0.20	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.410	GT106.4747.030.12.50.R	5.00	0.30	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.420	GT106.4747.030.17.50.R	5.00	0.30	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.430	GT106.4747.030.22.50.R	5.00	0.30	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.440	GT106.4747.030.27.50.R	5.00	0.30	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.450	GT106.4747.030.32.50.R	5.00	0.30	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.460	GT106.4747.030.37.50.R	5.00	0.30	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.470	GT106.4747.030.42.50.R	5.00	0.30	47	8	2.95	4.70	0.60	42.00	67.00	6.00

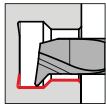
Series no. **25841** **25843** **25847**Cutting direction   

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

Series no. 25708 25710 25714

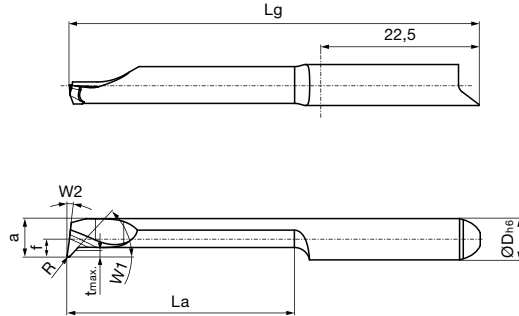


• radial free 47°

for tool holders type GB106/GH106 see from page 70

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Coating	S	a	circle
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

Code no.	Description	Cutting direction									
		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
6.017	GT106.4757.030.17.60.R	6.00	0.30	47	8	2.70	5.70	0.60	17.00	42.00	6.00

System 106



Cutting insert for boring out and profiling

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
6.018	GT106.4757.030.22.60.R	6.00	0.30	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.007	GT106.4757.030.27.60.R	6.00	0.30	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.008	GT106.4757.030.32.60.R	6.00	0.30	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.009	GT106.4757.030.37.60.R	6.00	0.30	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.010	GT106.4757.030.42.60.R	6.00	0.30	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.011	GT106.4757.030.47.60.R	6.00	0.30	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.012	GT106.4757.030.52.60.R	6.00	0.30	47	8	2.70	5.70	0.60	52.00	77.00	6.00

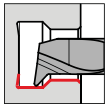
Series no. 25709 25711 25715

		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
6.019	GT106.4757.005.12.60.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	6.00	0.30	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.017	GT106.4757.030.17.60.L	6.00	0.30	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.018	GT106.4757.030.22.60.L	6.00	0.30	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.007	GT106.4757.030.27.60.L	6.00	0.30	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.008	GT106.4757.030.32.60.L	6.00	0.30	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.009	GT106.4757.030.37.60.L	6.00	0.30	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.010	GT106.4757.030.42.60.L	6.00	0.30	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.011	GT106.4757.030.47.60.L	6.00	0.30	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.012	GT106.4757.030.52.60.L	6.00	0.30	47	8	2.70	5.70	0.60	52.00	77.00	6.00



Cutting insert for boring out and profiling

Series no. 25888 25890 25894

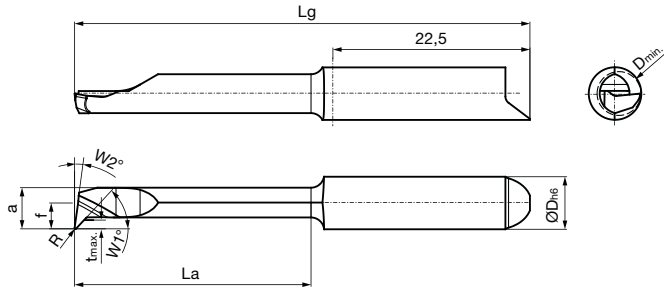


• radial free 47°, tmax 1

for tool holders type GB106/GH106 see from page 70

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Coating	S	a	○
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image



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

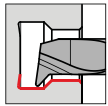


Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.4747.005.12.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.020	GT106.4747.005.17.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.030	GT106.4747.005.22.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.040	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
6.050	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
6.060	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
6.070	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
6.110	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
6.120	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
6.130	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
6.140	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
6.150	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
6.160	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
6.170	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
6.210	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
6.220	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
6.230	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
6.240	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
6.250	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
6.260	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
6.270	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
6.310	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
6.320	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
6.330	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
6.340	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
6.350	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
6.360	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
6.370	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
6.410	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
6.420	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
6.430	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
6.440	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
6.450	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
6.460	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
6.470	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

Series no. 25516 25518 25522



• radial free 47°, tmax 2

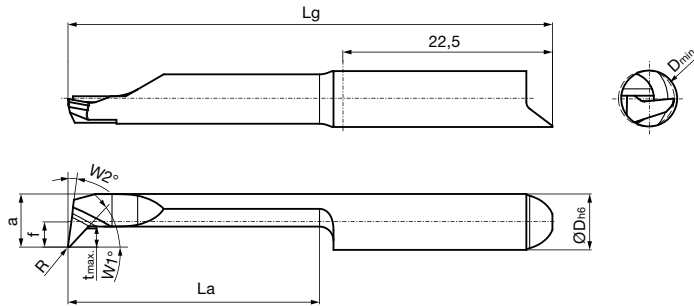
Tool material **Solid carbide**

Type GT 106 GT 106 GT 106

Coating **S** **a** ○
TiN nano-A uncoated

for tool holders type GB106/GH106 see from page 70

Cutting data page 214



Right hand version shown
Left hand version mirror image

Code no.	Description	Cutting direction									
		D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	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
6.020	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
6.030	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
6.040	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
6.050	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
6.060	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
6.070	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
6.080	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
6.090	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
6.110	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
6.120	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
6.130	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
6.140	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
6.150	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
6.160	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
6.170	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
6.180	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
6.190	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
6.210	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
6.220	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
6.230	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
6.240	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
6.250	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
6.260	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
6.270	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
6.280	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
6.290	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
6.310	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
6.320	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
6.330	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
6.340	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
6.350	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
6.360	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
6.370	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
6.380	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
6.390	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
6.410	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
6.420	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

System 106



Cutting insert for boring out and profiling

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

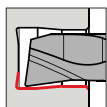
Code no.	Description	D min	R	W1	W2	Cutting direction					
						f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.430	GT106.4757.030.22.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	22.00	47.00	6.00
6.440	GT106.4757.030.27.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	27.00	52.00	6.00
6.450	GT106.4757.030.32.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	32.00	57.00	6.00
6.460	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
6.470	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
6.480	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
6.490	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**

Code no.	Description	D min	R	W1	W2	Cutting direction					
						f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	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
6.020	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
6.030	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
6.040	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
6.050	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
6.060	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
6.070	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
6.080	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
6.090	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
6.110	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
6.120	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
6.130	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
6.140	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
6.150	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
6.160	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
6.170	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
6.180	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
6.190	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
6.210	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
6.220	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
6.230	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
6.240	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
6.250	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
6.260	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
6.270	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
6.280	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
6.290	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
6.310	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
6.320	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
6.330	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
6.340	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
6.350	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
6.360	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
6.370	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
6.380	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
6.390	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
6.410	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
6.420	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
6.430	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
6.440	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
6.450	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
6.460	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
6.470	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
6.480	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
6.490	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

Cutting insert for boring out and profiling

Series no. 25500 25502 25506

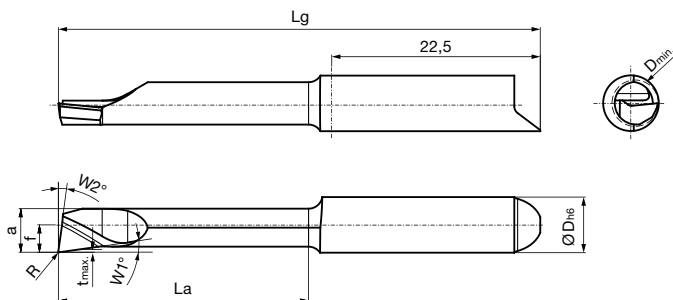


• radial free 8°

for tool holders type GB106/GH106 see from page 70

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Coating	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image



Cutting direction

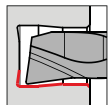
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.0847.005.12.50.R	5.00	0.05	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GT106.0847.005.17.50.R	5.00	0.05	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GT106.0847.005.22.50.R	5.00	0.05	8	8	2.95	4.70	0.30	22.00	47.00	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
6.010	GT106.0847.005.12.50.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	5.00	0.30	8	8	2.95	4.70	0.30	42.00	67.00	6.00

Cutting insert for boring out and profiling

Series no. **25508** **25510** **25514**

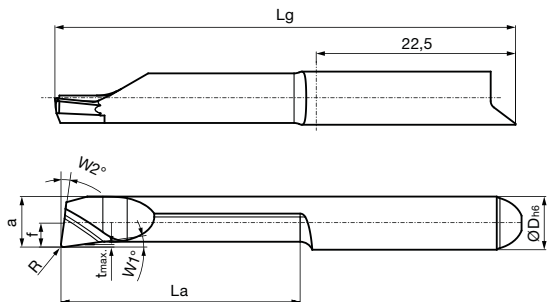


• radial free 8°

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Coating	S	a	○
	TiN	nano-A	uncoated

for tool holders type GB106/GH106 see from page 70

Cutting data page 214



Right hand version shown
Left hand version mirror image

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	GT106.0857.005.12.60.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

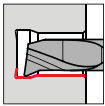
Series no. **25509** **25511** **25515**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.0857.005.12.60.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.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

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

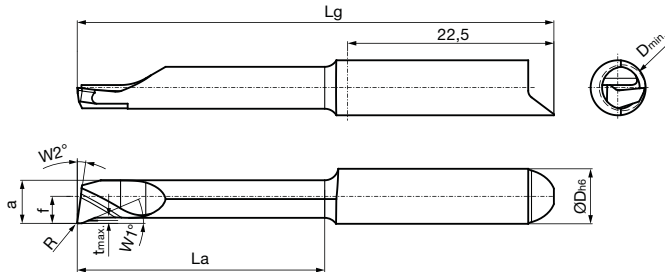


• WIPER-geometry

for tool holders type GB106/GH106 see from page 70

Tool material	Solid carbide		
Type	GJ 106	GJ 106	GJ 106
Coating	S	a	○
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image



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	GJ106.2347.005.12.50.R	5.00	0.05	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GJ106.2347.005.17.50.R	5.00	0.05	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GJ106.2347.005.22.50.R	5.00	0.05	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.040	GJ106.2347.005.27.50.R	5.00	0.05	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.050	GJ106.2347.005.32.50.R	5.00	0.05	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.060	GJ106.2347.005.37.50.R	5.00	0.05	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.070	GJ106.2347.005.42.50.R	5.00	0.05	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.110	GJ106.2347.010.12.50.R	5.00	0.10	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.120	GJ106.2347.010.17.50.R	5.00	0.10	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.130	GJ106.2347.010.22.50.R	5.00	0.10	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.140	GJ106.2347.010.27.50.R	5.00	0.10	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.150	GJ106.2347.010.32.50.R	5.00	0.10	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.160	GJ106.2347.010.37.50.R	5.00	0.10	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.170	GJ106.2347.010.42.50.R	5.00	0.10	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.210	GJ106.2347.015.12.50.R	5.00	0.15	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.220	GJ106.2347.015.17.50.R	5.00	0.15	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.230	GJ106.2347.015.22.50.R	5.00	0.15	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.240	GJ106.2347.015.27.50.R	5.00	0.15	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.250	GJ106.2347.015.32.50.R	5.00	0.15	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.260	GJ106.2347.015.37.50.R	5.00	0.15	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.270	GJ106.2347.015.42.50.R	5.00	0.15	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.310	GJ106.2347.020.12.50.R	5.00	0.20	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.320	GJ106.2347.020.17.50.R	5.00	0.20	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.330	GJ106.2347.020.22.50.R	5.00	0.20	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.340	GJ106.2347.020.27.50.R	5.00	0.20	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.350	GJ106.2347.020.32.50.R	5.00	0.20	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.360	GJ106.2347.020.37.50.R	5.00	0.20	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.370	GJ106.2347.020.42.50.R	5.00	0.20	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.410	GJ106.2347.030.12.50.R	5.00	0.30	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.420	GJ106.2347.030.17.50.R	5.00	0.30	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.430	GJ106.2347.030.22.50.R	5.00	0.30	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.440	GJ106.2347.030.27.50.R	5.00	0.30	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.450	GJ106.2347.030.32.50.R	5.00	0.30	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.460	GJ106.2347.030.37.50.R	5.00	0.30	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.470	GJ106.2347.030.42.50.R	5.00	0.30	23	8	2.95	4.70	0.30	42.00	67.00	6.00

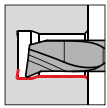
Series no. **25849** **25851** **25855**

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
6.010	GJ106.2347.005.12.50.L	5.00	0.05	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GJ106.2347.005.17.50.L	5.00	0.05	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GJ106.2347.005.22.50.L	5.00	0.05	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.040	GJ106.2347.005.27.50.L	5.00	0.05	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.050	GJ106.2347.005.32.50.L	5.00	0.05	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.060	GJ106.2347.005.37.50.L	5.00	0.05	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.070	GJ106.2347.005.42.50.L	5.00	0.05	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.110	GJ106.2347.010.12.50.L	5.00	0.10	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.120	GJ106.2347.010.17.50.L	5.00	0.10	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.130	GJ106.2347.010.22.50.L	5.00	0.10	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.140	GJ106.2347.010.27.50.L	5.00	0.10	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.150	GJ106.2347.010.32.50.L	5.00	0.10	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.160	GJ106.2347.010.37.50.L	5.00	0.10	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.170	GJ106.2347.010.42.50.L	5.00	0.10	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.210	GJ106.2347.015.12.50.L	5.00	0.15	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.220	GJ106.2347.015.17.50.L	5.00	0.15	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.230	GJ106.2347.015.22.50.L	5.00	0.15	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.240	GJ106.2347.015.27.50.L	5.00	0.15	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.250	GJ106.2347.015.32.50.L	5.00	0.15	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.260	GJ106.2347.015.37.50.L	5.00	0.15	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.270	GJ106.2347.015.42.50.L	5.00	0.15	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.310	GJ106.2347.020.12.50.L	5.00	0.20	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.320	GJ106.2347.020.17.50.L	5.00	0.20	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.330	GJ106.2347.020.22.50.L	5.00	0.20	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.340	GJ106.2347.020.27.50.L	5.00	0.20	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.350	GJ106.2347.020.32.50.L	5.00	0.20	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.360	GJ106.2347.020.37.50.L	5.00	0.20	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.370	GJ106.2347.020.42.50.L	5.00	0.20	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.410	GJ106.2347.030.12.50.L	5.00	0.30	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.420	GJ106.2347.030.17.50.L	5.00	0.30	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.430	GJ106.2347.030.22.50.L	5.00	0.30	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.440	GJ106.2347.030.27.50.L	5.00	0.30	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.450	GJ106.2347.030.32.50.L	5.00	0.30	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.460	GJ106.2347.030.37.50.L	5.00	0.30	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.470	GJ106.2347.030.42.50.L	5.00	0.30	23	8	2.95	4.70	0.30	42.00	67.00	6.00

Cutting insert for boring out and profiling

Series no. 25716 25718 25722

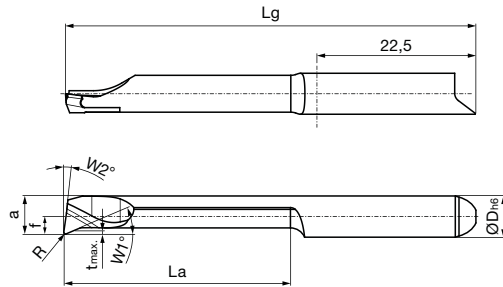


• WIPER-geometry

for tool holders type GB106/GH106 see from page 70

Tool material	Solid carbide		
Type	GJ 106	GJ 106	GJ 106
Coating	S TiN	a nano-A	○ uncoated


Cutting data page 214



Right hand version shown
Left hand version mirror image

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

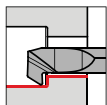
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.019	GJ106.2357.005.12.60.R	6.00	0.05	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.020	GJ106.2357.005.17.60.R	6.00	0.05	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.021	GJ106.2357.005.22.60.R	6.00	0.05	23	8	2.70	5.70	0.30	22.00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

Series no. 25856 25858 25862

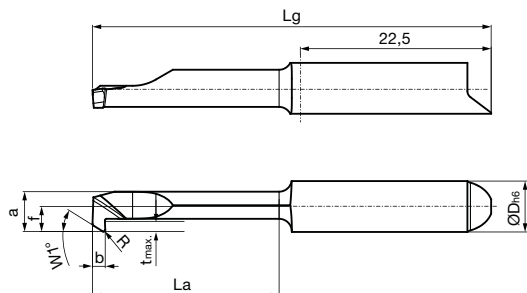


• radial free 32°

for tool holders type GB106/GH106 see from page 70

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Coating	 S	 a	
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
6.010	GT106.3247.020.12.50.R	5.00	0.20	32	2.95	4.70	1.20	12.00	37.00	6.00
6.020	GT106.3247.020.17.50.R	5.00	0.20	32	2.95	4.70	1.20	17.00	42.00	6.00
6.030	GT106.3247.020.22.50.R	5.00	0.20	32	2.95	4.70	1.20	22.00	47.00	6.00
6.040	GT106.3247.020.27.50.R	5.00	0.20	32	2.95	4.70	1.20	27.00	52.00	6.00
6.050	GT106.3247.020.32.50.R	5.00	0.20	32	2.95	4.70	1.20	32.00	57.00	6.00
6.060	GT106.3247.020.37.50.R	5.00	0.20	32	2.95	4.70	1.20	37.00	62.00	6.00
6.070	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

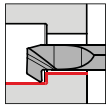
Cutting direction   

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



Cutting insert for back boring and profiling

Series no. **25732** **25734** **25738**

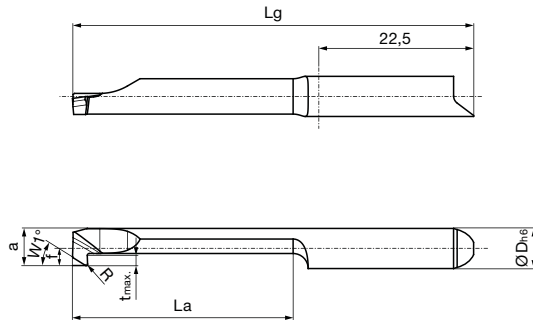


• radial free 32°

for tool holders type GB106/GH106 see from page 70

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Coating	S	a	○
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
6.013	GT106.3257.020.12.60.R	6.00	0.20	32	2.70	5.70	2.00	12.00	37.00	6.00
6.014	GT106.3257.020.17.60.R	6.00	0.20	32	2.70	5.70	2.00	17.00	42.00	6.00
6.001	GT106.3257.020.22.60.R	6.00	0.20	32	2.70	5.70	2.00	22.00	47.00	6.00
6.002	GT106.3257.020.32.60.R	6.00	0.20	32	2.70	5.70	2.00	32.00	57.00	6.00
6.003	GT106.3257.020.42.60.R	6.00	0.20	32	2.70	5.70	2.00	42.00	67.00	6.00
6.004	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. **25733** **25735** **25739**

Cutting direction

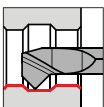
Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
6.013	GT106.3257.020.12.60.L	6.00	0.20	32	2.70	5.70	2.00	12.00	37.00	6.00
6.014	GT106.3257.020.17.60.L	6.00	0.20	32	2.70	5.70	2.00	17.00	42.00	6.00
6.001	GT106.3257.020.22.60.L	6.00	0.20	32	2.70	5.70	2.00	22.00	47.00	6.00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

System 106



Cutting insert for boring out and chamfering

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



• 45° both sides

Tool material **Solid carbide**

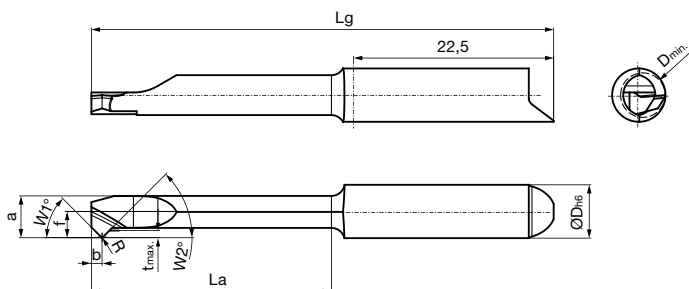
Type GT 106 GT 106 GT 106

Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GB106/GH106 see from page 70

Cutting data page 214



Right hand version shown
Left hand version mirror image



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	GT106.4547.010.12.50.R	5.00	0.10	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.020	GT106.4547.010.17.50.R	5.00	0.10	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.030	GT106.4547.010.22.50.R	5.00	0.10	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.040	GT106.4547.010.27.50.R	5.00	0.10	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.050	GT106.4547.010.32.50.R	5.00	0.10	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.060	GT106.4547.010.37.50.R	5.00	0.10	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.070	GT106.4547.010.42.50.R	5.00	0.10	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.110	GT106.4547.015.12.50.R	5.00	0.15	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.120	GT106.4547.015.17.50.R	5.00	0.15	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.130	GT106.4547.015.22.50.R	5.00	0.15	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.140	GT106.4547.015.27.50.R	5.00	0.15	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.150	GT106.4547.015.32.50.R	5.00	0.15	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.160	GT106.4547.015.37.50.R	5.00	0.15	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.170	GT106.4547.015.42.50.R	5.00	0.15	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.210	GT106.4547.020.12.50.R	5.00	0.20	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.220	GT106.4547.020.17.50.R	5.00	0.20	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.230	GT106.4547.020.22.50.R	5.00	0.20	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.240	GT106.4547.020.27.50.R	5.00	0.20	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.250	GT106.4547.020.32.50.R	5.00	0.20	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.260	GT106.4547.020.37.50.R	5.00	0.20	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.270	GT106.4547.020.42.50.R	5.00	0.20	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.310	GT106.4547.030.12.50.R	5.00	0.30	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.320	GT106.4547.030.17.50.R	5.00	0.30	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.330	GT106.4547.030.22.50.R	5.00	0.30	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.340	GT106.4547.030.27.50.R	5.00	0.30	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.350	GT106.4547.030.32.50.R	5.00	0.30	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.360	GT106.4547.030.37.50.R	5.00	0.30	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.370	GT106.4547.030.42.50.R	5.00	0.30	45	45	2.95	4.70	0.80	42.00	67.00	6.00

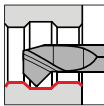
Series no. **25865** **25867** **25871**Cutting direction   

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	GT106.4547.010.12.50.L	5.00	0.10	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.020	GT106.4547.010.17.50.L	5.00	0.10	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.030	GT106.4547.010.22.50.L	5.00	0.10	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.040	GT106.4547.010.27.50.L	5.00	0.10	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.050	GT106.4547.010.32.50.L	5.00	0.10	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.060	GT106.4547.010.37.50.L	5.00	0.10	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.070	GT106.4547.010.42.50.L	5.00	0.10	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.110	GT106.4547.015.12.50.L	5.00	0.15	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.120	GT106.4547.015.17.50.L	5.00	0.15	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.130	GT106.4547.015.22.50.L	5.00	0.15	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.140	GT106.4547.015.27.50.L	5.00	0.15	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.150	GT106.4547.015.32.50.L	5.00	0.15	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.160	GT106.4547.015.37.50.L	5.00	0.15	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.170	GT106.4547.015.42.50.L	5.00	0.15	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.210	GT106.4547.020.12.50.L	5.00	0.20	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.220	GT106.4547.020.17.50.L	5.00	0.20	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.230	GT106.4547.020.22.50.L	5.00	0.20	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.240	GT106.4547.020.27.50.L	5.00	0.20	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.250	GT106.4547.020.32.50.L	5.00	0.20	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.260	GT106.4547.020.37.50.L	5.00	0.20	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.270	GT106.4547.020.42.50.L	5.00	0.20	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.310	GT106.4547.030.12.50.L	5.00	0.30	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.320	GT106.4547.030.17.50.L	5.00	0.30	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.330	GT106.4547.030.22.50.L	5.00	0.30	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.340	GT106.4547.030.27.50.L	5.00	0.30	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.350	GT106.4547.030.32.50.L	5.00	0.30	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.360	GT106.4547.030.37.50.L	5.00	0.30	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.370	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 boring out and chamfering

Series no. **25740** **25742** **25746**

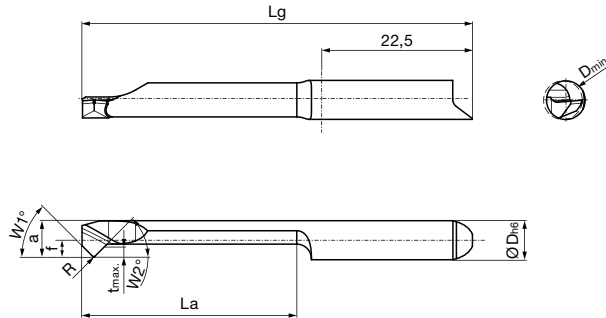


• 45° both sides

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Coating	S	a	○
	TiN	nano-A	uncoated

for tool holders type GB106/GH106 see from page 70

Cutting data page 214



Right hand version shown
Left hand version mirror image



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
6.019	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

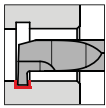
Series no. **25741** **25743** **25747**

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
6.019	GT106.4557.010.12.60.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.L	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.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

Series no. 25872 25874 25878

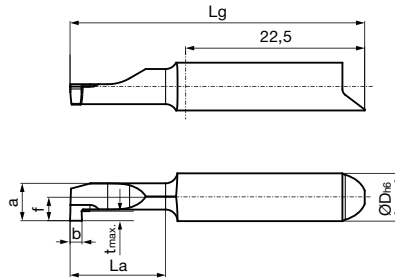


- grooving depth up to 1.2 mm

Tool material	Solid carbide		
Type	GE 106	GE 106	GE 106
Coating	S	a	○
	TiN	nano-A	uncoated

for tool holders type GB106/GH106 see from page 70

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
6.010	GE106.0100.000.12.50.R	5.00	1.00	2.95	4.70	1.20	12.00	37.00	6.00
6.020	GE106.0100.000.17.50.R	5.00	1.00	2.95	4.70	1.20	17.00	42.00	6.00
6.030	GE106.0100.000.22.50.R	5.00	1.00	2.95	4.70	1.20	22.00	47.00	6.00
6.040	GE106.0100.000.27.50.R	5.00	1.00	2.95	4.70	1.20	27.00	52.00	6.00
6.050	GE106.0100.000.32.50.R	5.00	1.00	2.95	4.70	1.20	32.00	57.00	6.00
6.060	GE106.0100.000.37.50.R	5.00	1.00	2.95	4.70	1.20	37.00	62.00	6.00
6.070	GE106.0100.000.42.50.R	5.00	1.00	2.95	4.70	1.20	42.00	67.00	6.00
6.110	GE106.0150.000.12.50.R	5.00	1.50	2.95	4.70	1.20	12.00	37.00	6.00
6.120	GE106.0150.000.17.50.R	5.00	1.50	2.95	4.70	1.20	17.00	42.00	6.00
6.130	GE106.0150.000.22.50.R	5.00	1.50	2.95	4.70	1.20	22.00	47.00	6.00
6.140	GE106.0150.000.27.50.R	5.00	1.50	2.95	4.70	1.20	27.00	52.00	6.00
6.150	GE106.0150.000.32.50.R	5.00	1.50	2.95	4.70	1.20	32.00	57.00	6.00
6.160	GE106.0150.000.37.50.R	5.00	1.50	2.95	4.70	1.20	37.00	62.00	6.00
6.170	GE106.0150.000.42.50.R	5.00	1.50	2.95	4.70	1.20	42.00	67.00	6.00
6.210	GE106.0200.000.12.50.R	5.00	2.00	2.95	4.70	1.20	12.00	37.00	6.00
6.220	GE106.0200.000.17.50.R	5.00	2.00	2.95	4.70	1.20	17.00	42.00	6.00
6.230	GE106.0200.000.22.50.R	5.00	2.00	2.95	4.70	1.20	22.00	47.00	6.00
6.240	GE106.0200.000.27.50.R	5.00	2.00	2.95	4.70	1.20	27.00	52.00	6.00
6.250	GE106.0200.000.32.50.R	5.00	2.00	2.95	4.70	1.20	32.00	57.00	6.00
6.260	GE106.0200.000.37.50.R	5.00	2.00	2.95	4.70	1.20	37.00	62.00	6.00
6.270	GE106.0200.000.42.50.R	5.00	2.00	2.95	4.70	1.20	42.00	67.00	6.00



Series no.	25873	25875	25879
Cutting direction			

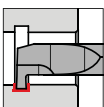
Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.010	GE106.0100.000.12.50.L	5.00	1.00	2.95	4.70	1.20	12.00	37.00	6.00
6.020	GE106.0100.000.17.50.L	5.00	1.00	2.95	4.70	1.20	17.00	42.00	6.00
6.030	GE106.0100.000.22.50.L	5.00	1.00	2.95	4.70	1.20	22.00	47.00	6.00
6.040	GE106.0100.000.27.50.L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

System 106



Cutting insert for internal grooving, straight slots

Series no. **25748** **25750** **25754**



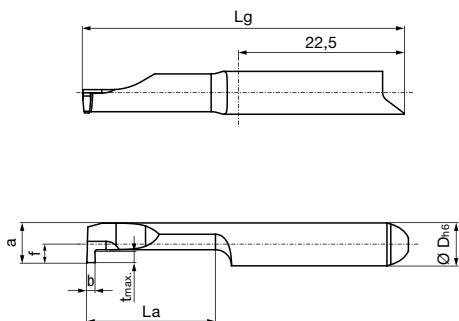
- grooving depth up to 2 mm

Tool material	Solid carbide		
Type	GE 106	GE 106	GE 106
Coating			
	TiN	nano-A	uncoated

for tool holders type GB106/GH106 see from page 70

Cutting data page 214

System 106



Right hand version shown
Left hand version mirror image

Cutting direction

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



Series no.	25749	25751	25755
Cutting direction			

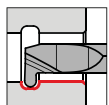
Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GE106.0100.000.12.60.L	6.00	1.00	2.70	5.70	2.00	12.00	37.00	6.00
6.002	GE106.0100.000.17.60.L	6.00	1.00	2.70	5.70	2.00	17.00	42.00	6.00
6.003	GE106.0100.000.22.60.L	6.00	1.00	2.70	5.70	2.00	22.00	47.00	6.00
6.004	GE106.0100.000.27.60.L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

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



• full radius R0.5-R1.0

for tool holders type GB106/GH106 see from page 70

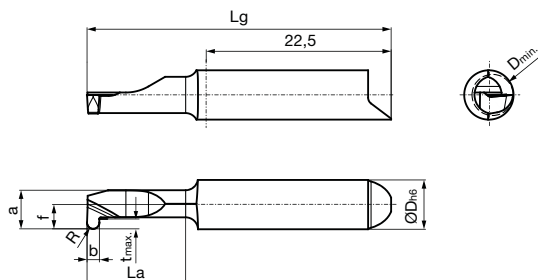
Tool material **Solid carbide**

Type GE 106 GE 106 GE 106

Coating **S** **a** ○

TiN nano-A uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image



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
6.010	GE106.0100.050.12.50.R	5.00	1.00	0.50	2.95	4.70	1.20	12.00	37.00	6.00
6.020	GE106.0100.050.17.50.R	5.00	1.00	0.50	2.95	4.70	1.20	17.00	42.00	6.00
6.030	GE106.0100.050.22.50.R	5.00	1.00	0.50	2.95	4.70	1.20	22.00	47.00	6.00
6.040	GE106.0100.050.27.50.R	5.00	1.00	0.50	2.95	4.70	1.20	27.00	52.00	6.00
6.050	GE106.0100.050.32.50.R	5.00	1.00	0.50	2.95	4.70	1.20	32.00	57.00	6.00
6.060	GE106.0100.050.37.50.R	5.00	1.00	0.50	2.95	4.70	1.20	37.00	62.00	6.00
6.070	GE106.0100.050.42.50.R	5.00	1.00	0.50	2.95	4.70	1.20	42.00	67.00	6.00
6.110	GE106.0150.075.12.50.R	5.00	1.50	0.75	2.95	4.70	1.20	12.00	37.00	6.00
6.120	GE106.0150.075.17.50.R	5.00	1.50	0.75	2.95	4.70	1.20	17.00	42.00	6.00
6.130	GE106.0150.075.22.50.R	5.00	1.50	0.75	2.95	4.70	1.20	22.00	47.00	6.00
6.140	GE106.0150.075.27.50.R	5.00	1.50	0.75	2.95	4.70	1.20	27.00	52.00	6.00
6.150	GE106.0150.075.32.50.R	5.00	1.50	0.75	2.95	4.70	1.20	32.00	57.00	6.00
6.160	GE106.0150.075.37.50.R	5.00	1.50	0.75	2.95	4.70	1.20	37.00	62.00	6.00
6.170	GE106.0150.075.42.50.R	5.00	1.50	0.75	2.95	4.70	1.20	42.00	67.00	6.00
6.210	GE106.0200.100.12.50.R	5.00	2.00	1.00	2.95	4.70	1.20	12.00	37.00	6.00
6.220	GE106.0200.100.17.50.R	5.00	2.00	1.00	2.95	4.70	1.20	17.00	42.00	6.00
6.230	GE106.0200.100.22.50.R	5.00	2.00	1.00	2.95	4.70	1.20	22.00	47.00	6.00
6.240	GE106.0200.100.27.50.R	5.00	2.00	1.00	2.95	4.70	1.20	27.00	52.00	6.00
6.250	GE106.0200.100.32.50.R	5.00	2.00	1.00	2.95	4.70	1.20	32.00	57.00	6.00
6.260	GE106.0200.100.37.50.R	5.00	2.00	1.00	2.95	4.70	1.20	37.00	62.00	6.00
6.270	GE106.0200.100.42.50.R	5.00	2.00	1.00	2.95	4.70	1.20	42.00	67.00	6.00



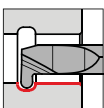
Series no.	25881	25883	25887
Cutting direction			

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

Series no. 25756 25758 25762



• full radius R0.5-R1.0

Tool material **Solid carbide**

Type GE 106 GE 106 GE 106

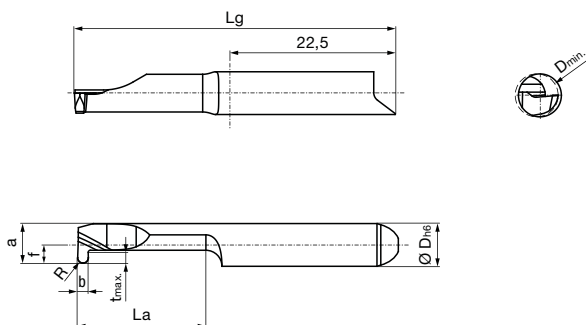
Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GB106/GH106 see from page 70

Cutting data page 214

System 106



Right hand version shown
Left hand version mirror image



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
6.001	GE106.0100.050.12.60.R	6.00	1.00	0.50	2.70	5.70	2.00	12.00	37.00	6.00
6.002	GE106.0100.050.17.60.R	6.00	1.00	0.50	2.70	5.70	2.00	17.00	42.00	6.00
6.003	GE106.0100.050.22.60.R	6.00	1.00	0.50	2.70	5.70	2.00	22.00	47.00	6.00
6.004	GE106.0100.050.27.60.R	6.00	1.00	0.50	2.70	5.70	2.00	27.00	52.00	6.00
6.005	GE106.0100.050.32.60.R	6.00	1.00	0.50	2.70	5.70	2.00	32.00	57.00	6.00
6.006	GE106.0100.050.37.60.R	6.00	1.00	0.50	2.70	5.70	2.00	37.00	62.00	6.00
6.007	GE106.0100.050.42.60.R	6.00	1.00	0.50	2.70	5.70	2.00	42.00	67.00	6.00
6.008	GE106.0150.075.12.60.R	6.00	1.50	0.75	2.70	5.70	2.00	12.00	37.00	6.00
6.009	GE106.0150.075.17.60.R	6.00	1.50	0.75	2.70	5.70	2.00	17.00	42.00	6.00
6.010	GE106.0150.075.22.60.R	6.00	1.50	0.75	2.70	5.70	2.00	22.00	47.00	6.00
6.011	GE106.0150.075.27.60.R	6.00	1.50	0.75	2.70	5.70	2.00	27.00	52.00	6.00
6.012	GE106.0150.075.32.60.R	6.00	1.50	0.75	2.70	5.70	2.00	32.00	57.00	6.00
6.013	GE106.0150.075.37.60.R	6.00	1.50	0.75	2.70	5.70	2.00	37.00	62.00	6.00
6.014	GE106.0150.075.42.60.R	6.00	1.50	0.75	2.70	5.70	2.00	42.00	67.00	6.00
6.015	GE106.0200.100.12.60.R	6.00	2.00	1.00	2.70	5.70	2.00	12.00	37.00	6.00
6.016	GE106.0200.100.17.60.R	6.00	2.00	1.00	2.70	5.70	2.00	17.00	42.00	6.00
6.017	GE106.0200.100.22.60.R	6.00	2.00	1.00	2.70	5.70	2.00	22.00	47.00	6.00
6.018	GE106.0200.100.27.60.R	6.00	2.00	1.00	2.70	5.70	2.00	27.00	52.00	6.00
6.019	GE106.0200.100.32.60.R	6.00	2.00	1.00	2.70	5.70	2.00	32.00	57.00	6.00
6.020	GE106.0200.100.37.60.R	6.00	2.00	1.00	2.70	5.70	2.00	37.00	62.00	6.00
6.021	GE106.0200.100.42.60.R	6.00	2.00	1.00	2.70	5.70	2.00	42.00	67.00	6.00

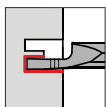
Series no. **25757** **25759** **25763**Cutting direction   

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

Series no. **25780** **25782** **25786**



• grooving depth up to 8 mm

Tool material **Solid carbide**

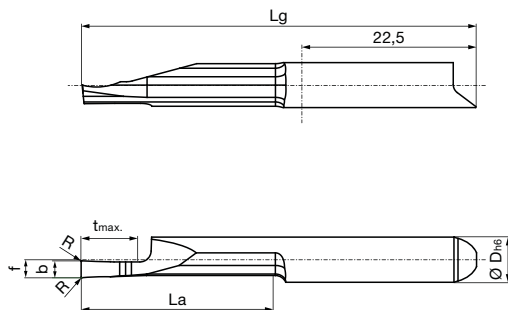
Type GA 106 GA 106 GA 106

Coating **S** **a**

TiN nano-A uncoated

for tool holders type GB106/GH106 see from page 70

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GA106.0150.010.17.60.R	6.00	1.50	0.10	2.60	5.00	17.00	42.00	6.00
6.002	GA106.0150.010.22.60.R	6.00	1.50	0.10	2.60	5.00	22.00	47.00	6.00
6.003	GA106.0200.015.17.60.R	6.00	2.00	0.15	2.60	8.00	17.00	42.00	6.00
6.004	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**

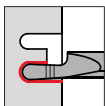
Cutting direction

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



Cutting insert for axial grooving bores, full radius slots

Series no. **25788** **25790** **25794**



• grooving depth up to 8 mm

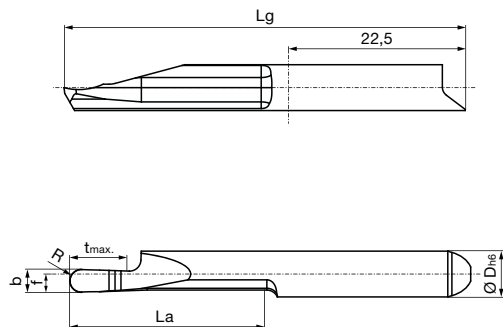
for tool holders type GB106/GH106 see from page 70

Tool material **Solid carbide**

Type GA 106 GA 106 GA 106

Coating **S** **a** ○
TiN nano-A uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

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

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GA106.0150.075.17.60.R	6.00	1.50	0.75	2.60	5.00	17.00	42.00	6.00
6.002	GA106.0150.075.22.60.R	6.00	1.50	0.75	2.60	5.00	22.00	47.00	6.00
6.003	GA106.0200.100.17.60.R	6.00	2.00	1.00	2.60	8.00	17.00	42.00	6.00
6.004	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**

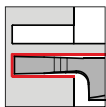
Cutting direction **(L)** **(L)** **(L)**

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

Series no. **25796** **25798** **25802**



• grooving depth up to 8 mm

Tool material **Solid carbide**

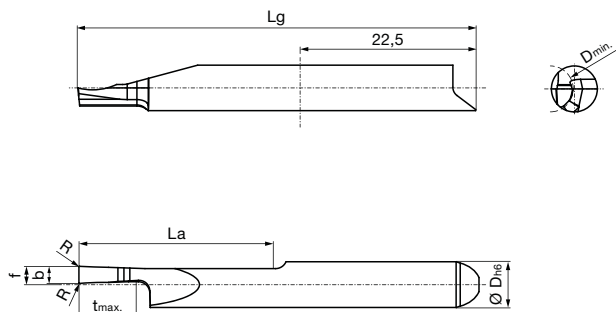
Type GA 106 GA 106 GA 106

Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GB106/GH106 see from page 70

Cutting data page 214



Right hand version shown
Left hand version mirror image



Cutting direction **R** **R** **R**

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

Series no. **25797** **25799** **25803**

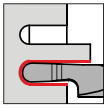
Cutting direction **L** **L** **L**

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



Cutting insert for axial grooving studs, full radius slots

Series no. **25804** **25806** **25810**



• grooving depth up to 8 mm

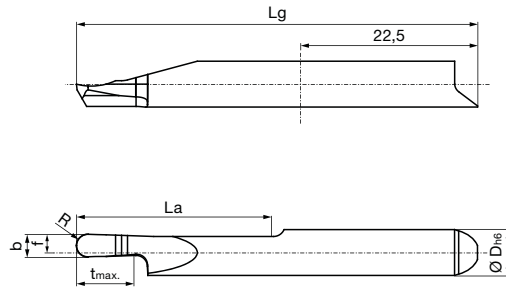
for tool holders type GB106/GH106 see from page 70

Tool material **Solid carbide**

Type GA 106 GA 106 GA 106

Coating **S** **a**
 TiN nano-A uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction

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

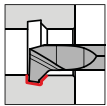
Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GA106.Z150.075.17.60.L	6.00	1.50	0.75	2.60	5.00	17.00	42.00	6.00
6.002	GA106.Z150.075.22.60.L	6.00	1.50	0.75	2.60	5.00	22.00	47.00	6.00
6.003	GA106.Z200.100.17.60.L	6.00	2.00	1.00	2.60	8.00	17.00	42.00	6.00
6.004	GA106.Z200.100.22.60.L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

System 106



Cutting insert for internal pre-grooving and chamfering

Series no. **26900** **26902** **26904**



• 45° chamfer

Tool material **Solid carbide**

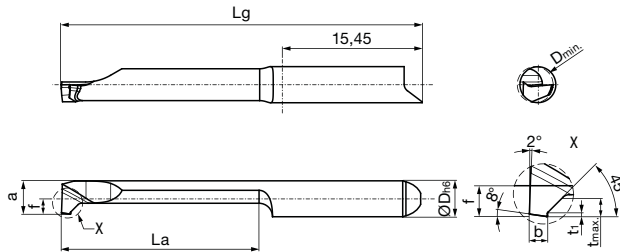
Type GV 106 GV 106 GV 106

Surface **S** **a** ○

TiN nano-A uncoated

for tool holders type GH106/GB106 see from page 70

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction **R** **R** **R**

Code no.	Description	D min	b	f	t1	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
6.001	GV106.0807.045.12.50.R	5.00	1.00	2.30	0.20	4.70	1.00	12.00	37.00	6.00
6.002	GV106.0807.045.17.50.R	5.00	1.00	2.30	0.20	4.70	1.00	17.00	42.00	6.00
6.003	GV106.0807.045.22.50.R	5.00	1.00	2.30	0.20	4.70	1.00	22.00	47.00	6.00
6.004	GV106.0807.045.27.50.R	5.00	1.00	2.30	0.20	4.70	1.00	27.00	52.00	6.00
6.005	GV106.0807.045.32.50.R	5.00	1.00	2.30	0.20	4.70	1.00	32.00	57.00	6.00

Series no. **26901** **26903** **26905**

Cutting direction **L** **L** **L**

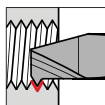
Code no.	Description	D min	b	f	t1	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
6.001	GV106.0807.045.12.50.L	5.00	1.00	2.30	0.20	4.70	1.00	12.00	37.00	6.00
6.002	GV106.0807.045.17.50.L	5.00	1.00	2.30	0.20	4.70	1.00	17.00	42.00	6.00
6.003	GV106.0807.045.22.50.L	5.00	1.00	2.30	0.20	4.70	1.00	22.00	47.00	6.00
6.004	GV106.0807.045.27.50.L	5.00	1.00	2.30	0.20	4.70	1.00	27.00	52.00	6.00
6.005	GV106.0807.045.32.50.L	5.00	1.00	2.30	0.20	4.70	1.00	32.00	57.00	6.00

System 106



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

Series no. **25764** **25766** **25770**



- pitch P = 1.25-1.75
- Dh6 = 6.00 mm

for tool holders type GB106/GH106 see from page 70

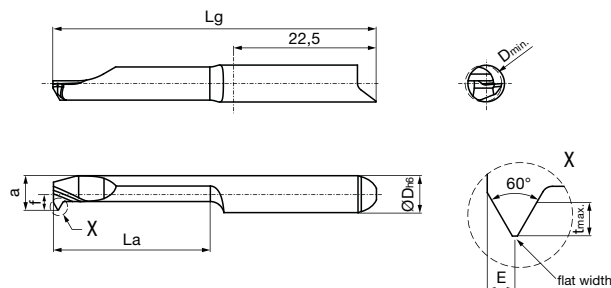
Tool material **Solid carbide**

Type GG 106 GG 106 GG 106

Coating **S** **a** ○

TiN nano-A uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction **R** **R** **R**

Code no.	Description	G	P	TPI	D min	f	E	a	flat width	t max	La	Lg
			mm		mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.TM08.125.12.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	12.00	37.00
6.001	GG106.TM08.125.17.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	17.00	42.00
6.002	GG106.TM08.125.22.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	22.00	47.00
6.003	GG106.TM08.125.27.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	27.00	52.00
6.011	GG106.TM08.125.32.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	32.00	57.00
6.012	GG106.TM08.125.37.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	37.00	62.00
6.013	GG106.TM08.125.42.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	42.00	67.00
6.014	GG106.TM10.150.12.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	12.00	37.00
6.004	GG106.TM10.150.17.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	17.00	42.00
6.005	GG106.TM10.150.22.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	22.00	47.00
6.006	GG106.TM10.150.27.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	27.00	52.00
6.015	GG106.TM10.150.32.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	32.00	57.00
6.016	GG106.TM10.150.37.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	37.00	62.00
6.017	GG106.TM10.150.42.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	42.00	67.00
6.018	GG106.TM12.175.12.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	12.00	37.00
6.007	GG106.TM12.175.17.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	17.00	42.00
6.008	GG106.TM12.175.22.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	22.00	47.00
6.009	GG106.TM12.175.27.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	27.00	52.00
6.019	GG106.TM12.175.32.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	32.00	57.00
6.020	GG106.TM12.175.37.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	37.00	62.00
6.021	GG106.TM12.175.42.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	42.00	67.00

System 106



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

Cutting direction   

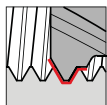
System 106

Code no.	Description	G	P	TPI	D min	f	E	a	flat width	t max	La	Lg
			mm		mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.TM08.125.12.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	12.00	37.00
6.001	GG106.TM08.125.17.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	17.00	42.00
6.002	GG106.TM08.125.22.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	22.00	47.00
6.003	GG106.TM08.125.27.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	27.00	52.00
6.011	GG106.TM08.125.32.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	32.00	57.00
6.012	GG106.TM08.125.37.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	37.00	62.00
6.013	GG106.TM08.125.42.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	42.00	67.00
6.014	GG106.TM10.150.12.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	12.00	37.00
6.004	GG106.TM10.150.17.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	17.00	42.00
6.005	GG106.TM10.150.22.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	22.00	47.00
6.006	GG106.TM10.150.27.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	27.00	52.00
6.015	GG106.TM10.150.32.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	32.00	57.00
6.016	GG106.TM10.150.37.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	37.00	62.00
6.017	GG106.TM10.150.42.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	42.00	67.00
6.018	GG106.TM12.175.12.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	12.00	37.00
6.007	GG106.TM12.175.17.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	17.00	42.00
6.008	GG106.TM12.175.22.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	22.00	47.00
6.009	GG106.TM12.175.27.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	27.00	52.00
6.019	GG106.TM12.175.32.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	32.00	57.00
6.020	GG106.TM12.175.37.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	37.00	62.00
6.021	GG106.TM12.175.42.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	42.00	67.00



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

Series no. 25772 25774 25778

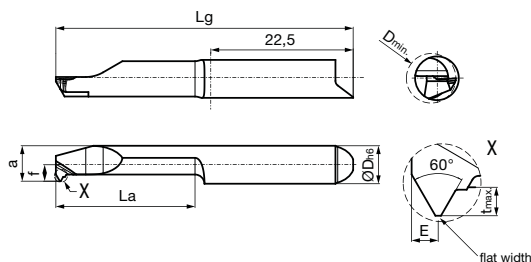


- pitch P = 1-1.75
- Dh6 = 6.00 mm

for tool holders type GB106/GH106 see from page 70

Tool material	Solid carbide		
Type	GG 106	GG 106	GG 106
Coating			
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction

Code no.	Description	G	P	D min	f	E	a	flat width	t max	La	Lg
			mm	mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.VM06.100.12.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	12.00	37.00
6.020	GG106.VM06.100.17.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	17.00	42.00
6.030	GG106.VM06.100.22.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	22.00	47.00
6.040	GG106.VM06.100.27.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	27.00	52.00
6.050	GG106.VM06.100.32.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	32.00	57.00
6.060	GG106.VM06.100.37.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	37.00	62.00
6.070	GG106.VM06.100.42.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	42.00	67.00
6.110	GG106.VM08.125.12.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	12.00	37.00
6.120	GG106.VM08.125.17.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	17.00	42.00
6.130	GG106.VM08.125.22.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	22.00	47.00
6.140	GG106.VM08.125.27.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	27.00	52.00
6.150	GG106.VM08.125.32.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	32.00	57.00
6.160	GG106.VM08.125.37.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	37.00	62.00
6.170	GG106.VM08.125.42.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	42.00	67.00
6.210	GG106.VM10.150.12.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	12.00	37.00
6.220	GG106.VM10.150.17.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	17.00	42.00
6.230	GG106.VM10.150.22.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	22.00	47.00
6.240	GG106.VM10.150.27.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	27.00	52.00
6.250	GG106.VM10.150.32.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	32.00	57.00
6.260	GG106.VM10.150.37.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	37.00	62.00
6.270	GG106.VM10.150.42.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	42.00	67.00
6.310	GG106.VM12.175.12.00.R	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	12.00	37.00
6.320	GG106.VM12.175.17.00.R	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	17.00	42.00
6.330	GG106.VM12.175.22.00.R	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	22.00	47.00
6.340	GG106.VM12.175.27.00.R	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	27.00	52.00
6.350	GG106.VM12.175.32.00.R	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	32.00	57.00
6.360	GG106.VM12.175.37.00.R	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	37.00	62.00
6.370	GG106.VM12.175.42.00.R	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	42.00	67.00

System 106



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

Cutting direction   

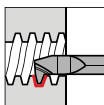
System 106

Code no.	Description	G	P	D min	f	E	a	flat width	t max	La	Lg
			mm	mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.VM06.100.12.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	12.00	37.00
6.020	GG106.VM06.100.17.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	17.00	42.00
6.030	GG106.VM06.100.22.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	22.00	47.00
6.040	GG106.VM06.100.27.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	27.00	52.00
6.050	GG106.VM06.100.32.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	32.00	57.00
6.060	GG106.VM06.100.37.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	37.00	62.00
6.070	GG106.VM06.100.42.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.115	0.60	42.00	67.00
6.110	GG106.VM08.125.12.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	12.00	37.00
6.120	GG106.VM08.125.17.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	17.00	42.00
6.130	GG106.VM08.125.22.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	22.00	47.00
6.140	GG106.VM08.125.27.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	27.00	52.00
6.150	GG106.VM08.125.32.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	32.00	57.00
6.160	GG106.VM08.125.37.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	37.00	62.00
6.170	GG106.VM08.125.42.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.146	0.75	42.00	67.00
6.210	GG106.VM10.150.12.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	12.00	37.00
6.220	GG106.VM10.150.17.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	17.00	42.00
6.230	GG106.VM10.150.22.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	22.00	47.00
6.240	GG106.VM10.150.27.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	27.00	52.00
6.250	GG106.VM10.150.32.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	32.00	57.00
6.260	GG106.VM10.150.37.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	37.00	62.00
6.270	GG106.VM10.150.42.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.178	0.90	42.00	67.00
6.310	GG106.VM12.175.12.00.L	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	12.00	37.00
6.320	GG106.VM12.175.17.00.L	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	17.00	42.00
6.330	GG106.VM12.175.22.00.L	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	22.00	47.00
6.340	GG106.VM12.175.27.00.L	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	27.00	52.00
6.350	GG106.VM12.175.32.00.L	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	32.00	57.00
6.360	GG106.VM12.175.37.00.L	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	37.00	62.00
6.370	GG106.VM12.175.42.00.L	M12	1.75	10.20	2.95	0.90	5.95	0.209	1.05	42.00	67.00



Cutting insert for internal threading, partial profile - trapezoidal thread

Series no. **25824** **25826** **25830**

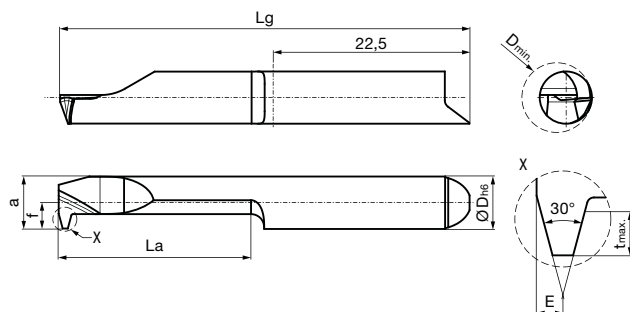


- pitch P = 1.5-3.0
- Dh6 = 6.00 mm

for tool holders type GB106/GH106 see from page 70

Tool material	Solid carbide		
Type	GG 106	GG 106	GG 106
Coating			
	TiN	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction

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

Series no. **25825** **25827** **25831**

Cutting direction

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

System 106



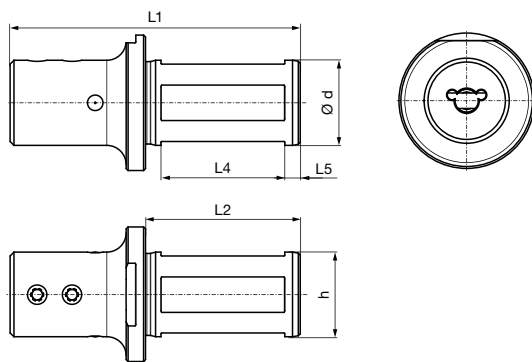
Round shank holder, 4 clamping surfaces

Series no. **25302**

- for inserts type 106
- with internal coolant delivery

Type GB 106

System 106



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

Spare parts

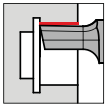
Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



Cutting insert for broaching longitudinal slots

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



• tolerance class C11, P9, JS9

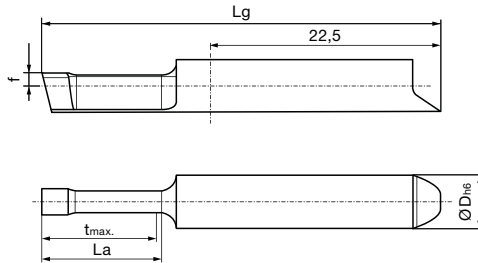
Tool material **Solid carbide**

Type GN 106 GN 106 GN 106

Coating **S** **a** ○
TiN nano-A uncoated

for tool holders type GB106 Series No. 25302 see page 128

Cutting data page 214



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
6.001	GN106.0198.010.12.06.N	2 P9	6.00	1.98	0.10	1.50	11.50	12.00	37.00	6.00
6.002	GN106.0298.010.12.06.N	3 P9	6.00	2.98	0.10	1.50	11.50	12.00	37.00	6.00
6.003	GN106.0398.010.12.06.N	4 P9	6.00	3.98	0.10	1.50	11.50	12.00	37.00	6.00
6.004	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
6.001	GN106.0200.010.12.06.N	2 JS9	6.00	2.00	0.10	1.50	11.50	12.00	37.00	6.00
6.002	GN106.0300.010.12.06.N	3 JS9	6.00	3.00	0.10	1.50	11.50	12.00	37.00	6.00
6.003	GN106.0400.010.12.06.N	4 JS9	6.00	4.00	0.10	1.50	11.50	12.00	37.00	6.00
6.004	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**

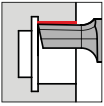
Code no.	Description	for slot width	D min	W	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm
6.001	GN106.0211.035.12.06.N	2 C11	6.00	2.11	0.35	1.50	11.50	12.00	37.00	6.00
6.002	GN106.0311.035.12.06.N	3 C11	6.00	3.11	0.35	1.50	11.50	12.00	37.00	6.00
6.003	GN106.0413.050.12.06.N	4 C11	6.00	4.13	0.50	1.50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

System 106



Cutting insert for internal hexagon

Series no. **25896** **25897** **25898**



• SW 4.0 - 10.0

Tool material **Solid carbide**

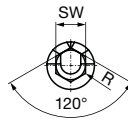
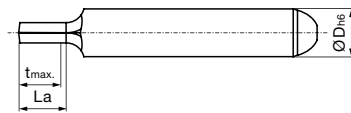
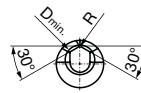
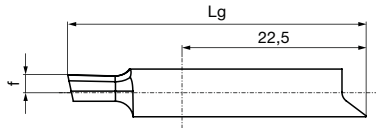
Type GN 106 GN 106 GN 106

Coating **S** **a** ○

TiN nano-A uncoated

for tool holders type GB106 Series 25302 see page 128

Cutting data page 214



Code no.	Description	SW	D min	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm
6.001	GN106.SW40.010.06.40.N.S1	4.00-4.50	4.00	0.10	1.50	6.00	6.50	37.00	6.00
6.002	GN106.SW45.010.07.45.N.S1	4.50-5.00	4.50	0.10	1.50	7.00	7.50	37.00	6.00
6.003	GN106.SW50.010.09.50.N.S1	5.00-8.00	5.00	0.10	1.50	9.00	9.50	37.00	6.00
6.004	GN106.SW80.010.12.80.N.S1	8.00-10.00	8.00	0.10	1.50	12.00	12.50	37.00	6.00

RT 100 **XF**

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▶ **POWERFUL** MACHINING

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- Internally developed exclusive finishing processes **maximize performance**
- **Reduced cycle times** for difficult-to-machine materials and special applications in high production



108





SYSTEM 108

MICRO-PRECISION TOOLS



Round shank holder

from page 134



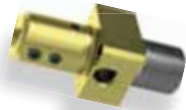
Square shank holder

from page 140



Modular holder

from page 142



Star holder

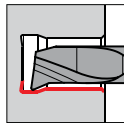
page 145



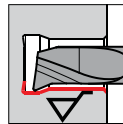
Round shank holder
Broaching

page 170

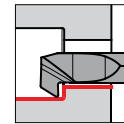
Tool holder



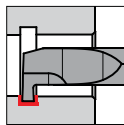
Boring out
and profiling, Type GT
from page 146



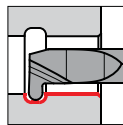
Boring out,
with Wiper, Type GJ
page 152



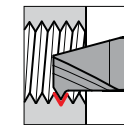
Back boring
and profiling, Type GT
page 154



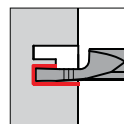
Internal grooving,
straight slots, Type GE
from page 156



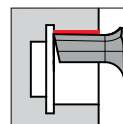
Internal grooving,
full radius slots, Type GE
from page 160



Internal threading,
Type GG
from page 164



Axial grooving bores,
Type GA
from page 166



Broaching,
Type GN
page 171

Cutting inserts from hole-Ø 7 mm

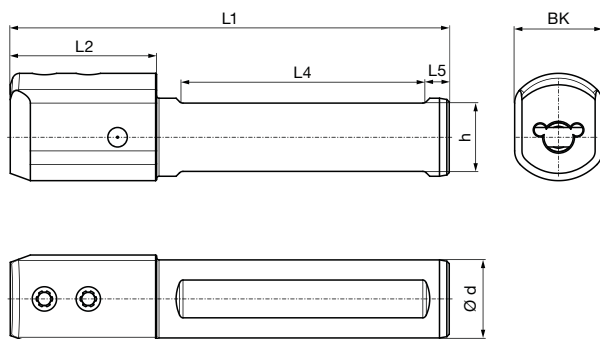


Round shank holder, clamping screw top

Series no. **27000**

- for inserts type 108
- with internal coolant supply

Type GB 108



System 108

Code no.	Description	d	d	h	L1	L2	L4	L5	BK
		mm	inch	mm	mm	mm	mm	mm	mm
8.001	GB108.0010.090.00.22.N.IK	10.00		9.00	90.00	30.00	50.00	5.00	16.5
8.002	GB108.0012.090.00.22.N.IK	12.00		11.00	90.00	30.00	50.00	5.00	16.5
8.015	GB108.0500.354.00.22.N.IK		1/2	11.00	89.92	26.67	54.86	5.00	16.5
8.016	GB108.0625.354.00.22.N.IK		5/8	14.00	89.92	26.67	54.86	5.00	16.5
8.003	GB108.0016.090.00.22.N.IK	16.00		14.00	90.00	30.00	50.00	5.00	16.5
8.017	GB108.0750.415.00.22.N.IK		3/4	17.00	105.41	26.67	69.85	5.00	20.5
8.004	GB108.0020.095.00.22.N.IK	20.00		18.00	95.00	30.00	55.00	5.00	20.5
8.005	GB108.0022.095.00.22.N.IK	22.00		20.00	95.00	30.00	55.00	5.00	N/A
8.006	GB108.0025.100.00.22.N.IK	25.00		23.00	100.00	N/A	55.00	5.00	N/A
8.018	GB108.1000.415.00.22.N.IK		1"	23.40	105.41	N/A	69.85	5.00	N/A

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

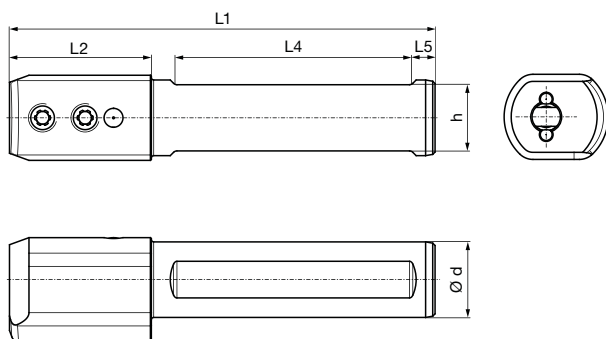


Round shank holder, clamping screw lateral

Series no. **27001**

- for inserts type 108
- with internal coolant supply

Type **GB 108**



System 108

Code no.	Description	d	d	h	L1	L2	L4	L5
		mm	inch	mm	mm	mm	mm	mm
8.001	GB108.0010.090.00.22.N.IK.90	10.00		9.00	90.00	30.00	50.00	5.00
8.002	GB108.0012.090.00.22.N.IK.90	12.00		11.00	90.00	30.00	50.00	5.00
8.015	GB108.0500.354.00.22.N.IK.90		1/2	11.00	89.92	26.67	54.86	5.00
8.016	GB108.0625.354.00.22.N.IK.90		5/8	14.00	89.92	26.67	54.86	5.00
8.003	GB108.0016.090.00.22.N.IK.90	16.00		14.00	90.00	30.00	50.00	5.00
8.017	GB108.0750.415.00.22.N.IK.90		3/4	17.00	105.41	26.67	69.85	5.00
8.004	GB108.0020.095.00.22.N.IK.90	20.00		18.00	95.00	30.00	55.00	5.00
8.005	GB108.0022.095.00.22.N.IK.90	22.00		20.00	95.00	30.00	55.00	5.00
8.006	GB108.0025.100.00.22.N.IK.90	25.00		23.00	100.00	N/A	55.00	5.00
8.018	GB108.1000.415.00.22.N.IK.90		1"	23.40	105.41	N/A	69.85	5.00

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

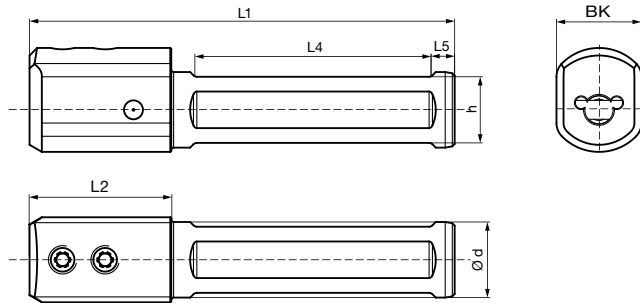


Round shank holder, clamping screw above, four clamping surfaces

Series no. **27002**

- for inserts type 108
- with internal coolant supply

Type GB 108



version left and right

Code no.	Description	d	h	L1	L2	L4	L5	BK
		mm	mm	mm	mm	mm	mm	mm
8.010	GB108.0016.090.00.22.N.IK.VSP	16.00	14.00	90.00	30.00	50.00	5.00	16.5
8.020	GB108.0020.095.00.22.N.IK.VSP	20.00	18.00	95.00	30.00	55.00	5.00	20.5
8.030	GB108.0022.095.00.22.N.IK.VSP	22.00	20.00	95.00	30.00	55.00	5.00	N/A
8.040	GB108.0025.100.00.22.N.IK.VSP	25.00	23.00	100.00	N/A	55.00	5.00	N/A

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

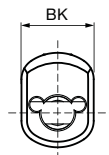
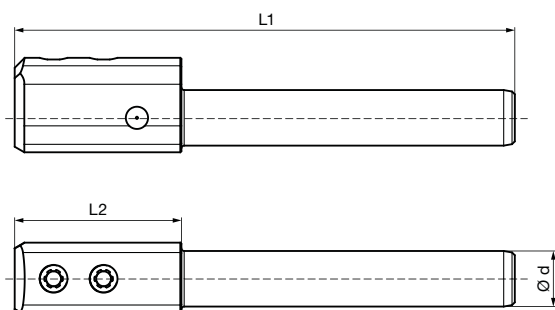


Round shank holder, clamping screw above, without clamping surfaces

Series no. **27003**

- for inserts type 108
- with internal coolant supply

Type GB 108



System 108

version left and right

Code no.	Description	d	L1	L2	BK
		mm	mm	mm	mm
8.010	GB108.0010.090.00.22.N.IK.RND	10.00	90.00	30.00	16.5
8.020	GB108.0012.090.00.22.N.IK.RND	12.00	90.00	30.00	16.5
8.030	GB108.0016.090.00.22.N.IK.RND	16.00	90.00	30.00	16.5

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

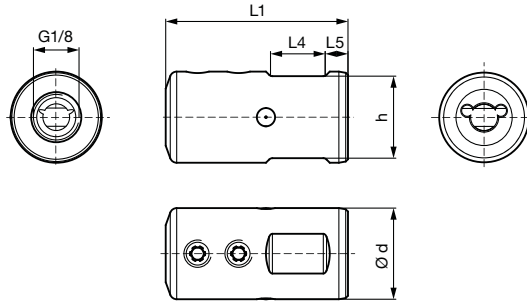


Round shank holder, clamping screw above, for Citizen machine

Series no. **27004**

- for inserts type 108
- with internal coolant delivery

Type **GB 108**



version left and right

Code no.	Description	d		h	L1	L4	L5
		mm	inch				
8.110	GB108.0750.040.00.22.N.IK.CIT		3/4	17.05	40.00	12.70	5.08
8.120	GB108.0750.050.00.22.N.IK.CIT		3/4	17.05	50.00	22.86	5.08
8.130	GB108.0750.070.00.22.N.IK.CIT		3/4	17.05	70.00	44.45	5.08
8.140	GB108.0750.100.00.22.N.IK.CIT		3/4	17.05	100.00	73.66	5.08
8.010	GB108.0020.040.00.22.N.IK.CIT	20		18.00	40.00	12.00	5.00
8.020	GB108.0020.050.00.22.N.IK.CIT	20		18.00	50.00	22.00	5.00
8.150	GB108.1000.060.00.22.N.IK.CIT		1"	23.40	60.00	31.75	5.08
8.160	GB108.1000.100.00.22.N.IK.CIT		1"	23.40	100.00	73.66	5.08

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

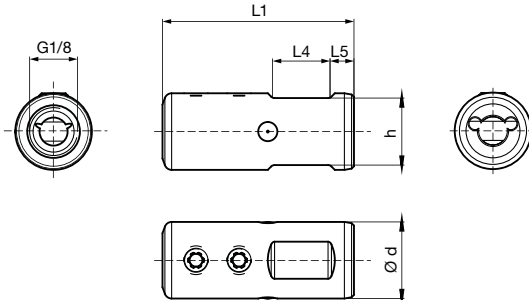


Round shank holder, clamping screw above, for Star machine

Series no. **27005**

- for inserts type 108
- with internal coolant delivery

Type **GB 108**



System 108

version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
8.010	GB108.0016.040.00.22.N.IK.STA	16.00	14.00	40.00	12.00	5.00
8.020	GB108.0016.050.00.22.N.IK.STA	16.00	14.00	50.00	22.00	5.00
8.030	GB108.0016.070.00.22.N.IK.STA	16.00	14.00	70.00	42.00	5.00
8.040	GB108.0022.038.00.22.N.IK.STA	22.00	20.00	38.00	10.00	5.00
8.050	GB108.0022.050.00.22.N.IK.STA	22.00	20.00	50.00	20.00	5.00
8.060	GB108.0022.070.00.22.N.IK.STA	22.00	20.00	70.00	40.00	5.00
8.070	GB108.0022.100.00.22.N.IK.STA	22.00	20.00	100.00	70.00	5.00
8.080	GB108.0022.120.00.22.N.IK.STA	22.00	20.00	120.00	90.00	5.00

Spare parts

Series no.	Clamping screw	Tightening torque
25904		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



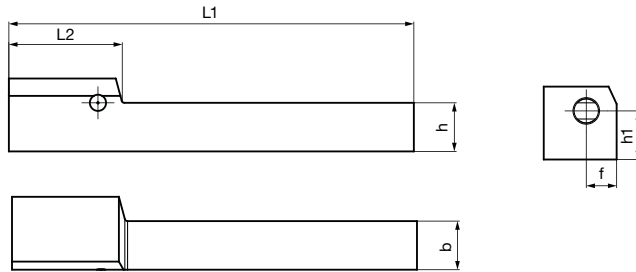
Square shank holder, straight 0°

Series no. **27007**

- for inserts type 108
- without internal coolant supply

Type GH 108

System 108



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	b = h	b = h	h1	f	L1	L2
		mm	inch				
8.110	GH108.0375.350.00.22.R		3/8	9.52	7.62	88.90	27.94
8.010	GH108.1010.100.00.22.R	10.00		10.00	7.50	100.00	28.00
8.020	GH108.1212.100.00.22.R	12.00		12.00	7.50	100.00	28.00
8.120	GH108.0500.350.00.22.R		1/2	12.70	7.62	88.90	27.94
8.130	GH108.0625.400.00.22.R		5/8	15.87	7.62	101.60	27.94
8.030	GH108.1616.120.00.22.R	16.00		16.00	7.50	120.00	28.00

Series no. **27008**

version left-hand

Code no.	Description	b = h	b = h	h1	f	L1	L2
		mm	inch				
8.110	GH108.0375.350.00.22.L		3/8	9.52	7.62	88.90	27.94
8.010	GH108.1010.100.00.22.L	10.00		10.00	7.50	100.00	28.00
8.020	GH108.1212.100.00.22.L	12.00		12.00	7.50	100.00	28.00
8.120	GH108.0500.350.00.22.L		1/2	12.70	7.62	88.90	27.94
8.130	GH108.0625.400.00.22.L		5/8	15.87	7.62	101.60	27.94
8.030	GH108.1616.120.00.22.L	16.00		16.00	7.50	120.00	28.00

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

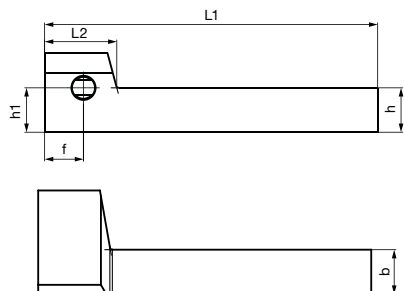


Square shank holder, 90° offset

Series no. **27009**

- for inserts type 108
- without internal coolant supply

Type GH 108



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	b = h	b = h	h1	f	L1	L2
		mm	inch				
8.010	GH108.0375.350.90.22.R		3/8	9.52	11.43	88.90	20.32
8.001	GH108.1010.090.90.22.R	10.00		10.00	11.50	90.00	20.50
8.002	GH108.1212.090.90.22.R	12.00		12.00	11.50	90.00	20.50
8.011	GH108.0500.350.90.22.R		1/2	12.70	11.43	88.90	20.32
8.012	GH108.0625.400.90.22.R		5/8	15.87	11.43	101.60	20.32
8.003	GH108.1616.120.90.22.R	16.00		16.00	11.50	120.00	20.50

Series no. **27010**

version left-hand

Code no.	Description	b = h	b = h	h1	f	L1	L2
		mm	inch				
8.010	GH108.0375.350.90.22.L		3/8	9.52	11.43	88.90	20.32
8.001	GH108.1010.090.90.22.L	10.00		10.00	11.50	90.00	20.50
8.002	GH108.1212.090.90.22.L	12.00		12.00	11.50	90.00	20.50
8.011	GH108.0500.350.90.22.L		1/2	12.70	11.43	88.90	20.32
8.012	GH108.0625.400.90.22.L		5/8	15.87	11.43	101.60	20.32
8.003	GH108.1616.120.90.22.L	16.00		16.00	11.50	120.00	20.50

System 108

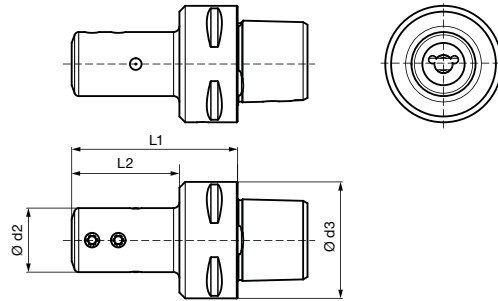


Polygon shank holder, to ISO 26623, straight 0°

Series no. **27011**

- for inserts type 108
- with internal coolant delivery

Type **GH 108**



version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
8.001	GH108.PO32.052.00.22.N.IK	24.00	PSC 32	52.00	37.00
8.002	GH108.PO40.057.00.22.N.IK	24.00	PSC 40	57.00	37.00
8.003	GH108.PO50.057.00.22.N.IK	24.00	PSC 50	57.00	37.00
8.004	GH108.PO63.060.00.22.N.IK	24.00	PSC 63	60.00	38.00

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

System 108

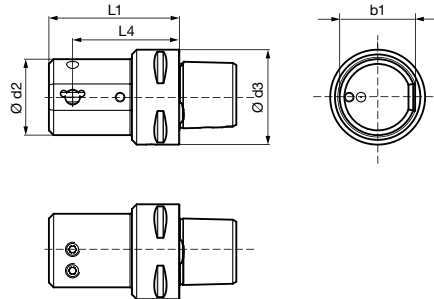


Polygon shank holder, to ISO 26623, offset to 90°

Series no. **27012**

- for inserts type 108
- with internal coolant delivery

Type GH 108



System 108

Series no. right hand

version

Code no.	Description	d2	d3	L1	L4	b1
		mm		mm	mm	mm
8.001	GH108.PO32.055.90.22.R.IK	32.00	PSC 32	55.00	45.00	31.00
8.002	GH108.PO40.055.90.22.R.IK	32.00	PSC 40	55.00	45.00	31.00
8.003	GH108.PO50.060.90.22.R.IK	32.00	PSC 50	60.00	50.00	31.00
8.004	GH108.PO63.060.90.22.R.IK	32.00	PSC 63	60.00	50.00	31.00

Series no. **27013**

version left hand

Code no.	Description	d2	d3	L1	L4	b1
		mm		mm	mm	mm
8.001	GH108.PO32.055.90.22.L.IK	32.00	PSC 32	55.00	45.00	31.00
8.002	GH108.PO40.055.90.22.L.IK	32.00	PSC 40	55.00	45.00	31.00
8.003	GH108.PO50.060.90.22.L.IK	32.00	PSC 50	60.00	50.00	31.00
8.004	GH108.PO63.060.90.22.L.IK	32.00	PSC 63	60.00	50.00	31.00

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



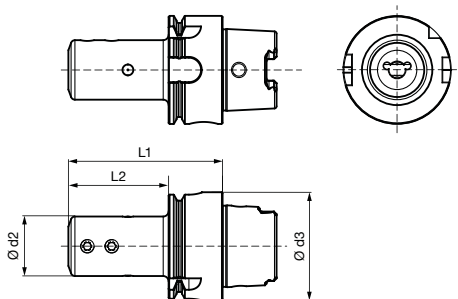
HSK-T holder, to ISO 12164-3, straight 0°

Series no. **27014**

- for inserts type 108
- with internal coolant delivery

Type GH 108

System 108



version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
8.001	GH108.HS40.057.00.22.N.IK	24.00	HSK-T 40	57.00	37.00
8.002	GH108.HS63.063.00.22.N.IK	24.00	HSK-T 63	63.00	37.00

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

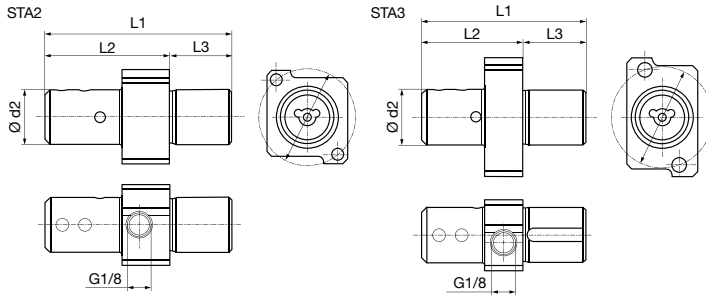


Star holders for backworking

Series no. **27016**

- for inserts type 108
- with internal coolant delivery

Type GB 108



System 108

version left and right

Code no.	Description	d	L1	L2	x	y
		mm	mm	mm		
8.010	GB108.0022.075.00.22.N.IK.STA2	22.00	75.00	50.00	25.00	30.00
8.020	GB108.0022.065.00.22.N.IK.STA3	22.00	65.00	40.00	13.66	37.60

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

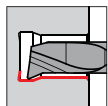
Series no.	Connecting screw	Holder Designation
25912		
Code 4.000	M4x30 (STA2)	GB106.022.....IK.STA2
Code 5.000	M5x30 (STA3)	GB106.022.....IK.STA3

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



Cutting insert for boring out and profiling

Series no. **27100** **27102**



• radial free 23°

Tool material **Solid carbide**

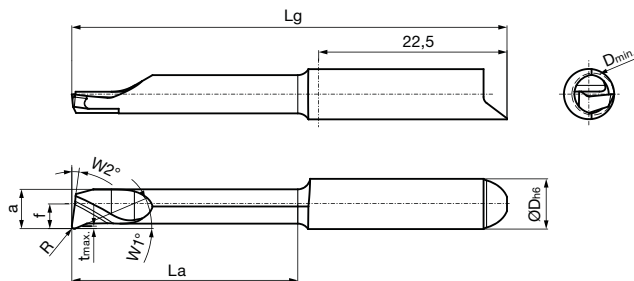
Type GT 108 GT 108

Coating

nano-A uncoated

for tool holders type GH108/GB108 see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
8.120	GT108.2367.010.17.70.R	7.00	0.10	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.140	GT108.2367.010.27.70.R	7.00	0.10	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.160	GT108.2367.010.37.70.R	7.00	0.10	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.170	GT108.2367.010.42.70.R	7.00	0.10	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.180	GT108.2367.010.47.70.R	7.00	0.10	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.190	GT108.2367.010.52.70.R	7.00	0.10	23	8	3.95	6.70	0.50	52.00	77.00	8.00
8.320	GT108.2367.020.17.70.R	7.00	0.20	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.340	GT108.2367.020.27.70.R	7.00	0.20	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.360	GT108.2367.020.37.70.R	7.00	0.20	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.370	GT108.2367.020.42.70.R	7.00	0.20	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.380	GT108.2367.020.47.70.R	7.00	0.20	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.390	GT108.2367.020.52.70.R	7.00	0.20	23	8	3.95	6.70	0.50	52.00	77.00	8.00

Series no. **27101** **27103**

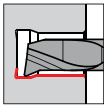
Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.2367.010.17.70.L	7.00	0.10	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.140	GT108.2367.010.27.70.L	7.00	0.10	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.160	GT108.2367.010.37.70.L	7.00	0.10	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.170	GT108.2367.010.42.70.L	7.00	0.10	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.180	GT108.2367.010.47.70.L	7.00	0.10	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.190	GT108.2367.010.52.70.L	7.00	0.10	23	8	3.95	6.70	0.50	52.00	77.00	8.00
8.320	GT108.2367.020.17.70.L	7.00	0.20	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.340	GT108.2367.020.27.70.L	7.00	0.20	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.360	GT108.2367.020.37.70.L	7.00	0.20	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.370	GT108.2367.020.42.70.L	7.00	0.20	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.380	GT108.2367.020.47.70.L	7.00	0.20	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.390	GT108.2367.020.52.70.L	7.00	0.20	23	8	3.95	6.70	0.50	52.00	77.00	8.00



Cutting insert for boring out and profiling

Series no. **27200** **27202**



• radial free 23°

Tool material **Solid carbide**

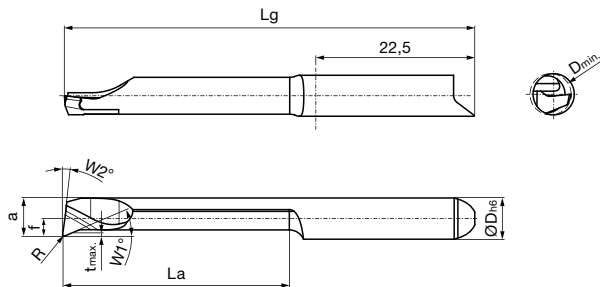
Type GT 108 GT 108



Coating  

nano-A uncoated

for tool holders type GH108/GB108 see from page 134

Cutting data page 214





Cutting direction  

Right hand version shown
Left hand version mirror image

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.2377.010.17.80.R	8.00	0.10	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.140	GT108.2377.010.27.80.R	8.00	0.10	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.160	GT108.2377.010.37.80.R	8.00	0.10	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.170	GT108.2377.010.42.80.R	8.00	0.10	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.180	GT108.2377.010.47.80.R	8.00	0.10	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.190	GT108.2377.010.52.80.R	8.00	0.10	23	8	3.70	7.70	0.60	52.00	77.00	8.00
8.320	GT108.2377.020.17.80.R	8.00	0.20	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.340	GT108.2377.020.27.80.R	8.00	0.20	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.360	GT108.2377.020.37.80.R	8.00	0.20	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.370	GT108.2377.020.42.80.R	8.00	0.20	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.380	GT108.2377.020.47.80.R	8.00	0.20	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.390	GT108.2377.020.52.80.R	8.00	0.20	23	8	3.70	7.70	0.60	52.00	77.00	8.00

Series no. **27201** **27203**

Cutting direction  

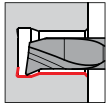
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.2377.010.17.80.L	8.00	0.10	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.140	GT108.2377.010.27.80.L	8.00	0.10	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.160	GT108.2377.010.37.80.L	8.00	0.10	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.170	GT108.2377.010.42.80.L	8.00	0.10	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.180	GT108.2377.010.47.80.L	8.00	0.10	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.190	GT108.2377.010.52.80.L	8.00	0.10	23	8	3.70	7.70	0.60	52.00	77.00	8.00
8.320	GT108.2377.020.17.80.L	8.00	0.20	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.340	GT108.2377.020.27.80.L	8.00	0.20	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.360	GT108.2377.020.37.80.L	8.00	0.20	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.370	GT108.2377.020.42.80.L	8.00	0.20	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.380	GT108.2377.020.47.80.L	8.00	0.20	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.390	GT108.2377.020.52.80.L	8.00	0.20	23	8	3.70	7.70	0.60	52.00	77.00	8.00

System 108



Cutting insert for boring out and profiling

Series no. **27104** **27106**



• radial free 47°, t_{max} 0.8

Tool material **Solid carbide**

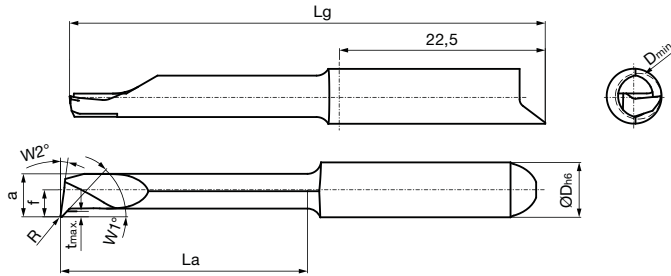
Type GT 108 GT 108

Coating  



nano-A uncoated

for tool holders type GH108/GB108 see from page 134

Cutting data page 214





Right hand version shown
Left hand version mirror image

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
8.120	GT108.4767.010.17.70.R	7.00	0.10	47	8	3.95	6.70	0.80	17.00	42.00	8.00
8.140	GT108.4767.010.27.70.R	7.00	0.10	47	8	3.95	6.70	0.80	27.00	52.00	8.00
8.160	GT108.4767.010.37.70.R	7.00	0.10	47	8	3.95	6.70	0.80	37.00	62.00	8.00
8.170	GT108.4767.010.42.70.R	7.00	0.10	47	8	3.95	6.70	0.80	42.00	67.00	8.00
8.180	GT108.4767.010.47.70.R	7.00	0.10	47	8	3.95	6.70	0.80	47.00	72.00	8.00
8.320	GT108.4767.020.17.70.R	7.00	0.20	47	8	3.95	6.70	0.80	17.00	42.00	8.00
8.340	GT108.4767.020.27.70.R	7.00	0.20	47	8	3.95	6.70	0.80	27.00	52.00	8.00
8.360	GT108.4767.020.37.70.R	7.00	0.20	47	8	3.95	6.70	0.80	37.00	62.00	8.00
8.370	GT108.4767.020.42.70.R	7.00	0.20	47	8	3.95	6.70	0.80	42.00	67.00	8.00
8.380	GT108.4767.020.47.70.R	7.00	0.20	47	8	3.95	6.70	0.80	47.00	72.00	8.00

Series no. **27105** **27107**

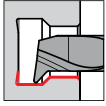
Cutting direction  

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.4767.010.17.70.L	7.00	0.10	47	8	3.95	6.70	0.80	17.00	42.00	8.00
8.140	GT108.4767.010.27.70.L	7.00	0.10	47	8	3.95	6.70	0.80	27.00	52.00	8.00
8.160	GT108.4767.010.37.70.L	7.00	0.10	47	8	3.95	6.70	0.80	37.00	62.00	8.00
8.170	GT108.4767.010.42.70.L	7.00	0.10	47	8	3.95	6.70	0.80	42.00	67.00	8.00
8.180	GT108.4767.010.47.70.L	7.00	0.10	47	8	3.95	6.70	0.80	47.00	72.00	8.00
8.320	GT108.4767.020.17.70.L	7.00	0.20	47	8	3.95	6.70	0.80	17.00	42.00	8.00
8.340	GT108.4767.020.27.70.L	7.00	0.20	47	8	3.95	6.70	0.80	27.00	52.00	8.00
8.360	GT108.4767.020.37.70.L	7.00	0.20	47	8	3.95	6.70	0.80	37.00	62.00	8.00
8.370	GT108.4767.020.42.70.L	7.00	0.20	47	8	3.95	6.70	0.80	42.00	67.00	8.00
8.380	GT108.4767.020.47.70.L	7.00	0.20	47	8	3.95	6.70	0.80	47.00	72.00	8.00



Cutting insert for boring out and profiling

Series no. **27204** **27206**



• radial free 47°, tmax 1

Tool material **Solid carbide**

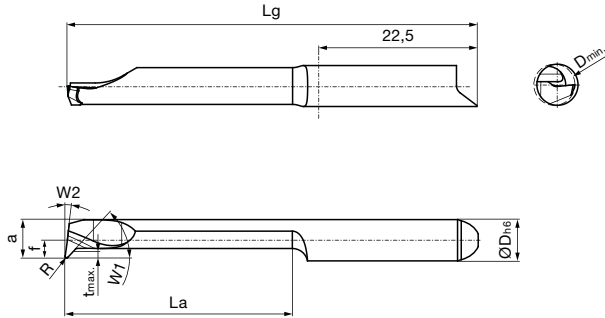
Type GT 108 GT 108

Coating

nano-A uncoated

for tool holders type GH108/GB108 see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
8.029	GT108.4777.010.17.80.R	8.00	0.10	47	8	3.70	7.70	1.00	17.00	42.00	8.00
8.031	GT108.4777.010.27.80.R	8.00	0.10	47	8	3.70	7.70	1.00	27.00	52.00	8.00
8.033	GT108.4777.010.37.80.R	8.00	0.10	47	8	3.70	7.70	1.00	37.00	62.00	8.00
8.034	GT108.4777.010.42.80.R	8.00	0.10	47	8	3.70	7.70	1.00	42.00	67.00	8.00
8.035	GT108.4777.010.47.80.R	8.00	0.10	47	8	3.70	7.70	1.00	47.00	72.00	8.00
8.038	GT108.4777.020.17.80.R	8.00	0.20	47	8	3.70	7.70	1.00	17.00	42.00	8.00
8.040	GT108.4777.020.27.80.R	8.00	0.20	47	8	3.70	7.70	1.00	27.00	52.00	8.00
8.042	GT108.4777.020.37.80.R	8.00	0.20	47	8	3.70	7.70	1.00	37.00	62.00	8.00
8.043	GT108.4777.020.42.80.R	8.00	0.20	47	8	3.70	7.70	1.00	42.00	67.00	8.00
8.044	GT108.4777.020.47.80.R	8.00	0.20	47	8	3.70	7.70	1.00	47.00	72.00	8.00

Series no. **27205** **27207**

Cutting direction

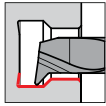
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.029	GT108.4777.010.17.80.L	8.00	0.10	47	8	3.70	7.70	1.00	17.00	42.00	8.00
8.031	GT108.4777.010.27.80.L	8.00	0.10	47	8	3.70	7.70	1.00	27.00	52.00	8.00
8.033	GT108.4777.010.37.80.L	8.00	0.10	47	8	3.70	7.70	1.00	37.00	62.00	8.00
8.034	GT108.4777.010.42.80.L	8.00	0.10	47	8	3.70	7.70	1.00	42.00	67.00	8.00
8.035	GT108.4777.010.47.80.L	8.00	0.10	47	8	3.70	7.70	1.00	47.00	72.00	8.00
8.038	GT108.4777.020.17.80.L	8.00	0.20	47	8	3.70	7.70	1.00	17.00	42.00	8.00
8.040	GT108.4777.020.27.80.L	8.00	0.20	47	8	3.70	7.70	1.00	27.00	52.00	8.00
8.042	GT108.4777.020.37.80.L	8.00	0.20	47	8	3.70	7.70	1.00	37.00	62.00	8.00
8.043	GT108.4777.020.42.80.L	8.00	0.20	47	8	3.70	7.70	1.00	42.00	67.00	8.00
8.044	GT108.4777.020.47.80.L	8.00	0.20	47	8	3.70	7.70	1.00	47.00	72.00	8.00

System 108



Cutting insert for boring out and profiling

Series no. **27108** **27110**



• radial free 47°, tmax 2

Tool material **Solid carbide**

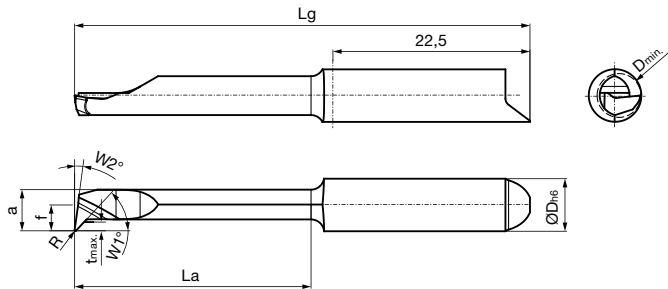
Type GT 108 GT 108

Coating

nano-A uncoated

for tool holders type GH108/GB108 see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
8.120	GT108.4767.010.17.70.R	7.00	0.10	47	8	3.95	6.70	2.00	17.00	42.00	8.00
8.140	GT108.4767.010.27.70.R	7.00	0.10	47	8	3.95	6.70	2.00	27.00	52.00	8.00
8.160	GT108.4767.010.37.70.R	7.00	0.10	47	8	3.95	6.70	2.00	37.00	62.00	8.00
8.170	GT108.4767.010.42.70.R	7.00	0.10	47	8	3.95	6.70	2.00	42.00	67.00	8.00
8.320	GT108.4767.020.17.70.R	7.00	0.20	47	8	3.95	6.70	2.00	17.00	42.00	8.00
8.340	GT108.4767.020.27.70.R	7.00	0.20	47	8	3.95	6.70	2.00	27.00	52.00	8.00
8.360	GT108.4767.020.37.70.R	7.00	0.20	47	8	3.95	6.70	2.00	37.00	62.00	8.00
8.370	GT108.4767.020.42.70.R	7.00	0.20	47	8	3.95	6.70	2.00	42.00	67.00	8.00

Series no. **27109** **27111**

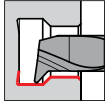
Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.4767.010.17.70.L	7.00	0.10	47	8	3.95	6.70	2.00	17.00	42.00	8.00
8.140	GT108.4767.010.27.70.L	7.00	0.10	47	8	3.95	6.70	2.00	27.00	52.00	8.00
8.160	GT108.4767.010.37.70.L	7.00	0.10	47	8	3.95	6.70	2.00	37.00	62.00	8.00
8.170	GT108.4767.010.42.70.L	7.00	0.10	47	8	3.95	6.70	2.00	42.00	67.00	8.00
8.320	GT108.4767.020.17.70.L	7.00	0.20	47	8	3.95	6.70	2.00	17.00	42.00	8.00
8.340	GT108.4767.020.27.70.L	7.00	0.20	47	8	3.95	6.70	2.00	27.00	52.00	8.00
8.360	GT108.4767.020.37.70.L	7.00	0.20	47	8	3.95	6.70	2.00	37.00	62.00	8.00
8.370	GT108.4767.020.42.70.L	7.00	0.20	47	8	3.95	6.70	2.00	42.00	67.00	8.00



Cutting insert for boring out and profiling

Series no. **27208** **27210**



• radial free 47°, tmax 2.5

Tool material **Solid carbide**

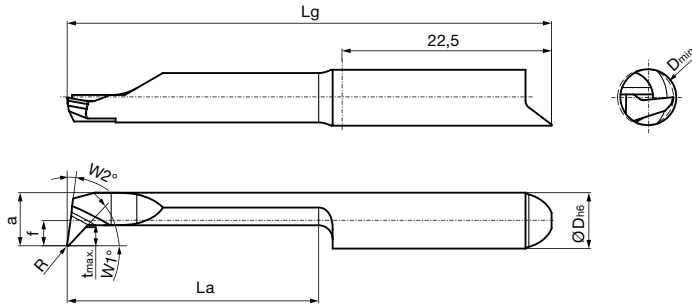
Type GT 108 GT 108

Coating

nano-A uncoated

for tool holders type GH108/GB108 see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
8.120	GT108.4777.010.17.80.R	8.00	0.10	47	8	3.70	7.70	2.50	17.00	42.00	8.00
8.140	GT108.4777.010.27.80.R	8.00	0.10	47	8	3.70	7.70	2.50	27.00	52.00	8.00
8.160	GT108.4777.010.37.80.R	8.00	0.10	47	8	3.70	7.70	2.50	37.00	62.00	8.00
8.170	GT108.4777.010.42.80.R	8.00	0.10	47	8	3.70	7.70	2.50	42.00	72.00	8.00
8.320	GT108.4777.020.17.80.R	8.00	0.20	47	8	3.70	7.70	2.50	17.00	42.00	8.00
8.340	GT108.4777.020.27.80.R	8.00	0.20	47	8	3.70	7.70	2.50	27.00	52.00	8.00
8.360	GT108.4777.020.37.80.R	8.00	0.20	47	8	3.70	7.70	2.50	37.00	62.00	8.00
8.370	GT108.4777.020.42.80.R	8.00	0.20	47	8	3.70	7.70	2.50	42.00	72.00	8.00

Series no. **27209** **27211**

Cutting direction

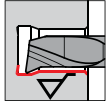
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.4777.010.17.80.L	8.00	0.10	47	8	3.70	7.70	2.50	17.00	42.00	8.00
8.140	GT108.4777.010.27.80.L	8.00	0.10	47	8	3.70	7.70	2.50	27.00	52.00	8.00
8.160	GT108.4777.010.37.80.L	8.00	0.10	47	8	3.70	7.70	2.50	37.00	62.00	8.00
8.170	GT108.4777.010.42.80.L	8.00	0.10	47	8	3.70	7.70	2.50	42.00	72.00	8.00
8.320	GT108.4777.020.17.80.L	8.00	0.20	47	8	3.70	7.70	2.50	17.00	42.00	8.00
8.340	GT108.4777.020.27.80.L	8.00	0.20	47	8	3.70	7.70	2.50	27.00	52.00	8.00
8.360	GT108.4777.020.37.80.L	8.00	0.20	47	8	3.70	7.70	2.50	37.00	62.00	8.00
8.370	GT108.4777.020.42.80.L	8.00	0.20	47	8	3.70	7.70	2.50	42.00	72.00	8.00

System 108



Cutting insert for boring out and profiling

Series no. **27116** **27118**



• **WIPER-geometry**

Tool material **Solid carbide**

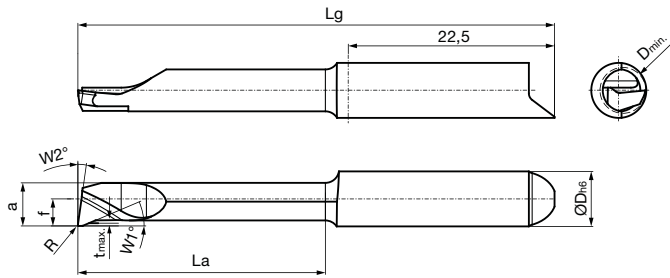
Type GJ 108 GJ 108

Coating **a** ○

nano-A uncoated

for tool holders type GH108/GB108 see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
8.120	GJ108.2367.010.17.70.R	7.00	0.10	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.140	GJ108.2367.010.27.70.R	7.00	0.10	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.160	GJ108.2367.010.37.70.R	7.00	0.10	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.170	GJ108.2367.010.42.70.R	7.00	0.10	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.180	GJ108.2367.010.47.70.R	7.00	0.10	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.190	GJ108.2367.010.52.70.R	7.00	0.10	23	8	3.95	6.70	0.50	52.00	77.00	8.00
8.320	GJ108.2367.020.17.70.R	7.00	0.20	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.340	GJ108.2367.020.27.70.R	7.00	0.20	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.360	GJ108.2367.020.37.70.R	7.00	0.20	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.370	GJ108.2367.020.42.70.R	7.00	0.20	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.380	GJ108.2367.020.47.70.R	7.00	0.20	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.390	GJ108.2367.020.52.70.R	7.00	0.20	23	8	3.95	6.70	0.50	52.00	77.00	8.00

Series no. **27117** **27119**

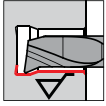
Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GJ108.2367.010.17.70.L	7.00	0.10	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.140	GJ108.2367.010.27.70.L	7.00	0.10	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.160	GJ108.2367.010.37.70.L	7.00	0.10	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.170	GJ108.2367.010.42.70.L	7.00	0.10	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.180	GJ108.2367.010.47.70.L	7.00	0.10	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.190	GJ108.2367.010.52.70.L	7.00	0.10	23	8	3.95	6.70	0.50	52.00	77.00	8.00
8.320	GJ108.2367.020.17.70.L	7.00	0.20	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.340	GJ108.2367.020.27.70.L	7.00	0.20	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.360	GJ108.2367.020.37.70.L	7.00	0.20	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.370	GJ108.2367.020.42.70.L	7.00	0.20	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.380	GJ108.2367.020.47.70.L	7.00	0.20	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.390	GJ108.2367.020.52.70.L	7.00	0.20	23	8	3.95	6.70	0.50	52.00	77.00	8.00



Cutting insert for boring out and profiling

Series no. **27216** **27218**



• WIPER-geometry

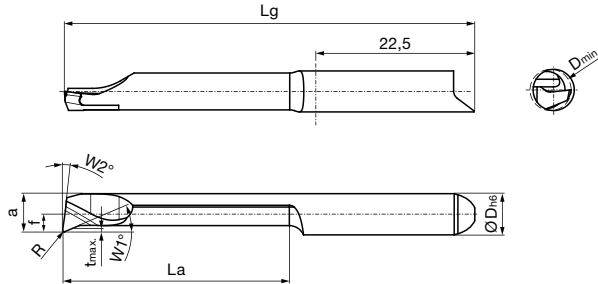
Tool material **Solid carbide**

Type GJ 108 GJ 108

Coating **a** ○
nano-A uncoated

for tool holders type GH108/GB108 see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction **(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
8.120	GJ108.2377.010.17.80.R	8.00	0.10	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.140	GJ108.2377.010.27.80.R	8.00	0.10	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.160	GJ108.2377.010.37.80.R	8.00	0.10	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.170	GJ108.2377.010.42.80.R	8.00	0.10	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.180	GJ108.2377.010.47.80.R	8.00	0.10	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.190	GJ108.2377.010.52.80.R	8.00	0.10	23	8	3.70	7.70	0.60	52.00	77.00	8.00
8.320	GJ108.2377.020.17.80.R	8.00	0.20	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.340	GJ108.2377.020.27.80.R	8.00	0.20	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.360	GJ108.2377.020.37.80.R	8.00	0.20	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.370	GJ108.2377.020.42.80.R	8.00	0.20	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.380	GJ108.2377.020.47.80.R	8.00	0.20	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.390	GJ108.2377.020.52.80.R	8.00	0.20	23	8	3.70	7.70	0.60	52.00	77.00	8.00

Series no. **27217** **27219**

Cutting direction **(L)** **(L)**

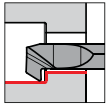
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GJ108.2377.010.17.80.L	8.00	0.10	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.140	GJ108.2377.010.27.80.L	8.00	0.10	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.160	GJ108.2377.010.37.80.L	8.00	0.10	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.170	GJ108.2377.010.42.80.L	8.00	0.10	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.180	GJ108.2377.010.47.80.L	8.00	0.10	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.190	GJ108.2377.010.52.80.L	8.00	0.10	23	8	3.70	7.70	0.60	52.00	77.00	8.00
8.320	GJ108.2377.020.17.80.L	8.00	0.20	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.340	GJ108.2377.020.27.80.L	8.00	0.20	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.360	GJ108.2377.020.37.80.L	8.00	0.20	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.370	GJ108.2377.020.42.80.L	8.00	0.20	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.380	GJ108.2377.020.47.80.L	8.00	0.20	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.390	GJ108.2377.020.52.80.L	8.00	0.20	23	8	3.70	7.70	0.60	52.00	77.00	8.00

System 108



Cutting insert for back boring and profiling

Series no. **27120** **27122**



• radial free 32°

Tool material **Solid carbide**

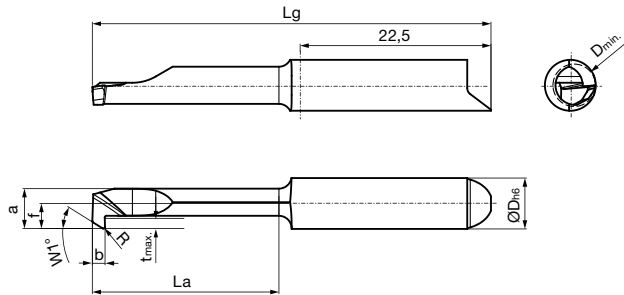
Type GT 108 GT 108

Coating

nano-A uncoated

for tool holders type GH108/GB108 see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
8.010	GT108.3267.020.17.70.R	7.00	0.20	32	3.95	6.70	1.80	17.00	42.00	8.00
8.020	GT108.3267.020.27.70.R	7.00	0.20	32	3.95	6.70	1.80	27.00	52.00	8.00
8.030	GT108.3267.020.37.70.R	7.00	0.20	32	3.95	6.70	1.80	37.00	62.00	8.00
8.040	GT108.3267.020.42.70.R	7.00	0.20	32	3.95	6.70	1.80	42.00	67.00	8.00
8.050	GT108.3267.020.47.70.R	7.00	0.20	32	3.95	6.70	1.80	47.00	72.00	8.00
8.060	GT108.3267.020.52.70.R	7.00	0.20	32	3.95	6.70	1.80	52.00	77.00	8.00

Series no. **27121** **27123**

Cutting direction

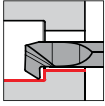
Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
8.010	GT108.3267.020.17.70.L	7.00	0.20	32	3.95	6.70	1.80	17.00	42.00	8.00
8.020	GT108.3267.020.27.70.L	7.00	0.20	32	3.95	6.70	1.80	27.00	52.00	8.00
8.030	GT108.3267.020.37.70.L	7.00	0.20	32	3.95	6.70	1.80	37.00	62.00	8.00
8.040	GT108.3267.020.42.70.L	7.00	0.20	32	3.95	6.70	1.80	42.00	67.00	8.00
8.050	GT108.3267.020.47.70.L	7.00	0.20	32	3.95	6.70	1.80	47.00	72.00	8.00
8.060	GT108.3267.020.52.70.L	7.00	0.20	32	3.95	6.70	1.80	52.00	77.00	8.00

System 108



Cutting insert for back boring and profiling

Series no. **27220** **27222**



• radial free 32°

Tool material **Solid carbide**

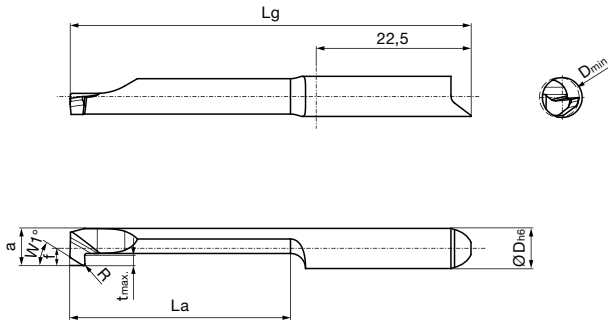
Type GT 108 GT 108

Coating

nano-A uncoated

for tool holders type GH108/GB108 see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image

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
8.010	GT108.3277.020.17.80.R	8.00	0.20	32	3.70	7.70	2.20	17.00	42.00	8.00
8.020	GT108.3277.020.27.80.R	8.00	0.20	32	3.70	7.70	2.20	27.00	52.00	8.00
8.030	GT108.3277.020.37.80.R	8.00	0.20	32	3.70	7.70	2.20	37.00	62.00	8.00
8.040	GT108.3277.020.42.80.R	8.00	0.20	32	3.70	7.70	2.20	42.00	67.00	8.00
8.050	GT108.3277.020.47.80.R	8.00	0.20	32	3.70	7.70	2.20	47.00	72.00	8.00
8.060	GT108.3277.020.52.80.R	8.00	0.20	32	3.70	7.70	2.20	52.00	77.00	8.00

Series no. **27221** **27223**

Cutting direction

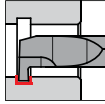
Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
8.010	GT108.3277.020.17.80.L	8.00	0.20	32	3.70	7.70	2.20	17.00	42.00	8.00
8.020	GT108.3277.020.27.80.L	8.00	0.20	32	3.70	7.70	2.20	27.00	52.00	8.00
8.030	GT108.3277.020.37.80.L	8.00	0.20	32	3.70	7.70	2.20	37.00	62.00	8.00
8.040	GT108.3277.020.42.80.L	8.00	0.20	32	3.70	7.70	2.20	42.00	67.00	8.00
8.050	GT108.3277.020.47.80.L	8.00	0.20	32	3.70	7.70	2.20	47.00	72.00	8.00
8.060	GT108.3277.020.52.80.L	8.00	0.20	32	3.70	7.70	2.20	52.00	77.00	8.00

System 108



Cutting insert for internal grooving, straight slots

Series no. **27124** **27126**

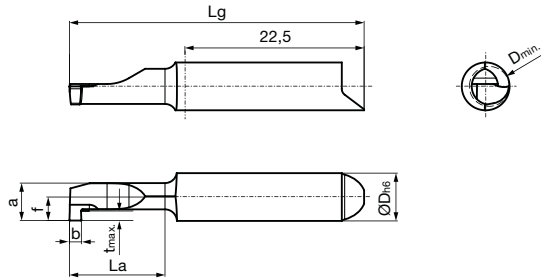


- grooving depth up to 2.5 mm

for tool holders type GH108/GB108 see from page 134

Tool material	Solid carbide	
Type	GE 108	GE 108
Coating		
	nano-A	uncoated

Cutting data page 214





Right hand version shown
Left hand version mirror image

Cutting direction

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.000.17.70.R	7.00	1.50	3.95	6.70	2.50	17.00	42.00	8.00
8.020	GE108.0150.000.27.70.R	7.00	1.50	3.95	6.70	2.50	27.00	52.00	8.00
8.030	GE108.0150.000.37.70.R	7.00	1.50	3.95	6.70	2.50	37.00	62.00	8.00
8.040	GE108.0150.000.42.70.R	7.00	1.50	3.95	6.70	2.50	42.00	67.00	8.00
8.050	GE108.0150.000.47.70.R	7.00	1.50	3.95	6.70	2.50	47.00	72.00	8.00
8.110	GE108.0200.000.17.70.R	7.00	2.00	3.95	6.70	2.50	17.00	42.00	8.00
8.120	GE108.0200.000.27.70.R	7.00	2.00	3.95	6.70	2.50	27.00	52.00	8.00
8.130	GE108.0200.000.37.70.R	7.00	2.00	3.95	6.70	2.50	37.00	62.00	8.00
8.140	GE108.0200.000.42.70.R	7.00	2.00	3.95	6.70	2.50	42.00	67.00	8.00
8.150	GE108.0200.000.47.70.R	7.00	2.00	3.95	6.70	2.50	47.00	72.00	8.00
8.210	GE108.0250.000.17.70.R	7.00	2.50	3.95	6.70	2.50	17.00	42.00	8.00
8.220	GE108.0250.000.27.70.R	7.00	2.50	3.95	6.70	2.50	27.00	52.00	8.00
8.230	GE108.0250.000.37.70.R	7.00	2.50	3.95	6.70	2.50	37.00	62.00	8.00
8.240	GE108.0250.000.42.70.R	7.00	2.50	3.95	6.70	2.50	42.00	67.00	8.00
8.250	GE108.0250.000.47.70.R	7.00	2.50	3.95	6.70	2.50	47.00	72.00	8.00
8.310	GE108.0300.000.17.70.R	7.00	3.00	3.95	6.70	2.50	17.00	42.00	8.00
8.320	GE108.0300.000.27.70.R	7.00	3.00	3.95	6.70	2.50	27.00	52.00	8.00
8.330	GE108.0300.000.37.70.R	7.00	3.00	3.95	6.70	2.50	37.00	62.00	8.00
8.340	GE108.0300.000.42.70.R	7.00	3.00	3.95	6.70	2.50	42.00	67.00	8.00
8.350	GE108.0300.000.47.70.R	7.00	3.00	3.95	6.70	2.50	47.00	72.00	8.00



Series no. **27125** **27127**

Cutting direction  

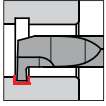
Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.000.17.70.L	7.00	1.50	3.95	6.70	2.50	17.00	42.00	8.00
8.020	GE108.0150.000.27.70.L	7.00	1.50	3.95	6.70	2.50	27.00	52.00	8.00
8.030	GE108.0150.000.37.70.L	7.00	1.50	3.95	6.70	2.50	37.00	62.00	8.00
8.040	GE108.0150.000.42.70.L	7.00	1.50	3.95	6.70	2.50	42.00	67.00	8.00
8.050	GE108.0150.000.47.70.L	7.00	1.50	3.95	6.70	2.50	47.00	72.00	8.00
8.110	GE108.0200.000.17.70.L	7.00	2.00	3.95	6.70	2.50	17.00	42.00	8.00
8.120	GE108.0200.000.27.70.L	7.00	2.00	3.95	6.70	2.50	27.00	52.00	8.00
8.130	GE108.0200.000.37.70.L	7.00	2.00	3.95	6.70	2.50	37.00	62.00	8.00
8.140	GE108.0200.000.42.70.L	7.00	2.00	3.95	6.70	2.50	42.00	67.00	8.00
8.150	GE108.0200.000.47.70.L	7.00	2.00	3.95	6.70	2.50	47.00	72.00	8.00
8.210	GE108.0250.000.17.70.L	7.00	2.50	3.95	6.70	2.50	17.00	42.00	8.00
8.220	GE108.0250.000.27.70.L	7.00	2.50	3.95	6.70	2.50	27.00	52.00	8.00
8.230	GE108.0250.000.37.70.L	7.00	2.50	3.95	6.70	2.50	37.00	62.00	8.00
8.240	GE108.0250.000.42.70.L	7.00	2.50	3.95	6.70	2.50	42.00	67.00	8.00
8.250	GE108.0250.000.47.70.L	7.00	2.50	3.95	6.70	2.50	47.00	72.00	8.00
8.310	GE108.0300.000.17.70.L	7.00	3.00	3.95	6.70	2.50	17.00	42.00	8.00
8.320	GE108.0300.000.27.70.L	7.00	3.00	3.95	6.70	2.50	27.00	52.00	8.00
8.330	GE108.0300.000.37.70.L	7.00	3.00	3.95	6.70	2.50	37.00	62.00	8.00
8.340	GE108.0300.000.42.70.L	7.00	3.00	3.95	6.70	2.50	42.00	67.00	8.00
8.350	GE108.0300.000.47.70.L	7.00	3.00	3.95	6.70	2.50	47.00	72.00	8.00

System 108



Cutting insert for internal grooving, straight slots

Series no. **27224** **27225**



- grooving depth up to 3 mm

for tool holders type GH108/GB108 see from page 134

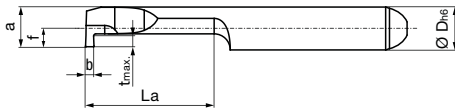
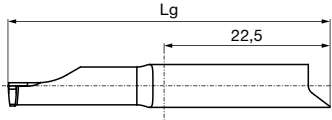
Tool material **Solid carbide**

Type **GE 108** **GE 108**

Coating **a**

nano-A uncoated



Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.000.17.80.R	8.00	1.50	3.70	7.70	3.00	17.00	42.00	8.00
8.020	GE108.0150.000.27.80.R	8.00	1.50	3.70	7.70	3.00	27.00	52.00	8.00
8.030	GE108.0150.000.37.80.R	8.00	1.50	3.70	7.70	3.00	37.00	62.00	8.00
8.040	GE108.0150.000.42.80.R	8.00	1.50	3.70	7.70	3.00	42.00	67.00	8.00
8.050	GE108.0150.000.47.80.R	8.00	1.50	3.70	7.70	3.00	47.00	72.00	8.00
8.110	GE108.0200.000.17.80.R	8.00	2.00	3.70	7.70	3.00	17.00	42.00	8.00
8.120	GE108.0200.000.27.80.R	8.00	2.00	3.70	7.70	3.00	27.00	52.00	8.00
8.130	GE108.0200.000.37.80.R	8.00	2.00	3.70	7.70	3.00	37.00	62.00	8.00
8.140	GE108.0200.000.42.80.R	8.00	2.00	3.70	7.70	3.00	42.00	67.00	8.00
8.150	GE108.0200.000.47.80.R	8.00	2.00	3.70	7.70	3.00	47.00	72.00	8.00
8.210	GE108.0250.000.17.80.R	8.00	2.50	3.70	7.70	3.00	17.00	42.00	8.00
8.220	GE108.0250.000.27.80.R	8.00	2.50	3.70	7.70	3.00	27.00	52.00	8.00
8.230	GE108.0250.000.37.80.R	8.00	2.50	3.70	7.70	3.00	37.00	62.00	8.00
8.240	GE108.0250.000.42.80.R	8.00	2.50	3.70	7.70	3.00	42.00	67.00	8.00
8.250	GE108.0250.000.47.80.R	8.00	2.50	3.70	7.70	3.00	47.00	72.00	8.00
8.310	GE108.0300.000.17.80.R	8.00	3.00	3.70	7.70	3.00	17.00	42.00	8.00
8.320	GE108.0300.000.27.80.R	8.00	3.00	3.70	7.70	3.00	27.00	52.00	8.00
8.330	GE108.0300.000.37.80.R	8.00	3.00	3.70	7.70	3.00	37.00	62.00	8.00
8.340	GE108.0300.000.42.80.R	8.00	3.00	3.70	7.70	3.00	42.00	67.00	8.00
8.350	GE108.0300.000.47.80.R	8.00	3.00	3.70	7.70	3.00	47.00	72.00	8.00

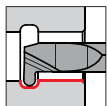
Series no. **27226** **27227**Cutting direction  

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.000.17.80.L	8.00	1.50	3.70	7.70	3.00	17.00	42.00	8.00
8.020	GE108.0150.000.27.80.L	8.00	1.50	3.70	7.70	3.00	27.00	52.00	8.00
8.030	GE108.0150.000.37.80.L	8.00	1.50	3.70	7.70	3.00	37.00	62.00	8.00
8.040	GE108.0150.000.42.80.L	8.00	1.50	3.70	7.70	3.00	42.00	67.00	8.00
8.050	GE108.0150.000.47.80.L	8.00	1.50	3.70	7.70	3.00	47.00	72.00	8.00
8.110	GE108.0200.000.17.80.L	8.00	2.00	3.70	7.70	3.00	17.00	42.00	8.00
8.120	GE108.0200.000.27.80.L	8.00	2.00	3.70	7.70	3.00	27.00	52.00	8.00
8.130	GE108.0200.000.37.80.L	8.00	2.00	3.70	7.70	3.00	37.00	62.00	8.00
8.140	GE108.0200.000.42.80.L	8.00	2.00	3.70	7.70	3.00	42.00	67.00	8.00
8.150	GE108.0200.000.47.80.L	8.00	2.00	3.70	7.70	3.00	47.00	72.00	8.00
8.210	GE108.0250.000.17.80.L	8.00	2.50	3.70	7.70	3.00	17.00	42.00	8.00
8.220	GE108.0250.000.27.80.L	8.00	2.50	3.70	7.70	3.00	27.00	52.00	8.00
8.230	GE108.0250.000.37.80.L	8.00	2.50	3.70	7.70	3.00	37.00	62.00	8.00
8.240	GE108.0250.000.42.80.L	8.00	2.50	3.70	7.70	3.00	42.00	67.00	8.00
8.250	GE108.0250.000.47.80.L	8.00	2.50	3.70	7.70	3.00	47.00	72.00	8.00
8.310	GE108.0300.000.17.80.L	8.00	3.00	3.70	7.70	3.00	17.00	42.00	8.00
8.320	GE108.0300.000.27.80.L	8.00	3.00	3.70	7.70	3.00	27.00	52.00	8.00
8.330	GE108.0300.000.37.80.L	8.00	3.00	3.70	7.70	3.00	37.00	62.00	8.00
8.340	GE108.0300.000.42.80.L	8.00	3.00	3.70	7.70	3.00	42.00	67.00	8.00
8.350	GE108.0300.000.47.80.L	8.00	3.00	3.70	7.70	3.00	47.00	72.00	8.00



Cutting insert for internal grooving, full radius slots

Series no. **27128** **27130**



• full radius R0.75-R1.5

Tool material **Solid carbide**

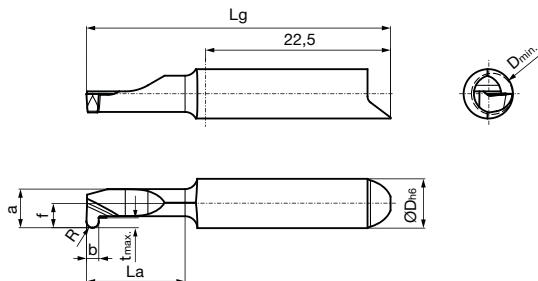
Type **GE 108** **GE 108**

Coating **a**

nano-A **uncoated**

for tool holders type GH108/GB108 see from page 134



Cutting data page 214



Right hand version shown
Left hand version mirror image

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
8.010	GE108.0150.075.17.70.R	7.00	1.50	0.75	3.95	6.70	2.50	17.00	42.00	8.00
8.020	GE108.0150.075.27.70.R	7.00	1.50	0.75	3.95	6.70	2.50	27.00	52.00	8.00
8.030	GE108.0150.075.37.70.R	7.00	1.50	0.75	3.95	6.70	2.50	37.00	62.00	8.00
8.040	GE108.0150.075.42.70.R	7.00	1.50	0.75	3.95	6.70	2.50	42.00	67.00	8.00
8.050	GE108.0150.075.47.70.R	7.00	1.50	0.75	3.95	6.70	2.50	47.00	72.00	8.00
8.110	GE108.0200.100.17.70.R	7.00	2.00	1.00	3.95	6.70	2.50	17.00	42.00	8.00
8.120	GE108.0200.100.27.70.R	7.00	2.00	1.00	3.95	6.70	2.50	27.00	52.00	8.00
8.130	GE108.0200.100.37.70.R	7.00	2.00	1.00	3.95	6.70	2.50	37.00	62.00	8.00
8.140	GE108.0200.100.42.70.R	7.00	2.00	1.00	3.95	6.70	2.50	42.00	67.00	8.00
8.150	GE108.0200.100.47.70.R	7.00	2.00	1.00	3.95	6.70	2.50	47.00	72.00	8.00
8.210	GE108.0250.125.17.70.R	7.00	2.50	1.25	3.95	6.70	2.50	17.00	42.00	8.00
8.220	GE108.0250.125.27.70.R	7.00	2.50	1.25	3.95	6.70	2.50	27.00	52.00	8.00
8.230	GE108.0250.125.37.70.R	7.00	2.50	1.25	3.95	6.70	2.50	37.00	62.00	8.00
8.240	GE108.0250.125.42.70.R	7.00	2.50	1.25	3.95	6.70	2.50	42.00	67.00	8.00
8.250	GE108.0250.125.47.70.R	7.00	2.50	1.25	3.95	6.70	2.50	47.00	72.00	8.00
8.310	GE108.0300.150.17.70.R	7.00	3.00	1.50	3.95	6.70	2.50	17.00	42.00	8.00
8.320	GE108.0300.150.27.70.R	7.00	3.00	1.50	3.95	6.70	2.50	27.00	52.00	8.00
8.330	GE108.0300.150.37.70.R	7.00	3.00	1.50	3.95	6.70	2.50	37.00	62.00	8.00
8.340	GE108.0300.150.42.70.R	7.00	3.00	1.50	3.95	6.70	2.50	42.00	67.00	8.00
8.350	GE108.0300.150.47.70.R	7.00	3.00	1.50	3.95	6.70	2.50	47.00	72.00	8.00

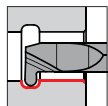
Series no. **27129** **27131**Cutting direction  

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.075.17.70.L	7.00	1.50	0.75	3.95	6.70	2.50	17.00	42.00	8.00
8.020	GE108.0150.075.27.70.L	7.00	1.50	0.75	3.95	6.70	2.50	27.00	52.00	8.00
8.030	GE108.0150.075.37.70.L	7.00	1.50	0.75	3.95	6.70	2.50	37.00	62.00	8.00
8.040	GE108.0150.075.42.70.L	7.00	1.50	0.75	3.95	6.70	2.50	42.00	67.00	8.00
8.050	GE108.0150.075.47.70.L	7.00	1.50	0.75	3.95	6.70	2.50	47.00	72.00	8.00
8.110	GE108.0200.100.17.70.L	7.00	2.00	1.00	3.95	6.70	2.50	17.00	42.00	8.00
8.120	GE108.0200.100.27.70.L	7.00	2.00	1.00	3.95	6.70	2.50	27.00	52.00	8.00
8.130	GE108.0200.100.37.70.L	7.00	2.00	1.00	3.95	6.70	2.50	37.00	62.00	8.00
8.140	GE108.0200.100.42.70.L	7.00	2.00	1.00	3.95	6.70	2.50	42.00	67.00	8.00
8.150	GE108.0200.100.47.70.L	7.00	2.00	1.00	3.95	6.70	2.50	47.00	72.00	8.00
8.210	GE108.0250.125.17.70.L	7.00	2.50	1.25	3.95	6.70	2.50	17.00	42.00	8.00
8.220	GE108.0250.125.27.70.L	7.00	2.50	1.25	3.95	6.70	2.50	27.00	52.00	8.00
8.230	GE108.0250.125.37.70.L	7.00	2.50	1.25	3.95	6.70	2.50	37.00	62.00	8.00
8.240	GE108.0250.125.42.70.L	7.00	2.50	1.25	3.95	6.70	2.50	42.00	67.00	8.00
8.250	GE108.0250.125.47.70.L	7.00	2.50	1.25	3.95	6.70	2.50	47.00	72.00	8.00
8.310	GE108.0300.150.17.70.L	7.00	3.00	1.50	3.95	6.70	2.50	17.00	42.00	8.00
8.320	GE108.0300.150.27.70.L	7.00	3.00	1.50	3.95	6.70	2.50	27.00	52.00	8.00
8.330	GE108.0300.150.37.70.L	7.00	3.00	1.50	3.95	6.70	2.50	37.00	62.00	8.00
8.340	GE108.0300.150.42.70.L	7.00	3.00	1.50	3.95	6.70	2.50	42.00	67.00	8.00
8.350	GE108.0300.150.47.70.L	7.00	3.00	1.50	3.95	6.70	2.50	47.00	72.00	8.00



Cutting insert for internal grooving, full radius slots

Series no. **27228** **27230**



• full radius R0.75-R1.5

Tool material **Solid carbide**

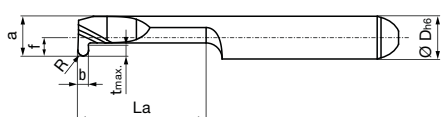
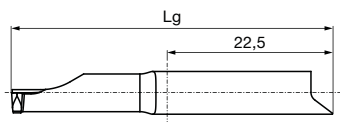
Type **GE 108** **GE 108**

Coating **a** **○**

nano-A uncoated

for tool holders type **GH108/GB108** see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image



Cutting direction **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
8.010	GE108.0150.075.17.80.R	8.00	1.50	0.75	3.70	7.70	3.00	17.00	42.00	8.00
8.020	GE108.0150.075.27.80.R	8.00	1.50	0.75	3.70	7.70	3.00	27.00	52.00	8.00
8.030	GE108.0150.075.37.80.R	8.00	1.50	0.75	3.70	7.70	3.00	37.00	62.00	8.00
8.040	GE108.0150.075.42.80.R	8.00	1.50	0.75	3.70	7.70	3.00	42.00	67.00	8.00
8.050	GE108.0150.075.47.80.R	8.00	1.50	0.75	3.70	7.70	3.00	47.00	72.00	8.00
8.110	GE108.0200.100.17.80.R	8.00	2.00	1.00	3.70	7.70	3.00	17.00	42.00	8.00
8.120	GE108.0200.100.27.80.R	8.00	2.00	1.00	3.70	7.70	3.00	27.00	52.00	8.00
8.130	GE108.0200.100.37.80.R	8.00	2.00	1.00	3.70	7.70	3.00	37.00	62.00	8.00
8.140	GE108.0200.100.42.80.R	8.00	2.00	1.00	3.70	7.70	3.00	42.00	67.00	8.00
8.150	GE108.0200.100.47.80.R	8.00	2.00	1.00	3.70	7.70	3.00	47.00	72.00	8.00
8.210	GE108.0250.125.17.80.R	8.00	2.50	1.25	3.70	7.70	3.00	17.00	42.00	8.00
8.220	GE108.0250.125.27.80.R	8.00	2.50	1.25	3.70	7.70	3.00	27.00	52.00	8.00
8.230	GE108.0250.125.37.80.R	8.00	2.50	1.25	3.70	7.70	3.00	37.00	62.00	8.00
8.240	GE108.0250.125.42.80.R	8.00	2.50	1.25	3.70	7.70	3.00	42.00	67.00	8.00
8.250	GE108.0250.125.47.80.R	8.00	2.50	1.25	3.70	7.70	3.00	47.00	72.00	8.00
8.310	GE108.0300.150.17.80.R	8.00	3.00	1.50	3.70	7.70	3.00	17.00	42.00	8.00
8.320	GE108.0300.150.27.80.R	8.00	3.00	1.50	3.70	7.70	3.00	27.00	52.00	8.00
8.330	GE108.0300.150.37.80.R	8.00	3.00	1.50	3.70	7.70	3.00	37.00	62.00	8.00
8.340	GE108.0300.150.42.80.R	8.00	3.00	1.50	3.70	7.70	3.00	42.00	67.00	8.00
8.350	GE108.0300.150.47.70.R	8.00	3.00	1.50	3.70	7.70	3.00	47.00	72.00	8.00

System 108



Series no. **27229** **27231**

Cutting direction  

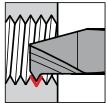
Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.075.17.80.L	8.00	1.50	0.75	3.70	7.70	3.00	17.00	42.00	8.00
8.020	GE108.0150.075.27.80.L	8.00	1.50	0.75	3.70	7.70	3.00	27.00	52.00	8.00
8.030	GE108.0150.075.37.80.L	8.00	1.50	0.75	3.70	7.70	3.00	37.00	62.00	8.00
8.040	GE108.0150.075.42.80.L	8.00	1.50	0.75	3.70	7.70	3.00	42.00	67.00	8.00
8.050	GE108.0150.075.47.80.L	8.00	1.50	0.75	3.70	7.70	3.00	47.00	72.00	8.00
8.110	GE108.0200.100.17.80.L	8.00	2.00	1.00	3.70	7.70	3.00	17.00	42.00	8.00
8.120	GE108.0200.100.27.80.L	8.00	2.00	1.00	3.70	7.70	3.00	27.00	52.00	8.00
8.130	GE108.0200.100.37.80.L	8.00	2.00	1.00	3.70	7.70	3.00	37.00	62.00	8.00
8.140	GE108.0200.100.42.80.L	8.00	2.00	1.00	3.70	7.70	3.00	42.00	67.00	8.00
8.150	GE108.0200.100.47.80.L	8.00	2.00	1.00	3.70	7.70	3.00	47.00	72.00	8.00
8.210	GE108.0250.125.17.80.L	8.00	2.50	1.25	3.70	7.70	3.00	17.00	42.00	8.00
8.220	GE108.0250.125.27.80.L	8.00	2.50	1.25	3.70	7.70	3.00	27.00	52.00	8.00
8.230	GE108.0250.125.37.80.L	8.00	2.50	1.25	3.70	7.70	3.00	37.00	62.00	8.00
8.240	GE108.0250.125.42.80.L	8.00	2.50	1.25	3.70	7.70	3.00	42.00	67.00	8.00
8.250	GE108.0250.125.47.80.L	8.00	2.50	1.25	3.70	7.70	3.00	47.00	72.00	8.00
8.310	GE108.0300.150.17.80.L	8.00	3.00	1.50	3.70	7.70	3.00	17.00	42.00	8.00
8.320	GE108.0300.150.27.80.L	8.00	3.00	1.50	3.70	7.70	3.00	27.00	52.00	8.00
8.330	GE108.0300.150.37.80.L	8.00	3.00	1.50	3.70	7.70	3.00	37.00	62.00	8.00
8.340	GE108.0300.150.42.80.L	8.00	3.00	1.50	3.70	7.70	3.00	42.00	67.00	8.00
8.350	GE108.0300.150.47.70.L	8.00	3.00	1.50	3.70	7.70	3.00	47.00	72.00	8.00

System 108



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

Series no. **27132** **27134**



- pitch P = 1.50-1.75
- Dh6 = 8.00 mm

Tool material **Solid carbide**

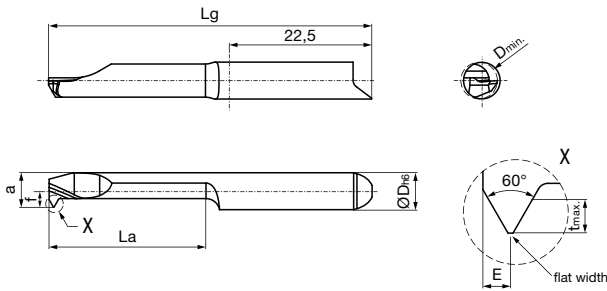
Type GG 108 GG 108

Coating **a** ○

nano-A uncoated

for tool holders type GB108/GH108 see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction **R** **R**

Code no.	Description	G	P	TPI	D min	f	E	a	flat width	t max	La	Lg
			mm		mm	mm	mm	mm	mm	mm	mm	mm
8.001	GG108.TM10.150.17.85.R	M10	1.50	16	8.50	3.95	0.85	7.95	0.178	0.90	17.00	42.00
8.002	GG108.TM10.150.27.85.R	M10	1.50	16	8.50	3.95	0.85	7.95	0.178	0.90	27.00	52.00
8.003	GG108.TM10.150.17.85.R	M10	1.50	16	8.50	3.95	0.85	7.95	0.178	0.90	37.00	62.00
8.004	GG108.TM12.175.17.00.R	M12	1.75	14	10.20	3.95	1.00	7.95	0.209	1.050	17.00	42.00
8.005	GG108.TM12.175.27.00.R	M12	1.75	14	10.20	3.95	1.00	7.95	0.209	1.050	27.00	52.00
8.006	GG108.TM12.175.37.00.R	M12	1.75	14	10.20	3.95	1.00	7.95	0.209	1.050	37.00	62.00

Series no. **27133** **27135**

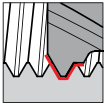
Cutting direction **L** **L**

Code no.	Description	G	P	TPI	D min	f	E	a	flat width	t max	La	Lg
			mm		mm	mm	mm	mm	mm	mm	mm	mm
8.001	GG108.TM10.150.17.85.L	M10	1.50	16	8.50	3.95	0.85	7.95	0.178	0.90	17.00	42.00
8.002	GG108.TM10.150.27.85.L	M10	1.50	16	8.50	3.95	0.85	7.95	0.178	0.90	27.00	52.00
8.003	GG108.TM10.150.17.85.L	M10	1.50	16	8.50	3.95	0.85	7.95	0.178	0.90	37.00	62.00
8.004	GG108.TM12.175.17.00.L	M12	1.75	14	10.20	3.95	1.00	7.95	0.209	1.05	17.00	42.00
8.005	GG108.TM12.175.27.00.L	M12	1.75	14	10.20	3.95	1.00	7.95	0.209	1.05	27.00	52.00
8.006	GG108.TM12.175.37.00.L	M12	1.75	14	10.20	3.95	1.00	7.95	0.209	1.05	37.00	62.00



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

Series no. **27136** **27138**



- pitch P = 1.50-1.75
- Dh6 = 8.00 mm

Tool material **Solid carbide**

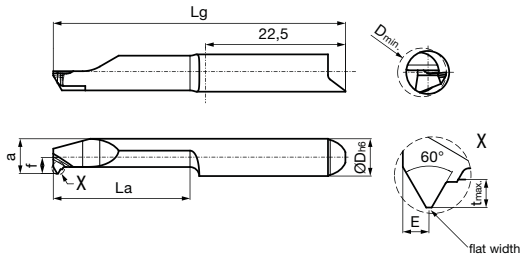
Type GG 108 GG 108

Coating **a** ○

nano-A uncoated

for tool holders type GB108/GH108 see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction

Code no.	Description	G	P	D min	f	E	a	flat width	t max	La	Lg
			mm	mm	mm	mm	mm	mm	mm	mm	mm
8.001	GG108.VM10.150.17.85.R	M10	1.50	8.50	2.95	0.90	7.95	0.178	0.90	17.00	42.00
8.002	GG108.VM10.150.27.85.R	M10	1.50	8.50	2.95	0.90	7.95	0.178	0.90	27.00	52.00
8.003	GG108.VM10.150.17.85.R	M10	1.50	8.50	2.95	0.90	7.95	0.178	0.90	37.00	62.00
8.004	GG108.VM12.175.17.00.R	M12	1.75	10.20	2.95	1.00	7.95	0.209	1.05	17.00	42.00
8.005	GG108.VM12.175.27.00.R	M12	1.75	10.20	2.95	1.00	7.95	0.209	1.05	27.00	52.00
8.006	GG108.VM12.175.37.00.R	M12	1.75	10.20	2.95	1.00	7.95	0.209	1.05	37.00	62.00

Series no. **27137** **27139**

Cutting direction

Code no.	Description	G	P	D min	f	E	a	flat width	t max	La	Lg
			mm	mm	mm	mm	mm	mm	mm	mm	mm
8.001	GG108.VM10.150.17.85.L	M10	1.50	8.50	2.95	0.90	7.95	0.178	0.90	17.00	42.00
8.002	GG108.VM10.150.27.85.L	M10	1.50	8.50	2.95	0.90	7.95	0.178	0.90	27.00	52.00
8.003	GG108.VM10.150.17.85.L	M10	1.50	8.50	2.95	0.90	7.95	0.178	0.90	37.00	62.00
8.004	GG108.VM12.175.17.00.L	M12	1.75	10.20	2.95	1.00	7.95	0.209	1.05	17.00	42.00
8.005	GG108.VM12.175.27.00.L	M12	1.75	10.20	2.95	1.00	7.95	0.209	1.05	27.00	52.00
8.006	GG108.VM12.175.37.00.L	M12	1.75	10.20	2.95	1.00	7.95	0.209	1.05	37.00	62.00

System 108

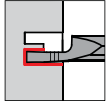


Cutting insert for axial grooving bores, straight slots

Series no.

27232

27234



• grooving depth up to 8 mm

Tool material

Solid carbide

Type

GA 108

GA 108

Coating

nano-A

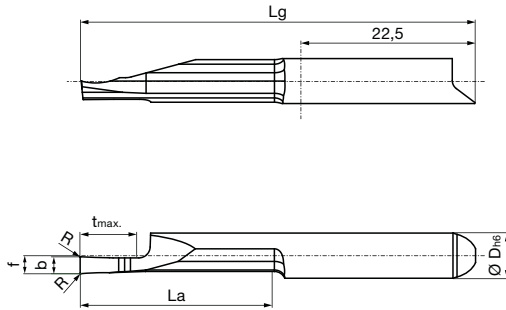
uncoated

nano-A

uncoated

for tool holders type GB108/GH108 see from page 134

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction



Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.001	GA108.0250.015.17.80.R	8.00	2.50	0.15	3.60	5.00	17.00	42.00	8.00
8.002	GA108.0250.015.22.80.R	8.00	2.50	0.15	3.60	5.00	22.00	47.00	8.00
8.003	GA108.0300.015.17.80.R	8.00	3.00	0.15	3.60	8.00	17.00	42.00	8.00
8.004	GA108.0300.015.22.80.R	8.00	3.00	0.15	3.60	8.00	22.00	47.00	8.00

Series no.

27233

27235

Cutting direction

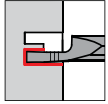


Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.001	GA108.0250.015.17.80.L	8.00	2.50	0.15	3.60	5.00	17.00	42.00	8.00
8.002	GA108.0250.015.22.80.L	8.00	2.50	0.15	3.60	5.00	22.00	47.00	8.00
8.003	GA108.0300.015.17.80.L	8.00	3.00	0.15	3.60	8.00	17.00	42.00	8.00
8.004	GA108.0300.015.22.80.L	8.00	3.00	0.15	3.60	8.00	22.00	47.00	8.00



Cutting insert for axial grooving bores, full radius slots

Series no. **27236** **27238**

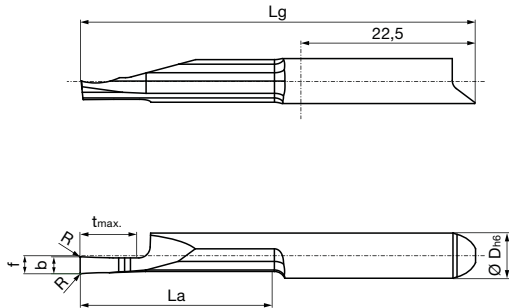


• grooving depth up to 8 mm

for tool holders type GB108/GH108 see from page 134

Tool material	Solid carbide	
Type	GA 108	GA 108
Coating		
	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.001	GA108.0250.125.17.80.R	8.00	2.50	1.25	3.60	5.00	17.00	42.00	8.00
8.002	GA108.0250.125.22.80.R	8.00	2.50	1.25	3.60	5.00	22.00	47.00	8.00
8.003	GA108.0300.125.17.80.R	8.00	3.00	1.50	3.60	8.00	17.00	42.00	8.00
8.004	GA108.0300.125.22.80.R	8.00	3.00	1.50	3.60	8.00	22.00	47.00	8.00

Series no. **27237** **27239**

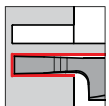
Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.001	GA108.0250.125.17.80.L	8.00	2.50	1.25	3.60	5.00	17.00	42.00	8.00
8.002	GA108.0250.125.22.80.L	8.00	2.50	1.25	3.60	5.00	22.00	47.00	8.00
8.003	GA108.0300.125.17.80.L	8.00	3.00	1.50	3.60	8.00	17.00	42.00	8.00
8.004	GA108.0300.125.22.80.L	8.00	3.00	1.50	3.60	8.00	22.00	47.00	8.00



Cutting insert for axial grooving studs, straight slots

Series no. **27240** **27242**



• grooving depth up to 8 mm

Tool material **Solid carbide**

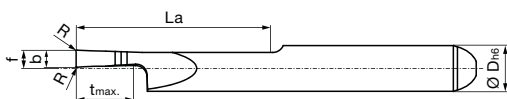
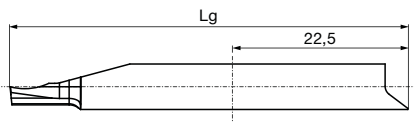
Type GA 108 GA 108

Coating  

nano-A uncoated

for tool holders type GB108/GH108 see from page 134

Cutting data page 214




Right hand version shown
Left hand version mirror image

Cutting direction  

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.001	GA108.Z250.015.17.80.R	8.00	2.50	0.15	3.60	5.00	17.00	42.00	8.00
8.002	GA108.Z250.015.22.80.R	8.00	2.50	0.15	3.60	5.00	22.00	47.00	8.00
8.003	GA108.Z300.015.17.80.R	8.00	3.00	0.15	3.60	8.00	17.00	42.00	8.00
8.004	GA108.Z300.015.22.80.R	8.00	3.00	0.15	3.60	8.00	22.00	47.00	8.00

Series no. **27241** **27243**

Cutting direction  

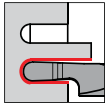
Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.001	GA108.Z250.015.17.80.L	8.00	2.50	1.25	3.60	5.00	17.00	42.00	8.00
8.002	GA108.Z250.015.22.80.L	8.00	2.50	1.25	3.60	5.00	22.00	47.00	8.00
8.003	GA108.Z300.015.17.80.L	8.00	3.00	1.50	3.60	8.00	17.00	42.00	8.00
8.004	GA108.Z300.015.22.80.L	8.00	3.00	1.50	3.60	8.00	22.00	47.00	8.00

System 108



Cutting insert for axial grooving studs, full radius slots

Series no. **27244** **27246**

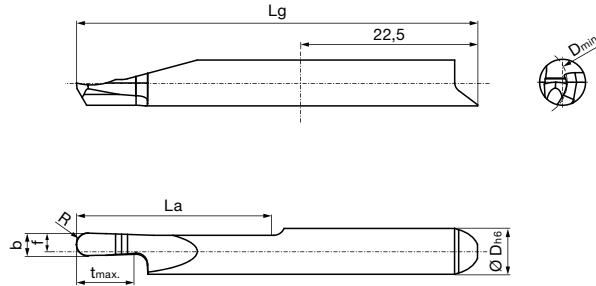


• grooving depth up to 8 mm

for tool holders type GB108/GH108 see from page 134

Tool material	Solid carbide	
Type	GA 108	GA 108
Coating		
	nano-A	uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.001	GA108.Z250.125.17.80.R	8.00	2.50	1.25	3.60	5.00	17.00	42.00	8.00
8.002	GA108.Z250.125.22.80.R	8.00	2.50	1.25	3.60	5.00	22.00	47.00	8.00
8.003	GA108.Z300.150.17.80.R	8.00	3.00	1.50	3.60	8.00	17.00	42.00	8.00
8.004	GA108.Z300.150.22.80.R	8.00	3.00	1.50	3.60	8.00	22.00	47.00	8.00

Series no. **27245** **27247**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.001	GA108.Z250.125.17.80.L	8.00	2.50	1.25	3.60	5.00	17.00	42.00	8.00
8.002	GA108.Z250.125.22.80.L	8.00	2.50	1.25	3.60	5.00	22.00	47.00	8.00
8.003	GA108.Z300.150.17.80.L	8.00	3.00	1.50	3.60	8.00	17.00	42.00	8.00
8.004	GA108.Z300.150.22.80.L	8.00	3.00	1.50	3.60	8.00	22.00	47.00	8.00

System 108

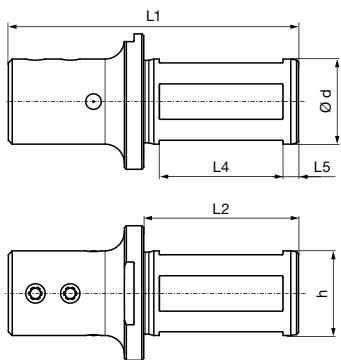


Round shank holder, 4 clamping surfaces

Series no. **27015**

- for inserts type 108
- with internal coolant delivery

Type GB 108



System 108

Code no.	Description	d	d	h	L1	L2	L4	L5
		mm	inch	mm	mm	mm	mm	mm
8.010	GB108.0750.300.00.22.S.IK		3/4	17.05	76.20	40.00	32.00	4.00
8.001	GB108.0020.075.00.22.S.IK	20.00		18.00	75.00	40.00	32.00	4.00
8.002	GB108.0022.075.00.22.S.IK	22.00		20.00	75.00	40.00	32.00	4.00
8.003	GB108.0025.075.00.22.S.IK	25.00		23.00	75.00	40.00	32.00	4.00
8.011	GB108.1000.300.00.22.S.IK		1"	23.40	76.20	40.00	32.00	4.00

Spare parts

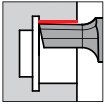
Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle





Cutting insert for broaching longitudinal slots

Series no. **27140** **27141**

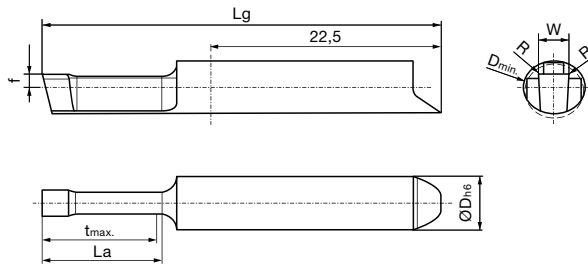


• tolerance class C11, P9, JS9

Tool material	Solid Carbide	
Type	GN 108	GN 108
Coating		
	nano-A	uncoated

for tool holders type GB108 Series No. 27015 see page 170

Cutting data page 214



System 108

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
8.001	GN108.0498.020.12.09.N	5 P9	9.00	4.98	0.20	1.50	11.50	12.00	42.00	8.00
8.002	GN108.0498.020.24.09.N	5 P9	9.00	4.98	0.20	1.50	23.50	24.00	52.00	8.00
8.003	GN108.0598.020.12.10.N	6 P9	10.00	5.98	0.20	1.50	11.50	12.00	42.00	8.00
8.004	GN108.0598.020.24.10.N	6 P9	10.00	5.98	0.20	1.50	23.50	24.00	52.00	8.00

Series no. **27142** **27143**

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
8.001	GN108.0500.020.12.09.N	5 JS9	9.00	5.00	0.20	1.50	11.50	12.00	42.00	8.00
8.002	GN108.0500.020.24.09.N	5 JS9	9.00	5.00	0.20	1.50	23.50	24.00	52.00	8.00
8.003	GN108.0600.020.12.10.N	6 JS9	10.00	6.00	0.20	1.50	11.50	12.00	42.00	8.00
8.004	GN108.0600.020.24.10.N	6 JS9	10.00	6.00	0.20	1.50	23.50	24.00	52.00	8.00

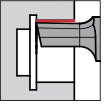
Series no. **27144** **27145**

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
8.001	GN108.0513.050.12.09.N	5 C11	9.00	5.13	0.50	1.50	11.50	12.00	42.00	8.00
8.002	GN108.0513.050.24.09.N	5 C11	9.00	5.13	0.50	1.50	23.50	24.00	52.00	8.00
8.003	GN108.0613.050.12.10.N	6 C11	10.00	6.13	0.50	1.50	11.50	12.00	42.00	8.00
8.004	GN108.0613.050.24.10.N	6 C11	10.00	6.13	0.50	1.50	23.50	24.00	52.00	8.00



Cutting insert for internal hexagon

Series no. **27146** **27147**



• SW 8.0 - 10.0, 10.0 - 14.0

Tool material **Solid Carbide**

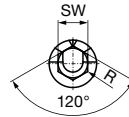
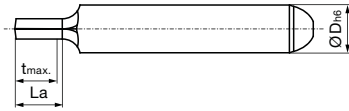
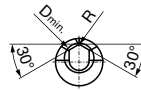
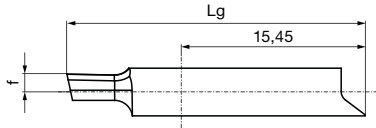
Type GN 108 GN 108

Surface

nano-A uncoated

for tool holders type GB108 Series No. 27015 see page 170

Cutting data page 214



System 108

Code no.	Description	SW	D min	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm
8.001	GN108.SW80.010.12.80.N	8.00-10.00	8.00	0.10	1.50	12.00	12.50	42.00	8.00
8.002	GN108.SW80.010.24.80.N	8.00-10.00	8.00	0.10	1.50	24.00	24.50	52.00	8.00
8.003	GN108.SW10.010.12.10.N	10.00-14.00	10.00	0.10	1.50	12.00	12.50	42.00	8.00
8.004	GN108.SW10.010.24.10.N	10.00-14.00	10.00	0.10	1.50	24.00	24.50	52.00	8.00

Micro-precision drills from Guhring

Small Diameter Drill Offering

- *High speed cobalt from 0.05 mm \varnothing*
- *Coolant fed carbide from 0.5 mm \varnothing*
- *Solid carbide from 0.1 mm \varnothing*
- *Fractional sizes, wire sizes*

featuring

EXCLUSIVELINE[®]

*Micro precision carbide drills
4xD and 7xD, non-coolant fed,
AlTiN coating
5xD, 8xD, and 15xD, coolant fed,
TiAlN coating*



GUHRING

110





SYSTEM 110

MICRO-PRECISION TOOLS



Round shank holder
from page 177



Square shank holder
from page 179



Round shank holder
page 181

Tool holder

110

SPECIAL SOLUTIONS

When designing custom-made special tools, Guhring can tap into decades of experience and substantial tool expertise in order to guide customers to the best possible solution.

The 110 tool system offers a rigid special solution in such cases. We keep blanks with a shank diameter of 10 mm up to a total length of 112 mm available at the factory in order to offer the best possible solution for the most difficult applications. We are happy to investigate the potential for even longer tools if needed.

The shank diameter of 10 mm offers excellent rigidity in challenging applications. Whether it be long overhangs or large recess widths and depths, the 110 tool system offers a myriad of options.

The 110 tool system is offered with a standard range of round shank holders.



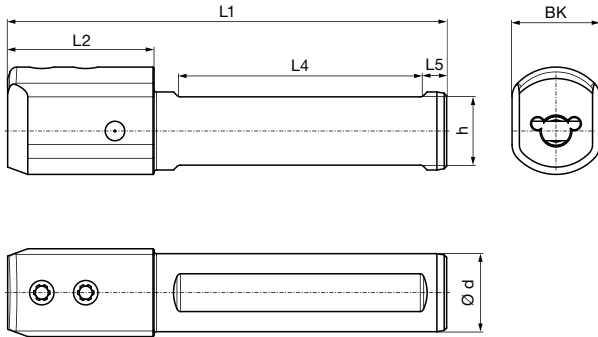


Round shank holder, clamping screw top

Series no. **27050**

- for inserts type 110
- with internal coolant supply

Type **GB 110**



version left and right

Code no.	Description	d	d	h	L1	L2	L4	L5	BK
		mm	inch	mm	mm	mm	mm	mm	mm
10.001	GB110.0010.090.00.22.N.IK	10.00		9.00	90.00	30.00	50.00	5.00	20.0
10.002	GB110.0012.090.00.22.N.IK	12.00		11.00	90.00	30.00	50.00	5.00	20.0
10.015	GB110.0500.354.00.22.N.IK		1/2	11.00	89.92	26.67	54.86	5.00	20.0
10.016	GB110.0625.354.00.22.N.IK		5/8	14.00	89.92	26.67	54.86	5.00	20.0
10.003	GB110.0016.090.00.22.N.IK	16.00		14.00	90.00	30.00	50.00	5.00	20.0
10.017	GB110.0750.415.00.22.N.IK		3/4	17.00	105.41	26.67	69.85	5.00	20.5
10.004	GB110.0020.095.00.22.N.IK	20.00		18.00	95.00	30.00	55.00	5.00	20.5
10.005	GB110.0022.095.00.22.N.IK	22.00		20.00	95.00	30.00	55.00	5.00	N/A
10.006	GB110.0025.100.00.22.N.IK	25.00		23.00	100.00	N/A	55.00	5.00	N/A
10.018	GB110.1000.415.00.22.N.IK		1"	23.40	105.41	N/A	69.85	5.00	N/A

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

System 110

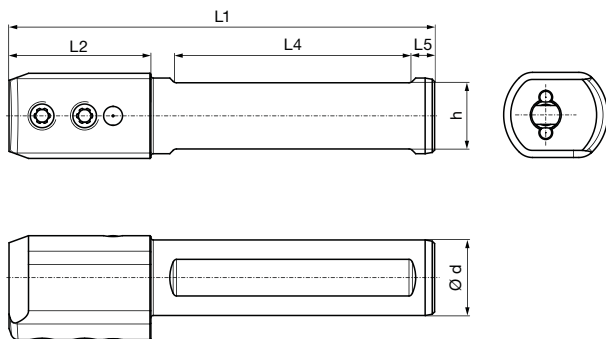


Round shank holder, clamping screw lateral

Series no. **27051**

- for inserts type 110
- with internal coolant supply

Type GB 110



version left and right

Code no.	Description	d	d	h	L1	L2	L4	L5
		mm	inch	mm	mm	mm	mm	mm
10.001	GB110.0010.090.00.22.N.IK90	10.00		9.00	90.00	30.00	50.00	5.00
10.002	GB110.0012.090.00.22.N.IK90	12.00		11.00	90.00	30.00	50.00	5.00
10.015	GB110.0500.354.00.22.N.IK90		1/2	11.00	89.92	26.67	54.86	5.00
10.016	GB110.0625.354.00.22.N.IK90		5/8	14.00	89.92	26.67	54.86	5.00
10.003	GB110.0016.090.00.22.N.IK90	16.00		14.00	90.00	30.00	50.00	5.00
10.017	GB110.0750.415.00.22.N.IK90		3/4	17.00	105.41	26.67	69.85	5.00
10.004	GB110.0020.095.00.22.N.IK90	20.00		18.00	95.00	30.00	55.00	5.00
10.005	GB110.0022.095.00.22.N.IK90	22.00		20.00	95.00	30.00	55.00	5.00
10.006	GB110.0025.100.00.22.N.IK90	25.00		23.00	100.00	N/A	55.00	5.00
10.018	GB110.1000.415.00.22.N.IK90		1"	23.40	105.41	N/A	69.85	5.00

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

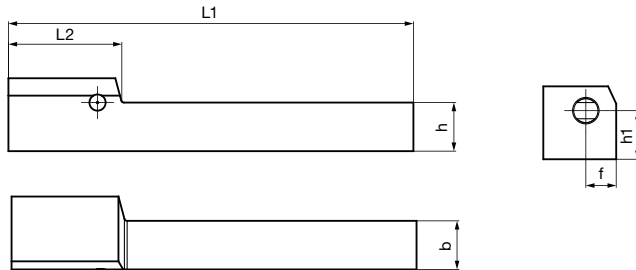


Square shank holder, straight 0°

Series no. **27052**

- for inserts type 110
- without internal coolant supply

Type GH 110



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	b = h		h1	f	L1	L2
		mm	inch				
10.110	GH110.0375.350.00.22.R		3/8	9.52	7.62	88.90	27.94
10.010	GH110.1010.100.00.22.R	10.00		10.00	7.50	100.00	28.00
10.020	GH110.1212.100.00.22.R	12.00		12.00	7.50	100.00	28.00
10.120	GH110.0500.350.00.22.R		1/2	12.70	7.62	88.90	27.94
10.130	GH110.0625.400.00.22.R		5/8	15.87	7.62	101.60	27.94
10.030	GH110.1616.120.00.22.R	16.00		16.00	7.50	120.00	28.00

Series no. **27053**

version left-hand

Code no.	Description	b = h		h1	f	L1	L2
		mm	inch				
10.110	GH110.0375.350.00.22.L		3/8	9.52	7.62	88.90	27.94
10.010	GH110.1010.100.00.22.L	10.00		10.00	7.50	100.00	28.00
10.020	GH110.1212.100.00.22.L	12.00		12.00	7.50	100.00	28.00
10.120	GH110.0500.350.00.22.L		1/2	12.70	7.62	88.90	27.94
10.130	GH110.0625.400.00.22.L		5/8	15.87	7.62	101.60	27.94
10.030	GH110.1616.120.00.22.L	16.00		16.00	7.50	120.00	28.00

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

System 110

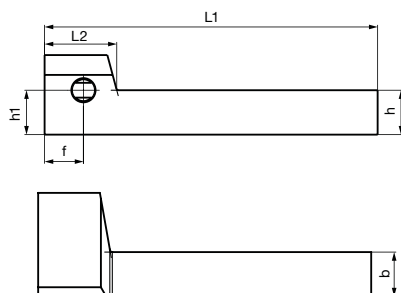


Square shank holder, straight 90°

Series no. **27054**

- for inserts type 110
- without internal coolant supply

Type **GH 110**



Right hand version shown
Left hand version mirror image

version **right-hand**

Code no.	Description	b = h	b = h	h1	f	L1	L2
		mm	inch				
10.010	GH110.0375.350.90.22.R		3/8	9.52	11.43	88.90	20.32
10.001	GH110.1010.090.90.22.R	10		10.00	11.50	90.00	20.50
10.002	GH110.1212.090.90.22.R	12		12.00	11.50	90.00	20.50
10.011	GH110.0500.350.90.22.R		1/2	12.70	11.43	88.90	20.32
10.012	GH110.0625.400.90.22.R		5/8	15.87	11.43	101.60	20.32
10.003	GH110.1616.120.90.22.R	16		16.00	11.50	120.00	20.50

Series no. **27055**

version **left-hand**

Code no.	Description	b = h	b = h	h1	f	L1	L2
		mm	inch				
10.110	GH110.0375.350.00.22.L		3/8	9.52	11.43	88.90	20.32
10.010	GH110.1010.100.00.22.L	10.00		10.00	11.50	90.00	20.50
10.020	GH110.1212.100.00.22.L	12.00		12.00	11.50	90.00	20.50
10.120	GH110.0500.350.00.22.L		1/2	12.70	11.43	88.90	20.32
10.130	GH110.0625.400.00.22.L		5/8	15.87	11.43	101.60	20.32
10.030	GH110.1616.120.00.22.L	16.00		16.00	11.50	120.00	20.50

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

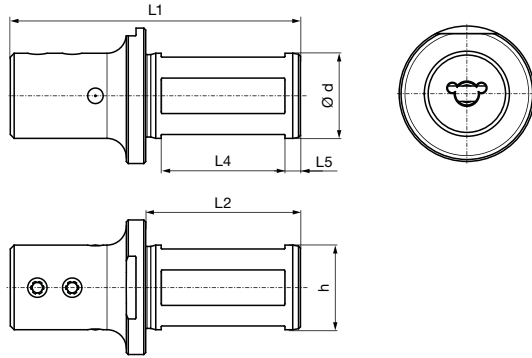


Round shank holder, 4 clamping surfaces

Series no. **27056**

- for inserts type 110
- with internal coolant delivery

Type GB 110



version left and right

Code no.	Description	d	d	h	L1	L2	L4	L5
		mm	inch	mm	mm	mm	mm	mm
10.010	GB110.0750.300.00.22.S.IK		3/4	17.05	76.20	40.00	32.00	4.00
10.001	GB110.0020.075.00.22.S.IK	20.00		18.00	75.00	40.00	32.00	4.00
10.002	GB110.0022.075.00.22.S.IK	22.00		20.00	75.00	40.00	32.00	4.00
10.003	GB110.0025.075.00.22.S.IK	25.00		23.00	75.00	40.00	32.00	4.00
10.011	GB110.1000.300.00.22.S.IK		1"	23.40	76.20	40.00	32.00	4.00

Spare parts

Series no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

305





SYSTEM 305

GROOVING AND PARTING OFF



Square shank holder straight
with and without IC
from page 184



Square shank holder, 90°
offset with and without IC
from page 190

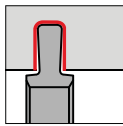


Square shank holder, 45°
offset with and without IC
from page 194

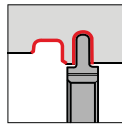


Round shank holder
with and without IC
from page 196

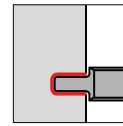
Tool holder



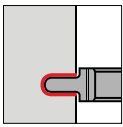
Radial grooving
straight slots, Type GE
from page 200



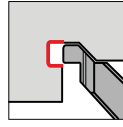
Radial grooving
full radius slots, Type GE
from page 202



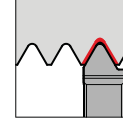
Axial grooving,
straight slots, Type GA
page 203



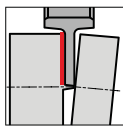
Axial grooving,
full radius slots, Type GA
page 204



Grooving axial recesses,
Type GA
page 205



External thread turning,
Type GG
from page 206



Parting off,
Type GZ
from page 210

Indexable inserts



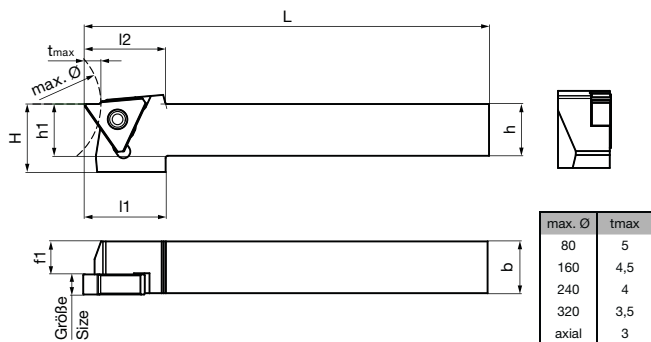
Square shank holder straight, external machining, without IC

Series no. 25350

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

Type GH 305

for indexable inserts type 305 see from page 200



Right hand version shown
Left hand version mirror image

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	
12.013	GH305.1010.125.00.04.R	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	04
12.014	GH305.1212.125.00.04.R	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	04
12.033	GH305.0500.500.00.04.R	5.00		1/2	127.00	12.70	21.70	25.40	25.40	8.90	04
12.021	GH305.0625.500.00.04.R	5.00		5/8	127.00	15.87	20.87	25.40	25.40	12.08	04
12.001	GH305.1616.125.00.04.R	5.00	16.00		125.00	16.00	21.00	25.00	25.00	12.20	04
12.022	GH305.0750.500.00.04.R	5.00		3/4	127.00	19.05	24.05	25.40	25.40	15.25	04
12.002	GH305.2020.125.00.04.R	5.00	20.00		125.00	20.00	25.00	25.00	25.00	16.20	04
12.003	GH305.2525.150.00.04.R	5.00	25.00		150.00	25.00	30.00	25.00	25.00	21.20	04
12.023	GH305.1000.600.00.04.R	5.00		1"	152.40	25.40	30.40	25.40	25.40	21.60	04
12.015	GH305.1010.125.00.06.R	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	06
12.016	GH305.1212.125.00.06.R	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	06
12.034	GH305.0500.500.00.06.R	5.00		1/2	127.00	12.70	21.70	25.40	25.40	6.90	06
12.024	GH305.0625.500.00.06.R	5.00		5/8	127.00	15.87	20.87	25.40	25.40	10.08	06
12.004	GH305.1616.125.00.06.R	5.00	16.00		125.00	16.00	21.00	25.00	25.00	10.20	06
12.025	GH305.0750.500.00.06.R	5.00		3/4	127.00	19.05	24.05	25.40	25.40	13.25	06
12.005	GH305.2020.125.00.06.R	5.00	20.00		125.00	20.00	25.00	25.00	25.00	14.20	06
12.006	GH305.2525.150.00.06.R	5.00	25.00		150.00	25.00	30.00	25.00	25.00	19.20	06
12.026	GH305.1000.600.00.06.R	5.00		1"	152.40	25.40	30.40	25.40	25.40	19.60	06
12.017	GH305.1010.125.00.08.R	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	08
12.018	GH305.1212.125.00.08.R	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	08
12.035	GH305.0500.500.00.08.R	5.00		1/2	127.00	12.70	21.70	25.40	25.40	4.90	08
12.027	GH305.0625.500.00.08.R	5.00		5/8	127.00	15.87	20.87	25.40	25.40	8.08	08
12.007	GH305.1616.125.00.08.R	5.00	16.00		125.00	16.00	21.00	25.00	25.00	8.20	08
12.028	GH305.0750.500.00.08.R	5.00		3/4	127.00	19.05	24.05	25.40	25.40	11.25	08
12.008	GH305.2020.125.00.08.R	5.00	20.00		125.00	20.00	25.00	25.00	25.00	12.20	08
12.009	GH305.2525.150.00.08.R	5.00	25.00		150.00	25.00	30.00	25.00	25.00	17.20	08
12.029	GH305.1000.600.00.08.R	5.00		1"	152.40	25.40	30.40	25.40	25.40	17.60	08
12.019	GH305.1010.125.00.12.R	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	12
12.020	GH305.1212.125.00.12.R	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	12
12.036	GH305.0500.500.00.12.R	5.00		1/2	127.00	12.70	21.70	25.40	25.40	8.90	12
12.030	GH305.0625.500.00.12.R	5.00		5/8	127.00	15.87	20.87	24.40	25.40	8.28	12
12.010	GH305.1616.125.00.12.R	5.00	16.00		125.00	16.00	21.00	24.00	25.00	8.60	12
12.031	GH305.0750.500.00.12.R	5.00		3/4	127.00	19.05	24.05	25.40	25.40	7.25	12
12.011	GH305.2020.125.00.12.R	5.00	20.00		125.00	20.00	25.00	25.00	25.00	8.20	12
12.012	GH305.2525.150.00.12.R	5.00	25.00		150.00	25.00	30.00	25.00	25.00	13.20	12
12.032	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	
12.013	GH305.1010.125.00.04.L	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	04
12.014	GH305.1212.125.00.04.L	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	04
12.033	GH305.0500.500.00.04.L	5.00		1/2	127.00	12.70	21.70	25.40	25.40	0.00	04
12.021	GH305.0625.500.00.04.L	5.00		5/8	127.00	15.87	20.87	25.40	25.40	12.07	04
12.001	GH305.1616.125.00.04.L	5.00	16.00		125.00	16.00	21.00	25.00	25.00	12.20	04
12.022	GH305.0750.500.00.04.L	5.00		3/4	127.00	19.05	24.05	25.40	25.40	15.25	04
12.002	GH305.2020.125.00.04.L	5.00	20.00		125.00	20.00	25.00	25.00	25.00	16.20	04
12.003	GH305.2525.150.00.04.L	5.00	25.00		150.00	25.00	30.00	25.00	25.00	21.20	04
12.023	GH305.1000.600.00.04.L	5.00		1"	152.40	25.40	30.40	25.40	25.40	21.60	04
12.015	GH305.1010.125.00.06.L	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	06
12.016	GH305.1212.125.00.06.L	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	06
12.034	GH305.0500.500.00.06.L	5.00		1/2	127.00	12.70	21.70	25.40	25.40	0.00	06
12.024	GH305.0625.500.00.06.L	5.00		5/8	127.00	15.87	20.87	25.40	25.40	10.07	06
12.004	GH305.1616.125.00.06.L	5.00	16.00		125.00	16.00	21.00	25.00	25.00	10.20	06
12.025	GH305.0750.500.00.06.L	5.00		3/4	127.00	19.05	24.05	25.40	25.40	13.25	06
12.005	GH305.2020.125.00.06.L	5.00	20.00		125.00	20.00	25.00	25.00	25.00	14.20	06
12.006	GH305.2525.150.00.06.L	5.00	25.00		150.00	25.00	30.00	25.00	25.00	19.20	06
12.026	GH305.1000.600.00.06.L	5.00		1"	152.40	25.40	30.40	25.40	25.40	19.60	06
12.017	GH305.1010.125.00.08.L	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	08
12.018	GH305.1212.125.00.08.L	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	08
12.035	GH305.0500.500.00.08.L	5.00		1/2	127.00	12.70	21.70	25.40	25.40	0.00	08
12.027	GH305.0625.500.00.08.L	5.00		5/8	127.00	15.87	20.87	25.40	25.40	8.07	08
12.007	GH305.1616.125.00.08.L	5.00	16.00		125.00	16.00	21.00	25.00	25.00	8.20	08
12.028	GH305.0750.500.00.08.L	5.00		3/4	127.00	19.05	24.05	25.40	25.40	11.25	08
12.008	GH305.2020.125.00.08.L	5.00	20.00		125.00	20.00	25.00	25.00	25.00	12.20	08
12.009	GH305.2525.150.00.08.L	5.00	25.00		150.00	25.00	30.00	25.00	25.00	17.20	08
12.029	GH305.1000.600.00.08.L	5.00		1"	152.40	25.40	30.40	25.40	25.40	17.60	08
12.019	GH305.1010.125.00.12.L	5.00	10.00		125.00	10.00	20.00	24.00	25.00	8.20	12
12.020	GH305.1212.125.00.12.L	5.00	12.00		125.00	12.00	20.00	24.00	25.00	8.20	12
12.036	GH305.0500.500.00.12.L	5.00		1/2	127.00	12.70	21.70	25.40	25.40	0.00	12
12.030	GH305.0625.500.00.12.L	5.00		5/8	127.00	15.87	20.87	24.40	25.40	8.27	12
12.010	GH305.1616.125.00.12.L	5.00	16.00		125.00	16.00	21.00	24.00	25.00	8.60	12
12.031	GH305.0750.500.00.12.L	5.00		3/4	127.00	19.05	24.05	25.40	25.40	7.25	12
12.011	GH305.2020.125.00.12.L	5.00	20.00		125.00	20.00	25.00	25.00	25.00	8.20	12
12.012	GH305.2525.150.00.12.L	5.00	25.00		150.00	25.00	30.00	25.00	25.00	13.20	12
12.032	GH305.1000.600.00.12.L	5.00		1"	152.40	25.40	30.40	25.40	25.40	13.60	12

Spare parts

Series no.	Clamping screw	Tightening torque	Size	Description
25901		Nm		
Code 4.002	M4x11x15IP	3 - 3.5	04 - 06	GH305.1010.125....; GH305.1212.125...
Code 4.000	M4x15x15IP	3 - 3.5	04 - 06	GH305.0625.500....; GH305.0750.500...
Code 4.000	M4x15x15IP	3 - 3.5	04 - 06	GH305.1616.125....; GH305.1000.600...
Code 4.000	M4x15x15IP	3 - 3.5	04 - 06	GH305.2020.125....; GH305.2525.150...
Code 4.000	M4x15x15IP	3 - 3.5	08	GH305....
Code 4.003	M4x17x15IP	3 - 3.5	12	GH305....

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



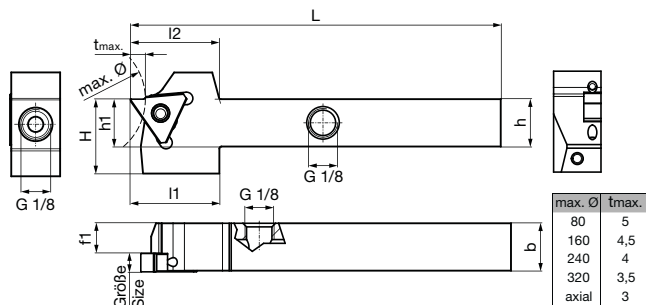
Square shank holder straight, external machining, with IC

Series no. 25352

- 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 200



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	t max	h=b	h=b	L	h1	H	l1	l2	f1	Size
		mm	mm	inch							
12.014	GH305.1212.125.00.04.R.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	10.20	04
12.033	GH305.0500.500.00.04.R.IK	5.00		1/2	127.00	12.70	21.70	30.48	30.48	8.90	04
12.021	GH305.0625.500.00.04.R.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	12.08	04
12.001	GH305.1616.125.00.04.R.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	12.20	04
12.022	GH305.0750.500.00.04.R.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	15.25	04
12.002	GH305.2020.125.00.04.R.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	16.20	04
12.003	GH305.2525.150.00.04.R.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	21.20	04
12.023	GH305.1000.600.00.04.R.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	21.60	04
12.016	GH305.1212.125.00.06.R.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	10.20	06
12.034	GH305.0500.500.00.06.R.IK	5.00		1/2	127.00	12.70	21.70	30.48	30.48	6.90	06
12.024	GH305.0625.500.00.06.R.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	10.08	06
12.004	GH305.1616.125.00.06.R.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	10.20	06
12.025	GH305.0750.500.00.06.R.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	13.25	06
12.005	GH305.2020.125.00.06.R.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	14.20	06
12.006	GH305.2525.150.00.06.R.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	19.20	06
12.026	GH305.1000.600.00.06.R.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	19.60	06
12.018	GH305.1212.125.00.08.R.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	10.20	08
12.035	GH305.0500.500.00.08.R.IK	5.00		1/2	127.00	12.70	21.70	30.48	30.48	4.90	08
12.027	GH305.0625.500.00.08.R.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	8.08	08
12.007	GH305.1616.125.00.08.R.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	8.20	08
12.028	GH305.0750.500.00.08.R.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	11.25	08
12.008	GH305.2020.125.00.08.R.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	12.20	08
12.009	GH305.2525.150.00.08.R.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	17.20	08
12.029	GH305.1000.600.00.08.R.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	17.60	08
12.020	GH305.1212.125.00.12.R.IK	5.00	12.00		125.00	12.00	25.00	30.00	30.00	10.20	12
12.036	GH305.0500.500.00.12.R.IK	5.00		1/2	127.00	12.70	21.70	30.48	30.48	10.90	12
12.030	GH305.0625.500.00.12.R.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	8.08	12
12.010	GH305.1616.125.00.12.R.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	8.20	12
12.031	GH305.0750.500.00.12.R.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	7.25	12
12.011	GH305.2020.125.00.12.R.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	8.20	12
12.012	GH305.2525.150.00.12.R.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	13.20	12
12.032	GH305.1000.600.00.12.R.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	13.60	12

System 305

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	
12.014	GH305.1212.125.00.04.L.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	8.20	04
12.033	GH305.0500.500.00.04.L.IK	5.00		1/2	127.00	12.70	21.70	30.48	30.48		04
12.021	GH305.0625.500.00.04.L.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	12.07	04
12.001	GH305.1616.125.00.04.L.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	12.20	04
12.022	GH305.0750.500.00.04.L.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	15.25	04
12.002	GH305.2020.125.00.04.L.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	16.20	04
12.003	GH305.2525.150.00.04.L.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	21.20	04
12.023	GH305.1000.600.00.04.L.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	21.60	04
12.016	GH305.1212.125.00.06.L.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	6.20	06
12.034	GH305.0500.500.00.06.L.IK	5.00		1/2	127.00	12.70	21.70	30.48	30.48		06
12.024	GH305.0625.500.00.06.L.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	10.07	06
12.004	GH305.1616.125.00.04.L.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	12.20	06
12.025	GH305.0750.500.00.06.L.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	13.25	06
12.005	GH305.2020.125.00.06.L.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	14.20	06
12.006	GH305.2525.150.00.06.L.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	19.20	06
12.026	GH305.1000.600.00.06.L.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	19.60	06
12.018	GH305.1212.125.00.08.L.IK	5.00	12.00		125.00	12.00	21.00	30.00	30.00	4.20	08
12.035	GH305.0500.500.00.08.L.IK	5.00		1/2	127.00	12.70	21.70	30.48	30.48		08
12.027	GH305.0625.500.00.08.L.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	8.07	08
12.007	GH305.1616.125.00.08.L.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	8.20	08
12.028	GH305.0750.500.00.08.L.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	11.25	08
12.008	GH305.2020.125.00.08.L.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	12.20	08
12.009	GH305.2525.150.00.08.L.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	17.20	08
12.029	GH305.1000.600.00.08.L.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	17.60	08
12.020	GH305.1212.125.00.12.L.IK	5.00	12.00		125.00	12.00	25.00	30.00	30.00	0.20	12
12.036	GH305.0500.500.00.12.L.IK	5.00		1/2	127.00	12.70	21.70	30.48	30.48		12
12.030	GH305.0625.500.00.12.L.IK	5.00		5/8	127.00	15.87	24.87	30.48	30.48	4.07	12
12.010	GH305.1616.125.00.12.L.IK	5.00	16.00		125.00	16.00	25.00	30.00	30.00	4.20	12
12.031	GH305.0750.500.00.12.L.IK	5.00		3/4	127.00	19.05	24.05	30.48	30.48	7.25	12
12.011	GH305.2020.125.00.12.L.IK	5.00	20.00		125.00	20.00	25.00	30.00	30.00	8.20	12
12.012	GH305.2525.150.00.12.L.IK	5.00	25.00		150.00	25.00	30.00	30.00	30.00	13.20	12
12.032	GH305.1000.600.00.12.L.IK	5.00		1"	152.40	25.40	30.40	30.48	30.48	13.60	12

System 305

Spare parts

Series no.	Clamping screw	Tightening torque	Size	Description
25901		Nm		
Code 4.002	M4x11x15IP	3 - 3.5	04 - 06	GH305.1010.125....; GH305.1212.125...
Code 4.000	M4x15x15IP	3 - 3.5	04 - 06	GH305.0625.500....; GH305.0750.500...
Code 4.000	M4x15x15IP	3 - 3.5	04 - 06	GH305.1616.125....; GH305.1000.600...
Code 4.000	M4x15x15IP	3 - 3.5	04 - 06	GH305.2020.125....; GH305.2525.150...
Code 4.000	M4x15x15IP	3 - 3.5	08	GH305....
Code 4.003	M4x17x15IP	3 - 3.5	12	GH305....

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



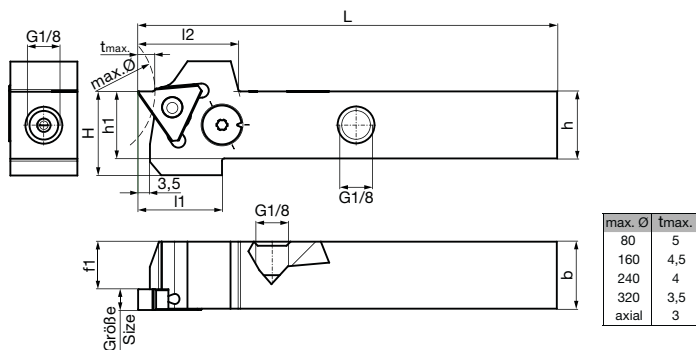
Square shank holder straight, external machining, IC adjustable

Series no. **25372**

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

Type **GH 305**

for indexable inserts type 305 see from page 200



Right hand version shown
Left hand version mirror image

version right-hand

System 305

Code no.	Description	t max	h = b	h = b	L	h1	H	l1	l2	f1	Size
		mm	mm	inch							
12.021	GH305.0625.500.00.04.R.IK.EST	5.00		5/8	127.00	15.87	24.87	30.48	30.48	12.07	04
12.001	GH305.1616.125.00.04.R.IK.EST	5.00	16.00		125.00	16.00	25.00	30.00	30.00	12.20	04
12.022	GH305.0750.500.00.04.R.IK.EST	5.00		3/4	127.00	19.05	24.05	30.48	30.48	15.24	04
12.002	GH305.2020.125.00.04.R.IK.EST	5.00	20.00		125.00	20.00	25.00	30.00	30.00	16.20	04
12.003	GH305.2525.150.00.04.R.IK.EST	5.00	25.00		150.00	25.00	30.00	30.00	30.00	21.20	04
12.023	GH305.1000.600.00.04.R.IK.EST	5.00		1"	152.40	25.40	30.40	30.48	30.48	21.59	04
12.024	GH305.0625.500.00.06.R.IK.EST	5.00		5/8	127.00	15.87	24.87	30.48	30.48	10.08	06
12.004	GH305.1616.125.00.06.R.IK.EST	5.00	16.00		125.00	16.00	25.00	30.00	30.00	10.20	06
12.025	GH305.0750.500.00.06.R.IK.EST	5.00		3/4	127.00	19.05	24.05	30.48	30.48	13.26	06
12.005	GH305.2020.125.00.06.R.IK.EST	5.00	20.00		125.00	20.00	25.00	30.00	30.00	14.20	06
12.006	GH305.2525.150.00.06.R.IK.EST	5.00	25.00		150.00	25.00	30.00	30.00	30.00	19.20	06
12.026	GH305.1000.600.00.06.R.IK.EST	5.00		1"	152.40	25.40	30.40	30.48	30.48	19.61	06

Series no. **25373**

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	
12.021	GH305.0625.500.00.04.L.IK.EST	5.00		5/8	127.00	15.87	24.87	30.48	30.48	12.07	04
12.001	GH305.1616.125.00.04.L.IK.EST	5.00	16.00		125.00	16.00	25.00	30.00	30.00	12.20	04
12.022	GH305.0750.500.00.04.L.IK.EST	5.00		3/4	127.00	19.05	24.05	30.48	30.48	15.24	04
12.002	GH305.2020.125.00.04.L.IK.EST	5.00	20.00		125.00	20.00	25.00	30.00	30.00	16.20	04
12.003	GH305.2525.150.00.04.L.IK.EST	5.00	25.00		150.00	25.00	30.00	30.00	30.00	21.20	04
12.023	GH305.1000.600.00.04.L.IK.EST	5.00		1"	152.40	25.40	30.40	30.48	30.48	21.59	04
12.024	GH305.0625.500.00.06.L.IK.EST	5.00		5/8	127.00	15.87	24.87	30.48	30.48	10.08	06
12.004	GH305.1616.125.00.06.L.IK.EST	5.00	16.00		125.00	16.00	25.00	30.00	30.00	10.20	06
12.025	GH305.0750.500.00.06.L.IK.EST	5.00		3/4	127.00	19.05	24.05	30.48	30.48	13.26	06
12.005	GH305.2020.125.00.06.L.IK.EST	5.00	20.00		125.00	20.00	25.00	30.00	30.00	14.20	06
12.006	GH305.2525.150.00.06.L.IK.EST	5.00	25.00		150.00	25.00	30.00	30.00	30.00	19.20	06
12.026	GH305.1000.600.00.06.L.IK.EST	5.00		1"	152.40	25.40	30.40	30.48	30.48	19.61	06

Spare parts

Series no.	Clamping screw	Tightening torque	Size	Description
25901		Nm		
Code 4.002	M4x11x15IP	3 - 3.5	04 - 06	GH305.1010.125....; GH305.1212.125...
Code 4.000	M4x15x15IP	3 - 3.5	04 - 06	GH305.0625.500....; GH305.0750.500...
Code 4.000	M4x15x15IP	3 - 3.5	04 - 06	GH305.1616.125....; GH305.1000.600...
Code 4.000	M4x15x15IP	3 - 3.5	04 - 06	GH305.2020.125....; GH305.2525.150...
Code 4.000	M4x15x15IP	3 - 3.5	08	GH305....
Code 4.003	M4x17x15IP	3 - 3.5	12	GH305....

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



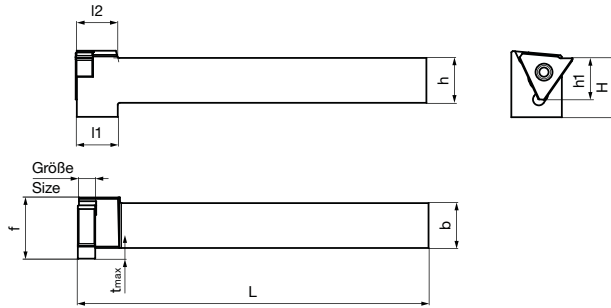
Square shank holder 90° offset, external machining, without IC

Series no. 25356

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

Type GH 305

for indexable inserts type 305 see from page 200



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	t max	h=b	h=b	L	h1	H	l1	l2	f	Size
		mm	mm	inch							
12.013	GH305.1010.125.90.04.R	3.50	10.00		125.00	10.00	19.00	14.60	14.60	13.80	04
12.014	GH305.1212.125.90.04.R	3.50	12.00		125.00	12.00	21.00	14.60	14.60	15.80	04
12.033	GH305.0500.500.90.04.R	3.50		1/2	127.00	12.70	21.70	14.84	14.84	16.50	04
12.021	GH305.0625.500.90.04.R	3.50		5/8	127.00	15.87	20.87	14.84	14.84	19.67	04
12.001	GH305.1616.125.90.04.R	3.50	16.00		125.00	16.00	21.00	14.60	14.60	19.80	04
12.022	GH305.0750.500.90.04.R	3.50		3/4	127.00	19.05	24.05	14.84	14.84	22.85	04
12.002	GH305.2020.125.90.04.R	3.50	20.00		125.00	20.00	25.00	14.60	14.60	23.80	04
12.003	GH305.2525.150.90.04.R	3.50	25.00		150.00	25.00	30.00	14.60	14.60	28.80	04
12.023	GH305.1000.600.90.04.R	3.50		1"	152.40	25.40	30.40	14.84	14.84	29.20	04
12.015	GH305.1010.125.90.06.R	3.50	10.00		125.00	10.00	19.00	14.60	14.60	13.80	06
12.016	GH305.1212.125.90.06.R	3.50	12.00		125.00	12.00	21.00	14.60	14.60	15.80	06
12.034	GH305.0500.500.90.06.R	3.50		1/2	127.00	12.70	21.70	14.84	14.84	16.50	06
12.024	GH305.0625.500.90.06.R	3.50		5/8	127.00	15.87	20.87	14.84	14.84	19.67	06
12.004	GH305.1616.125.90.06.R	3.50	16.00		125.00	16.00	21.00	14.60	14.60	19.80	06
12.025	GH305.0750.500.90.06.R	3.50		3/4	127.00	19.05	24.05	14.84	14.84	22.85	06
12.005	GH305.2020.125.90.06.R	3.50	20.00		125.00	20.00	25.00	14.60	14.60	23.80	06
12.006	GH305.2525.150.90.06.R	3.50	25.00		150.00	25.00	30.00	14.60	14.60	28.80	06
12.026	GH305.1000.600.90.06.R	3.50		1"	152.40	25.40	30.40	14.84	14.84	29.20	06
12.017	GH305.1010.125.90.08.R	3.50	10.00		125.00	10.00	19.00	16.60	16.60	13.80	08
12.018	GH305.1212.125.90.08.R	3.50	12.00		125.00	12.00	21.00	16.60	16.60	15.80	08
12.035	GH305.0500.500.90.08.R	3.50		1/2	127.00	12.70	21.70	16.84	16.84	16.50	08
12.027	GH305.0625.500.90.08.R	3.50		5/8	127.00	15.87	20.87	16.84	16.84	19.67	08
12.007	GH305.1616.125.90.08.R	3.50	16.00		125.00	16.00	21.00	16.60	16.60	19.80	08
12.028	GH305.0750.500.90.08.R	3.50		3/4	127.00	19.05	24.05	16.84	16.84	22.85	08
12.008	GH305.2020.125.90.08.R	3.50	20.00		125.00	20.00	25.00	16.60	16.60	23.80	08
12.009	GH305.2525.150.90.08.R	3.50	25.00		150.00	25.00	30.00	16.60	16.60	28.80	08
12.029	GH305.1000.600.90.08.R	3.50		1"	152.40	25.40	30.40	16.84	16.84	29.20	08
12.019	GH305.1010.125.90.12.R	3.50	10.00		125.00	10.00	19.00	16.60	20.60	13.80	12
12.020	GH305.1212.125.90.12.R	3.50	12.00		125.00	12.00	21.00	20.60	20.60	15.80	12
12.036	GH305.0500.500.90.12.R	3.50		1/2	127.00	12.70	21.70	20.84	20.84	16.50	12
12.030	GH305.0625.500.90.12.R	3.50		5/8	127.00	15.87	20.87	20.84	20.84	19.67	12
12.010	GH305.1616.125.90.12.R	3.50	16.00		125.00	16.00	21.00	20.60	20.60	19.80	12
12.031	GH305.0750.500.90.12.R	3.50		3/4	127.00	19.05	24.05	20.84	20.84	22.85	12
12.011	GH305.2020.125.90.12.R	3.50	20.00		125.00	20.00	25.00	20.60	20.60	23.80	12
12.012	GH305.2525.150.90.12.R	3.50	25.00		150.00	25.00	30.00	20.60	20.60	28.80	12
12.032	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	
12.013	GH305.1010.125.90.04.L	3.50	10.00		125.00	10.00	19.00	14.60	14.60	13.80	04
12.014	GH305.1212.125.90.04.L	3.50	12.00		125.00	12.00	21.00	14.60	14.60	15.80	04
12.033	GH305.0500.500.90.04.L	3.50		1/2	127.00	12.70	21.70	14.84	14.84	16.50	04
12.021	GH305.0625.500.90.04.L	3.50		5/8	127.00	15.87	20.87	14.84	14.84	19.67	04
12.001	GH305.1616.125.90.04.L	3.50	16.00		125.00	16.00	21.00	14.60	14.60	19.80	04
12.022	GH305.0750.500.90.04.L	3.50		3/4	127.00	19.05	24.05	14.84	14.84	22.85	04
12.002	GH305.2020.125.90.04.L	3.50	20.00		125.00	20.00	25.00	14.60	14.60	23.80	04
12.003	GH305.2525.150.90.04.L	3.50	25.00		150.00	25.00	30.00	14.60	14.60	28.80	04
12.023	GH305.1000.600.90.04.L	3.50		1"	152.40	25.40	30.40	14.84	14.84	29.20	04
12.015	GH305.1010.125.90.06.L	3.50	10.00		125.00	10.00	19.00	14.60	14.60	13.80	06
12.016	GH305.1212.125.90.06.L	3.50	12.00		125.00	12.00	21.00	14.60	14.60	15.80	06
12.034	GH305.0500.500.90.06.L	3.50		1/2	127.00	12.70	21.70	14.84	14.84	16.50	06
12.024	GH305.0625.500.90.06.L	3.50		5/8	127.00	15.87	20.87	14.84	14.84	19.67	06
12.004	GH305.1616.125.90.06.L	3.50	16.00		125.00	16.00	21.00	14.60	14.60	19.80	06
12.025	GH305.0750.500.90.06.L	3.50		3/4	127.00	19.05	24.05	14.84	14.84	22.85	06
12.005	GH305.2020.125.90.06.L	3.50	20.00		125.00	20.00	25.00	14.60	14.60	23.80	06
12.006	GH305.2525.150.90.06.L	3.50	25.00		150.00	25.00	30.00	14.60	14.60	28.80	06
12.026	GH305.1000.600.90.06.L	3.50		1"	152.40	25.40	30.40	14.84	14.84	29.20	06
12.017	GH305.1010.125.90.08.L	3.50	10.00		125.00	10.00	19.00	16.60	16.60	13.80	08
12.018	GH305.1212.125.90.08.L	3.50	12.00		125.00	12.00	21.00	16.60	16.60	15.80	08
12.035	GH305.0500.600.90.08.L	3.50		1/2	127.00	12.70	21.70	16.84	16.84	16.50	08
12.027	GH305.0625.500.90.08.L	3.50		5/8	127.00	15.87	20.87	16.84	16.84	19.67	08
12.007	GH305.1616.125.90.08.L	3.50	16.00		125.00	16.00	21.00	16.60	16.60	19.80	08
12.028	GH305.0750.500.90.08.L	3.50		3/4	127.00	19.05	24.05	16.84	16.84	22.85	08
12.008	GH305.2020.125.90.08.L	3.50	20.00		125.00	20.00	25.00	16.60	16.60	23.80	08
12.009	GH305.2525.150.90.08.L	3.50	25.00		150.00	25.00	30.00	16.60	16.60	28.80	08
12.029	GH305.1000.600.90.08.L	3.50		1"	152.40	25.40	30.40	16.84	16.84	29.20	08
12.019	GH305.1010.125.90.12.L	3.50	10.00		125.00	10.00	19.00	16.60	20.60	13.80	12
12.020	GH305.1212.125.90.12.L	3.50	12.00		125.00	12.00	21.00	16.60	20.60	15.80	12
12.036	GH305.0500.500.90.12.L	3.50		1/2	127.00	12.70	21.70	20.84	20.84	16.50	12
12.030	GH305.0625.500.90.12.L	3.50		5/8	127.00	15.87	20.87	20.84	20.84	19.67	12
12.010	GH305.1616.125.90.12.L	3.50	16.00		125.00	16.00	21.00	20.60	20.60	19.80	12
12.031	GH305.0750.500.90.12.L	3.50		3/4	127.00	19.05	24.05	20.84	20.84	22.85	12
12.011	GH305.2020.125.90.12.L	3.50	20.00		125.00	20.00	25.00	20.60	20.60	23.80	12
12.012	GH305.2525.150.90.12.L	3.50	25.00		150.00	25.00	30.00	20.60	20.60	28.80	12
12.032	GH305.1000.600.90.12.L	3.50		1"	152.40	25.40	30.40	20.84	20.84	29.20	12

System 305

Spare parts

Series no.	Clamping screw	Tightening torque	Size
25901		Nm	
Code 4.000	M4x15x15IP	4-4.5	04 - 08
Code 4.003	M4x17x15IP	4-4.5	12

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



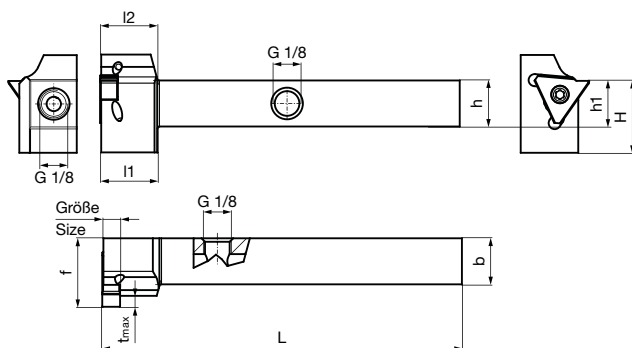
Square shank holder 90° offset, external machining, with IC

Series no. **25358**

- 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 200



Right hand version shown
Left hand version mirror image



version right-hand

Code no.	Description	t max	h=b	h=b	L	h1	H	l1	l2	f	Size
		mm	mm	inch							
12.014	GH305.1212.125.90.04.R.IK	3.50	12.00		125.00	12.00	21.00	21.60	21.60	23.80	04
12.033	GH305.0500.500.90.04.R.IK	3.50		1/2	127.00	12.70	21.70	19.92	19.92	22.70	04
12.021	GH305.0625.500.90.04.R.IK	3.50		5/8	127.00	15.87	24.87	19.92	19.92	24.12	04
12.001	GH305.1616.125.90.04.R.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	04
12.022	GH305.0750.500.90.04.R.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	04
12.002	GH305.2020.125.90.04.R.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	04
12.003	GH305.2525.150.90.04.R.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	04
12.023	GH305.1000.600.90.04.R.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	04
12.016	GH305.1212.125.90.06.R.IK	3.50	12.00		125.00	12.00	21.00	21.60	21.60	23.80	06
12.034	GH305.0500.500.90.06.R.IK	3.50		1/2	127.00	12.70	21.70	19.92	19.92	22.70	06
12.024	GH305.0625.500.90.06.R.IK	3.50		5/8	127.00	15.87	24.87	19.92	19.92	24.12	06
12.004	GH305.1616.125.90.06.R.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	06
12.025	GH305.0750.500.90.06.R.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	06
12.005	GH305.2020.125.90.06.R.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	06
12.006	GH305.2525.150.90.06.R.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	06
12.026	GH305.1000.600.90.06.R.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	06
12.018	GH305.1212.125.90.08.R.IK	3.50	12.00		125.00	12.00	21.00	23.60	23.60	23.80	08
12.035	GH305.0500.500.90.08.R.IK	3.50		1/2	127.00	12.70	21.70	19.92	21.92	22.70	08
12.027	GH305.0625.500.90.08.R.IK	3.50		5/8	127.00	15.87	24.87	21.92	21.92	24.12	08
12.007	GH305.1616.125.90.08.R.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	08
12.028	GH305.0750.500.90.08.R.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	08
12.008	GH305.2020.125.90.08.R.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	08
12.009	GH305.2525.150.90.08.R.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	08
12.029	GH305.1000.600.90.08.R.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	08
12.020	GH305.1212.125.90.12.R.IK	3.50	12.00		125.00	12.00	21.00	27.60	27.60	23.80	12
12.036	GH305.0500.500.90.12.R.IK	3.50		1/2	127.00	12.70	21.70	19.92	25.92	22.70	12
12.030	GH305.0625.500.90.12.R.IK	3.50		5/8	127.00	15.87	24.87	25.92	25.92	24.12	12
12.010	GH305.1616.125.90.12.R.IK	3.50	16.00		125.00	16.00	25.00	27.60	27.60	23.80	12
12.031	GH305.0750.500.90.12.R.IK	3.50		3/4	127.00	19.05	24.05	25.92	25.92	24.12	12
12.011	GH305.2020.125.90.12.R.IK	3.50	20.00		125.00	20.00	25.00	27.60	27.60	23.80	12
12.012	GH305.2525.150.90.12.R.IK	3.50	25.00		150.00	25.00	30.00	27.60	27.60	28.80	12
12.032	GH305.1000.600.90.12.R.IK	3.50		1"	152.40	25.40	30.40	25.92	25.92	29.20	12

System 305

Series no. **25359**

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	
12.014	GH305.1212.125.90.04.L.IK	3.50	12.00		125.00	12.00	21.00	21.60	21.60	23.80	04
12.033	GH305.0500.500.90.04.L.IK	3.50		1/2	127.00	12.70	21.70	19.92	19.92	22.70	04
12.021	GH305.0625.500.90.04.L.IK	3.50		5/8	127.00	15.87	24.87	19.92	19.92	24.12	04
12.001	GH305.1616.125.90.04.L.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	04
12.022	GH305.0750.500.90.04.L.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	04
12.002	GH305.2020.125.90.04.L.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	04
12.003	GH305.2525.150.90.04.L.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	04
12.023	GH305.1000.600.90.04.L.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	04
12.016	GH305.1212.125.90.06.L.IK	3.50	12.00		125.00	12.00	21.00	21.60	21.60	23.80	06
12.034	GH305.0500.500.90.06.L.IK	3.50		1/2	127.00	12.70	21.70	19.92	19.92	22.70	06
12.024	GH305.0625.500.90.06.L.IK	3.50		5/8	127.00	15.87	24.87	19.92	19.92	24.12	06
12.004	GH305.1616.125.90.06.L.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	06
12.025	GH305.0750.500.90.06.L.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	06
12.005	GH305.2020.125.90.06.L.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	06
12.006	GH305.2525.150.90.06.L.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	06
12.026	GH305.1000.600.90.06.L.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	06
12.018	GH305.1212.125.90.08.L.IK	3.50	12.00		125.00	12.00	21.00	23.60	23.60	23.80	08
12.035	GH305.0500.500.90.08.L.IK	3.50		1/2	127.00	12.70	21.70	19.92	21.92	22.70	08
12.027	GH305.0625.500.90.08.L.IK	3.50		5/8	127.00	15.87	24.87	21.92	21.92	24.12	08
12.007	GH305.1616.125.90.08.L.IK	3.50	16.00		125.00	16.00	25.00	19.60	19.60	23.80	08
12.028	GH305.0750.500.90.08.L.IK	3.50		3/4	127.00	19.05	24.05	19.92	19.92	22.85	08
12.008	GH305.2020.125.90.08.L.IK	3.50	20.00		125.00	20.00	25.00	19.60	19.60	23.80	08
12.009	GH305.2525.150.90.08.L.IK	3.50	25.00		150.00	25.00	30.00	19.60	19.60	28.80	08
12.029	GH305.1000.600.90.08.L.IK	3.50		1"	152.40	25.40	30.40	19.92	19.92	29.20	08
12.020	GH305.1212.125.90.12.L.IK	3.50	12.00		125.00	12.00	21.00	27.60	27.60	23.80	12
12.036	GH305.0500.500.90.12.L.IK	3.50		1/2	127.00	12.70	21.70	19.92	25.92	22.70	12
12.030	GH305.0625.500.90.12.L.IK	3.50		5/8	127.00	15.87	24.87	25.92	25.92	24.12	12
12.010	GH305.1616.125.90.12.L.IK	3.50	16.00		125.00	16.00	25.00	27.60	27.60	23.80	12
12.031	GH305.0750.500.90.12.L.IK	3.50		3/4	127.00	19.05	24.05	25.92	25.92	24.12	12
12.011	GH305.2020.125.90.12.L.IK	3.50	20.00		125.00	20.00	25.00	27.60	27.60	23.80	12
12.012	GH305.2525.150.90.12.L.IK	3.50	25.00		150.00	25.00	30.00	27.60	27.60	28.80	12
12.032	GH305.1000.600.90.12.L.IK	3.50		1"	152.40	25.40	30.40	25.92	25.92	29.20	12

System 305

Spare parts

Series no.	Clamping screw	Tightening torque	Size
25901		Nm	
Code 4.000	M4x15x15IP	4-4.5	04 - 08
Code 4.003	M4x17x15IP	4-4.5	12

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



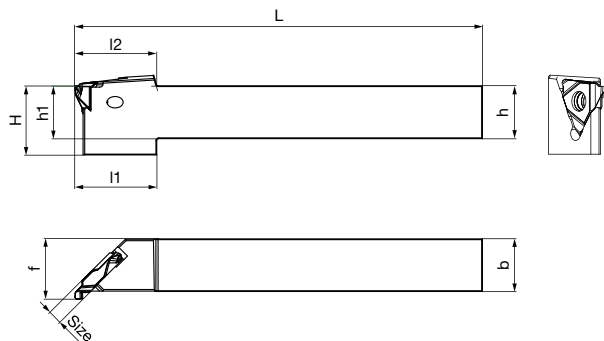
Square shank holder 45° offset, external machining, without IC

Series no. **25362**

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

Type **GH 305**

for indexable inserts type 305 see page 200



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	h=b	h=b	L	h1	H	l1	l2	f	Size
		mm	inch							
12.004	GH305.1010.125.45.04.R	10.00		125.00	10.00	21.00	25.66	25.66	12.56	04
12.005	GH305.1212.125.45.04.R	12.00		125.00	12.00	21.00	25.66	25.66	14.56	04
12.020	GH305.0500.500.45.04.R		1/2	127.00	12.70	21.70	25.40	25.40	15.10	04
12.021	GH305.0625.500.45.04.R		5/8	127.00	15.87	20.87	26.06	26.06	18.44	04
12.001	GH305.1616.125.45.04.R	16.00		125.00	16.00	21.00	25.66	25.66	18.56	04
12.022	GH305.0750.500.45.04.R		3/4	127.00	19.05	24.05	26.06	26.06	21.61	04
12.002	GH305.2020.125.45.04.R	20.00		125.00	20.00	25.00	25.66	25.66	22.56	04
12.003	GH305.2525.150.45.04.R	25.00		150.00	25.00	30.00	30.66	30.66	27.56	04
12.023	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							
12.004	GH305.1010.125.45.04.L	10.00		125.00	10.00	21.00	25.66	25.66	12.56	04
12.005	GH305.1212.125.45.04.L	12.00		125.00	12.00	21.00	25.66	25.66	14.56	04
12.020	GH305.0500.500.45.04.L		1/2	127.00	12.70	21.70	25.40	25.40	15.10	04
12.021	GH305.0625.500.45.04.L		5/8	127.00	15.87	20.87	26.06	26.06	18.44	04
12.001	GH305.1616.125.45.04.L	16.00		125.00	16.00	21.00	25.66	25.66	18.56	04
12.022	GH305.0750.500.45.04.L		3/4	127.00	19.05	24.05	26.06	26.06	21.61	04
12.002	GH305.2020.125.45.04.L	20.00		125.00	20.00	25.00	25.66	25.66	22.56	04
12.003	GH305.2525.150.45.04.L	25.00		150.00	25.00	30.00	30.66	30.66	27.56	04
12.023	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 4.001	M4x0.5x7x15IP	3-3.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

System 305



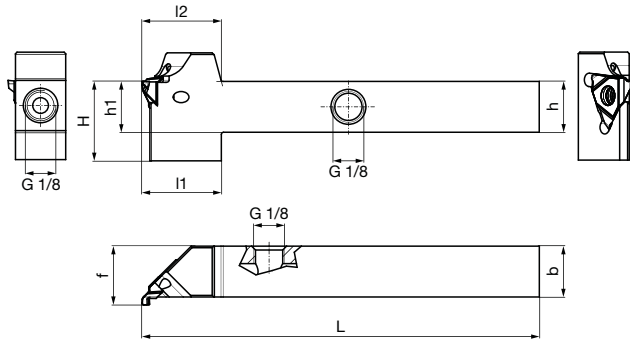
Square shank holder 45° offset, external machining, with IC

Series no. **25364**

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

Type **GH 305**

for indexable inserts type 305 see page 200



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	h=b mm	h=b inch	L mm	h1 mm	H mm	l1 mm	l2 mm	f mm	Size
12.005	GH305.1212.125.45.04.R.IK	12.00		125.00	12.00	25.00	25.66	25.66	14.56	04
12.020	GH305.0500.500.45.04.R.IK		1/2	127.00	12.70	21.70	25.65	25.40	15.10	04
12.021	GH305.0625.500.45.04.R.IK		5/8	127.00	15.87	24.87	26.06	26.06	18.44	04
12.001	GH305.1616.125.45.04.R.IK	16.00		125.00	16.00	25.00	25.66	25.66	18.56	04
12.022	GH305.0750.500.45.04.R.IK		3/4	127.00	19.05	24.05	26.06	26.06	21.61	04
12.002	GH305.2020.125.45.04.R.IK	20.00		125.00	20.00	25.00	25.66	25.66	22.56	04
12.003	GH305.2525.150.45.04.R.IK	25.00		150.00	25.00	30.00	30.66	30.66	27.56	04
12.023	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 mm	h=b inch	L mm	h1 mm	H mm	l1 mm	l2 mm	f mm	Size
12.005	GH305.1212.125.45.04.L.IK	12.00		125.00	12.00	25.00	25.66	25.66	14.56	04
12.020	GH305.0500.500.45.04.L.IK		1/2	127.00	12.70	21.70	25.65	25.40	15.10	04
12.021	GH305.0625.500.45.04.L.IK		5/8	127.00	15.87	24.87	26.06	26.06	18.44	04
12.001	GH305.1616.125.45.04.L.IK	16.00		125.00	16.00	25.00	25.66	25.66	18.56	04
12.022	GH305.0750.500.45.04.L.IK		3/4	127.00	19.05	24.05	26.06	26.06	21.61	04
12.002	GH305.2020.125.45.04.L.IK	20.00		125.00	20.00	25.00	25.66	25.66	22.56	04
12.003	GH305.2525.150.45.04.L.IK	25.00		150.00	25.00	30.00	30.66	30.66	27.56	04
12.023	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 4.001	M4x0.5x7x15IP	3-3.5

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

System 305



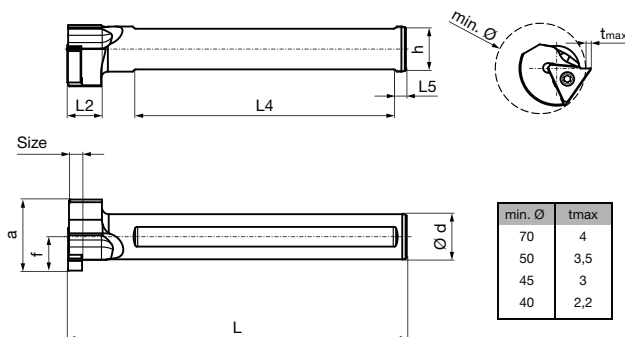
Round shank holder, internal machining, without IC

Series no. 25368

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

Type GB 305

for indexable inserts type 305 see from page 200



Right hand version shown
Left hand version mirror image

version right-hand

Code no.	Description	d		L	L2	L4	L5	h	f	a	Size
		mm	inch								
12.021	GB305.0750.600.90.04.R		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	04
12.001	GB305.0020.150.90.04.R	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	04
12.002	GB305.0025.170.90.04.R	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	04
12.022	GB305.1000.670.90.04.R		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	04
12.023	GB305.1250.800.90.04.R		1-1/4	205.20	14.60	162.56	5.08	29.74	21.08	39.37	04
12.003	GB305.0032.200.90.04.R	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	04
12.024	GB305.0750.600.90.06.R		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	06
12.004	GB305.0020.150.90.06.R	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	06
12.005	GB305.0025.170.90.06.R	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	06
12.025	GB305.1000.670.90.06.R		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	06
12.026	GB305.1250.800.90.06.R		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	06
12.006	GB305.0032.200.90.06.R	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	06
12.027	GB305.0750.600.90.08.R		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	08
12.007	GB305.0020.150.90.08.R	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	08
12.008	GB305.0025.170.90.08.R	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	08
12.028	GB305.1000.670.90.08.R		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	08
12.029	GB305.1250.800.90.08.R		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	08
12.009	GB305.0032.200.90.08.R	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	08
12.030	GB305.0750.600.90.12.R		3/4	152.40	19.60	116.84	5.08	17.04	14.48	30.48	12
12.010	GB305.0020.150.90.12.R	20.00		150.00	19.60	115.00	5.00	18.00	15.00	31.50	12
12.011	GB305.0025.170.90.12.R	25.00		170.00	19.60	130.00	5.00	23.00	17.50	34.50	12
12.031	GB305.1000.670.90.12.R		1"	170.18	19.60	129.54	5.08	23.39	17.78	34.54	12
12.032	GB305.1250.800.90.12.R		1-1/4	203.20	19.60	162.56	5.08	29.74	21.08	39.37	12
12.012	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	
12.021	GB305.0750.600.90.04.L		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	04
12.001	GB305.0020.150.90.04.L	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	04
12.002	GB305.0025.170.90.04.L	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	04
12.022	GB305.1000.670.90.04.L		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	04
12.023	GB305.1250.800.90.04.L		1-1/4	205.20	14.60	162.56	5.08	29.74	21.08	39.37	04
12.003	GB305.0032.200.90.04.L	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	04
12.024	GB305.0750.600.90.06.L		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	06
12.004	GB305.0020.150.90.06.L	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	06
12.005	GB305.0025.170.90.06.L	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	06
12.025	GB305.1000.670.90.06.L		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	06
12.026	GB305.1250.800.90.06.L		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	06
12.006	GB305.0032.200.90.06.L	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	06
12.027	GB305.0750.600.90.08.L		3/4	152.40	14.60	116.84	5.08	17.04	14.48	30.48	08
12.007	GB305.0020.150.90.08.L	20.00		150.00	14.60	115.00	5.00	18.00	15.00	31.50	08
12.008	GB305.0025.170.90.08.L	25.00		170.00	14.60	130.00	5.00	23.00	17.50	34.50	08
12.028	GB305.1000.670.90.08.L		1"	170.18	14.60	129.54	5.08	23.39	17.78	34.54	08
12.029	GB305.1250.800.90.08.L		1-1/4	203.20	14.60	162.56	5.08	29.74	21.08	39.37	08
12.009	GB305.0032.200.90.08.L	32.00		200.00	14.60	160.00	5.00	30.00	21.00	39.25	08
12.030	GB305.0750.600.90.12.L		3/4	152.40	19.60	116.84	5.08	17.04	14.48	30.48	12
12.010	GB305.0020.150.90.12.L	20.00		150.00	19.60	115.00	5.00	18.00	15.00	31.50	12
12.011	GB305.0025.170.90.12.L	25.00		170.00	19.60	130.00	5.00	23.00	17.50	34.50	12
12.031	GB305.1000.670.90.12.L		1"	170.18	19.60	129.54	5.08	23.39	17.78	34.54	12
12.032	GB305.1250.800.90.12.L		1-1/4	203.20	19.60	162.56	5.08	29.74	21.08	39.37	12
12.012	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	Size
25901		Nm	
Code 4.000	M4x15x15IP	4-4.5	04 - 08
Code 4.003	M4x17x15IP	4-4.5	12

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



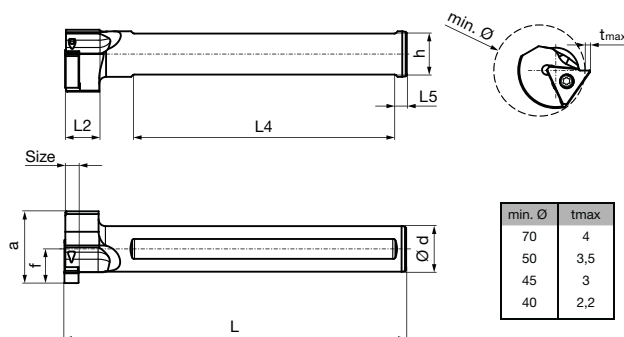
Round shank holder, internal machining, with IC

Series no. 25370

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

Type GB 305

for indexable inserts type 305 see from page 200



Right hand version shown
Left hand version mirror image

version right-hand

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

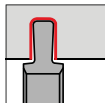
Series no.	Clamping screw	Tightening torque	Size
25901		Nm	
Code 4.000	M4x15x15IP	4-4.5	04 - 08
Code 4.003	M4x17x15IP	4-4.5	12

Series no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



Indexable insert for radial grooving external and internal

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

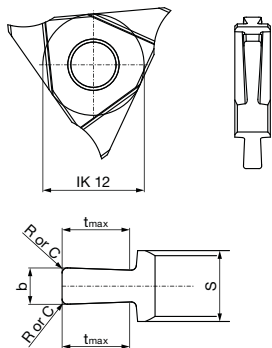


- Snap ring grooves to DIN471/472, NW = 0.5-5.15
- Indexable insert applicable in right and left holders
- Geometry .BA ground
- Pay attention to insert seat size 04 / 06

for tool holders type GH305/GB305 see from page 184

Tool material	Solid carbide		
Type	GE 305	GE 305	GE 305
Coating	F	C	○
	FIREX	TiCN	uncoated

Cutting data page 215

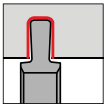


Code no.	Description	NW	b ± 0.02	R	C	t max	s	Size
		mm	mm	mm	mm	mm	mm	
12.001	GE305.0050.000.BA.04.N	0.50	0.55			1.50	4.20	04
12.002	GE305.0060.000.BA.04.N	0.60	0.65			1.50	4.20	04
12.003	GE305.0070.000.BA.04.N	0.70	0.75			1.50	4.20	04
12.004	GE305.0080.000.BA.04.N	0.80	0.85			1.50	4.20	04
12.005	GE305.0090.000.BA.04.N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

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



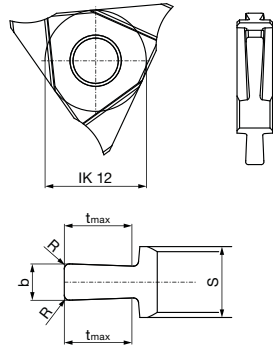
- grooving depth up to 5 mm
- Indexable insert applicable in right and left holders
- Geometry .BA ground

for tool holders type GH305/GB305 size 04 see from page 184

Tool material **Solid carbide**

Type	GE 305	GE 305	GE 305
Coating	F	C	○
	FIREX	TiCN	uncoated

Cutting data page 215

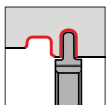


Code no.	Description	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	
12.001	GE305.0100.010.BA.04.N	1.00	0.10	3.00	4.20	04
12.002	GE305.0150.020.BA.04.N	1.50	0.20	3.00	4.20	04
12.003	GE305.0200.020.BA.04.N	2.00	0.20	4.00	4.20	04
12.004	GE305.0250.030.BA.04.N	2.50	0.30	5.00	4.20	04
12.005	GE305.0300.030.BA.04.N	3.00	0.30	5.00	4.20	04
12.006	GE305.0350.030.BA.04.N	3.50	0.30	5.00	4.20	04
12.007	GE305.0400.020.BA.04.N	4.00	0.20	5.00	4.20	04
12.008	GE305.0400.040.BA.04.N	4.00	0.40	5.00	4.20	04
12.009	GE305.0200.015.BA.04.N	2.00	0.15	4.00	4.20	04
12.010	GE305.0250.030.BA.04.N	2.50	0.20	5.00	4.20	04
12.011	GE305.0300.015.BA.04.N	3.00	0.15	5.00	4.20	04
12.012	GE305.0300.020.BA.04.N	3.00	0.20	5.00	4.20	04



Indexable insert for radial grooving and copying external and internal

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



- 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 184

Tool material

Solid carbide

Type

GE 305

GE 305

GE 305

Coating

F

C

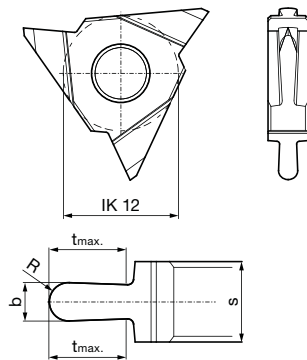
○

FIREX

TiCN

uncoated

Cutting data page 215

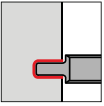


Code no.	Description	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	
12.001	GE305.0050.025.AA.04.N	0.50	0.25	1.50	4.20	04
12.002	GE305.0100.050.AA.04.N	1.00	0.50	3.00	4.20	04
12.003	GE305.0110.055.AA.04.N	1.10	0.55	3.00	4.20	04
12.004	GE305.0120.060.AA.04.N	1.20	0.60	3.00	4.20	04
12.005	GE305.0140.070.AA.04.N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



Indexable insert for axial grooving, straight slots

Series no. **25626** **25628** **25630**



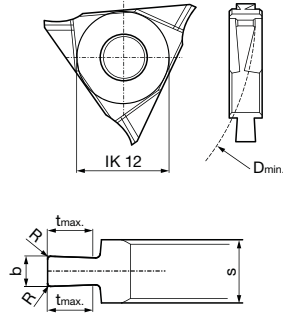
- grooving depth up to 3 mm
- right index. inserts in rh, left index. inserts in lh tool holders
- Geometry .BA ground

for tool holders type GH305 size 04 see from page 184

Tool material **Solid carbide**

Type	GA 305	GA 305	GA 305
Coating	F	C	○
	FIREX	TiCN	uncoated

Cutting data page 215



Right hand version shown
Left hand version mirror image

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

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

Series no. **25627** **25629** **25631**

Cutting direction **(L)** **(L)** **(L)**

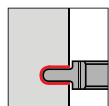
Code no.	Description	D min	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	mm	
12.001	GA305.0150.020.BA.04.L	15.00	1.50	0.20	2.00	4.20	04
12.002	GA305.0200.020.BA.04.L	30.00	2.00	0.20	3.00	4.20	04
12.003	GA305.0250.020.BA.04.L	30.00	2.50	0.20	3.00	4.20	04
12.004	GA305.0300.020.BA.04.L	30.00	3.00	0.20	3.00	4.20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

System 305



Indexable insert for axial grooving, full radius slots

Series no. **25634** **25636** **25638**

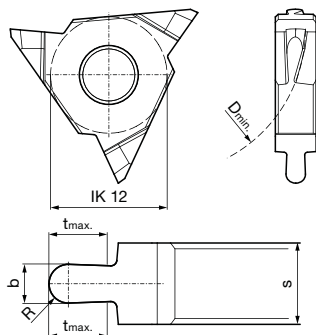


- grooving depth up to 3 mm
- right index. inserts in rh, left index. inserts in lh tool holders
- Geometry .AA ground

for tool holders type GH305 size 04 see from page 184

Tool material	Solid carbide		
Type	GA 305	GA 305	GA 305
Coating	F	C	○
	FIREX	TiCN	uncoated

Cutting data page 215



Right hand version shown
Left hand version mirror image

Cutting direction

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

Series no. **25635** **25637** **25639**

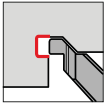
Cutting direction

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



Indexable insert for grooving axial external recesses

Series no. **25618** **25620** **25622**



- 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 194

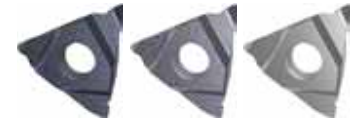
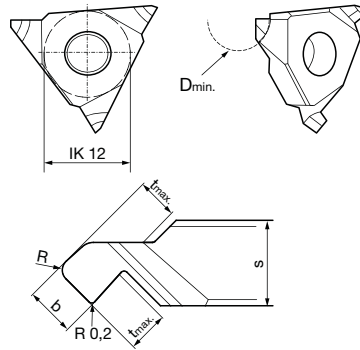
Tool material **Solid carbide**

Type GA 305 GA 305 GA 305

Coating **F** **C** ○

FIREX TiCN uncoated

Cutting data page 215



Right hand version shown
Left hand version mirror image

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

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

Series no. **25619** **25621** **25623**

Cutting direction **(L)** **(L)** **(L)**

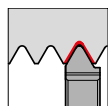
Code no.	Description	D min	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	mm	
12.001	GA305.0150.040.AA.04.L	8.00	1.50	0.40	1.60	4.20	04
12.002	GA305.0200.050.AA.04.L	12.00	2.00	0.50	1.90	4.20	04
12.003	GA305.0240.060.AA.04.L	20.00	2.40	0.60	2.00	4.20	04

System 305



Indexable insert for thread turning, metric partial profile

Series no. **25654** **25656** **25658**

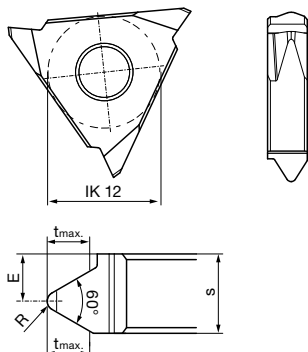


- thread depth up to 3.5 mm
- ground top rake
- Geometry .AA ground

for tool holders type GH305 size 04 see from page 184

Tool material	Solid carbide		
Type	GG 305	GG 305	GG 305
Coating	F	C	○
	FIREX	TiCN	uncoated

Cutting data page 215



Right hand version shown
Left hand version mirror image



Cutting direction

Code no.	Description	P	E	R	t max	s	Size
			mm	mm	mm	mm	
12.010	GG305.TM00.100.AA.04.R	1.00	3.60	0.14	0.70	4.20	04
12.020	GG305.TM00.125.AA.04.R	1.25	3.50	0.17	0.85	4.20	04
12.030	GG305.TM00.150.AA.04.R	1.50	3.40	0.21	1.00	4.20	04
12.040	GG305.TM00.175.AA.04.R	1.75	3.20	0.25	1.20	4.20	04
12.050	GG305.TM00.200.AA.04.R	2.00	3.10	0.28	1.35	4.20	04
12.060	GG305.TM00.250.AA.04.R	2.50	2.90	0.36	1.65	4.20	04
12.070	GG305.TM00.300.AA.04.R	3.00	2.60	0.43	2.60	4.20	04
12.080	GG305.TM00.600.AA.06.R	3.0-6.0	3.50	0.43	3.50	6.20	06
12.090	GG305.TM00.350.AA.04.R	3.50	2.50	0.50	2.50	4.20	04
12.100	GG305.TM00.050.AA.04.R	0.3-0.5	3.90	0.04	0.40	4.20	04
12.110	GG305.TM00.080.AA.04.R	0.5-0.8	3.80	0.07	0.60	4.20	04
12.120	GG305.TM00.099.AA.04.R	0.8-1.0	3.70	0.11	0.70	4.20	04

Series no. **25655** **25657** **25659**

Cutting direction

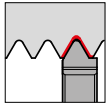
Code no.	Description	P	E	R	t max	s	Size
			mm	mm	mm	mm	
12.010	GG305.TM00.100.AA.04.L	1.00	3.60	0.14	0.70	4.20	04
12.020	GG305.TM00.125.AA.04.L	1.25	3.50	0.17	0.85	4.20	04
12.030	GG305.TM00.150.AA.04.L	1.50	3.40	0.21	1.00	4.20	04
12.040	GG305.TM00.175.AA.04.L	1.75	3.20	0.25	1.20	4.20	04
12.050	GG305.TM00.200.AA.04.L	2.00	3.10	0.28	1.35	4.20	04
12.060	GG305.TM00.250.AA.04.L	2.50	2.90	0.36	1.65	4.20	04
12.070	GG305.TM00.300.AA.04.L	3.00	2.60	0.43	2.60	4.20	04
12.080	GG305.TM00.600.AA.06.L	3.0-6.0	3.50	0.43	3.50	6.20	06
12.090	GG305.TM00.350.AA.04.L	3.50	2.50	0.50	2.50	4.20	04
12.100	GG305.TM00.050.AA.04.L	0.3-0.5	3.90	0.04	0.40	4.20	04
12.110	GG305.TM00.080.AA.04.L	0.5-0.8	3.80	0.07	0.60	4.20	04
12.120	GG305.TM00.099.AA.04.L	0.8-1.0	3.70	0.11	0.70	4.20	04

System 305



Indexable insert for thread turning, metric full profile

Series no. **25662** **25664** **25666**



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

for tool holders type GH305 size 04 see from page 184

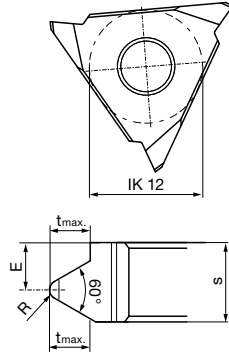
Tool material **Solid carbide**

Type GG 305 GG 305 GG 305

Coating **F** **C** ○

FIREX TiCN uncoated

Cutting data page 215



Right hand version shown
Left hand version mirror image

Cutting direction

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

Series no. **25663** **25665** **25667**

Cutting direction

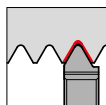
Code no.	Description	P	E	R	t max	s	Size
		mm	mm	mm	mm	mm	
12.010	GG305.VM00.100.AA.04.L	1.00	3.60	0.14	0.70	4.20	04
12.020	GG305.VM00.125.AA.04.L	1.25	3.40	0.17	1.00	4.20	04
12.030	GG305.VM00.150.AA.04.L	1.50	3.30	0.21	1.15	4.20	04
12.040	GG305.VM00.175.AA.04.L	1.75	3.20	0.25	1.30	4.20	04
12.050	GG305.VM00.200.AA.04.L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

System 305



Indexable insert for thread turning, UN partial profile

Series no. **25674** **25676** **25678**

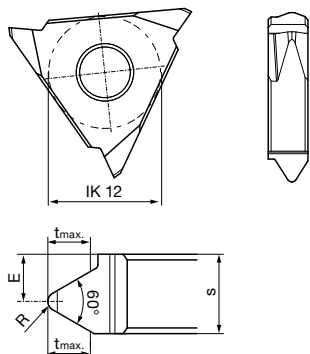


- thread depth up to 1.4 mm
- ground top rake
- Geometry .AA ground

for tool holders type GH305 size 04 see from page 184

Tool material	Solid carbide		
Type	GG 305	GG 305	GG 305
Coating			
	FIREX	TiCN	uncoated

Cutting data page 215



Right hand version shown
Left hand version mirror image



Cutting direction

Code no.	Description	TPI	E	R	t max	Size
			mm	mm	mm	
12.010	GG305.VU00.024.AA.04.R	24	3.60	0.12	0.80	04
12.020	GG305.VU00.020.AA.04.R	20	3.50	0.15	0.90	04
12.030	GG305.VU00.018.AA.04.R	18	3.40	0.17	1.00	04
12.040	GG305.VU00.016.AA.04.R	16	3.30	0.18	1.10	04
12.050	GG305.VU00.014.AA.04.R	14	3.30	0.22	1.20	04
12.060	GG305.VU00.012.AA.04.R	12	3.20	0.26	1.40	04

Series no. **25675** **25677** **25679**

Cutting direction

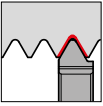
Code no.	Description	TPI	E	R	t max	Size
			mm	mm	mm	
12.010	GG305.VU00.024.AA.04.L	24	3.60	0.12	0.80	04
12.020	GG305.VU00.020.AA.04.L	20	3.50	0.15	0.90	04
12.030	GG305.VU00.018.AA.04.L	18	3.40	0.17	1.00	04
12.040	GG305.VU00.016.AA.04.L	16	3.30	0.18	1.10	04
12.050	GG305.VU00.014.AA.04.L	14	3.30	0.22	1.20	04
12.060	GG305.VU00.012.AA.04.L	12	3.20	0.26	1.40	04

System 305



Indexable insert for thread turning, Whitworth pipe threads, partial profile

Series no. **25668** **25670** **25672**

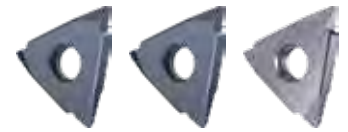
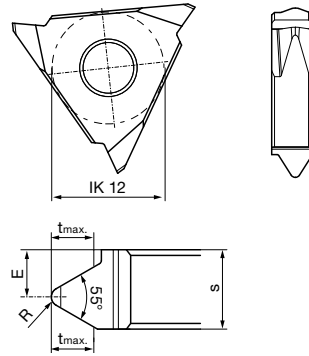


- thread depth up to 1.48 mm
- ground top rake
- Geometry .AA ground

for tool holders type GH305 size 04 see from page 184

Tool material	Solid carbide		
Type	GG 305	GG 305	GG 305
Coating	F	C	○
	FIREX	TiCN	uncoated

Cutting data page 215



Right hand version shown
Left hand version mirror image

Cutting direction

Code no.	Description	TPI	E	R	t max	Size
			mm	mm	mm	
12.010	GG305.VW00.028.AA.04.R	28	3.40	0.11	0.58	04
12.020	GG305.VW00.019.AA.04.R	19	3.30	0.17	0.86	04
12.030	GG305.VW00.014.AA.04.R	14	3.00	0.23	1.16	04
12.040	GG305.VW00.011.AA.04.R	11	2.70	0.30	1.48	04

Series no. **25669** **25671** **25673**

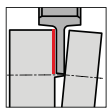
Cutting direction

Code no.	Description	TPI	E	R	t max	Size
			mm	mm	mm	
12.010	GG305.VW00.028.AA.04.L	28	3.40	0.11	0.58	04
12.020	GG305.VW00.019.AA.04.L	19	3.30	0.17	0.86	04
12.030	GG305.VW00.014.AA.04.L	14	3.00	0.23	1.16	04
12.040	GG305.VW00.011.AA.04.L	11	2.70	0.30	1.48	04

System 305



Indexable insert for parting off



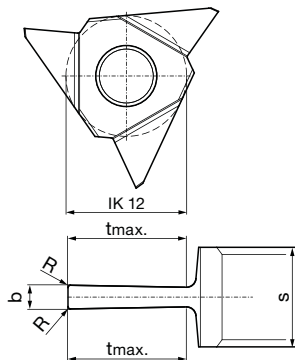
- grooving depth up to 5 mm
- Indexable insert applicable in right and left holders
- Geometry .AA ground
- without front cutting angle

for tool holders type GH305 size 04 see from page 184

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

Tool material	Solid carbide		
Type	GZ 305	GZ 305	GZ 305
Coating	F	C	○
	FIREX	TiCN	uncoated

Cutting data page 215

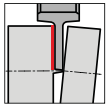


Code no.	Description	b ± 0.02	R	t max	s	Size
		mm	mm	mm	mm	
12.001	GZ305.0100.000.AA.04.N	1.00	0.10	5.00	4.20	04
12.002	GZ305.0150.000.AA.04.N	1.50	0.10	5.00	4.20	04



Indexable insert for parting off

Series no. **25646** **25648** **25650**



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

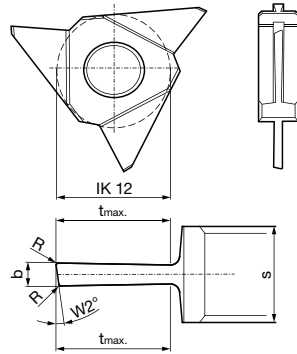
for tool holders type GH305 size 04 see from page 184

Tool material **Solid carbide**

Type GZ 305 GZ 305 GZ 305

Coating **F** **C** ○
 FIREX TiCN uncoated

Cutting data page 215



Right hand version shown
 Left hand version mirror image



version right-hand right-hand right-hand

Code no.	Description	b ± 0.02	R	W2	t max	s	Size
		mm	mm	°	mm	mm	
12.001	GZ305.0100.080.AA.04.R	1.00	0.10	8.00	5.00	4.20	04
12.002	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	
12.001	GZ305.0100.080.AA.04.L	1.00	0.10	8.00	5.00	4.20	04
12.002	GZ305.0150.080.AA.04.L	1.50	0.10	8.00	5.00	4.20	04

System 305

GUHRING

TOOL MANAGEMENT



FLEXIBLE
PROFESSIONAL
SUSTAINABLE



Tool Management
Powered by

GUHRING



TECHNICAL SECTION & ACCESSORIES



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 ²)	Brinell hardness (HB)	Cutting speed SFM (surface feet / min)						
						TiN	nano-A	uncoated				
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 X4CrNiMo16-5-1 / 1.4418	800 1000	240 300	65-230	100-295	-			
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							
Grey cast iron			low tensile strength	EN-GJL-200 (GG20) / 0.6020		180				100-490	100-590	100-295
K	Spheroidal graphite iron	high tensile strength	EN-GJL-400 (GG40) / 0.6040		260	100-395	100-490	100-230				
		low tensile strength	EN-GJS-400-15 (GGG40) / 0.7040		160	100-425	100-525	-				
	Malleable cast iron	high tensile strength	EN-GJS-700-2 (GGG70) / 0.7070		260	100-360	100-460	-				
		low tensile strength	EN-GJMW-350-4 (GTW35) / 0.8035		125	100-425	100-525	-				
N	Al-alloys	high tensile strength	EN-GJMB-550-4 (GTS55) / 0.8155		250	100-360	100-460	-				
		non-heat-treatable <12% Si	EN-AW-2017 (AlCuMg1) / 3.1325		60	100-1805	100-1805	100-820				
	Al-cast-alloys	heat-treatable <12% Si	EN-AW-6082 (AlMgSi1) / 3.2315		100	100-1310	100-1310	100-590				
		non-heat-treatable <12% Si	AlSi9Cu3 / 3.2163		80	100-1805	100-1805	100-820				
	Copper alloys	heat-treatable <12% Si	AlSi10Mg / 3.2383		100	100-1310	100-1310	100-590				
		brass, lead alloy	CuZn39Pb2 (MS58) / 2.0380	400	120	100-1310	100-1310	100-590				
	S	Heat resistant alloys, super alloys	bronze	CuSn6 / 2.1020	500	150	100-240	100-240	100-590			
			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	-				
Titanium-alloys		NiCo-base, hardened	NiCr19NbMo (Alloy718) / 2.4668	1200		-	30-115					
		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.

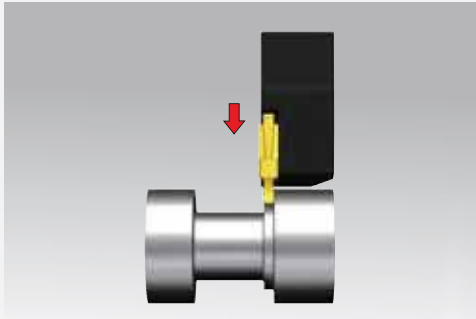
SYSTEM 305

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

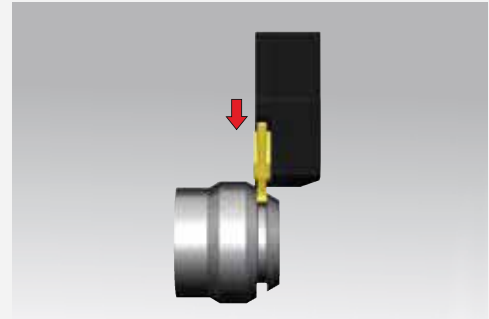
ISO	Material	Material examples/ material number	Tensile strength (N/mm ²)	Brinell hardness (HB)	Cutting speed (surface feet / min)		
					FIREX/nanoFIREX Ⓡ	TICN Ⓢ	
P	Carbon steel	C <= 0.15 %	11SMn30+C / 1.0715 C15 / 1.0401	500 600	150 180	490-720	425-655
		C ≥ 0.15-0.45 %	S235JR (ST37-2) / 1.0037 Ck22 / 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	295-490	230-425
	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	230-395	-
	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	230-460
		austenitic, Ni > 8%	X5CrNi18-10 / 1.4301 X2CrNiMo17-12-2 / 1.4404	650	200	295-525	230-460
		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.

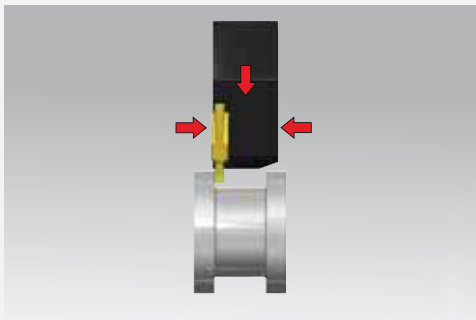
General machining hints



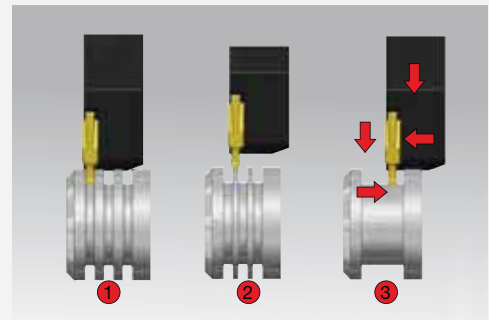
Width of machining should be min. 70% of the width of the cutting edge



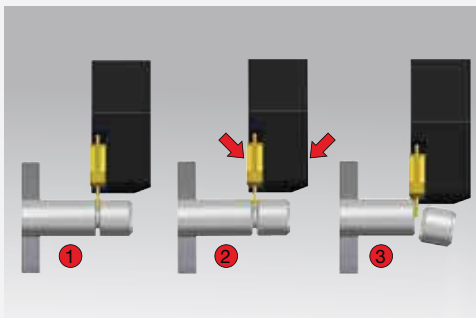
Reduce feed by 20 – 50% when grooving on angled faces



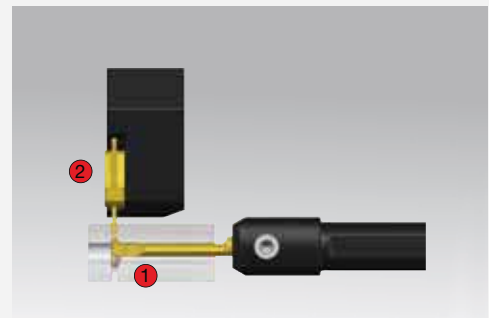
Recessing
 - radial in-feed
 - turning in axial direction
 - leave axial and radial stock for finishing



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

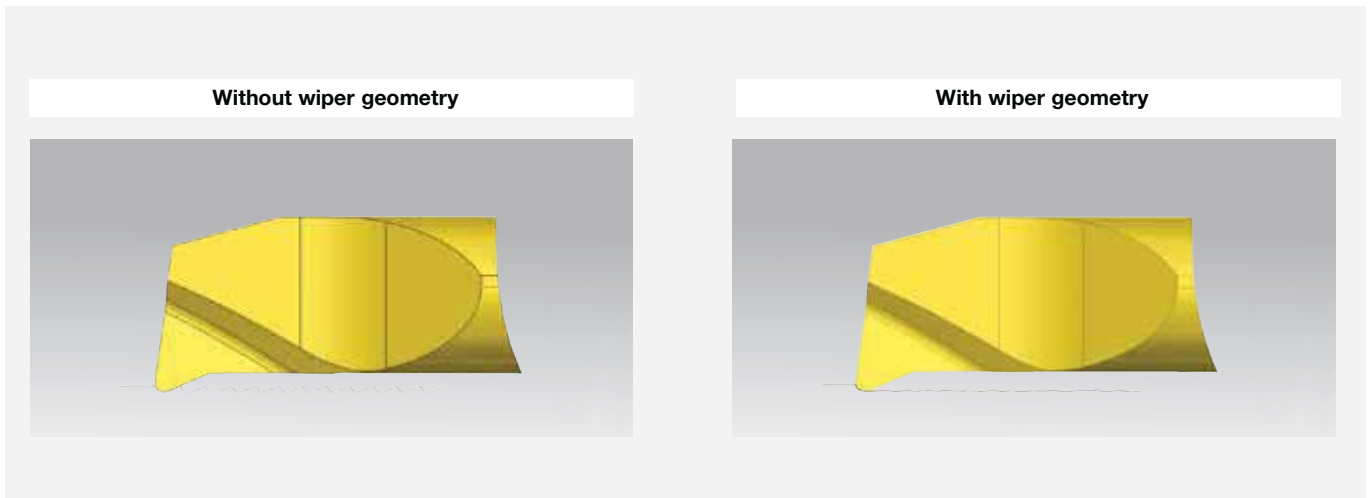
Solution

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 GJ104/106/108/110 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

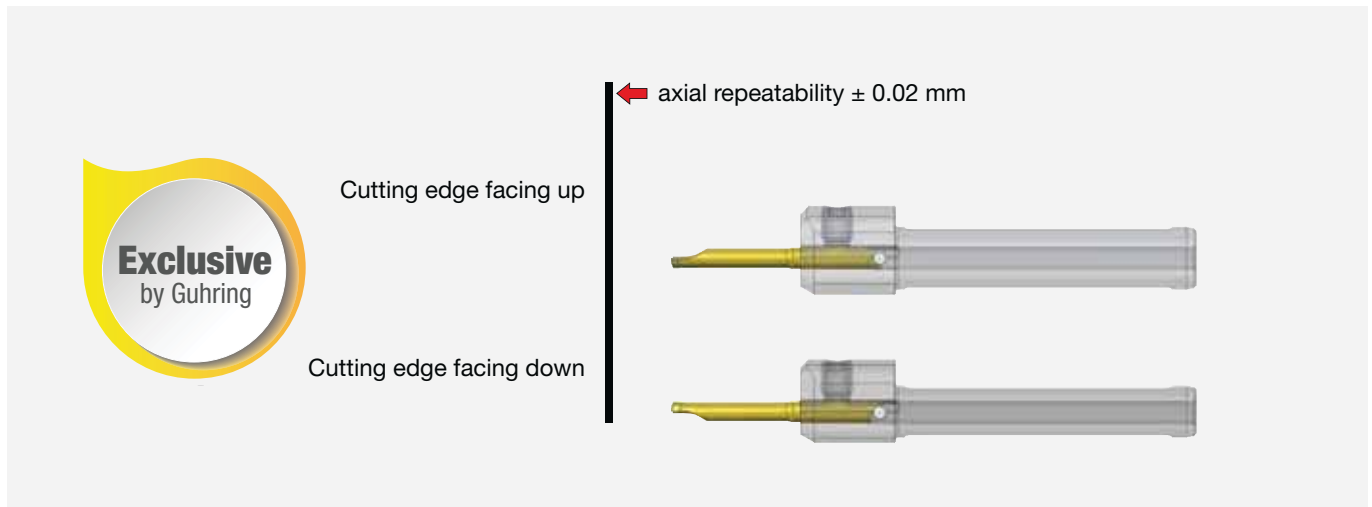
$R_{th} = f^2 / 8 \cdot r$	$r = f^2 / 8 \cdot R_{th}$	$f = \sqrt{8 \cdot r \cdot R_{th}}$
----------------------------	----------------------------	-------------------------------------

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		nano-A	
Cooling:	20 bar			
Operat. step:	Finishing			
vc:	90 m/min			
f:	0.08 mm			
ap:	0.15			
Groov. depth:	-			

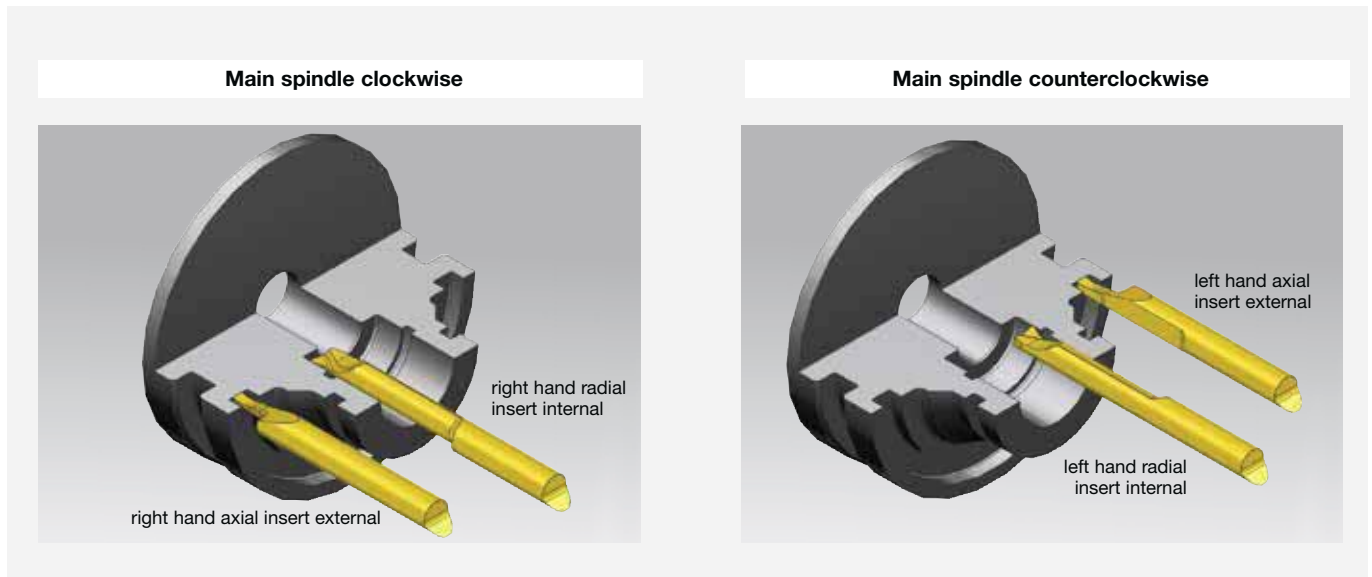


System 104/106/108/110 Positioning and clamping



Gühring's system 104/106/108/110 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



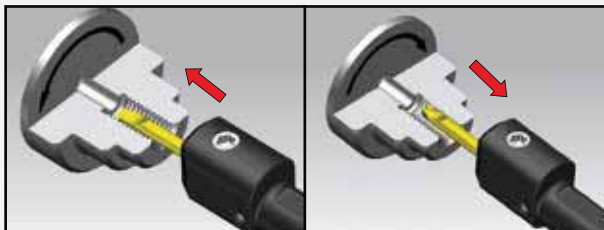
Internal threading

System GG 104/106/108

Pitch/P		Recommended number of cuts with internal threading						
		Steel materials (tensile strength in N/mm ²)			Stainless steel	Cast iron	Heat-resistant alloys	Aluminium
mm	TPI	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



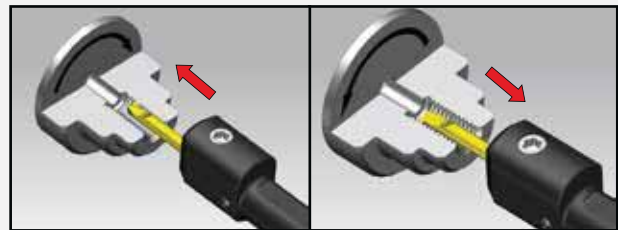
Insert: Right-hand design

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



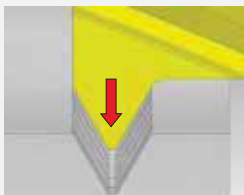
Insert: Left-hand design

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 104/106/108

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

Conversion table - pitch (in.) to pitch (mm)

TPI	Pitch, in	Pitch, mm	TPI	Pitch, in	Pitch, mm	TPI	Pitch, in	Pitch, mm	TPI	Pitch, in	Pitch, mm
127	0.00787	0.200	44	0.02273	0.577	20	0.05000	1.270	7	0.14286	3.629
120	0.00833	0.212	42.33	0.02362	0.600	19	0.05263	1.337	6.35	0.15748	4.000
112	0.00893	0.227	40	0.02500	0.635	18	0.05556	1.411	6	0.16667	4.233
101.6	0.00984	0.250	36.29	0.02756	0.700	16.93	0.05907	1.500	5.64	0.17730	4.504
100	0.01000	0.254	36	0.02778	0.706	16	0.06250	1.588	5.08	0.19685	5.000
96	0.01042	0.265	34	0.02941	0.747	14.51	0.06892	1.751	5	0.20000	5.080
90	0.01111	0.282	33.87	0.02952	0.750	14	0.07143	1.814	4.62	0.21645	5.498
84.67	0.01181	0.300	32	0.03125	0.794	13	0.07692	1.954	4.5	0.22222	5.644
80	0.01250	0.318	31.75	0.03150	0.800	12.7	0.07874	2.000	4.23	0.23641	6.005
72.57	0.01378	0.350	30	0.03333	0.847	12	0.08333	2.117	4	0.25000	6.350
72	0.01389	0.353	28.22	0.03544	0.900	11.5	0.08696	2.209	3	0.33333	8.467
64	0.01563	0.397	28	0.03571	0.907	11	0.09091	2.309	2	0.50000	1.270
63.5	0.01575	0.400	27	0.03704	0.941	10.16	0.09843	2.500			
60	0.01667	0.423	26	0.03846	0.977	10	0.10000	2.540			
56.44	0.01772	0.450	25.4	0.03937	1.000	9	0.11111	2.822			
56	0.01786	0.454	24	0.04167	1.058	8.47	0.11806	2.999			
50.8	0.01969	0.500	22	0.04545	1.155	8	0.12500	3.175			
48	0.02083	0.529	20.32	0.04921	1.250	7.26	0.13774	3.499			

Broaching System GN 104/106/108/110

General hints

Please align the tool accurately.

The alignment surface on the tool holder GB104/106/108/110 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 = radius workpiece (hole \varnothing 8/2) = 4

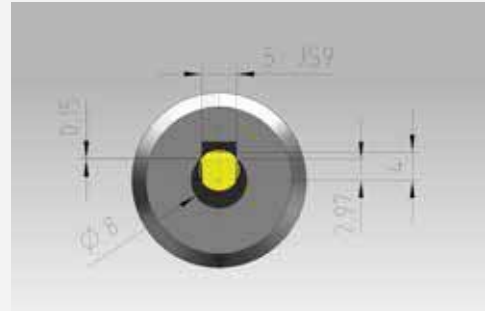
b = Cutting edge / 2 (5/2) = 2.5

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

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

Feed diameter $\varnothing d1$ = 2.97 x 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 ²)					
	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 104/106/108/110

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 Gühring 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		nano-A	
Cooling:	20 bar			
Operat. step:	Semifinishing & fnishing			
vc:	-			
f:	3200 mm			
ap:	0,06			
Groov. depth:	SW 9.3 (special)			

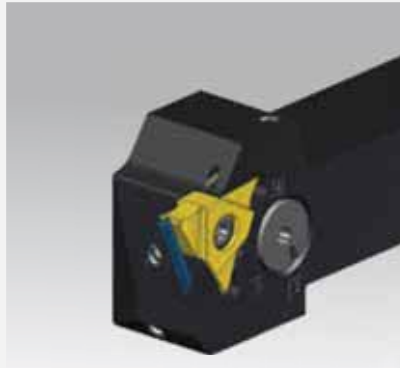
Application hints for holder GH305...EST with adjustable coolant supply



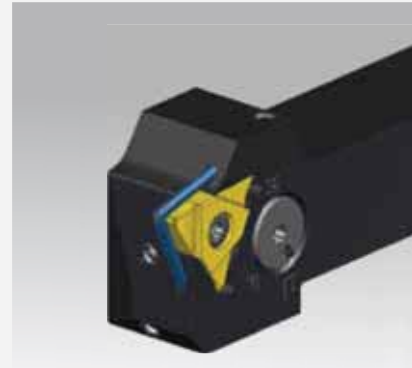
The adjustable valve directs the coolant to the cutting edge as follows:



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			

Conversion Table Inch-Millimeter

Size (Inch)	mm	Part of Inch (decimal)	Size (Inch)	mm	Part of Inch (decimal)	Size (Inch)	mm	Part of Inch (decimal)	Size (Inch)	mm	Part of Inch (decimal)
-	0.10	0.0039	51	1.70	0.0670	4	5.31	0.2090	-	14.00	0.5512
97	0.15	0.0059		1.75	0.0689	3	5.41	0.213	9/16	14.29	0.5625
96	0.16	0.0063	50	1.78	0.0700		5.50	0.2165		14.50	0.5709
95	0.17	0.0067		1.80	0.0709	7/32	5.56	0.2188	37/64	14.68	0.5781
94	0.18	0.0071	49	1.85	0.0730	2	5.61	0.221	-	15.00	0.5906
93	0.19	0.0075		1.90	0.0748	1	5.79	0.228	19/32	15.08	0.5938
92	0.20	0.0079	48	1.93	0.0760	A	5.94	0.234	39/64	15.48	0.6094
91	0.21	0.0083		1.95	0.0768	15/64	5.95	0.2344		15.50	0.6102
90	0.22	0.0087	5/64	1.98	0.0781	-	6.00	0.2362	5/8	15.88	0.625
89	0.23	0.0091	47	1.99	0.0785	B	6.05	0.238	-	16.00	0.6299
88	0.24	0.0095	-	2.00	0.0787	C	6.15	0.242	41/64	16.27	0.6406
-	0.25	0.0098		2.05	0.0807	D	6.25	0.246		16.50	0.6496
87	0.25	0.0100	46	2.06	0.0810	1/4	6.35	0.25	21/32	16.67	0.6562
	0.26	0.0102	45	2.08	0.0820	E	6.35	0.25	-	17.00	0.6693
86	0.27	0.0105		2.15	0.0846		6.50	0.2559	43/64	17.07	0.6719
	0.27	0.0106	44	2.18	0.0860	F	6.53	0.257	11/16	17.46	0.6875
85	0.28	0.0110	43	2.26	0.0890	G	6.63	0.261		17.50	0.689
	0.29	0.0114	42	2.37	0.0935	17/64	6.75	0.2656	45/64	17.86	0.7031
84	0.29	0.0115	3/32	2.38	0.0938		6.75	0.2657	-	18.00	0.7087
-	0.30	0.0118	41	2.44	0.0960	H	6.76	0.266	23/32	18.26	0.7188
83	0.30	0.0120	40	2.50	0.0980	I	6.91	0.272		18.50	0.7283
82	0.32	0.0125	39	2.53	0.0995	-	7.00	0.2756	47/64	18.65	0.7344
	0.32	0.0126	38	2.58	0.1015	J	7.04	0.2772	-	19.00	0.748
81	0.33	0.0130	37	2.64	0.1040	K	7.14	0.281	3/4	19.05	0.75
80	0.34	0.0135	36	2.71	0.1065	9/32	7.14	0.2812	49/64	19.45	0.7656
79	0.37	0.0145	7/64	2.78	0.1094	L	7.37	0.29		19.50	0.7677
1/64	0.40	0.0156	35	2.79	0.11	M	7.49	0.2949	25/32	19.84	0.7812
78	0.41	0.0160	34	2.82	0.111		7.50	0.2953	-	20.00	0.7874
77	0.46	0.0180	33	2.87	0.113	19/64	7.54	0.2969	51/64	20.24	0.7969
-	0.50	0.0197		2.90	0.1142	N	7.67	0.3020		20.50	0.8071
76	0.51	0.0200	32	2.95	0.116		7.75	0.3051	13/16	20.64	0.8125
75	0.53	0.0210	-	3.00	0.1181	5/16	7.94	0.3125	-	21.00	0.8268
74	0.57	0.0225	31	3.05	0.12	-	8.00	0.315	53/64	21.03	0.8281
-	0.60	0.0236	1/8	3.18	0.125	O	8.03	0.316	27/32	21.43	0.8438
73	0.61	0.0240	30	3.26	0.1285	P	8.20	0.323		21.50	0.8465
72	0.64	0.0250		3.30	0.1299	21/64	8.33	0.3281	55/64	21.84	0.8594
71	0.66	0.0260	29	3.45	0.136	Q	8.43	0.332	-	22.00	0.8661
-	0.70	0.0276		3.50	0.1378		8.50	0.3346	7/8	22.23	0.875
70	0.71	0.0280	28	3.57	0.1405	R	8.61	0.339		22.50	0.8858
69	0.74	0.0292	9/64	3.57	0.1406	11/32	8.73	0.3438	57/64	22.62	0.8906
-	0.75	0.0295	27	3.66	0.144		8.75	0.3445	-	23.00	0.9055
68	0.79	0.0310	26	3.73	0.147	S	8.84	0.348	29/32	23.02	0.9062
1/32	0.79	0.0313		3.75	0.1476	-	9.00	0.3543	59/64	23.42	0.9219
-	0.80	0.0315	25	3.80	0.1495	T	9.09	0.358		23.50	0.9252
67	0.81	0.0320	24	3.86	0.152	23/64	9.13	0.3594	15/16	23.81	0.9375
66	0.84	0.0330	23	3.91	0.154	U	9.35	0.368	-	24.00	0.9449
65	0.89	0.0350	5/32	3.97	0.1562		9.50	0.374	61/64	24.21	0.9531
-	0.90	0.0354	22	3.99	0.157	3/8	9.53	0.375		24.50	0.9646
64	0.91	0.0360	-	4.00	0.1575	V	9.56	0.377	31/32	24.61	0.9688
63	0.94	0.0370	21	4.04	0.159	W	9.80	0.386	-	25.00	0.9843
62	0.97	0.0380	20	4.09	0.161	25/64	9.92	0.3906	63/64	25.00	0.9844
61	0.99	0.0390		4.20	0.1654	-	10.00	0.3937	1	25.40	1.00
-	1.00	0.0394	19	4.22	0.166	X	10.08	0.397			
60	1.02	0.0400	18	4.31	0.1695	Y	10.26	0.4040			
59	1.04	0.0410	11/64	4.37	0.1719	13/32	10.32	0.4062			
58	1.07	0.0420	17	4.39	0.173	Z	10.49	0.413			
57	1.09	0.0430	16	4.50	0.177		10.50	0.4134			
56	1.18	0.0465	15	4.57	0.18	27/64	10.72	0.4219			
3/64	1.19	0.0469	14	4.62	0.182	-	11.00	0.4331			
	1.20	0.0472	13	4.70	0.185	7/16	11.11	0.4375			
	1.25	0.0492	3/16	4.76	0.1875		11.50	0.4528			
	1.30	0.0512	12	4.80	0.189	29/64	11.51	0.4531			
55	1.32	0.0520	11	4.85	0.191	15/32	11.91	0.4688			
54	1.40	0.0550	10	4.91	0.1935	-	12.00	0.4724			
	1.45	0.0571	9	4.98	0.196	31/64	12.30	0.4844			
	1.50	0.0591	-	5.00	0.1968		12.50	0.4921			
53	1.51	0.0595	8	5.05	0.199	1/2	12.70	0.50			
	1.55	0.0610	7	5.11	0.2010	-	13.00	0.5118			
1/16	1.59	0.0625	13/64	5.16	0.2031	33/64	13.10	0.5156			
	1.60	0.0630	6	5.18	0.2040	17/32	13.49	0.5312			
52	1.61	0.0635	5	5.22	0.2055		13.50	0.5315			
	1.65	0.0650		5.25	0.2067	35/64	13.89	0.5469			

Replacement parts and accessories

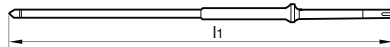
Torque wrenches



Series no. **4915**

Size	Nm	l1 mm	Code no.
1/4	2-8	200.000	8.000

Torx-Plus interchangeable blade



Series no. **4960**

Size	Nm	l1 mm	Code no.
6,6 NM		175.000	15.000

Torx-Plus screwdriver



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



Series no. **25904**

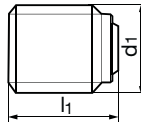
Size	l1 mm	Code no.
15IP	65.000	15.000
15IP	97.000	15.001

Replacement parts and accessories

Clamping screws



• for system 104/106/108/110



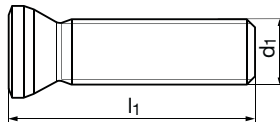
Series no. **25900**

Size	d1	l1	Code no.
		mm	
15IP	M6	7.500	6.000

Clamping screws



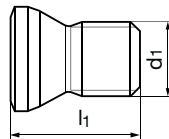
• for system 305



Series no. **25901**

Size	d1	l1	Code no.
		mm	
15IP	M4 x 0.70	15.000	4.000
15IP	M4 x 0.70	22.000	4.001
15IP	M4 x 0.35	11.000	4.002
15IP	M4 x 0.5	17.000	4.003

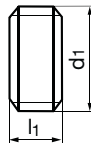
Clamping screws



Series no. **25902**

Size	d1	l1	Code no.
		mm	
15IP	M4	15.000	4.000
15IP	M4	7.000	4.001

Activation screws



Series no. **25905**

Size	d1	l1	Code no.
		mm	
SW 4	G1/8	5.000	5.000

SPECIAL SOLUTIONS made to measure

SYSTEM 104



**Face grooving and copying
dovetail grooving**

Insert: GA 104



Internal threading

Insert: GG 104

SYSTEM 106



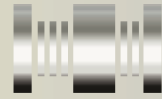
**Copying a radius at the bottom
of a bore on a turning center**

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



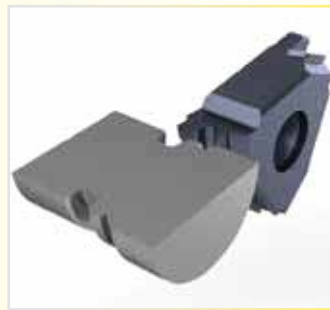
**External/internal circular milling
of form recesses**

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

SYSTEM HOLDERS & MODULAR TOOLS

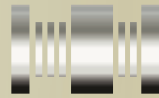
Manufactured for you - quickly and cost-effectively

- Suitable for all inserts type 104, type 106 and indexable inserts type 305
- System holders can be supplied with polygon HSK-T or TS interface



System holder HSK-T
DIN ISO 12164-4

System holder with polygon
shank ISO 26623-1



GROOVING SYSTEMS
BY **GUHRING**



System holder
TS ISO 26622-1

System holder with polygon
shank ISO 26623-1



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25012	Polygon shank holder, to ISO 26623, off-set 90°	28
25013	Polygon shank holder, to ISO 26623, off-set 90°	28
25016	HSK-T holder, to ISO 12164-3, straight 0°	29
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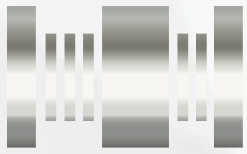
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Guhring has taken its many years of experience with PCD and PCBN tooling and applied it specifically to create a new product line of grooving and turning tools.

Our team of application technicians and sales consultants is available to answer all of your technical questions.

GÜHRING



GROOVING
SYSTEMS



FROM DRILL PIONEER TO **COMPLETE SUPPLIER**

Gühring is a leading manufacturer worldwide of precision tools for metal machining. With more than 8,000 employees globally, and more than 70 production facilities in 48 countries, the company is known and respected for its ability to develop, manufacture and distribute innovative cutting tools.

The latest product line introduced to the cutting tools marketplace includes perfectly coordinated tool systems for boring, internal grooving, axial grooving bores, external grooving and broaching. The Grooving Systems offering now includes approximately 6,000 items.



COMPREHENSIVE
PERFECT INTEGRATION
MARKET-DRIVEN

Whether required for a small production lot or for continuous production, customer-specific solutions are one of our strengths. Our vertical integration -- from carbide production, in-house coating technology and in-house development through to our competent product specialists

-- makes our tools incredibly adept at mastering even the most demanding machining tasks. By continuously adding new products to the portfolio, Guhring is well and truly meeting the expectations of a complete supplier.



GÜHRING'S OWN CARBIDE PRODUCTION

- \ Blanks – indexable inserts and cutting inserts
- \ Gühring's own carbide grades



GRINDING INDEXABLE INSERTS AND CUTTING INSERTS

- \ Complete production on Gühring-built grinding machines



COATING INDEXABLE INSERTS AND CUTTING INSERTS

- \ In-house coating on Gühring-built coating systems
- \ Latest coating technology and coating types

VERTICAL INTEGRATION
MADE IN GERMANY
HIGHLY SPECIALIZED



Drilling

Tapping/Thread milling/
Fluteless tapping

Milling

PCD

Reaming

Countersinking

Services

Grooving systems

Special solutions

Modular systems

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