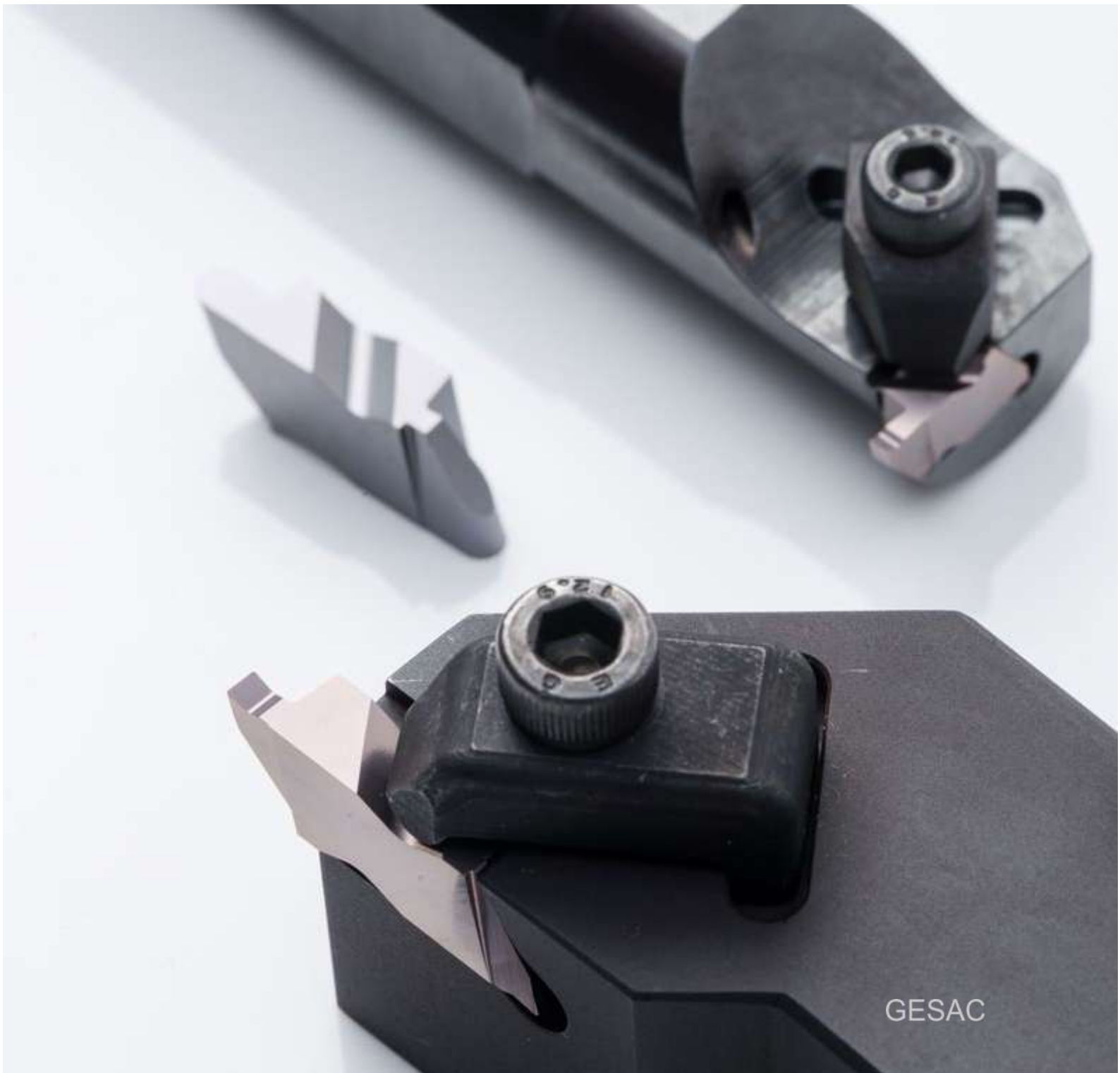


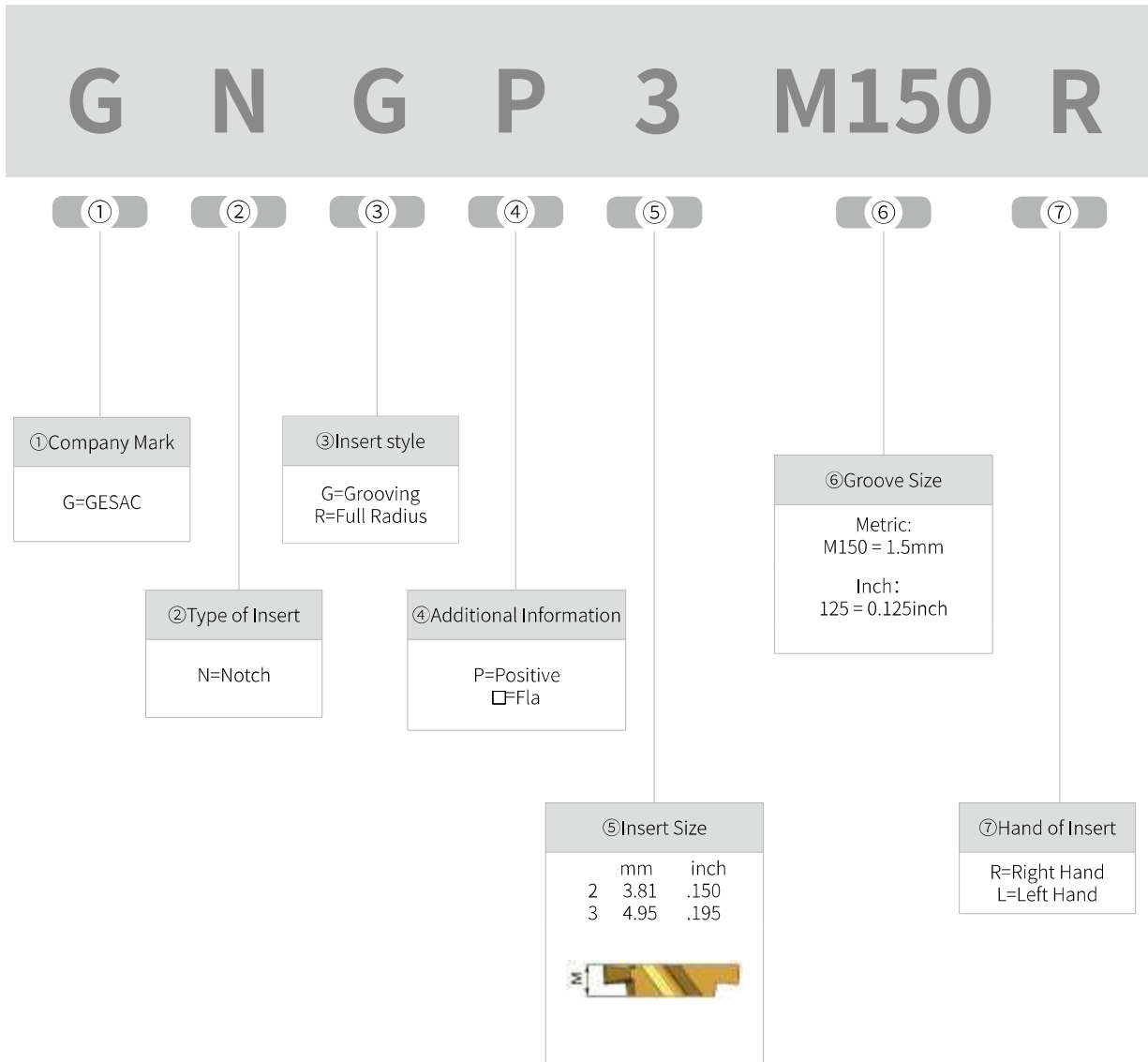
F

## G-NotchSeries Tools

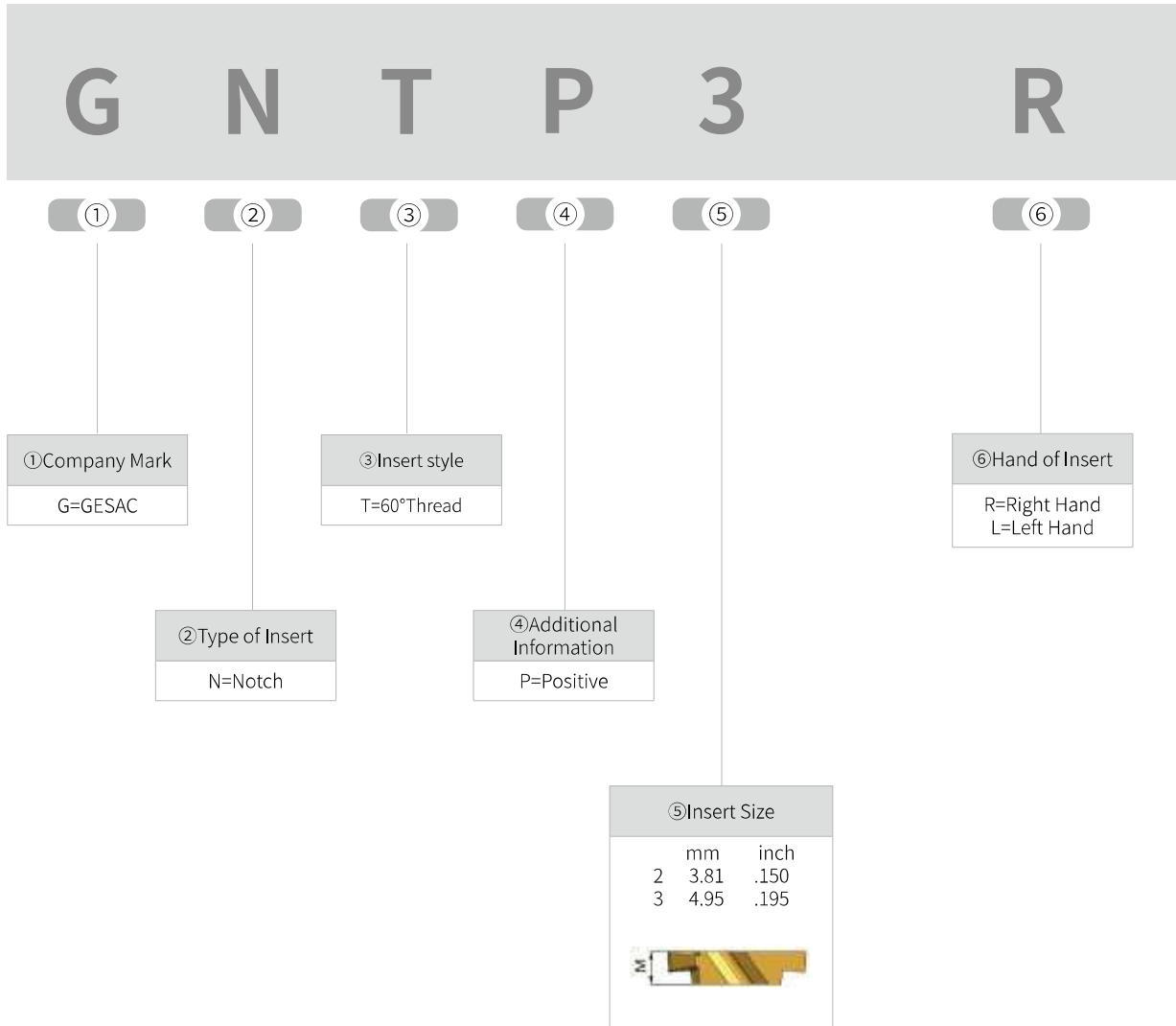


GESAC

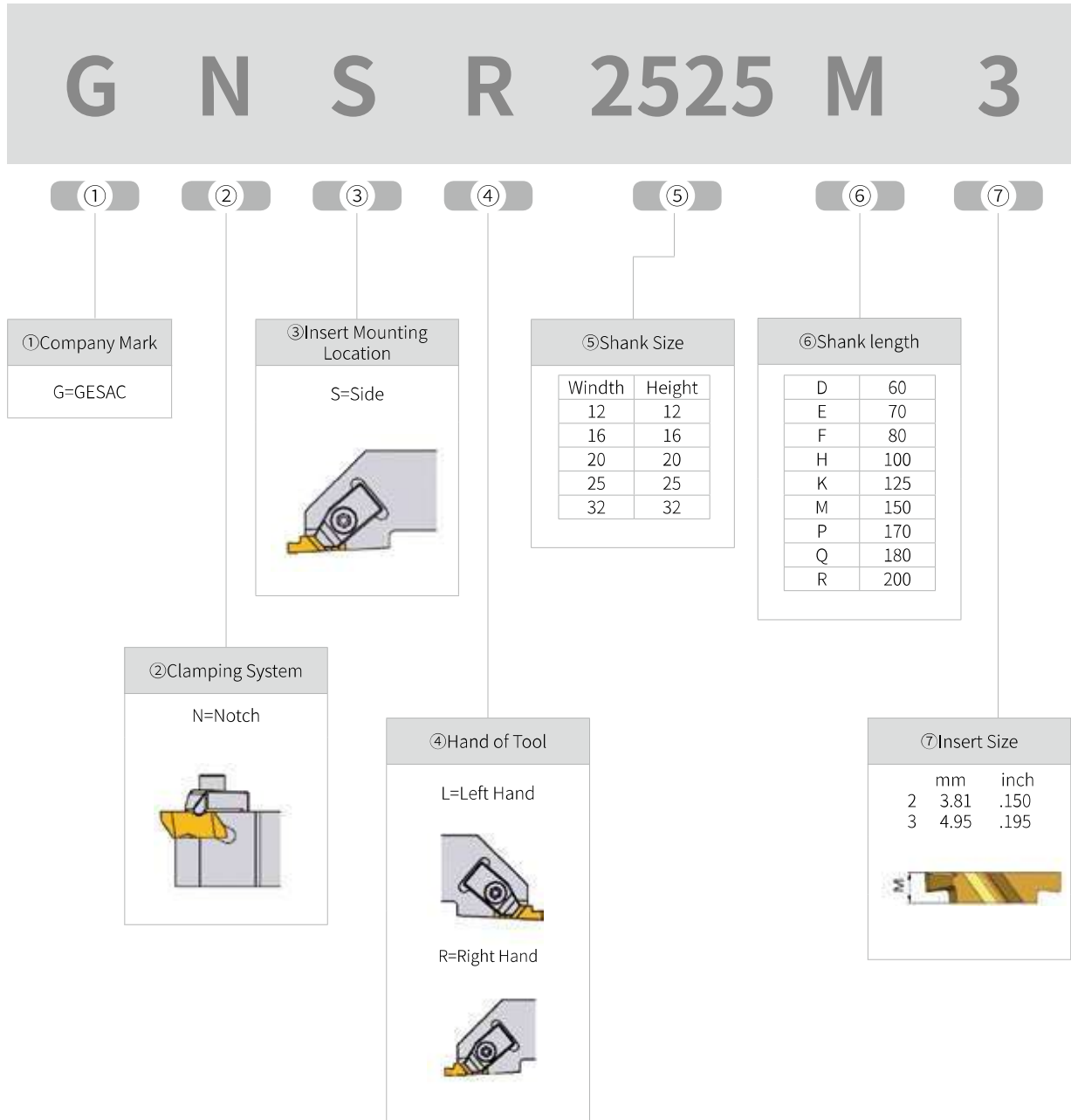
## G-Notch Series Grooving Inserts Identification System



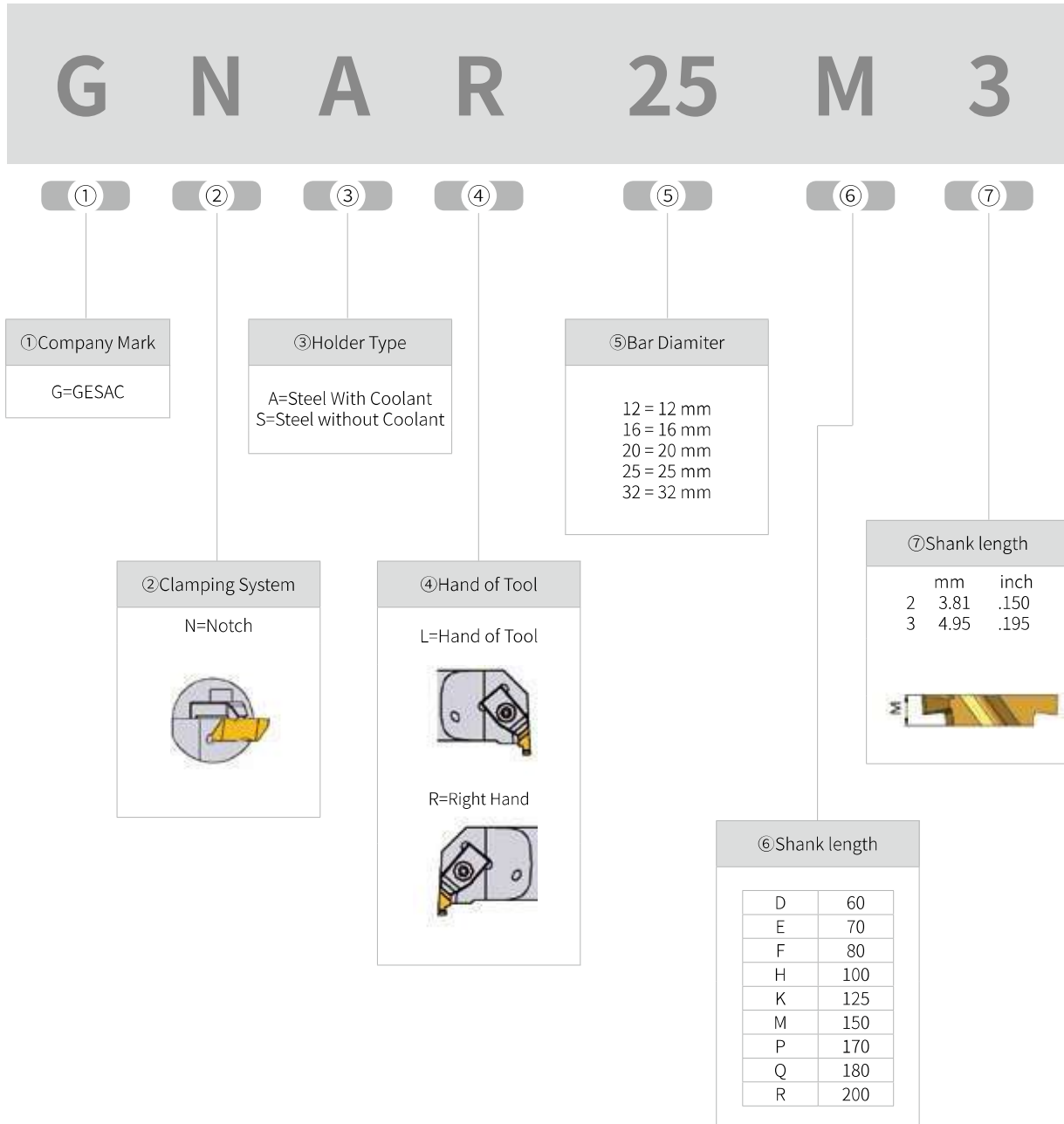
## G-Notch Series Threading Inserts Identification System



## G-Notch External Holder Identification System






## G-Notch Internal Bar Identification System



Note: Left hand bars use right hand inserts, Right hand bars use left hand inserts.

## Overview of G-Notch Series Inserts

Application	Style	Shape	Width/Pitch	Page
Precision Grooving	GNGP		1.00-3.50 (mm)	P169
Precision Profiling	GNR		2.00-3.18 (mm)	P171
Threading	GNTP		0.70-5.00(mm) 36-5(TPI)	P171

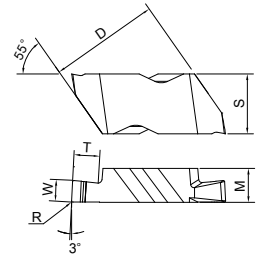
## Grades for G-Notch Series Inserts

Workpiece Material	<b>P</b> Steel						<b>M</b> Stainless Steel					<b>K</b> Cast Iron					
	ISO	01	10	20	30	40	50	01	10	20	30	40	01	10	20	30	40
Coated	PVD																
			GM3225						GM3225					GM3225			

Precision Grooving Inserts

# GNGP

Grooving Positive Rake Insert



Ordering Code	Dimensions(mm)						Insert Size	Stock
	W	R	T	S	M	D		GM3225
GNGP2M100L	1.00	0.09	1.27	5.56	3.81	8.74	2	○
GNGP2M100R	1.00	0.09	1.27	5.56	3.81	8.74	2	○
GNGP2047L	1.19	0.09	1.27	5.56	3.81	8.74	2	●
GNGP2047R	1.19	0.09	1.27	5.56	3.81	8.74	2	●
GNGP2M150L	1.50	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2M150R	1.50	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2062L	1.57	0.19	2.79	5.56	3.81	8.74	2	●
GNGP2062R	1.57	0.19	2.79	5.56	3.81	8.74	2	●
GNGP2M170L	1.70	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2M170R	1.70	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2070L	1.78	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2078L	1.98	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2078R	1.98	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2M200L	2.00	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2M200R	2.00	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2M220L	2.20	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2M220R	2.20	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2094L	2.38	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2094R	2.38	0.19	2.79	5.56	3.81	8.74	2	●
GNGP2M250L	2.50	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2M250R	2.50	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2125L	3.18	0.19	2.79	5.56	3.81	8.74	2	○
GNGP2125R	3.18	0.19	2.79	5.56	3.81	8.74	2	●
GNGP3031L	0.79	0.09	1.27	8.74	4.95	16.1	3	○
GNGP3031R	0.79	0.09	1.27	8.74	4.95	16.1	3	○
GNGP3M100L	1.00	0.19	1.91	8.74	4.95	16.1	3	○
GNGP3M100R	1.00	0.19	1.91	8.74	4.95	16.1	3	○
GNGP3047L	1.19	0.19	1.91	8.74	4.95	16.1	3	●
GNGP3047R	1.19	0.19	1.91	8.74	4.95	16.1	3	●



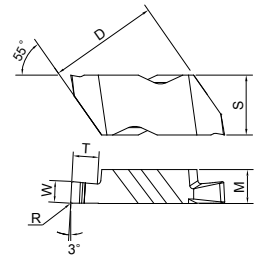
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● Stock ○ Available upon Order

Precision Grooving Inserts

# GNGP

Grooving Positive Rake Inserts



Ordering Code	Dimensions(mm)						Insert Size	Stock
	W	R	T	S	M	D		GM3225
GNGP3M150L	1.50	0.19	2.39	8.74	4.95	16.1	3	○
GNGP3M150R	1.50	0.19	2.39	8.74	4.95	16.1	3	○
GNGP3062L	1.58	0.19	2.39	8.74	4.95	16.1	3	●
GNGP3062R	1.58	0.19	2.39	8.74	4.95	16.1	3	●
GNGP3070L	1.78	0.19	2.39	8.74	4.95	16.1	3	○
GNGP3078L	1.98	0.19	2.39	8.74	4.95	16.1	3	○
GNGP3078R	1.98	0.19	2.39	8.74	4.95	16.1	3	○
GNGP3M200L	2.00	0.19	2.39	8.74	4.95	16.1	3	●
GNGP3M200R	2.00	0.19	2.39	8.74	4.95	16.1	3	●
GNGP3094L	2.39	0.19	3.81	8.74	4.95	16.1	3	●
GNGP3094R	2.39	0.19	3.81	8.74	4.95	16.1	3	●
GNGP3M250L	2.50	0.19	3.81	8.74	4.95	16.1	3	●
GNGP3M250R	2.50	0.19	3.81	8.74	4.95	16.1	3	●
GNGP3M300L	3.00	0.19	3.81	8.74	4.95	16.1	3	●
GNGP3M300R	3.00	0.19	3.81	8.74	4.95	16.1	3	●
GNGP3125L	3.18	0.19	3.81	8.74	4.95	16.1	3	●
GNGP3125R	3.18	0.19	3.81	8.74	4.95	16.1	3	●
GNGP3M350L	3.50	0.19	3.81	8.74	4.95	16.1	3	○
GNGP3M350R	3.50	0.19	3.81	8.74	4.95	16.1	3	○



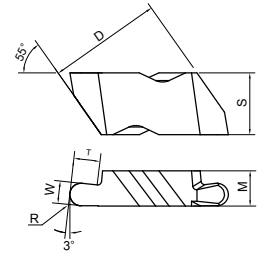
● Stock ○ Available upon Order




Precision Grooving Inserts

# GNR

Full Radius Inserts



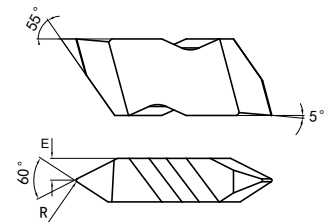
Ordering Code	Dimensions(mm)						Insert Size	Stock	
	W	R	T	S	M	D		GM3225	
	GNR3M100L	2.00	1.00	2.39	8.74	4.95	16.10	3	○
	GNR3M100R	2.00	1.00	2.39	8.74	4.95	16.10	3	○
	GNR3M150L	3.00	1.50	3.81	8.74	4.95	16.10	3	○
	GNR3M150R	3.00	1.50	3.81	8.74	4.95	16.10	3	○
	GNR3047L	2.39	1.19	3.81	8.74	4.95	16.1	3	●
	GNR3047R	2.39	1.19	3.81	8.74	4.95	16.1	3	●
	GNR3062L	3.18	1.59	3.81	8.74	4.95	16.10	3	○
	GNR3062R	3.18	1.59	3.81	8.74	4.95	16.10	3	○


● Stock ○ Available upon Order

Threading Inserts

# GNTP

60° Partial Profile Threading Inserts With Positive Top Rake



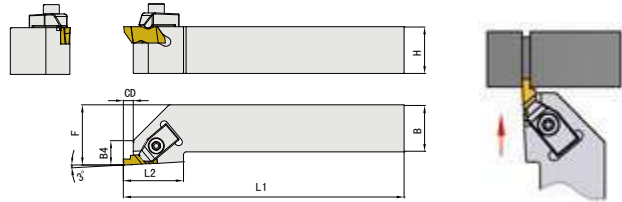
Ordering Code	Dimensions						Insert Size	Stock	
	R	E	Pitch					GM3225	
			External	Internal	External	Internal			
	Gntp2L	0.10	1.91	0.70-3.00	1.25-3.50	8-36	7-20	2	●
	Gntp2R	0.10	1.91	0.70-3.00	1.25-3.50	8-36	7-20	2	●
	Gntp3L	0.17	2.49	1.25-4.00	2.00-5.00	4-20	5-12	3	●
	Gntp3R	0.17	2.49	1.25-4.00	2.00-5.00	4-20	5-12	3	●
	Gntp3004L	0.10	2.49	1.25-4.00	2.00-5.00	5-36	5-12	3	○
	Gntp3004R	0.10	2.49	1.25-4.00	2.00-5.00	5-36	5-12	3	○

● Stock ○ Available upon Order

External Holders

G-Notch Series

GNSR/L



The Picture is Right Hand Holder

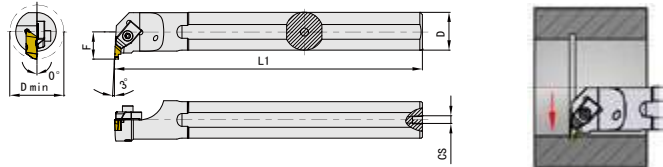
Ordering Code	Dimensions(mm)							Insert	Spare Parts			Stock
	H	B	F	L1	L2	B4	CD		Clamp	Screw	Wrench	
GNSR1616H2	16	16	20	100	19	9	3.5	GN.2R	CAN02RH	SCAM040120H	TH30LH	●
GNSR2020K2	20	20	25	125	19	9	3.5	GN.2R	CAN02RH	SCAM040120H	TH30LH	●
GNSR2525M2	25	25	32	150	19	9	3.5	GN.2R	CAN02RH	SCAM040120H	TH30LH	●
GNSR2020K3	20	20	25	125	32	13	5.3	GN.3R	CAN03RH	SCAM050200H	TH40LH	●
GNSR2525M3	25	25	32	150	32	13	5.3	GN.3R	CAN03RH	SCAM050200H	TH40LH	●
GNSL1616H2	16	16	20	100	19	9	3.5	GN.2L	CAN02LH	SCAM040120H	TH30LH	●
GNSL2020K2	20	20	25	125	19	9	3.5	GN.2L	CAN02LH	SCAM040120H	TH30LH	●
GNSL2525M2	25	25	32	150	19	9	3.5	GN.2L	CAN02LH	SCAM040120H	TH30LH	●
GNSL2020K3	25	20	25	125	32	13	5.3	GN.3L	CAN03LH	SCAM050200H	TH40LH	●
GNSL2525M3	25	25	32	150	32	13	5.3	GN.3L	CAN03LH	SCAM050200H	TH40LH	●

● Stock ○ Available upon Order

Internal Bars

G-Notch Series

GNAR/L



The Picture is Right Hand Holder

Ordering Code	Dimensions(mm)					Insert	Spare Parts			Stock
	D	D min	L1	F	CS		Clamp	Screw	Wrench	
GNAR20Q2	20	26	180	13	1/8-27 NPT	GN.2L	CAN02LH	SCAM040120H	TH30LH	●
GNAR25R2	25	34	200	17	1/4-18 NPT	GN.2L	CAN02LH	SCAM040120H	TH30LH	●
GNAR25R3	25	34	200	17	1/4-18 NPT	GN.3L	CAN03LH	SCAM050200H	TH40LH	●
GNAL20Q2	20	26	180	13	1/8-27 NPT	GN.2R	CAN02RH	SCAM040120H	TH30LH	●
GNAL25R2	25	34	200	17	1/4-18 NPT	GN.2R	CAN02RH	SCAM040120H	TH30LH	●
GNAL25R3	25	34	200	17	1/4-18 NPT	GN.3R	CAN03RH	SCAM050200H	TH40LH	●

Note: Left hand bars use right hand inserts, Right hand bars use left hand inserts.

● Stock ○ Available upon Order

## Recommended Feed

Width(mm)	Feed(mm/r)
0.79-1.50	0.08 (0.03-0.12)
1.50-2.50	0.10 (0.04-0.16)
2.50-3.50	0.12 (0.05-0.20)
3.50-4.50	0.14 (0.05-0.25)

## Recommended Cutting Speed

Workpiece Material	Hardness (HB)	Cutting Speed Vc (m/min)			
		GM3125	GA4230	GS3115	
<b>P</b>	Low Carbon Steel	80 – 170	105 (60-170)	110 (70-180)	
	High Carbon Steel	170 –250	105 (60-160)	110 (70-160)	
	Low-alloy Steel	140– 260	105 (50-160)	110 (60-160)	
	High-alloy Steel	180– 300	105 (50-160)	110 (60-160)	
<b>M</b>	Ferritic/Martensitic	150– 270	90 (40-140)	100 (40-180)	90 (50-150)
	Austenitic	150– 270	90 (40-140)	100 (40-180)	90 (50-150)
<b>K</b>	Malleable Cast Iron	150– 230	160 (60-300)	180 (70-300)	
	Gray Cast Iron	150– 230	160 (60-300)	180 (70-300)	
	Nodular Cast Iron	160– 260	140 (50-250)	160 (60-300)	
<b>S</b>	Heat-resistant Alloy	130– 400			35 (15-60)
	Titanium Alloys	130– 400			35 (15-60)

