

2022

Insert Catalogue
Grooving

BEYOND THE MACHINING

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IMAGINATION AND
FUNCTIONALITY IS
HARMONIZED WITH
MATERIALS AND
TOOL COMES TRUE...



BEYOND THE MACHINING



STARTING A NEW JOURNEY OF SUCCESS REQUIRES FORESEEN

EX-PERIENCE, EX-PERT TEAM, STRATEGY AND VISION BY STRIVING FOR
MANUFACTURING EXCELLENCE.

Dear Valued Customers and Business Partners

We, Karcan, as the biggest cutting tool manufacturer of Turkey with our modern machine and measuring park, R&D Center, number of qualified employees, sales figures and export share, owe you a great debt of gratitude for being a part of our journey all through these years and being a part of our achievement.

As the leading company steering the cutting tool industry of Turkey, we keep being your solution partner in machinability of hi-tech materials thanks to our highly skilled and trained R&D, process and technical sales team by following the recent developments in machining and material engineering and bringing the world's technology to your hands.

We are not just a Cutting Tools manufacturer! We make a difference in terms of our production improving activities, technical applications and consultancy services and we put all our efforts of our valued customers' gaining in 'cost per part' a competitive edge in global markets. From this point of view, we aim to provide products and services 'Beyond The Machining'.

We intend to present at our catalogue the carbide insert studies and improvements on the series within our standard program carried out together with our national and foreign universities, institutes, local and global partners.

We keep on bringing innovations to our customers in our country and 21 countries globally, and keep working with great passion in the belief that improvements are constant and a never ending process.

Welcome again to the world of Karcan Cutting Tools

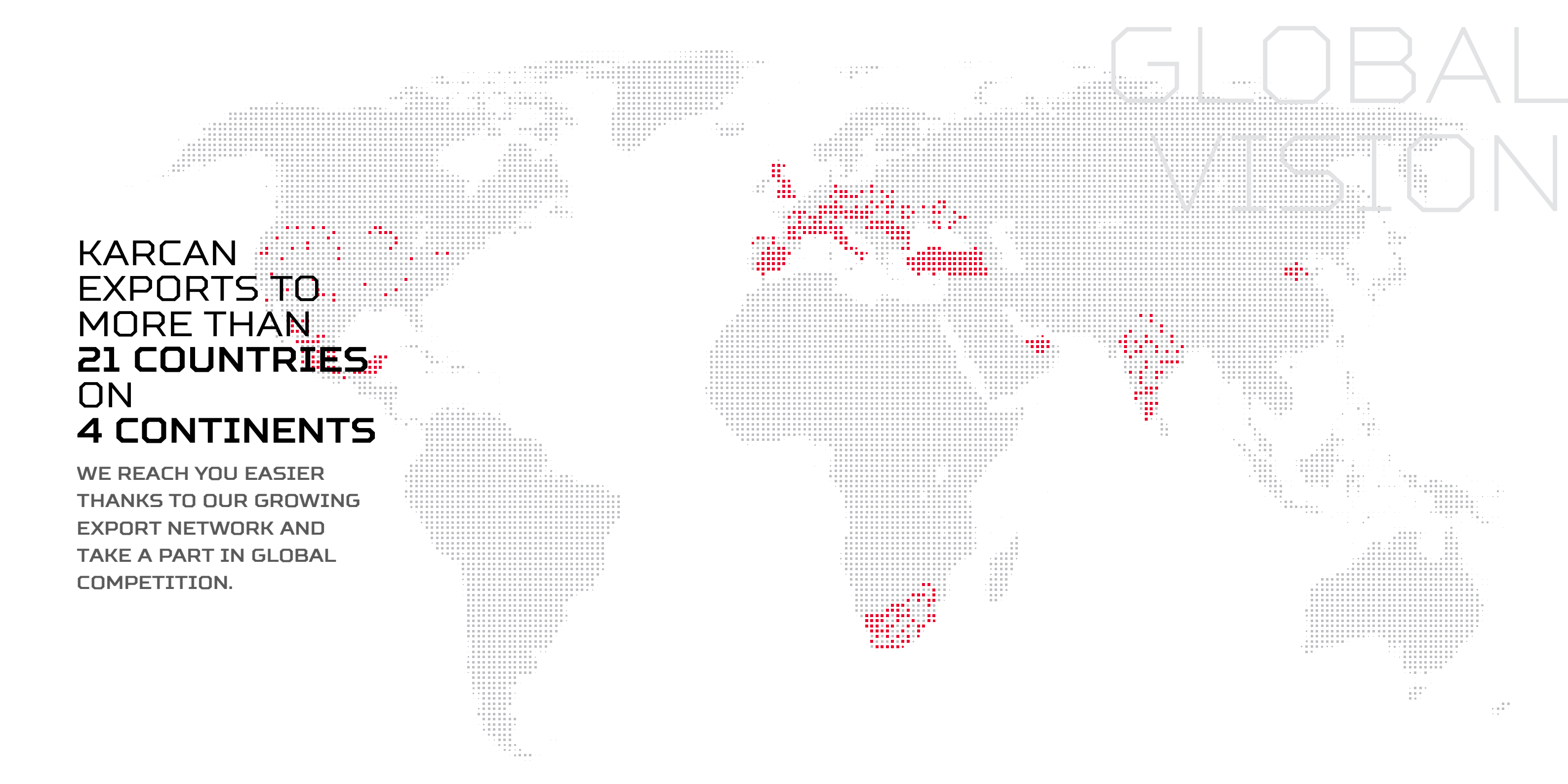
On behalf of Karcan Cutting Tools,

Ümit GEZER
Founder / General Manager

A handwritten signature in blue ink that reads "Ümit Gezer".

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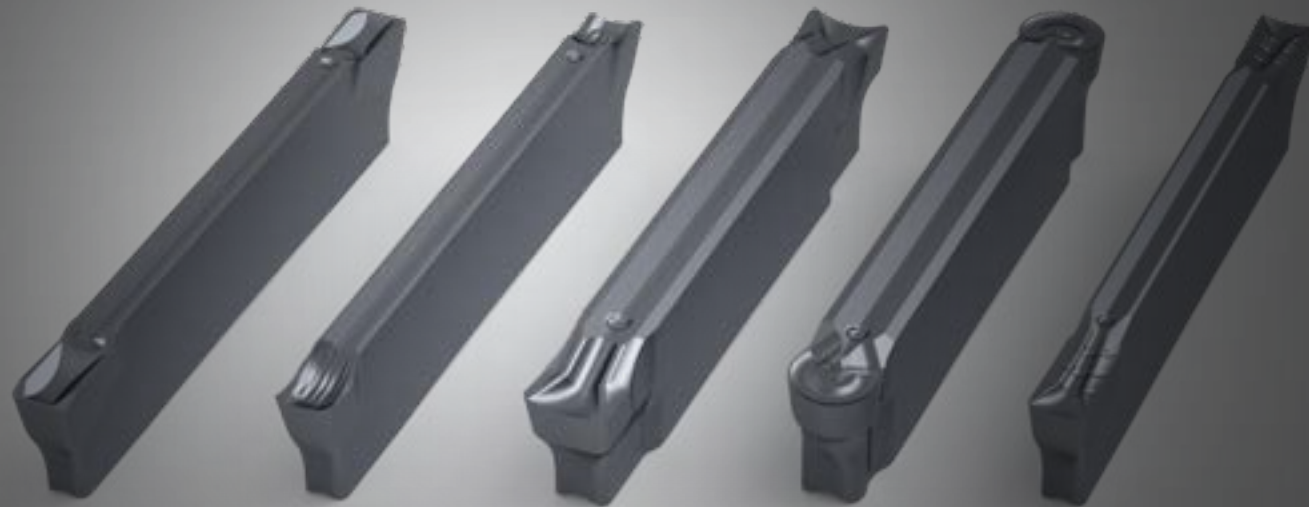
KARCAN
EXPORTS TO
MORE THAN
21 COUNTRIES
ON
4 CONTINENTS

WE REACH YOU EASIER
THANKS TO OUR GROWING
EXPORT NETWORK AND
TAKE A PART IN GLOBAL
COMPETITION.

GLOBAL
VISION

CUTTING GEOMETRIES

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TOOLING SOLUTIONS
BY KARCAN

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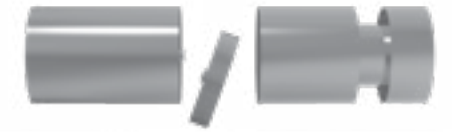
TOOLING SOLUTIONS
BY KARCAN

GD/GO



M1 – Medium cutting

- Insert with narrow negative chamfer
- Suitable for all steel materials with high strength
- Suitable for all applications
- For steel and grey cast iron



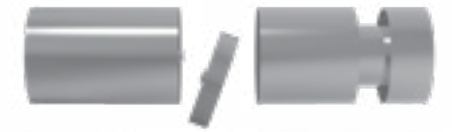
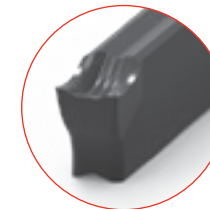
Parting

Grooving



F1 – Very soft cutting

- Excellent cutting chipbreaker with low cutting forces
- For low or medium strength materials
- Particularly suitable for parting off tubes and thin-walled work pieces
- High cutting edge stability
- Excellent chip control also with low feed
- Low built up edge



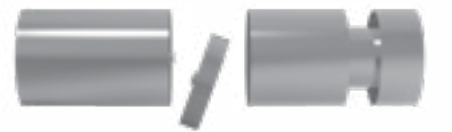
Parting

Grooving



ST1 – Stainless und super alloys

- Especially for stainless steel
- Problem solver for steel machining



Parting

Grooving

GROOVING CATALOGUE

GD/GO

T – Grooving and Turning

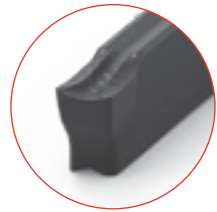
- For grooving and turning
- Suitable for all steel and stainless steel materials
- Very good chip control



Parting

Grooving

Turning



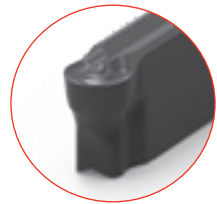
M – Radius grooves

- Insert for radius grooves
- For copy turning
- Suitable for all steel and cast iron materials



Grooving

Turning



NEW

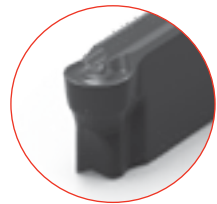
MM – General application and Turning

- Especially for stainless steel materials



Grooving

Turning



GD/GO

LM – Non ferrous metals

- Insert with highly positive cutting chipbreaker and sharp cutting edge
- Extra-smooth rake face through “microfinish”
- Reduced built-up edge



Parting

Grooving

Turning



GS

■ ■ M1 – Medium cutting

- Insert with narrow negative chamfer
- Suitable for all steel materials with high strength
- Suitable for all applications
- For steel and grey cast iron



Parting

Grooving

■ ■ ST1 – Stainless and super alloys

- Especially for stainless steel
- Problem solver for steel machining

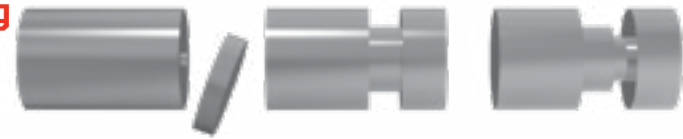


Parting

Grooving

■ ■ M2 – Grooving and Turning

- For grooving and turning
- Suitable for all steel and cast iron materials
- Very good chip control



Parting

Grooving

Turning

GS

■ LM – Non ferrous metals

- Insert with highly positive cutting chipbreaker and sharp cutting edge
- Extra-smooth rake face through “microfinish”
- Reduced built-up edge



Parting

Grooving

■ ■ M – General application and Turning

- Insert for radius grooves
- For copy turning
- Suitable for all steel and cast iron materials



Grooving

Turning



■ MM – General application and Turning

- Especially for stainless steel materials



Grooving

Turning

GA

T – Grooving and Turning

- For grooving and turning
- Suitable for all steel and stainless steel materials
- Very good chip control



Grooving

Turning

M – General application and Turning

- Insert for radius grooves
- For copy turning
- Suitable for all steel and cast iron materials



Grooving

Turning

Application

GD/GO/GA

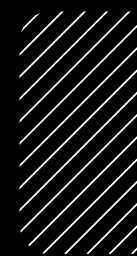
Material Group		Choice chipbreaker		Grades	
		First choice	First choice	Higher wear resistance	Higher toughness
Steel		M1 – F1	KRP1340	KRCP320ST	KRPP345
		T – M	KRP1340		
Stainless steel		ST1 – F1 – T – M – MM	KRP1340		KRPP345
Cast iron		M1	KRP1340	KRCP320ST	KRPP345
		M	KRP1340		
Exotic		ST1	KRPP345		
Non-ferrous metals		LM	KRWN715		

GS

Material Group		Choice chipbreaker		Grades	
		First choice	First choice	Higher wear resistance	Higher toughness
Steel		M1 – M2 – M	KRP1340	KRCP320ST	KRPP345
Stainless steel		ST1 – MM	KRP1340		KRPP345
Cast iron		M1 – M2	KRP1340		KRPP345
Non-ferrous metals		LM	KRWN715		

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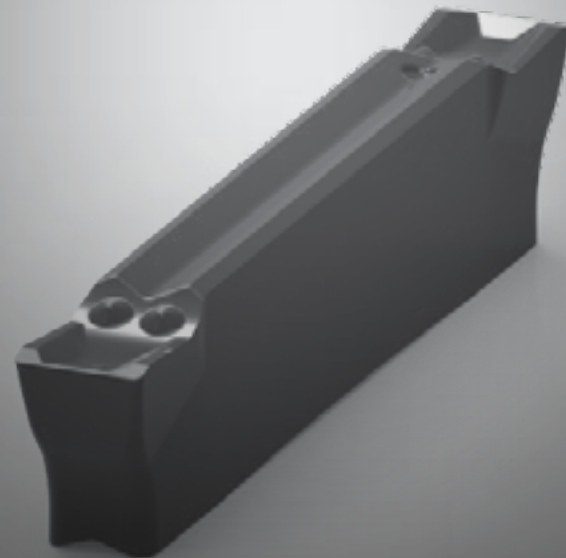
GD

Double-sided



M1 1.5 - 8

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GD - M1

Insert	Designation
1.5	GD24NT-15.015-00-M1 KRCP320ST
	GD24NT-15.015-00-M1 KRP1340
	GD24NT-15.015-00-M1 KRPP345
2.0	GD24LT-20.015-06-M1 KRCP320ST
	GD24LT-20.015-06-M1 KRP1340
	GD24LT-20.015-06-M1 KRPP345
	GD24NT-20.02-00-M1 KRCP320ST
	GD24NT-20.02-00-M1 KRP1340
	GD24NT-20.02-00-M1 KRPP345
3.0	GD24RT-20.015-06-M1 KRCP320ST
	GD24RT-20.015-06-M1 KRP1340
	GD24RT-20.015-06-M1 KRPP345
	GD24LT-30.02-06-M1 KRCP320ST
	GD24LT-30.02-06-M1 KRP1340
	GD24LT-30.02-06-M1 KRPP345
3.0	GD24NT-30.02-00-M1 KRCP320ST
	GD24NT-30.02-00-M1 KRP1340
	GD24NT-30.02-00-M1 KRPP345
	GD24RT-30.02-06-M1 KRCP320ST
	GD24RT-30.02-06-M1 KRP1340
	GD24RT-30.02-06-M1 KRPP345

Insert	Designation
4.0	 GD24LT-40.03-04-M1 KRCP320ST
	GD24LT-40.03-04-M1 KRP1340
	GD24LT-40.03-04-M1 KRPP345
	 GD24NT-40.03-00-M1 KRCP320ST
	GD24NT-40.03-00-M1 KRP1340
	GD24NT-40.03-00-M1 KRPP345
	 GD24RT-40.03-04-M1 KRCP320ST
	GD24RT-40.03-04-M1 KRP1340
	GD24RT-40.03-04-M1 KRPP345
5.0	 GD24NT-50.04-00-M1 KRCP320ST
	GD24NT-50.04-00-M1 KRP1340
	GD24NT-50.04-00-M1 KRPP345
6.0	 GD24NT-60.04-00-M1 KRCP320ST
	GD24NT-60.04-00-M1 KRP1340
	GD24NT-60.04-00-M1 KRPP345
8.0	 GD35NT-80.08-00-M1 KRP1340

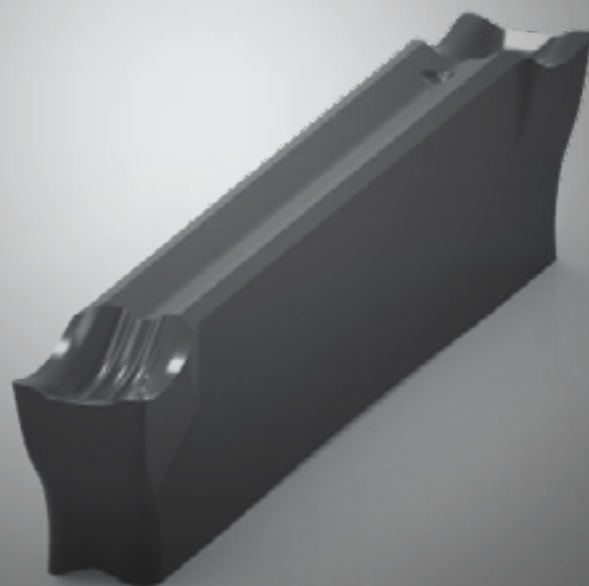
BEYOND
THE
MACHINING

F1 2-5

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P

M



GD – F1

Insert	Designation
2.0	GD24LT-20.015-06-F1 KRCP320ST
	GD24LT-20.015-06-F1 KRP1340
	GD24LT-20.015-06-F1 KRPP345
	GD24NT-20.02-00-F1 KRCP320ST
	GD24NT-20.02-00-F1 KRP1340
	GD24NT-20.02-00-F1 KRPP345
	GD24RT-20.015-06-F1 KRCP320ST
	GD24RT-20.015-06-F1 KRP1340
	GD24RT-20.015-06-F1 KRPP345
3.0	GD24LT-30.02-06-F1 KRCP320ST
	GD24LT-30.02-06-F1 KRP1340
	GD24LT-30.02-06-F1 KRPP345
	GD24NT-30.02-00-F1 KRCP320ST
	GD24NT-30.02-00-F1 KRP1340
	GD24NT-30.02-00-F1 KRPP345
	GD24RT-30.02-06-F1 KRCP320ST
	GD24RT-30.02-06-F1 KRP1340
	GD24RT-30.02-06-F1 KRPP345
4.0	GD24LT-40.03-04-F1 KRCP320ST
	GD24LT-40.03-04-F1 KRP1340
	GD24LT-40.03-04-F1 KRPP345
	GD24NT-40.03-00-F1 KRCP320ST
	GD24NT-40.03-00-F1 KRP1340
	GD24NT-40.03-00-F1 KRPP345
	GD24RT-40.03-04-F1 KRCP320ST
	GD24RT-40.03-04-F1 KRP1340
	GD24RT-40.03-04-F1 KRPP345
5.0	GD24RT-50.04-00-F1 KRCP320ST
	GD24RT-50.04-00-F1 KRP1340
	GD24RT-50.04-00-F1 KRPP345

ST1 1,5-6

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M

S



GD – ST1

Insert	Designation
1.5	GD24NT-15.015-00-ST1 KRCP320ST
	GD24NT-15.015-00-ST1 KRP1340
	GD24NT-15.015-00-ST1 KRPP345
2.0	GD24LT-20.015-06-ST1 KRCP320ST
	GD24LT-20.015-06-ST1 KRP1340
	GD24LT-20.015-06-ST1 KRPP345
	GD24NT-20.02-00-ST1 KRCP320ST
	GD24NT-20.02-00-ST1 KRP1340
	GD24NT-20.02-00-ST1 KRPP345
	GD24RT-20.015-06-ST1 KRCP320ST
	GD24RT-20.015-06-ST1 KRP1340
	GD24RT-20.015-06-ST1 KRPP345
3.0	GD24LT-30.02-06-ST1 KRCP320ST
	GD24LT-30.02-06-ST1 KRP1340
	GD24LT-30.02-06-ST1 KRPP345
	GD24NT-30.02-00-ST1 KRCP320ST
	GD24NT-30.02-00-ST1 KRP1340
	GD24NT-30.02-00-ST1 KRPP345
	GD24RT-30.02-06-ST1 KRCP320ST
	GD24RT-30.02-06-ST1 KRP1340
	GD24RT-30.02-06-ST1 KRPP345

BEYOND TURNING MACHINING

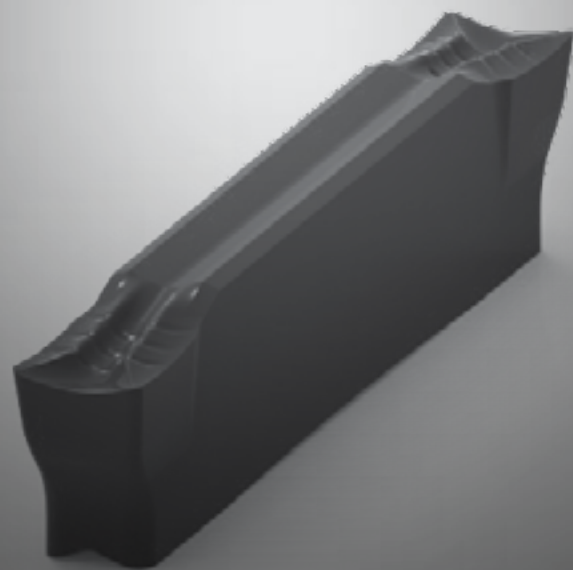
Insert	Designation
4.0	
	GD24LT-40.03-04-ST1 KRCP320ST
	GD24LT-40.03-04-ST1 KRP1340
	GD24LT-40.03-04-ST1 KRPP345
	GD24NT-40.04-00-ST1 KRCP320ST
	GD24NT-40.04-00-ST1 KRP1340
	GD24NT-40.04-00-ST1 KRPP345
	GD24RT-40.03-04-ST1 KRCP320ST
	GD24RT-40.03-04-ST1 KRP1340
	GD24RT-40.03-04-ST1 KRPP345
5.0	
	GD24NT-50.04-00-ST1 KRPP345
	GD24NT-50.04-00-ST1 KRP1340
6.0	
	GD24NT-60.04-00-ST1 KRPP345
	GD24NT-60.04-00-ST1 KRP1340
6.0	GD24NT-60.04-00-ST1 KRCP320ST

T 2-6

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P

M



GD - T

Insert	Designation
  	GD24LT-20.02-06-T KRCP320ST
	GD24LT-20.02-06-T KRP1340
	GD24LT-20.02-06-T KRPP345
	GD24NT-20.02-00-T KRCP320ST
	GD24NT-20.02-00-T KRP1340
	GD24NT-20.02-00-T KRPP345
	GD24RT-20.02-06-T KRCP320ST
	GD24RT-20.02-06-T KRP1340
	GD24RT-20.02-06-T KRPP345

  	GD24LT-30.02-06-T KRCP320ST
	GD24LT-30.02-06-T KRP1340
	GD24LT-30.02-06-T KRPP345
	GD24NT-30.03-00-T KRCP320ST
	GD24NT-30.03-00-T KRP1340
	GD24NT-30.03-00-T KRPP345
	GD24RT-30.02-06-T KRCP320ST
	GD24RT-30.02-06-T KRP1340
	GD24RT-30.02-06-T KRPP345

Insert	Designation
4.0	GD24NT-40.04-00-T KRCP320ST
	GD24NT-40.04-00-T KRP1340
	GD24NT-40.04-00-T KRPP345
5.0	GD24NT-50.04-00-T KRCP320ST
	GD24NT-50.04-00-T KRP1340
	GD24NT-50.04-00-T KRPP345
6.0	GD24NT-60.04-00-T KRCP320ST
	GD24NT-60.04-00-T KRP1340
	GD24NT-60.04-00-T KRPP345

BEYOND
THE
MACHINING

M

2-6

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GD – M

Insert	Designation
2.0	GD24NR-20.00-00-M KRCP320ST
	GD24NR-20.00-00-M KRP1340
	GD24NR-20.00-00-M KRPP345
3.0	GD24NR-30.00-00-M KRCP320ST
	GD24NR-30.00-00-M KRP1340
	GD24NR-30.00-00-M KRPP345
4.0	GD24NR-40.00-00-M KRCP320ST
	GD24NR-40.00-00-M KRP1340
	GD24NR-40.00-00-M KRPP345
5.0	GD24NR-50.00-00-M KRCP320ST
	GD24NR-50.00-00-M KRP1340
	GD24NR-50.00-00-M KRPP345
6.0	GD24NR-60.00-00-M KRCP320ST
	GD24NR-60.00-00-M KRP1340
	GD24NR-60.00-00-M KRPP345

MM

2 - 6

M

LM

2 - 6

N

GD - MM

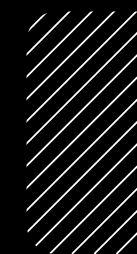
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	GD24NR-20.00-00-MM KRPP345
3.0 	GD24NR-30.00-00-MM KRCP320ST
	GD24NR-30.00-00-MM KRP1340
	GD24NR-30.00-00-MM KRPP345
4.0 	GD24NR-40.00-00-MM KRCP320ST
	GD24NR-40.00-00-MM KRP1340
	GD24NR-40.00-00-MM KRPP345
5.0 	GD24NR-50.00-00-MM KRCP320ST
	GD24NR-50.00-00-MM KRP1340
	GD24NR-50.00-00-MM KRPP345
6.0 	GD24NR-60.00-00-MM KRCP320ST
	GD24NR-60.00-00-MM KRP1340
	GD24NR-60.00-00-MM KRPP345

Insert	Designation
	GD24NT-20.02-00-LM KRWN715
	GD24NT-30.03-00-LM KRWN715
	GD24NT-40.04-00-LM KRWN715
	GD24NT-50.04-00-LM KRWN715
	GD24NT-60.05-00-LM KRWN715



BEYOND THE MACHINING

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GO
Single-sided

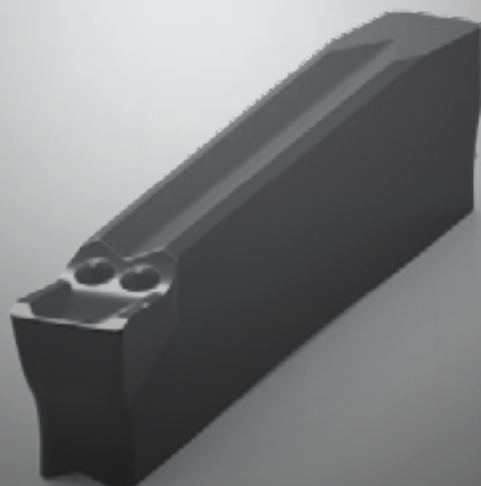


M1₂₋₄

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GO – M1

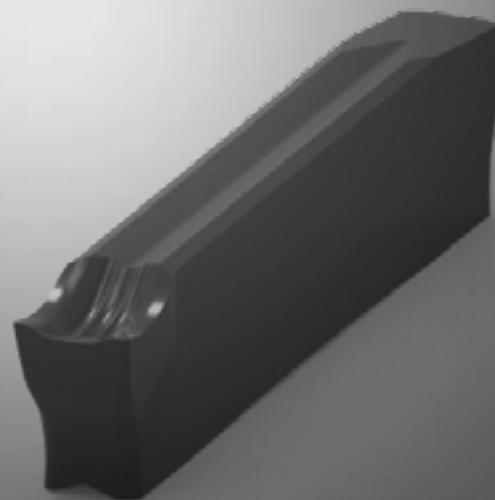
Insert	Designation
2.0 	GO24LT-20.015-06-M1 KRCP320ST
	GO24LT-20.015-06-M1 KRP1340
	GO24LT-20.015-06-M1 KRPP345
2.0 	GO24NT-20.02-00-M1 KRCP320ST
	GO24NT-20.02-00-M1 KRP1340
	GO24NT-20.02-00-M1 KRPP345
2.0 	GO24RT-20.015-06-M1 KRCP320ST
	GO24RT-20.015-06-M1 KRP1340
	GO24RT-20.015-06-M1 KRPP345
3.0 	GO24LT-30.02-06-M1 KRCP320ST
	GO24LT-30.02-06-M1 KRP1340
	GO24LT-30.02-06-M1 KRPP345
3.0 	GO24NT-30.02-00-M1 KRCP320ST
	GO24NT-30.02-00-M1 KRP1340
	GO24NT-30.02-00-M1 KRPP345
3.0 	GO24RT-30.02-06-M1 KRCP320ST
	GO24RT-30.02-06-M1 KRP1340
	GO24RT-30.02-06-M1 KRPP345
4.0 	GO24NT-40.03-00-M1 KRCP320ST
	GO24NT-40.03-00-M1 KRP1340
	GO24NT-40.03-00-M1 KRPP345

F1 2-4

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P

M



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GO – F1

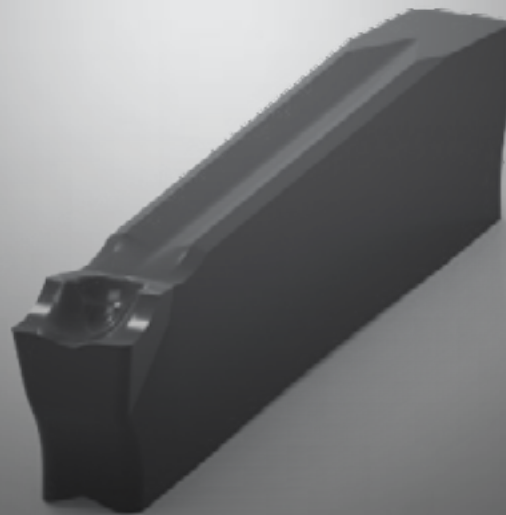
Insert	Designation
2.0 	GO24LT-20.015-06-F1 KRCP320ST
	GO24LT-20.015-06-F1 KRP1340
	GO24LT-20.015-06-F1 KRPP345
2.0 	GO24NT-20.02-00-F1 KRCP320ST
	GO24NT-20.02-00-F1 KRP1340
	GO24NT-20.02-00-F1 KRPP345
2.0 	GO24RT-20.015-06-F1 KRCP320ST
	GO24RT-20.015-06-F1 KRP1340
	GO24RT-20.015-06-F1 KRPP345
3.0 	GO24LT-30.02-06-F1 KRCP320ST
	GO24LT-30.02-06-F1 KRP1340
	GO24LT-30.02-06-F1 KRPP345
3.0 	GO24NT-30.02-00-F1 KRCP320ST
	GO24NT-30.02-00-F1 KRP1340
	GO24NT-30.02-00-F1 KRPP345
3.0 	GO24RT-30.02-06-F1 KRCP320ST
	GO24RT-30.02-06-F1 KRP1340
	GO24RT-30.02-06-F1 KRPP345
4.0 	GO24NT-40.03-00-F1 KRCP320ST
	GO24NT-40.03-00-F1 KRP1340
	GO24NT-40.03-00-F1 KRPP345

ST1₂₋₄

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M

S



GO – ST1

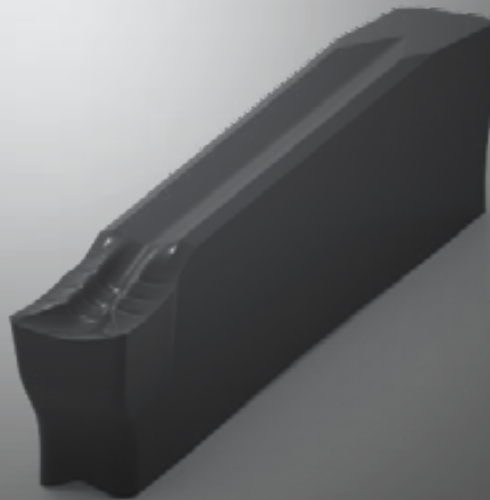
Insert	Designation
2.0 	GO24NT-20.02-00-ST1 KRCP320ST
	GO24NT-20.02-00-ST1 KRP1340
	GO24NT-20.02-00-ST1 KRPP345
3.0 	GO24NT-30.03-00-ST1 KRCP320ST
	GO24NT-30.03-00-ST1 KRP1340
	GO24NT-30.03-00-ST1 KRPP345
4.0 	GO24NT-40.04-00-ST1 KRCP320ST
	GO24NT-40.04-00-ST1 KRP1340
	GO24NT-40.04-00-ST1 KRPP345

T 2-4

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P

M



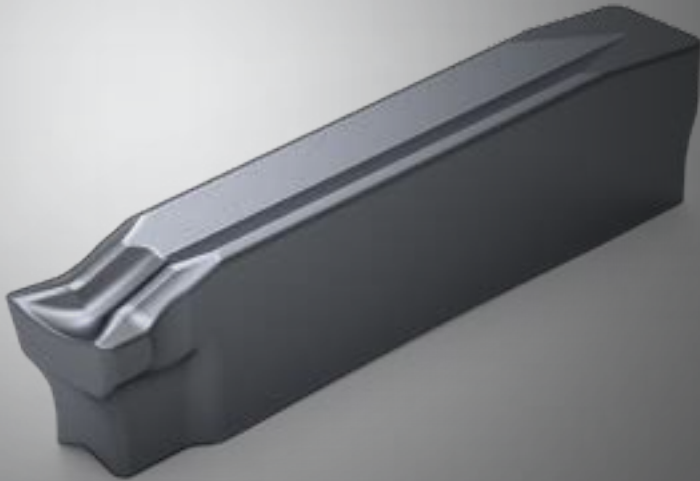
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GO - T

	Insert	Designation
2.0		GO24NT-20.02-00-T KRCP320ST
		GO24NT-20.02-00-T KRP1340
		GO24NT-20.02-00-T KRPP345
3.0		GO24NT-30.03-00-T KRCP320ST
		GO24NT-30.03-00-T KRP1340
		GO24NT-30.03-00-T KRPP345
4.0		GO24NT-40.04-00-T KRCP320ST
		GO24NT-40.04-00-T KRP1340
		GO24NT-40.04-00-T KRPP345

LM₂₋₄

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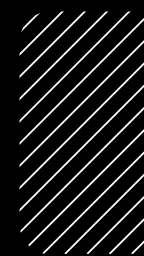
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GO – LM

Insert	Designation
	GO24NT-20.02-00-LM KRWN715
	GO24NT-30.03-00-LM KRWN715
	GO24NT-40.04-00-LM KRWN715

BEYOND THE MACHINING

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GS

Small size insert

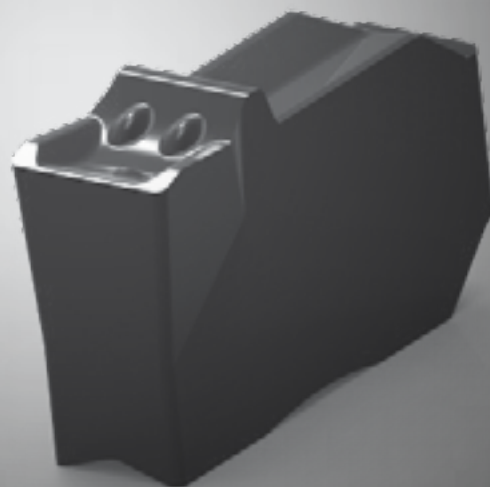


M1 2-6

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P

K



GS – M1

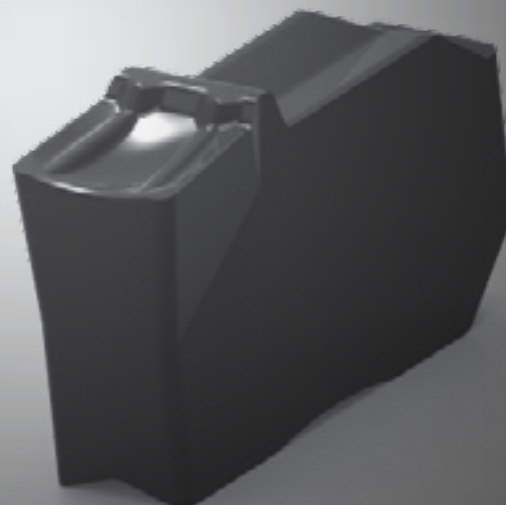
Insert	Designation
2.0 	GSNT-20.02-00-M1 KRCP320ST
	GSNT-20.02-00-M1 KRPP345
	GSNT-20.02-00-M1 KRP1340
3.0 	GSNT-30.02-00-M1 KRCP320ST
	GSNT-30.02-00-M1 KRPP345
	GSNT-30.02-00-M1 CT1340
4.0 	GSNT-40.03-00-M1 KRCP320ST
	GSNT-40.03-00-M1 KRPP345
	GSNT-40.03-00-M1 KRP1340
5.0 	GSNT-50.03-00-M1 KRCP320ST
	GSNT-50.03-00-M1 KRPP345
	GSNT-50.03-00-M1 KRP1340
6.0 	GSNT-60.04-00-M1 KRCP320ST
	GSNT-60.04-00-M1 KRPP345
	GSNT-60.04-00-M1 KRP1340

M2₂₋₆

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P

K



GS – M2

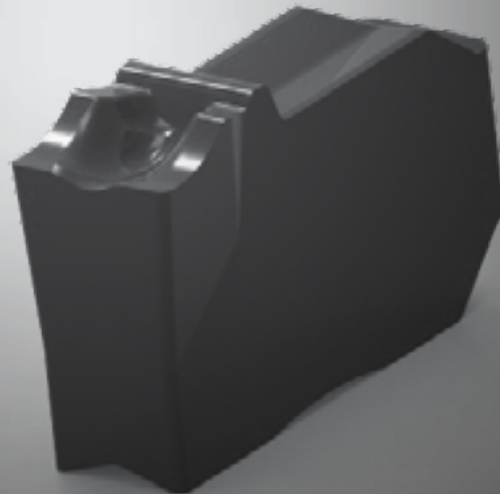
Insert	Designation
2.0 	GSNT-20.02-00-M2 KRCP320ST
	GSNT-20.02-00-M2 KRPP345
	GSNT-20.02-00-M2 KRP1340
3.0 	GSNT-30.03-00-M2 KRCP320ST
	GSNT-30.03-00-M2 KRPP345
	GSNT-30.03-00-M2 KRP1340
4.0 	GSNT-40.04-00-M2 KRCP320ST
	GSNT-40.04-00-M2 KRPP345
	GSNT-40.04-00-M2 KRP1340
5.0 	GSNT-50.04-00-M2 KRCP320ST
	GSNT-50.04-00-M2 KRPP345
	GSNT-50.04-00-M2 KRP1340
6.0 	GSNT-60.05-00-M2 KRCP320ST
	GSNT-60.05-00-M2 KRPP345
	GSNT-60.05-00-M2 KRP1340

ST1₂₋₆

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M

S



GS – ST1

Insert	Designation
2.0 	GSNT-20.02-00-ST1 KRP1340
	GSNT-20.02-00-ST1 KRCP320ST
	GSNT-20.02-00-ST1 KRPP345
3.0 	GSNT-30.02-00-ST1 KRP1340
	GSNT-30.02-00-ST1 KRCP320ST
	GSNT-30.02-00-ST1 KRPP345
4.0 	GSNT-40.04-00-ST1 KRCP320ST
	GSNT-40.04-00-ST1 KRP1340
	GSNT-40.04-00-ST1 KRPP345
5.0 	GSNT-50.04-00-ST1 KRCP320ST
	GSNT-50.04-00-ST1 KRP1340
	GSNT-50.04-00-ST1 KRPP345
6.0 	GSNT-60.04-00-ST1 KRCP320ST
	GSNT-60.04-00-ST1 KRP1340
	GSNT-60.04-00-ST1 KRPP345

LM

2 - 6



M

2 - 6



GS - LM

Insert	Designation
2.0	GSNT-20.02-00-LM KRWN715
3.0	GSNT-30.03-00-LM KRWN715
4.0	GSNT-40.04-00-LM KRWN715
5.0	GSNT-50.04-00-LM KRWN715
6.0	GSNT-60.04-00-LM KRWN715



GS - M

Insert	Designation
2.0	GSNR-20.00-00-M KRP1340
3.0	GSNR-30.00-00-M KRP1340
4.0	GSNR-40.00-00-M KRP1340
5.0	GSNR-50.00-00-M KRP1340
6.0	GSNR-60.00-00-M KRP1340



MM 2-6

M



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TOOLING SOLUTIONS
BY KARCAN

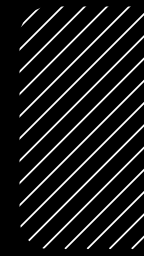
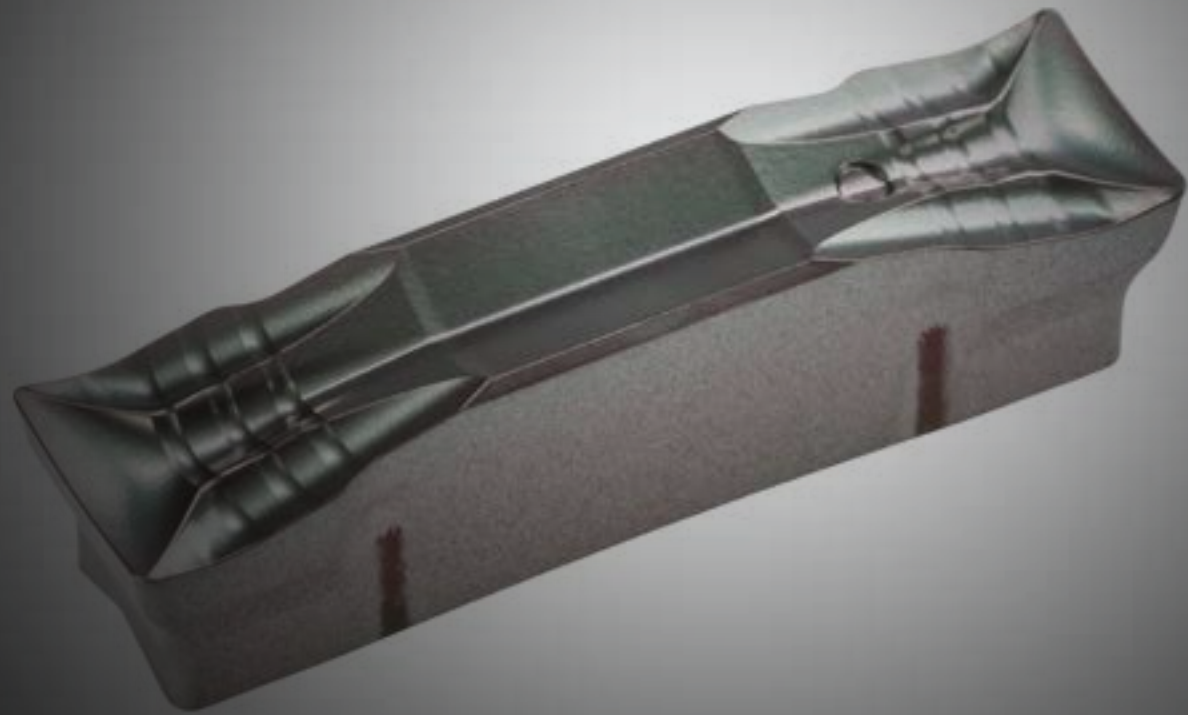
GS – MM

Insert	Designation
2.0	GSR-20.00-00-MM KRP1340
3.0	GSR-30.00-00-MM KRP1340
4.0	GSR-40.00-00-MM KRP1340
5.0	GSR-50.00-00-MM KRP1340
6.0	GSR-60.00-00-MM KRP1340



BEYOND THE MACHINING

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GA
Axial grooving



T 3 - 5

GA - T

Insert	Designation
3.0 	GA24NT-30.03-00-T KRCP320ST
	GA24NT-30.03-00-T KRP1340
	GA24NT-30.03-00-T KRPP345
4.0 	GA24NT-40.04-00-T KRCP320ST
	GA24NT-40.04-00-T KRP1340
	GA24NT-40.04-00-T KRPP345
5.0 	GA24NT-50.04-00-T KRCP320ST
	GA24NT-50.04-00-T KRP1340
	GA24NT-50.04-00-T KRPP345



M 3 - 4

GA - T

Insert	Designation
3.0 	GA24NR-30.00-00-M KRCP320ST
	GA24NR-30.00-00-M KRP1340
	GA24NR-30.00-00-M KRPP345
4.0 	GA24NR-40.00-00-M KRCP320ST
	GA24NR-40.00-00-M KRP1340
	GA24NR-40.00-00-M KRPP345



BEYOND THE MACHINING

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Tools



Blade
GO/GD



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2 – 6

Blades	Designation	T _{max} [mm]
	GBL-2602-G02402	25
	GBL-3202-G02402	25
	GBR-2602-G02402	25
	GBR-3202-G02402	25
	GBN-2602-G02402	25
	GBN-3202-G02402	25
	GBN-2603-G02403	35
	GBN-3203-G02403	50
	GBN-2604-G02404	35
	GBN-3204-G02404	50
	GBN-3205-G02405	60
	GBN-3206-G02406	60

Spare parts *	Designation
	GK-3 (2 and 3 mm)
	GK-4 (4, 5 and 6 mm)

For information on how to use the system go to page 98.

Monoblocks

GO/GD



Tool	Designation	T _{max} [mm]	h	
	GMEL-12-GD2402-K-T13	13	12	L
	GMER-12-GD2402-K-T13	13	12	R
	GMEL-16-GD2402-K-T13	13	16	L
	GMER-16-GD2402-K-T13	13	16	R
	GMEL-20-GD2402-K-T13	13	20	L
	GMER-20-GD2402-K-T13	13	20	R
	GMEL-12-GD24015-K-T23	23	12	L
	GMER-12-GD24015-K-T23	23	12	R
	GMEL-16-GD24015-K-T23	23	16	L
	GMER-16-GD24015-K-T23	23	16	R

Spare parts	Designation
	Key T15
	Key T20
	Key SW4
	M3.5X14,0/T15 (for h=12)
	M4.0X16/T20 (for h=16)
	M4.0X18/T20 (for h=20)
	M5.0X20

Tool	Designation					
		T _{max} [mm]	h			
	GMEL-12-GD2403-K-T13	13	12	L		
	GMER-12-GD2403-K-T13	13	12	R		
	GMEL-16-GD2403-K-T13	13	16	L		
	GMER-16-GD2403-K-T13	13	16	R		
	GMEL-20-GD2403-K-T13	13	20	L		
	GMER-20-GD2403-K-T13	13	20	R		
	GMEL-25-GD2403-K-T13	13	25	L		
	GMER-25-GD2403-K-T13	13	25	R		
	GMEL-16-GD2403-K-T25	25	16	L		
	GMER-16-GD2403-K-T25	25	16	R		
	GMEL-20-GD2403-K-T25	25	20	L		
	GMER-20-GD2403-K-T25	25	20	R		
	GMEL-25-GD2403-K-T25	25	25	L		
	GMER-25-GD2403-K-T25	25	25	R		
	GMEL-32-GD2403-P-T25	25	32	L		
	GMER-32-GD2403-P-T25	25	32	R		
	GMEL-40-GD2403-S-T25	25	40	L		
	GMER-40-GD2403-S-T25	25	40	R		

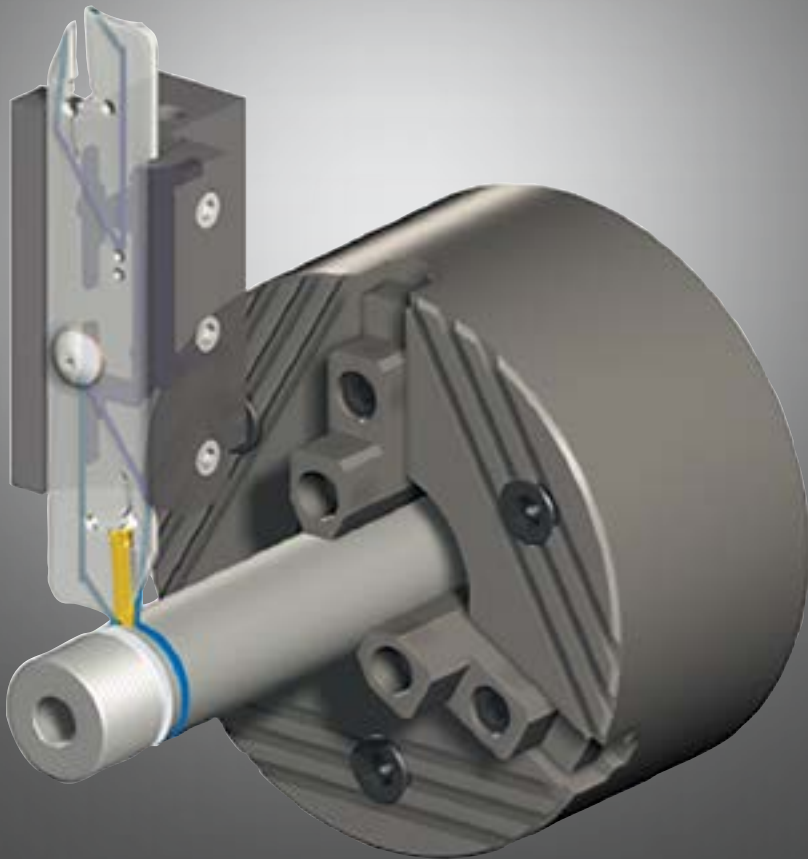
Spare parts	Designation
	Key T15
	Key T20
	M3.5X14.0/T15 (for h=12)
	M4.0X16/T20 (for h=16)
	M4.0X18/T20 (for h=20/25)

Tool	Designation					
		T _{max} [mm]	h			
	GMEL-16-GD2404-K-T25	25	16	L		
	GMER-16-GD2404-K-T25	25		R		
	GMEL-20-GD2404-K-T25	25	20	L		
	GMER-20-GD2404-K-T25	25		R		
	GMEL-25-GD2404-K-T25	25	25	L		
	GMER-25-GD2404-K-T25	25		R		
	GMEL-20-GD2405-M-T25	25	20	L		
	GMER-20-GD2405-M-T25	25		R		
	GMEL-25-GD2405-M-T25	25	25	L		
	GMER-25-GD2405-M-T25	25		R		
	GMEL-20-GD2406-M-T25	25	20	L		
	GMER-20-GD2406-M-T25	25		R		
	GMEL-25-GD2406-M-T25	25	25	L		
	GMER-25-GD2406-M-T25	25		R		
	GMEL-32-GD2406-P-T25	25	32	L		
	GMER-32-GD2406-P-T25	25	32	R		
	GMEL-40-GD2406-S-T25	25	40	L		
	GMER-40-GD2406-S-T25	25	40	R		
	GMEL-25-GD3508-P-T32	32	25	L		
	GMER-25-GD3508-P-T32	32	25	R		
	GMEL-32-GD3508-P-T32	32	32	L		
	GMER-32-GD3508-P-T32	32	32	R		

Spare parts	Designation
	Key T20
	M4.0X16 T20 (for h=16)
	M4.0X18/T20 (for h=20/25)
	Key SW5
	M6.0X20

Blades GO/GD

with internal cooling



Blades	Designation	T _{max} [mm]
	GBL-2602-G02402-C	25
	GBL-3202-G02402-C	25
	GBR-2602-G02402-C	25
	GBR-3202-G02402-C	25
	GBN-2602-G02402-C	25
	GBN-3202-G02402-C	25
	GBN-2603-G02403-C	35
	GBN-3203-G02403-C	50
	GBN-2604-G02404-C	35
	GBN-3204-G02404-C	50
	GBN-3205-G02405-C	60
	GBN-3206-G02406-C	60

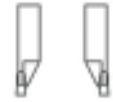
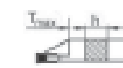
Spare parts	Designation
	Key T15 58MM
	Coolant screw plug M4X3

Spare parts *	Designation
	GK-3 (2 and 3 mm)
	GK-4 (4, 5 and 6 mm)

For information on how to use the system go to page 98.

Monoblocks GO/GD

with internal cooling



Tool	Designation	T _{max} [mm]	h	L
	GMEL-16-GD2402-K-T13-C	13	16	L
	GMER-16-GD2402-K-T13-C	13	16	R
	GMEL-20-GD2402-K-T13-C	13	25	L
	GMER-20-GD2402-K-T13-C	13	25	R
	GMEL-16-GD2403-K-T25-C	25	16	L
	GMER-16-GD2403-K-T25-C	25	16	R
	GMEL-20-GD2403-K-T25-C	25	20	L
	GMER-20-GD2403-K-T25-C	25	20	R
	GMEL-25-GD2403-K-T25-C	25	25	L
	GMER-25-GD2403-K-T25-C	25	25	R
	GMEL-16-GD2404-K-T25-C	25	16	L
	GMER-16-GD2404-K-T25-C	25	16	R
	GMEL-20-GD2404-K-T25-C	25	20	L
	GMER-20-GD2404-K-T25-C	25	20	R
	GMEL-25-GD2404-K-T25-C	25	25	L
	GMER-25-GD2404-K-T25-C	25	25	R
	GMEL-32-GD2403-P-T25-C	25	32	L
	GMER-32-GD2403-P-T25-C	25	32	R
	GMEL-32-GD2404-P-T25-C	25	32	L
	GMER-32-GD2404-P-T25-C	25	32	R
	GMEL-40-GD2403-S-T25-C	25	40	L
	GMER-40-GD2403-S-T25-C	25	40	R
	GMEL-40-GD2404-S-T25-C	25	40	L
	GMER-40-GD2404-S-T25-C	25	40	R

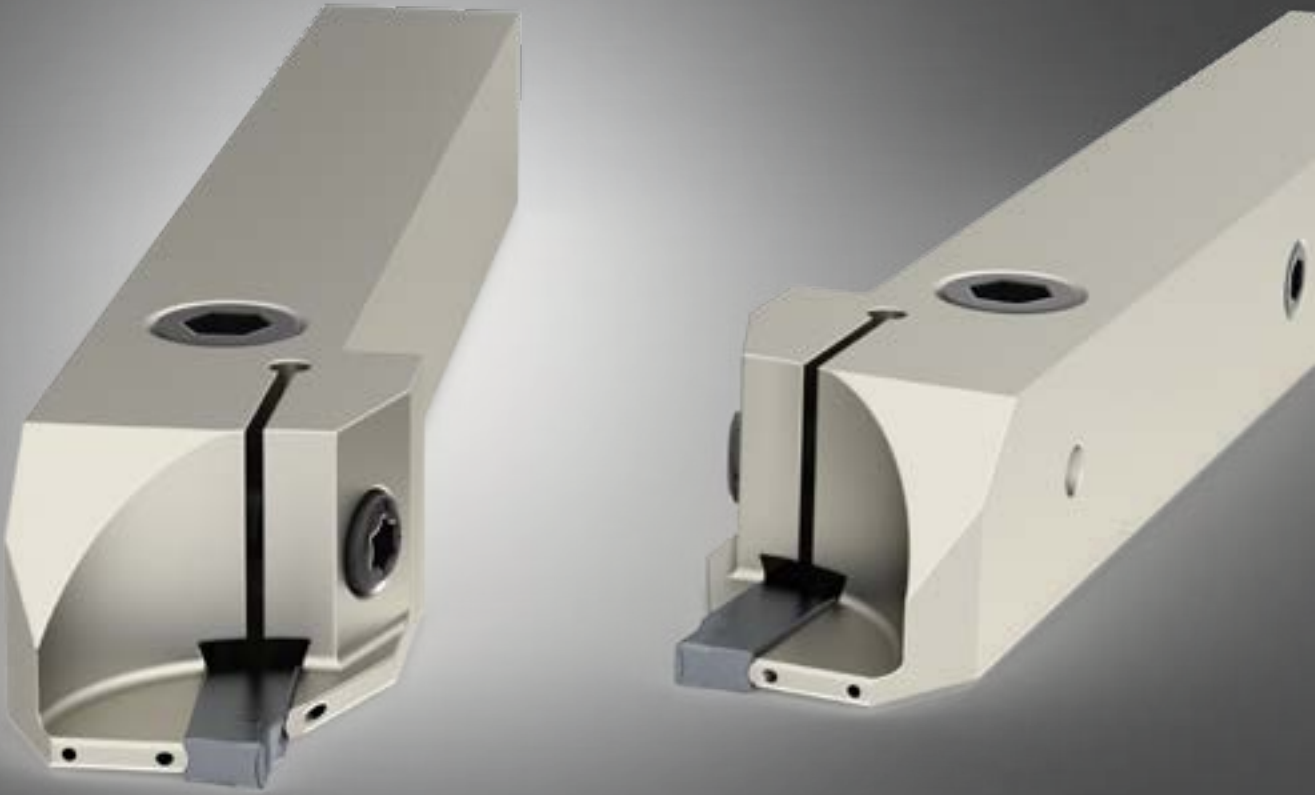




Tool	Designation	T _{max} [mm]	h	
	GMEL-20-GD2405-M-T25-C	25	20	L
	GMER-20-GD2405-M-T25-C	25	20	R
	GMEL-25-GD2405-M-T25-C	25	25	L
	GMER-25-GD2405-M-T25-C	25	25	R
	GMEL-20-GD2406-M-T25-C	25	20	L
	GMER-20-GD2406-M-T25-C	25	20	R
	GMEL-25-GD2406-M-T25-C	25	25	L
	GMER-25-GD2406-M-T25-C	25	25	R
	GMEL-40-GD3508-P-T32-C	32	40	L
	GMER-40-GD3508-P-T32-C	32	40	R

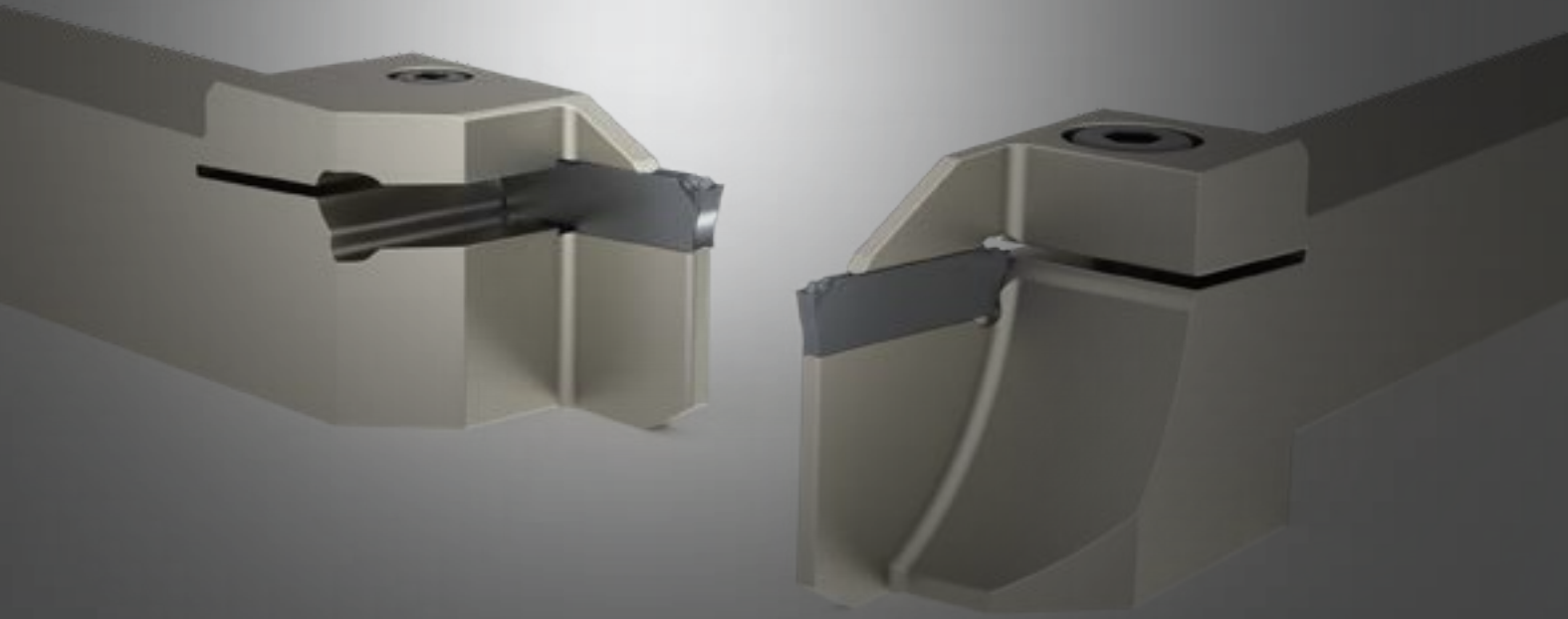
Spare parts	Designation
	Key SW5
	M6.0x20
	M6x6 DIN 913
	G1/8 DIN 913

BEYOND THE MACHINING



Monoblocks GO/GD

– R (reinforced)



Tool	Designation	T _{max} [mm]	h	
	GMEL-12-GD2402-K-T13-R	13	12	L
	GMER-12-GD2402-K-T13-R	13		R
	GMEL-16-GD2402-K-T13-R	13	16	L
	GMER-16-GD2402-K-T13-R	13		R
	GMEL-12-GD2402-K-T21-R	21	12	L
	GMER-12-GD2402-K-T21-R	21		R
	GMEL-16-GD2402-K-T21-R	21	16	L
	GMER-16-GD2402-K-T21-R	21		R
	GMEL-12-GD2403-K-T13-R	13	12	L
	GMER-12-GD2403-K-T13-R	13		R
	GMEL-16-GD2403-K-T13-R	13	16	L
	GMER-16-GD2403-K-T13-R	13		R
	GMEL-12-GD2403-K-T21-R	21	12	L
	GMER-12-GD2403-K-T21-R	21		R
	GMEL-16-GD2403-K-T21-R	21	16	L
	GMER-16-GD2403-K-T21-R	21		R

Spare parts

Designation



Key T15

M4.0X14/T15

Monoblocks GO/GD

-R (reinforced) with internal cooling



Tool	Designation	T _{max} [mm]	h	
	GMEL-12-GD2402-K-T13-R-C	13	12	L
	GMER-12-GD2402-K-T13-R-C	13	12	R
	GMEL-16-GD2402-K-T13-R-C	13	16	L
	GMER-16-GD2402-K-T13-R-C	13	16	R
	GMEL-16-GD2402-K-T21-R-C	21	16	L
	GMER-16-GD2402-K-T21-R-C	21	16	R
	GMEL-12-GD2403-K-T13-R-C	13	12	L
	GMER-12-GD2403-K-T13-R-C	13	12	R
	GMEL-16-GD2403-K-T13-R-C	13	16	L
	GMER-16-GD2403-K-T13-R-C	13	16	R
	GMEL-16-GD2403-K-T21-R-C	21	16	L
	GMER-16-GD2403-K-T21-R-C	21	16	R

Spare parts



Designation

Key T15

M4.0X14/T15

M6.0X6.0 DIN 913

G1/8 DIN 913

Blades GS



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Blades	Designation	T _{max} [mm]
	GBR-2602-GS02	25
	GBL-2602-GS02	25
	GBR-3202-GS02	25
	GBL-3202-GS02	25
	GBN-2603-GS03	35
	GBN-3203-GS03	50

Blades	Designation	T _{max} [mm]
	GBN-2604-GS04	40
	GBN-3204-GS04	50
	GBN-3205-GS05	55
	GBN-3206-GS06	60

Spare parts *	Designation
	GK-3 (2 and 3 mm)
	GK-4 (4, 5 and 6 mm)

For information on how to use the system go to page 98.



Blades GS

with internal cooling

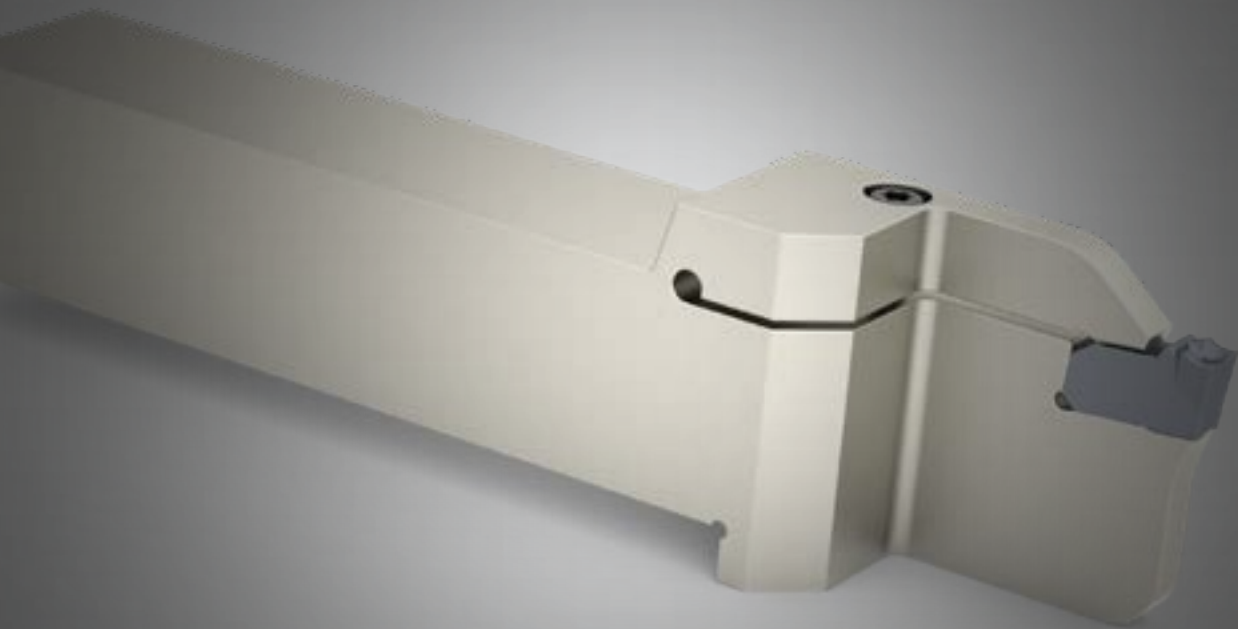


Blades	Designation	T _{max} [mm]
	GBL-2602-GS02-C	25
	GBL-3202-GS02-C	25
	GBR-2602-GS02-C	25
	GBR-3202-GS02-C	25
	GBN-2603-GS03-C	35
	GBN-3203-GS03-C	50
	GBN-2604-GS04-C	40
	GBN-3204-GS04-C	50

Spare parts *	Designation
	GK-3 (2 and 3 mm)
	GK-4 (4, 5 and 6 mm)

For information on how to use the system go to page 98.

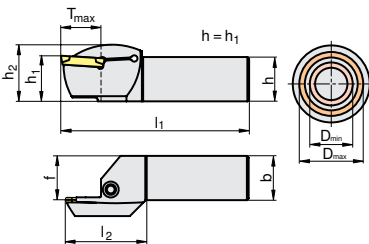
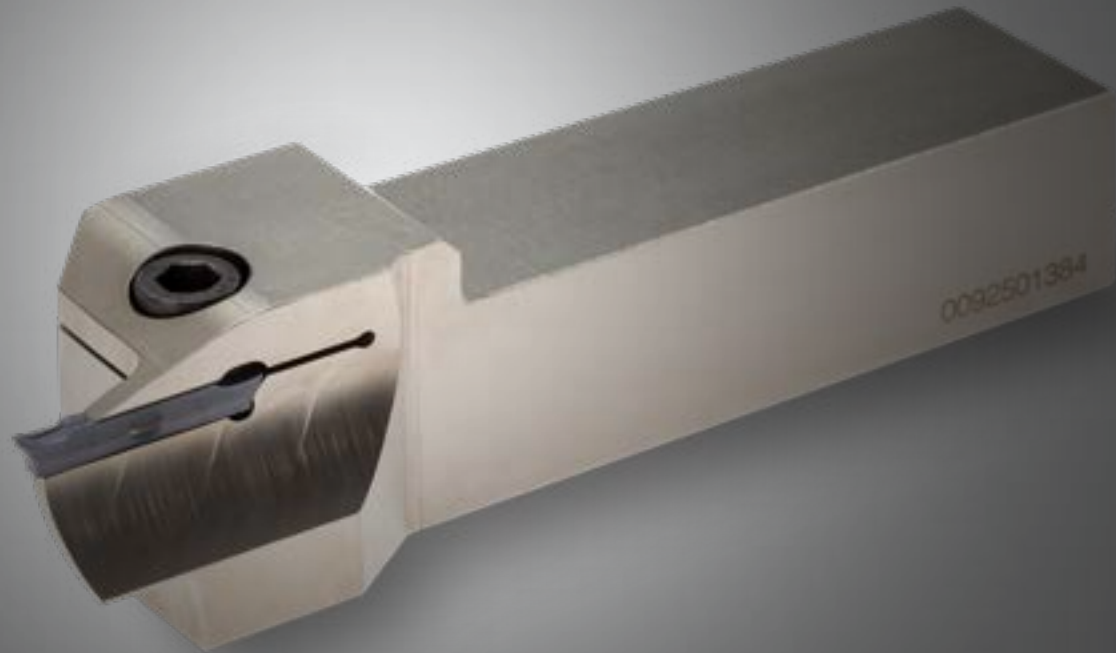
Monoblocks GS



Tool	Designation	T _{max} [mm]	h	
	GMEL-16-GS02-K-T20	20	16	L
	GMER-16-GS02-K-T20	20	16	R
	GMEL-16-GS03-K-T20	20	16	L
	GMER-16-GS03-K-T20	20	16	R
	GMEL-20-GS02-K-T20	20	20	L
	GMER-20-GS02-K-T20	20	20	R
	GMEL-20-GS03-K-T20	20	20	L
	GMER-20-GS03-K-T20	20	20	R
	GMEL-20-GS04-K-T25	25	20	L
	GMER-20-GS04-K-T25	25	20	R
	GMEL-20-GS05-K-T25	25	20	L
	GMER-20-GS05-K-T25	25	20	R
	GMEL-20-GS06-K-T25	25	20	L
	GMER-20-GS06-K-T25	25	20	R
	GMEL-25-GS03-M-T20	20	25	L
	GMER-25-GS03-M-T20	20	25	R
	GMEL-25-GS04-M-T25	25	25	L
	GMER-25-GS04-M-T25	25	25	R
	GMEL-25-GS05-M-T25	25	25	L
	GMER-25-GS05-M-T25	25	25	R
	GMEL-25-GS06-M-T32	32	25	L
	GMER-25-GS06-M-T32	32	25	R

Spare parts	Designation
	Key T20
	M4.0X18/T20

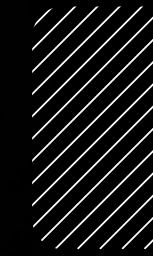
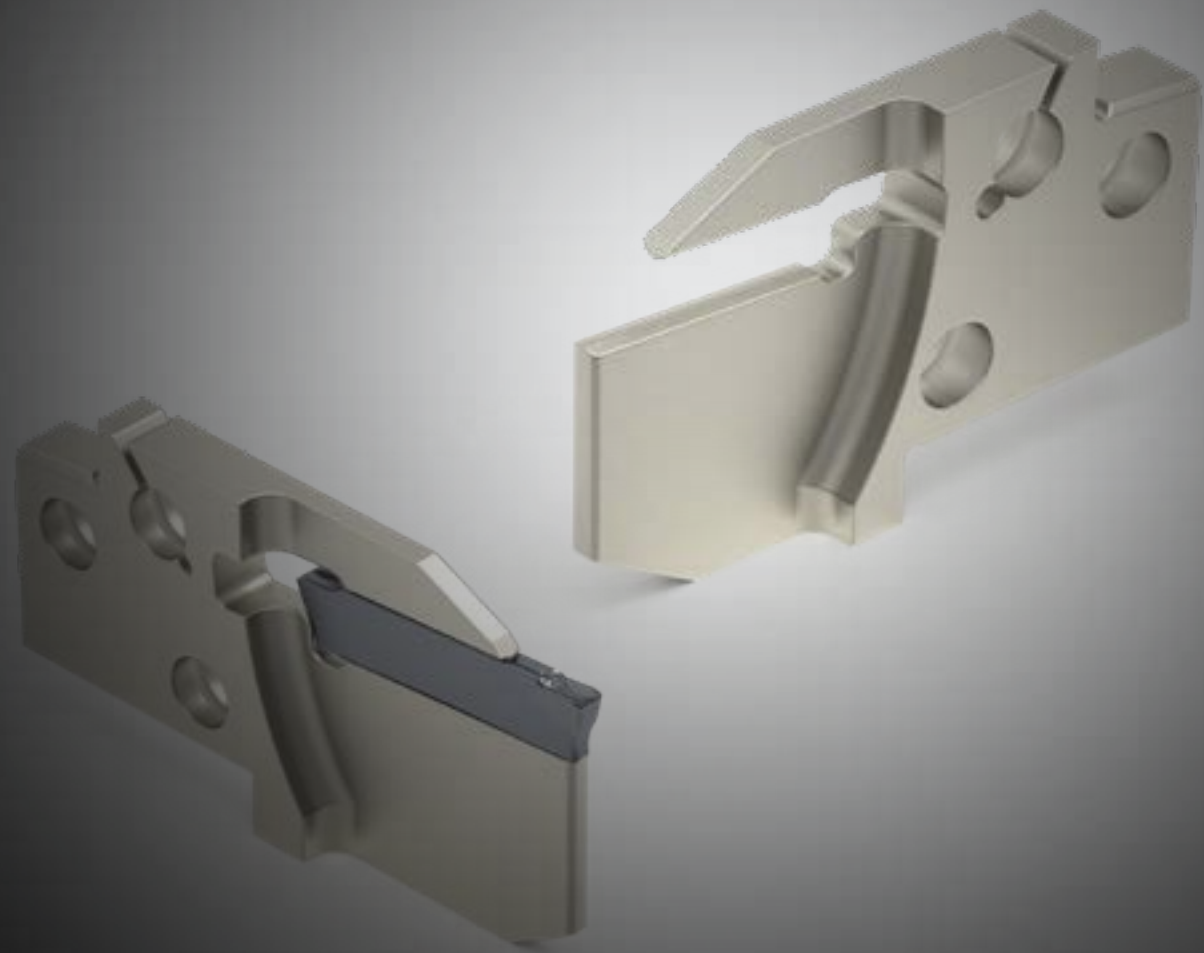
Monoblocks GA



Designation	s [mm]	T _{max} [mm]	D _{min} [mm]	D _{max} [mm]	h = h ₁ [mm]	h ₂ [mm]	b [mm]	l ₁ [mm]	l ₂ [mm]	f [mm]
GMAR-25-GA03-K-T13-40-50	3	13	40	50	25	33	25	125	39.7	24.3
GMAR-25-GA03-K-T13-50-60	3	13	50	60	25	33	25	125	39.7	24.3
GMAR-25-GA03-K-T13-60-70	3	13	60	70	25	33	25	125	39.7	24.3
GMAR-25-GA03-K-T13-75-100	3	13	75	100	25	33	25	125	39.7	24.3
GMAR-25-GA03-K-T13-100-140	3	13	100	140	25	33	25	125	39.7	24.3
GMAR-25-GA03-K-T13-140-200	3	13	140	200	25	33	25	125	39.7	24.3
GMAL-25-GA03-K-T13-40-50	3	13	40	50	25	33	25	125	39.7	24.3
GMAL-25-GA03-K-T13-50-60	3	13	50	60	25	33	25	125	39.7	24.3
GMAL-25-GA03-K-T13-60-70	3	13	60	70	25	33	25	125	39.7	24.3
GMAL-25-GA03-K-T13-75-100	3	13	75	100	25	33	25	125	39.7	24.3
GMAL-25-GA03-K-T13-100-140	3	13	100	140	25	33	25	125	39.7	24.3
GMAL-25-GA03-K-T13-140-200	3	13	140	200	25	33	25	125	39.7	24.3
GMAR-25-GA04-K-T13-40-50	4	13	40	50	25	33	25	125	39.7	24.3
GMAR-25-GA04-K-T13-50-60	4	13	50	60	25	33	25	125	39.7	24.3
GMAR-25-GA04-K-T13-60-70	4	13	60	70	25	33	25	125	39.7	24.3
GMAR-25-GA04-K-T13-75-100	4	13	75	100	25	33	25	125	39.7	24.3
GMAR-25-GA04-K-T13-100-140	4	13	100	140	25	33	25	125	39.7	24.3
GMAR-25-GA04-K-T13-140-200	4	13	140	200	25	33	25	125	39.7	24.3
GMAL-25-GA04-K-T13-40-50	4	13	40	50	25	33	25	125	39.7	24.3
GMAL-25-GA04-K-T13-50-60	4	13	50	60	25	33	25	125	39.7	24.3
GMAL-25-GA04-K-T13-60-70	4	13	60	70	25	33	25	125	39.7	24.3
GMAL-25-GA04-K-T13-75-100	4	13	75	100	25	33	25	125	39.7	24.3
GMAL-25-GA04-K-T13-100-140	4	13	100	140	25	33	25	125	39.7	24.3
GMAL-25-GA04-K-T13-140-200	4	13	140	200	25	33	25	125	39.7	24.3
GMAR-25-GA05-K-T13-45-60	5	20	45	60	25	33	25	150	39	23.3
GMAR-25-GA05-K-T13-60-75	5	20	60	75	25	33	25	150	39	23.3
GMAR-25-GA05-K-T13-75-100	5	28	75	100	25	33	25	150	47	23.3
GMAR-25-GA05-K-T13-100-180	5	28	100	180	25	33	25	150	47	23.3
GMAR-25-GA05-K-T13-180-400	5	32	180	400	25	33	25	150	51	23.3
GMAL-25-GA05-K-T13-45-60	5	20	45	60	25	33	25	150	39	23.3
GMAL-25-GA05-K-T13-60-75	5	20	60	75	25	33	25	150	39	23.3
GMAL-25-GA05-K-T13-75-100	5	28	75	100	25	33	25	150	47	23.3
GMAL-25-GA05-K-T13-100-180	5	28	100	180	25	33	25	150	47	23.3
GMAL-25-GA05-K-T13-180-400	5	32	180	400	25	33	25	150	51	23.3

BEYOND THE MACHINING

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Module ^{NEW}

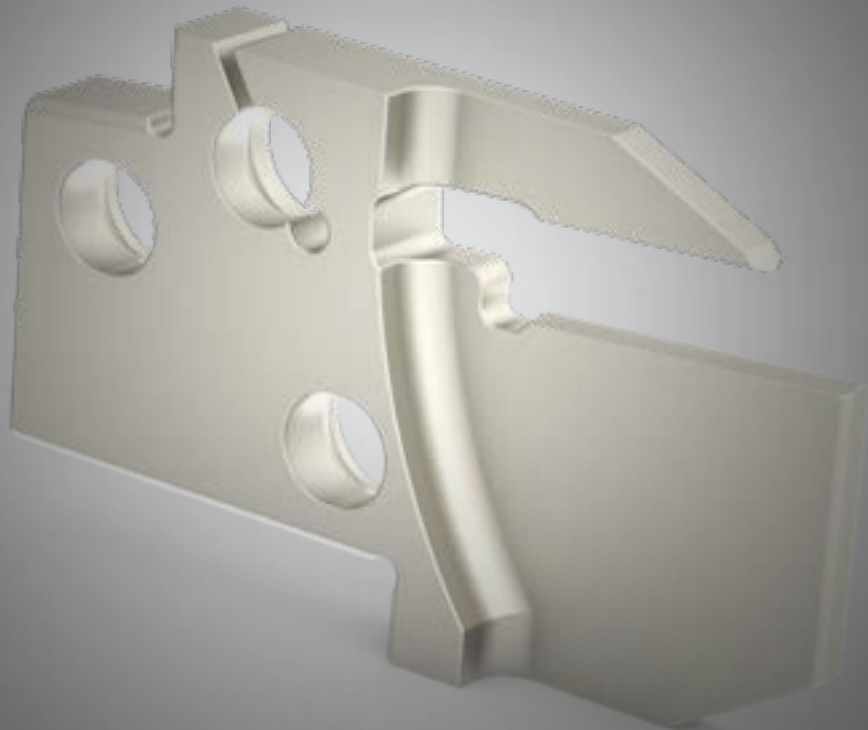




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Module GO/GD

Radial



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Tool	Designation	T _{max} [mm]	h	
	GEML-2002-G02402-T25	25	20	L
	GEMR-2002-G02402-T25	25	20	R
	GEML-2003-G02403-T25	25	20	L
	GEMR-2003-G02403-T25	25	20	R
	GEML-2004-G02404-T25	25	20	L
	GEMR-2004-G02404-T25	25	20	R
	GEML-2005-G02405-T25	25	20	L
	GEMR-2005-G02405-T25	25	20	R
	GEML-2006-G02406-T25	25	20	L
	GEMR-2006-G02406-T25	25	20	R
	GEML-2502-G02402-T25	25	25	L
	GEMR-2502-G02402-T25	25	25	R
	GEML-2503-G02403-T25	25	25	L
	GEMR-2503-G02403-T25	25	25	R
	GEML-2504-G02404-T25	25	25	L
	GEMR-2504-G02404-T25	25	25	R
	GEML-2505-G02405-T25	25	25	L
	GEMR-2505-G02405-T25	25	25	R
	GEML-2506-G02406-T25	25	25	L
	GEMR-2506-G02406-T25	25	25	R

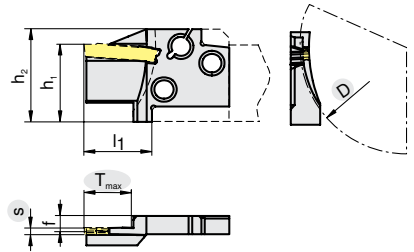


Module GA

Axial



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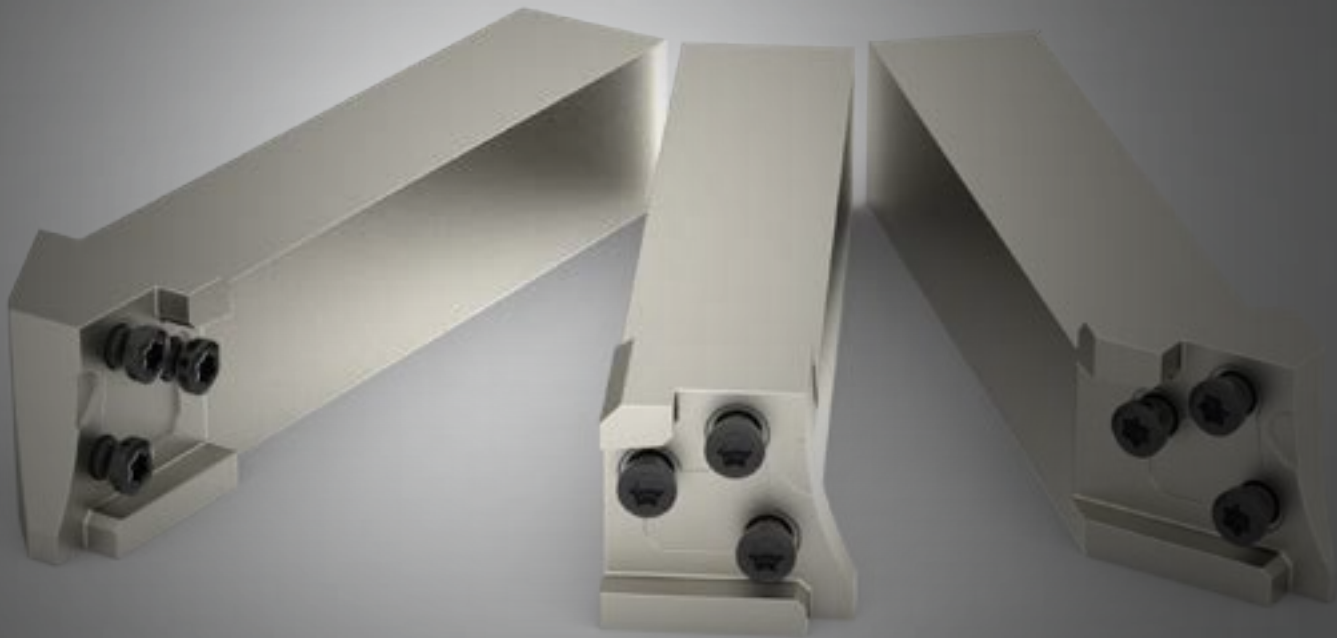


Designation	s [mm]	T _{max} [mm]	D _{min} [mm]	D _{max} [mm]	h = h ₁ [mm]	h ₂ [mm]	l ₁ [mm]	f [mm]
GAMR-25-GA03-K-T15-40-50	3	15	40	50	25	30	22	4.9
GAMR-25-GA03-K-T15-50-60	3	15	50	60	25	30	22	4.9
GAMR-25-GA03-K-T15-60-70	3	15	60	70	25	30	22	4.9
GAMR-25-GA03-K-T15-75-100	3	15	75	100	25	30	22	4.9
GAMR-25-GA03-K-T15-100-140	3	15	100	140	25	30	22	4.9
GAMR-25-GA03-K-T15-140-200	3	15	140	200	25	30	22	4.9
GAML-25-GA03-K-T15-40-50	3	15	40	50	25	30	22	4.9
GAML-25-GA03-K-T15-50-60	3	15	50	60	25	30	22	4.9
GAML-25-GA03-K-T15-60-70	3	15	60	70	25	30	22	4.9
GAML-25-GA03-K-T15-75-100	3	15	75	100	25	30	22	4.9
GAML-25-GA03-K-T15-100-140	3	15	100	140	25	30	22	4.9
GAML-25-GA03-K-T15-140-200	3	15	140	200	25	30	22	4.9
GAMR-25-GA04-K-T15-40-50	4	15	40	50	25	30	22	4.4
GAMR-25-GA04-K-T15-50-60	4	15	50	60	25	30	22	4.4
GAMR-25-GA04-K-T15-60-70	4	15	60	70	25	30	22	4.4
GAMR-25-GA04-K-T15-75-100	4	15	75	100	25	30	22	4.4
GAMR-25-GA04-K-T15-100-140	4	15	100	140	25	30	22	4.4
GAMR-25-GA04-K-T15-140-200	4	15	140	200	25	30	22	4.4
GAML-25-GA04-K-T15-40-50	4	15	40	50	25	30	22	4.4
GAML-25-GA04-K-T15-50-60	4	15	50	60	25	30	22	4.4
GAML-25-GA04-K-T15-60-70	4	15	60	70	25	30	22	4.4
GAML-25-GA04-K-T15-75-100	4	15	75	100	25	30	22	4.4
GAML-25-GA04-K-T15-100-140	4	15	100	140	25	30	22	4.4
GAML-25-GA04-K-T15-140-200	4	15	140	200	25	30	22	4.4

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Module Holder



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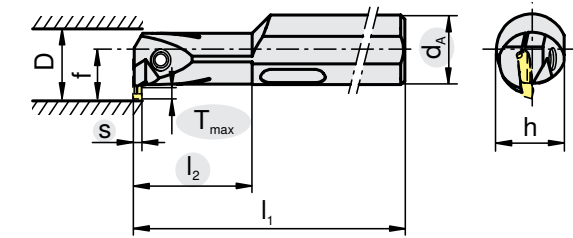
Tool	Designation	s	Module Radial	Module axial
	GMML-20-GD2400-J	0	GEML-20	
	GMMR-20-GD2400-J	0	GEMR-20	
	GMML-20-GD2445-J	45	GEML-20	
	GMMR-20-GD2445-J	45	GEMR-20	
	GMML-20-GD2490-J	90	GEML-20	
	GMMR-20-GD2490-J	90	GEMR-20	
	GMML-25-GD2400-J	0	GEML-25	GAML-25
	GMMR-25-GD2400-J	0	GEMR-25	GAMR-25
	GMML-25-GD2445-J	45	GEMR-25	GAMR-25
	GMMR-25-GD2445-J	45	GEML-25	GAML-25
	GMML-25-GD2490-J	90	GEMR-25	GAMR-25
	GMMR-25-GD2490-J	90	GEML-25	GAML-25

Spare parts	Designation
	Key T15
	Key T20
	M4.0X11/T15
	M4.0X14/T15
	M5.0X13.5/T20
	M5.0X18/T20

Boring Bars

NEW

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Designation	d_A [mm]	T_{max} [mm]	s [mm]	h [mm]	f [mm]	l_1 [mm]	l_2 [mm]	D_{min} [mm]
GMIR-25-GD2402-T08-C	25	8	2	24.4	21	200	52	32
GMIR-25-GD2403-T09-C	25	9	3	24.5	22	200	52	32
GMIR-32-GD2403-T11-C	32	11	3	31	27.5	250	64	42
GMIR-32-GD2404-T11-C	32	11	4	31	27.5	250	64	42
GMIR-40-GD2404-T12-C	40	12	4	38.5	32.5	300	80	53
GMIR-40-GD2405-T12-C	40	12	5	38.5	32.5	300	80	53
GMIL-25-GD2402-T08-C	25	8	2	24.4	21	200	52	32
GMIL-25-GD2403-T09-C	25	9	3	24.5	22	200	52	32
GMIL-32-GD2403-T11-C	32	11	3	31	27.5	250	64	42
GMIL-32-GD2404-T11-C	32	11	4	31	27.5	250	64	42
GMIL-40-GD2404-T12-C	40	12	4	38.5	32.5	300	80	53
GMIL-40-GD2405-T12-C	40	12	5	38.5	32.5	300	80	53

Spare parts

Designation

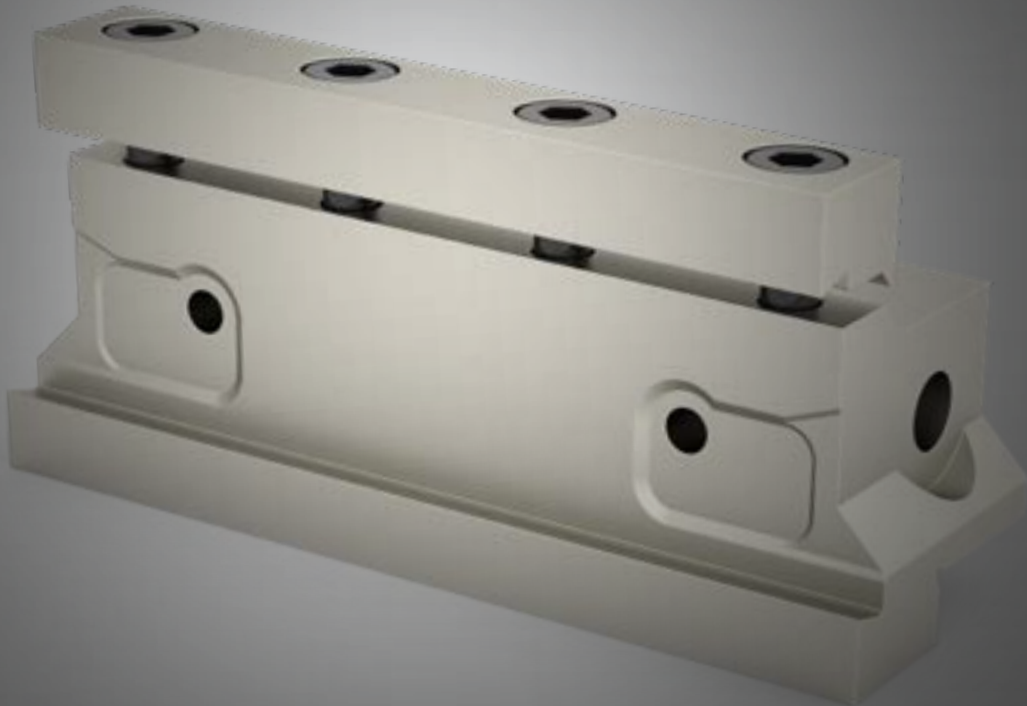


Key T20

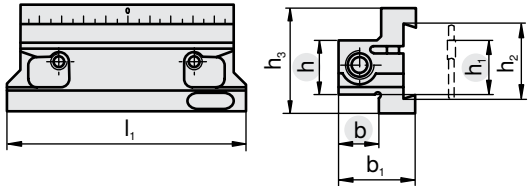
M5.0X18/T20

M4.0X4.0 DIN 913

Clamping block



SCB



Designation	Material	h ₂ [mm]	h [mm]	h ₁ [mm]	h ₃ [mm]	l ₁ [mm]	b [mm]	b ₁ [mm]	For blade
SCB-GB26-2020	12279141	26	20	20	43	90	20	37	GBN...26...
SCB-GB32-2520	12279142	32	25	25	49	110	20	38	GBN...32...

Spare part for clamping block without cooling

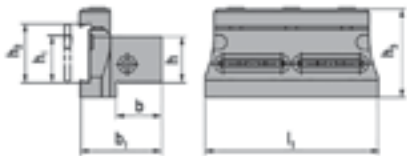
Spare parts	Designation
	Clamping screw M6.0x25

Clamping block

with internal cooling



Range



Designation	Material	h ₂ [mm]	h [mm]	h ₁ [mm]	h ₃ [mm]	l ₁ [mm]	b [mm]	b ₁ [mm]	For blade
SCB-GB26-2020-C	12279139	26	20	20	43	82	20	40	GBN...26...
SCB-GB32-2525-C	12279137	32	25	25	49	95	25	44.5	GBN...32...

Spare part for clamping block with cooling

Spare parts	Designation
	Grub screw M6.0x8
	Clamping screw M6.0x12

BEYOND THE MACHINING

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**Technical
Information**



How to use the system?



1

Insert mounting key with handle towards the front into the 2 tool location points



2

When moving the mounting key in the direction of the arrows the insert seat is opened



3

Position the insert pressing it against the location face



4

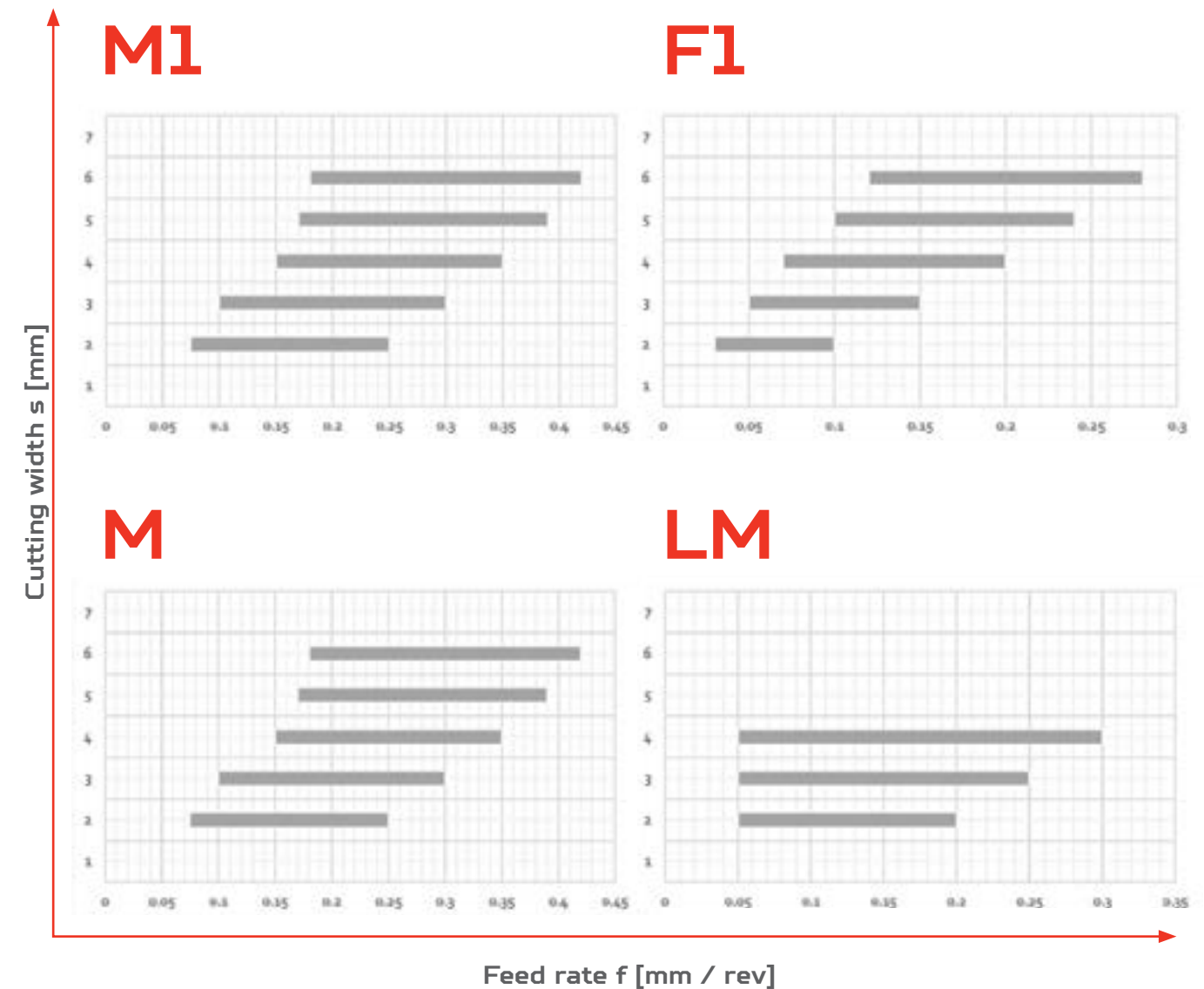
Moving the mounting key forward the insert seat locks and insert is clamped securely

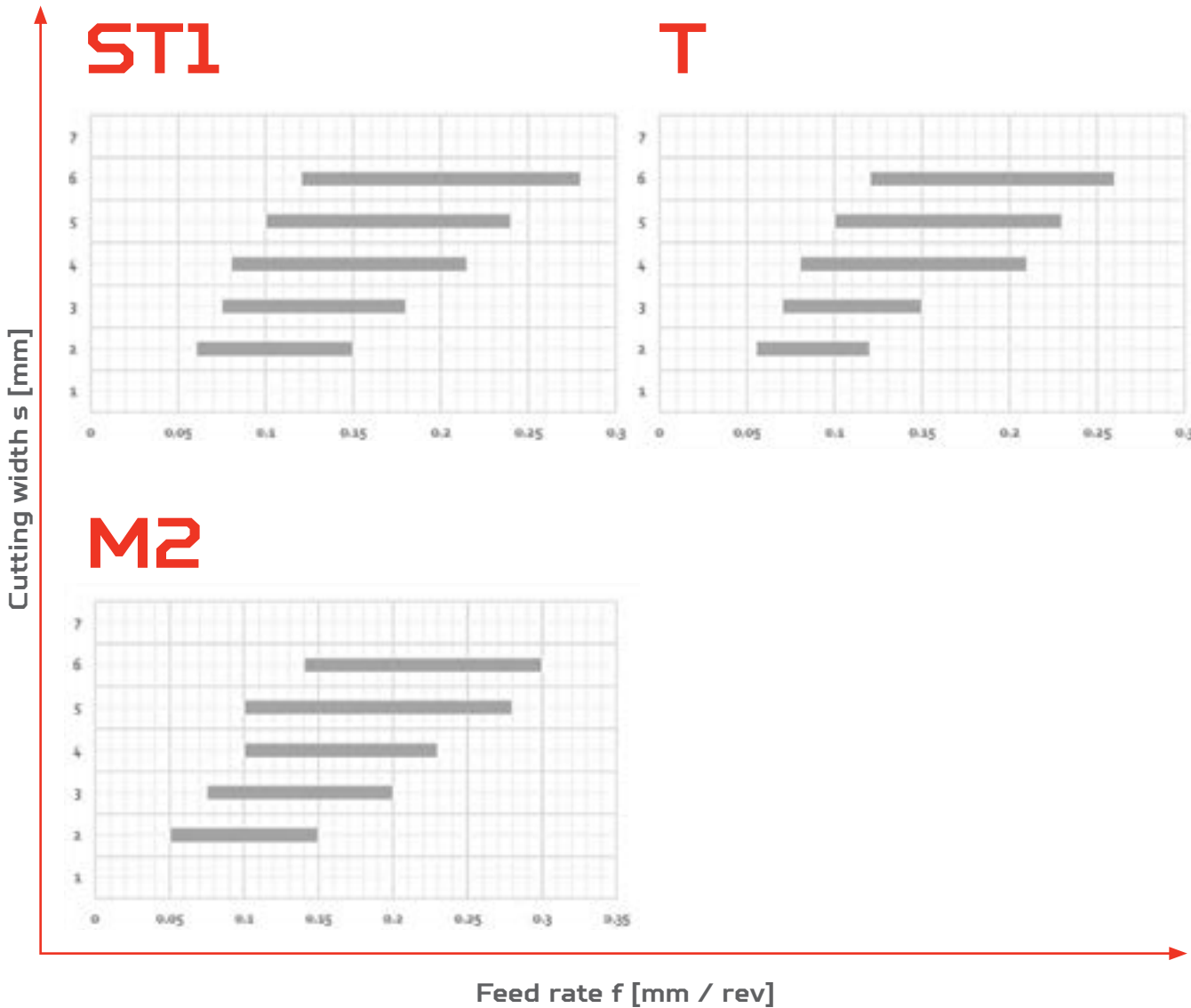


When changing the inserts, always maintain tension on the key!



Feed rate recommendation





Feed rate recommendation

T

Geometry T	0.5 a_p [mm]	1 a_p [mm]	1.5 a_p [mm]	2 a_p [mm]	2.5 a_p [mm]	3 a_p [mm]	3.5 a_p [mm]
Cutting width	avance f mm/tr						
2	0.10 - 0.15	0.05 - 0.15	0.05 - 0.12	0.05 - 0.10			
3	0.10 - 0.17	0.05 - 0.17	0.05 - 0.17	0.05 - 0.15	0.05 - 0.12		
4	0.10 - 0.20	0.07 - 0.20	0.07 - 0.20	0.07 - 0.20	0.07 - 0.17	0.07 - 0.15	
5	0.10 - 0.25	0.10 - 0.25	0.07 - 0.25	0.07 - 0.25	0.07 - 0.22	0.07 - 0.20	
6	0.15 - 0.30	0.15 - 0.30	0.15 - 0.30	0.15 - 0.30	0.15 - 0.30	0.15 - 0.25	0.15 - 0.22

M2

Geometry T	0.5 a_p [mm]	1 a_p [mm]	1.5 a_p [mm]	2 a_p [mm]	2.5 a_p [mm]	3 a_p [mm]
Cutting width	avance f mm/tr					
2	0.05 - 0.17	0.05 - 0.13	0.05 - 0.10			
3	0.07 - 0.20	0.07 - 0.20	0.07 - 0.18	0.07 - 0.15		
4	0.10 - 0.25	0.10 - 0.25	0.10 - 0.25	0.10 - 0.22	0.10 - 0.18	
5	0.12 - 0.27	0.12 - 0.27	0.12 - 0.27	0.12 - 0.25	0.12 - 0.22	
6	0.15 - 0.30	0.15 - 0.30	0.15 - 0.30	0.15 - 0.30	0.15 - 0.25	0.15 - 0.20

M / MM

Geometry T	0.5 a_p [mm]	1 a_p [mm]	1.5 a_p [mm]	2 a_p [mm]	2.5 a_p [mm]	3 a_p [mm]
Cutting width	avance f mm/tr					
2	0.15 - 0.30	0.15 - 0.27				
3	0.15 - 0.35	0.15 - 0.35	0.15 - 0.30			
4	0.15 - 0.40	0.15 - 0.40	0.15 - 0.40	0.15 - 0.30		
5	0.15 - 0.50	0.15 - 0.50	0.15 - 0.50	0.15 - 0.40	0.15 - 0.35	
6	0.20 - 0.70	0.20 - 0.70	0.20 - 0.70	0.20 - 0.60	0.20 - 0.50	0.20 - 0.40

Cutting speed recommendation

M1, F1, T, M, M2

Work piece material	Type of treatment/alloy	Hardness HB	Coated carbide		
			KRP1340 v_c [m/min]	KRCP320ST v_c [m/min]	KRPP345 v_c [m/min]
P Steel	non alloyed steel 0.15% – 0.45% C	150 – 250	80 – 180	110 – 190	80 – 150
	low alloyed steel tempered	250 – 300	60 – 150	110 – 180	70 – 120
	high alloyed steel tempered	350	50 – 120	70 – 160	60 – 100
	corrosion resistant steel annealed	200	50 – 200	120 – 200	90 – 160
M Stainless steel	annealed pearlitic	200	50 – 200	120 – 200	100 – 180
	quenched austenitic	180	50 – 180	100 – 170	80 – 150
	quenched duplex	230 – 260	50 – 100	70 – 110	70 – 110
	hardened martensitic	330	50 – 80	60 – 90	60 – 90
K Cast iron	grey cast iron	180	100 – 200	90 – 180	–
	spheroidal	160	100 – 180	100 – 160	–
	malleable pearlitic	130	80 – 160	80 – 150	–

ST1, MM

Work piece material	Type of treatment/alloy	Hardness HB	Coated carbide		
			KRP1340 v_c [m/min]	KRCP320ST v_c [m/min]	KRPP345 v_c [m/min]
M Stainless steel	annealed pearlitic	200	50 – 200	120 – 200	100 – 180
	quenched austenitic	180	50 – 180	100 – 170	80 – 150
	quenched duplex	230 – 260	50 – 100	70 – 110	70 – 110
	hardened martensitic	330	50 – 80	60 – 90	60 – 90
S Exotic	Fe base	200	–	–	20 – 45
	Nickel or cobalt base	250	–	–	15 – 25
	Titanium	Rm 440	–	–	50 – 120

LM

Work piece material	Type of treatment/alloy	Hardness HB	Uncoated carbide	
			KRWN 715 v_c [m/min]	
N Non-ferrous	Aluminium wrought alloys	100	200 – 2000	
	Aluminium cast alloys < 12% Si	90	400 – 1500	
	Copper alloys (bronze)	90	200 – 600	

Maximal torque for screws

Designation	max. torque/Nm
7812115/M6X20 DIN 912	7
7802115/M6X25 DIN 912-12.9	7
7897218/M4.0X18/T20	4
M6X6 DIN 913	0
7897221/M3.5X14.0/T15	3.2
10010029/M6X12 DIN 912-12.9	7
M0102554/M4.0X16/T20 SCREW	4
7897203/M4.0X14/T15	4
7897209/M4.0X11/T15	4
7897205/M5.0X18/T20	5
7897210/M5.0X13.5/T20	5

Grades

Grade overview

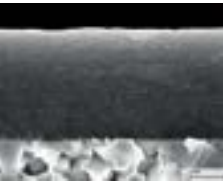
Grade designation	Standard designation		*Type of cutting material	Application range																	P	M	K	N	S	H																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
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• Main application
o Extended application

Grade description

KRP1340

HC-P30 | HC-M25 | HC-K30 | HC-S30



Specification:
Composition: Co 9.0 %; mixed carbides 2.0 %; WC balance | Grain size: 0.7-1 µm | Hardness: HV₃₀ 1590 | Coating specification: PVD TiAlN

Recommended application:
The universal high-performance grade for steel, austenitic steel, cast iron and heat-resistant alloys.

- Excellent suitability for universal application
- High cutting edge stability

KRCP320ST

HC-P35 | HC-K35 | HC-M30



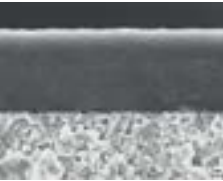
Specification:
Composition: Co 10.5 %; mixed carbides 2.0 %; WC balance | Grain size: 1 µm | Hardness: HV₃₀ 1400 | Coating specification: CVD TiCN-Al₂O₃ multi-layer

Recommended application:
The reliable choice for the machining of steel and cast iron.

- Excellent wear resistance
- Good resistance to oxidation
- High toughness
- Good heat resistance

KRPP345

HC-P45 | HC-M40 | HC-S40



Specification:
Composition: Co 12.5 %; mixed carbides 2.0 %; WC balance | Grain size: 1-1.5 µm | Hardness: HV₃₀ 1380 | Coating specification: PVD TiAlTaN

Recommended application:
The reliable solution for steel and austenitic steels under unstable conditions.

- Ideal for stainless steel
- Excellent toughness
- Good wear resistance
- High application security

KRWN715

HW-K15



Specification:
Composition: Co 6.0% | WC balance; other: 0.20% | Grain size: 0.8-1.3 µm | Hardness: HV₃₀ 1650

Recommended application:
The uncoated carbide grade for the machining of aluminium and other non-ferrous metals.

- Optimal suitable for aluminium
- High wear resistance
- High heat resistance
- Low tendency to adhesion

KARCAN Designation System

Designation System For Inserts

GD	Double-sided
GO	One-sided
GS	Single-sided
GA	Axial

Insert system

R	Right
L	Left
N	Neutral

Hand

15	15 mm
20	2 mm
30	3 mm
40	4 mm
50	5 mm
60	6 mm
80	8 mm
100	10 mm

Insert width

00	0°
04	4°
06	6°
15	15°

Clearance angle

GD	24	N	T	-	30	.	02	-	00	-	M1
----	----	---	---	---	----	---	----	---	----	---	----

Insert length

24	24 mm
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Insert shape / application

T	Trapezoidal
R	Radius
S	Special

Corner radius

0.00	00
0.20	02
0.30	03
0.40	04

Chipbreaker

GD/GO
M1
F1
ST1
T
LM
M (Radius)

GS
M1
M2
ST1
LM

KARCAN Designation System

For Monoblocks Tools

GM
Monoblocks

GMM
Monoblocks
Module

Tool Group

R	Right
L	Left
N	Neutral

Tool design

GD24
GO24
GS
GA

Insert type

01	1.5 mm
02	2 mm
03	3 mm
04	4 mm
05	5 mm
06	6 mm
08	8 mm
10	10 mm
Holder angle	
00	0°
45	45°
90	90°

Insert width

T13	13 mm
T25	25 mm

GM	E	R	-	16	-	GD24	02	-	K	-	T13	-	C
----	---	---	---	----	---	------	----	---	---	---	-----	---	---

Application

E	External
I	Internal
A	Axial

Tool size

12	12x12 mm
16	16x16 mm
20	20x20 mm
25	25x25 mm
32	32x32 mm

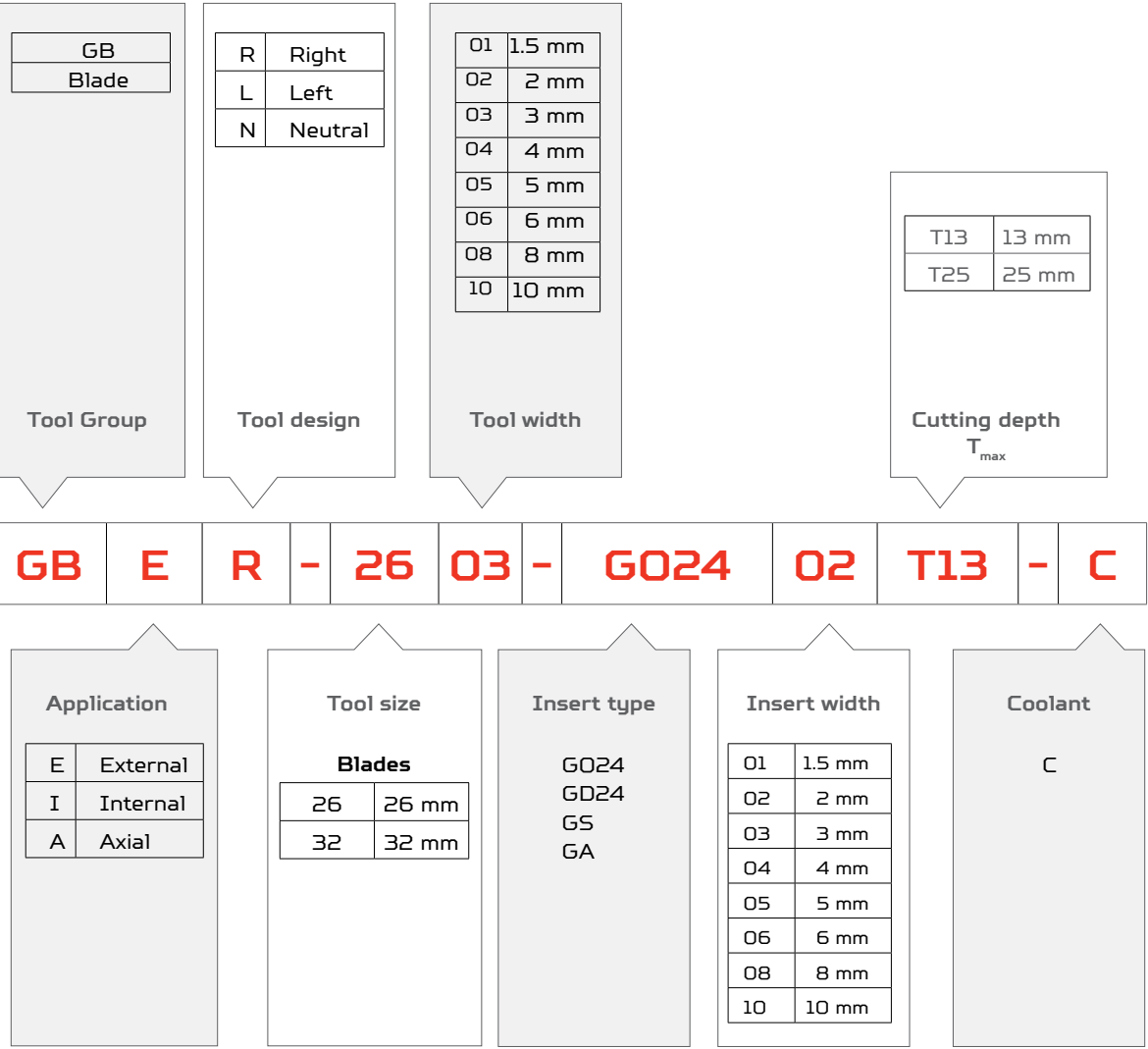
Tool length

K	125 mm
M	150 mm
J	110 mm
L	140 mm

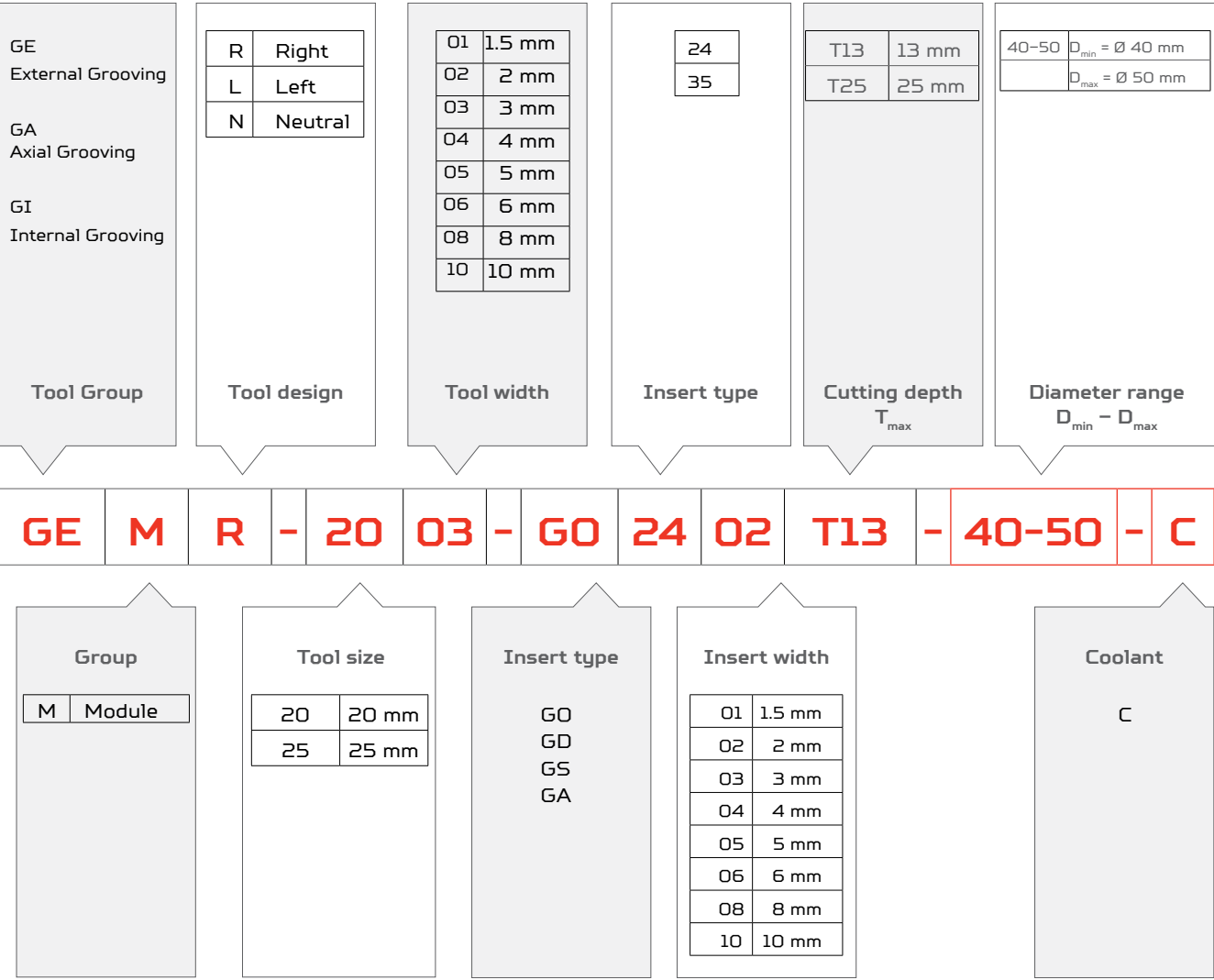
Coolant

C

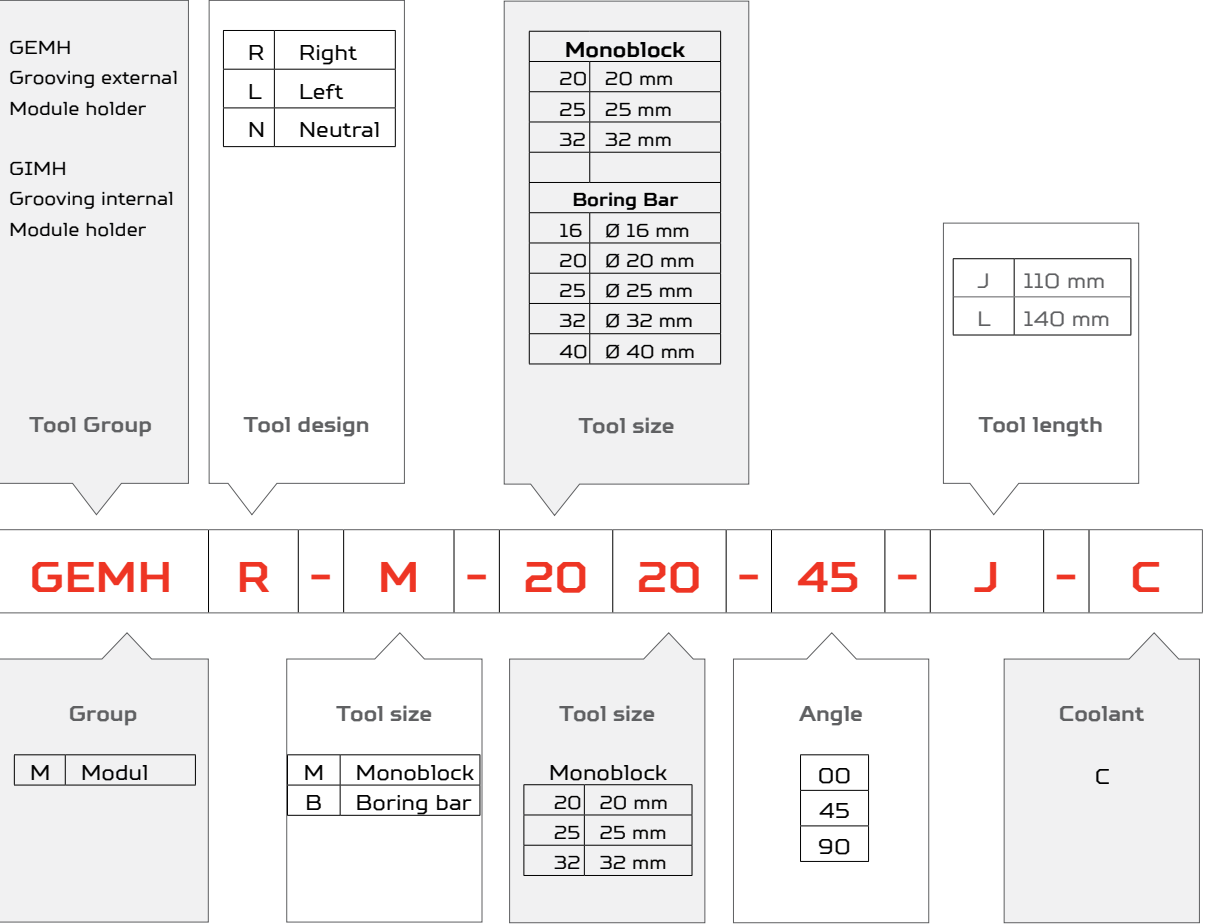
KARCAN Designation System For Blades



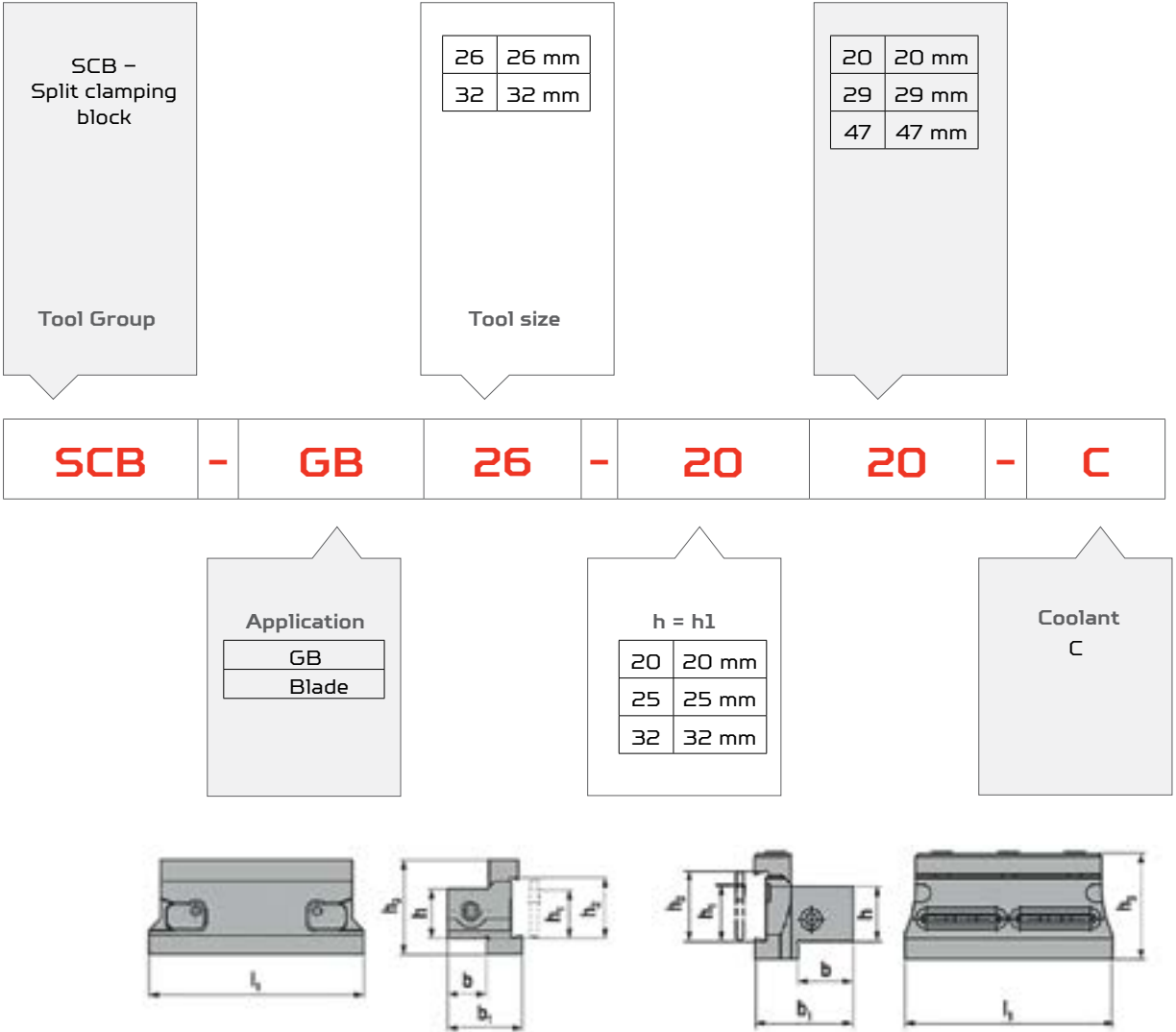
KARCAN Designation System For Moduls



KARCAN Designation System For Module Holders



KARCAN Designation System For Clamping Blocks



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