

Grooving System

GY Series

New Inserts

GU Breaker
VP10RT
VP20RT

GM Breaker
NX2525

Grooving Revolution

Innovative clamping system ensures reliable grooving.

■ New GU breaker gives excellent chip control for mild steel grooving applications.

■ NX2525 cermet grade with GM chipbreaker for good surface finishes in carbon and alloy steel applications.

INSERTS

Applications	Geometry	Order Number	Stock				Seat Size	Dimensions (mm)				
			Coated		Cermet			W3		Re	ar (Max.)	L2
			VP10RT	VP20RT	MY5015	NX2525		Grooving Width	Tolerance			
For Grooving / Cutting off	GU Breaker (For Mild steel) 	NEW GY2M0400G030N-GU	●	●			G	4.00	±0.04	0.3	24.2	25.65
		NEW 0475H040N-GU	●	●			H	4.75	±0.04	0.4	24.2	25.65
		NEW 0500H040N-GU	●	●			H	5.00	±0.04	0.4	24.2	25.65
		NEW 0600J040N-GU	●	●			J	6.00	±0.04	0.4	24.2	25.65
		NEW 0635J040N-GU	●	●			J	6.35	±0.04	0.4	24.2	25.65
	GM Breaker (Medium feeds) 	GY2M0200D020N-GM	●	●	●	●	D	2.00	±0.03	0.2	19.4	20.70
		0239E020N-GM	●	●	●	●	E	2.39	±0.03	0.2	19.4	20.70
		0250E020N-GM	●	●	●	●	E	2.50	±0.03	0.2	19.4	20.70
		0300F030N-GM	●	●	●	●	F	3.00	±0.03	0.3	19.4	20.70
		0318F030N-GM	●	●	●	●	F	3.18	±0.03	0.3	19.4	20.70
		0400G030N-GM	●	●	●	●	G	4.00	±0.04	0.3	24.4	25.65
		0475H040N-GM	●	●	●	●	H	4.75	±0.04	0.4	24.3	25.65
		0500H040N-GM	●	●	●	●	H	5.00	±0.04	0.4	24.3	25.65
		0600J040N-GM	●	●	●	●	J	6.00	±0.04	0.4	24.3	25.65
0635J040N-GM	●	●	●	●	J	6.35	±0.04	0.4	24.3	25.65		

● : Inventory maintained. (10 inserts in one case)

Recommended Cutting Speed [External Grooving]

Work Material	Hardness	Grade	Cutting Speed (m/min)					
			50	100	150	200	250	300
P Mild Steel	≤160HB	VP20RT		100		220		
		VP10RT		110		230		
		MY5015			140			300
		NX2525		90		210		
Carbon Steel Alloy Steel	160–280HB	VP20RT		80		180		
		VP10RT		90		190		
		MY5015			110		250	
		NX2525		70		170		
	280HB≤	VP20RT		60		140		
		VP10RT		70		150		
		MY5015			90		210	
		NX2525		55		135		

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

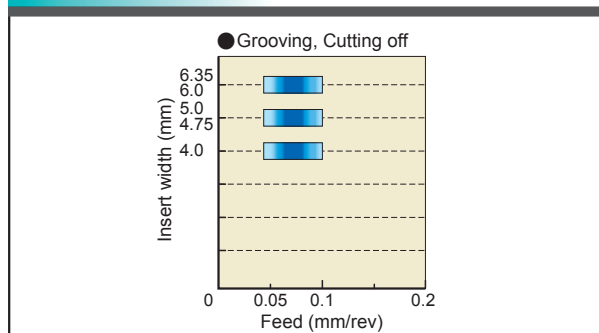
(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.

Recommended Feed Rate [External Grooving]

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

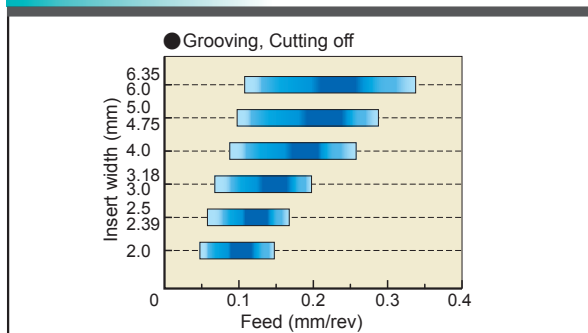
GU Breaker

■ : 1st recommended area



GM Breaker

■ : 1st recommended area



* For the recommended internal and face grooving cutting conditions, please refer to the brochure B140G.

For Your Safety

●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When attaching inserts or spare parts, please use only the correct wrench or spanner. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

MITSUBISHI MATERIALS CORPORATION

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(Tools specifications subject to change without notice.)