

GROOVING



INSERT GRADE GUIDE

		P STEEL				M STAINLESS STEEL				K CAST IRON			
		05	15	25	35	05	15	25	35	05	15	25	35
PVD	ET602	602				602				602			
		← HARDER → TOUGHER				← HARDER → TOUGHER				← HARDER → TOUGHER			
		N NON-FERROUS				S HRSA				H HARDENED STEEL			
		05	15	25	35	05	15	25	35	05	15	25	35
PVD	ET602	602				602							
		← HARDER → TOUGHER				← HARDER → TOUGHER				← HARDER → TOUGHER			

	P20 - P35	ET602 Ultra dense PVD coating optimised for grooving applications, suitable for most materials
	M20 - M40	
	K20 - K40	
	N05 - N35	
	S15 - S25	PVD - TiAlN

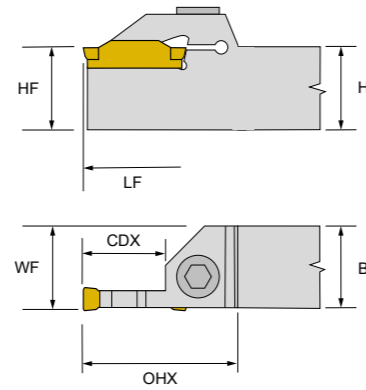
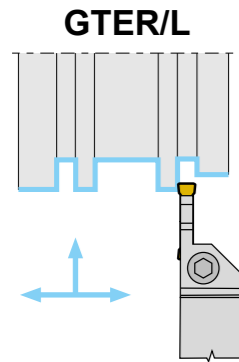
INSERT GEOMETRY

P	M	K	N	S	H	Edge Preparation Guide	
•	•	○	•	•			TDP For Aluminium, Stainless Steel and HRSA
•	•	•					TDN General machining
•	•	•	○	•			TDY Grooving and Turning

APPLICATION GUIDE & INDEX

Holder	GROOVING	TURNING	PARTING	Page No	Insert	Page No.
 GTER/L				64		
 GTIR/L				65	 TDP/TDN/TDY	68-69
 GTFR/L				66		
 PGIB				67	 TDP/TDN	68-69

EXTERNAL GROOVING HOLDER

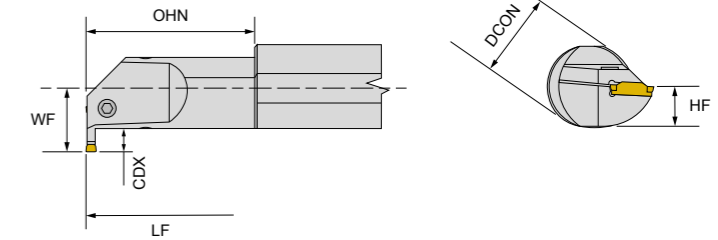
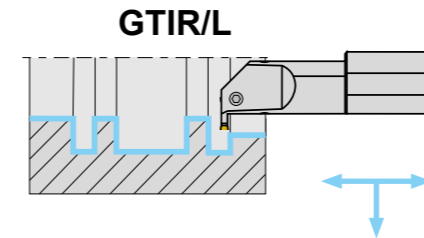


EDP Code	Description	R	L	CDX	H	HF	B	LF	OHX	WF	Insert	Screw	Key
PGH0001	GTER 2020-2	●	○	12	20	20	20	125	31	19.1	TDP2 TDN2	M6X20IMB	HA5
PGH0029	GTER 2020L-2	●	○	20	20	20	20	125	39	20.3			
PGH0002	GTER 2525-2	●	○	12	25	25	25	150	31	24.1			
PGH0003	GTER 2020-3	●	○	12	20	20	20	125	31	18.8	TDP3 TDN3 TDY3	M6X20IMB	
PGH0030	GTER 2020L-3	●	○	20	20	20	20	125	39	20.4			
PGH0004	GTER 2525-3	●	○	12	25	25	25	150	31	23.8			
PGH0031	GTER 2525L-3	●	○	22	25	25	25	150	41	25.4			
PGH0005	GTER 2020-4	●	○	15	20	20	20	125	33	18.4	TDP4 TDN4 TDY4	M6X20IMB	
PGH0006	GTER 2525-4	●	○	15	25	25	25	150	33	23.4			
PGH0032	GTER 2525-5	●	○	25	25	25	25	150	41	25.5	TDN5	M8X20IMB	

● : Stock ○ : Available to order

To order left hand add L to EDP code. Example: GTER 2020-2 = PGH0001L

INTERNAL GROOVING HOLDER

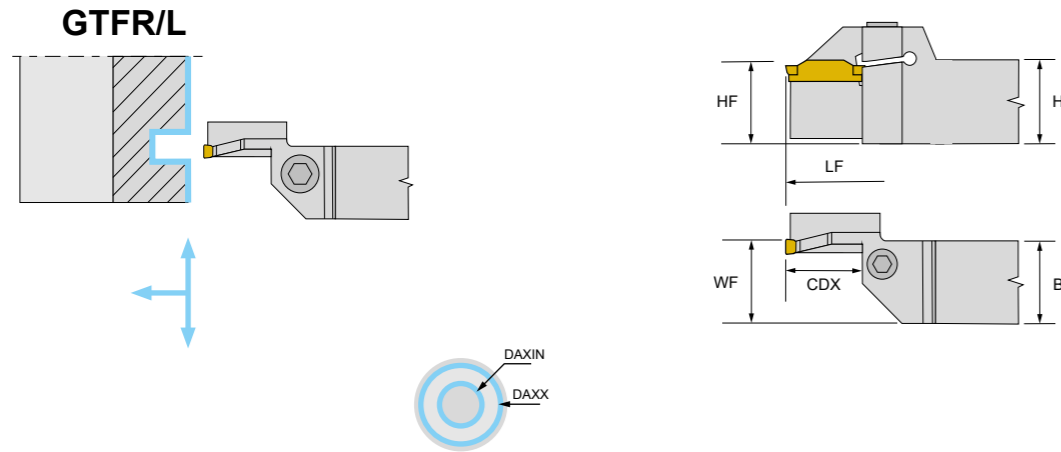


EDP Code	Description	R	L	CDX	DCON	HF	LF	OHN	WF	Insert	Screw	Key
PGH0007	GTIR 0016-2	●	○	8.5	16	7.5	125	-	16.5	TDP2 TDN2	M5X10IMB	HA4
PGH0008	GTIR 0020-2	●	○	6	20	9	160	40	15.8		M5X12IMB	
PGH0009	GTIR 0020-3	●	○	6	20	9	160	40	15.8	TDP3 TDN3 TDY3	M5X12IMB	
PGH0010	GTIR 0025-3	●	○	5.1	25	11.5	200	40	17.5			
PGH0011	GTIR 0020-4	●	○	6	20	9	160	40	15.8	TDP4 TDN4 TDY4	M5X12IMB	
PGH0012	GTIR 0025-4	●	○	5.2	25	11.5	200	40	17.5			

● : Stock ○ : Available to order

To order left hand add L to EDP code. Example: GTIR 0020-3 = PGH0009L

FACE GROOVING HOLDER

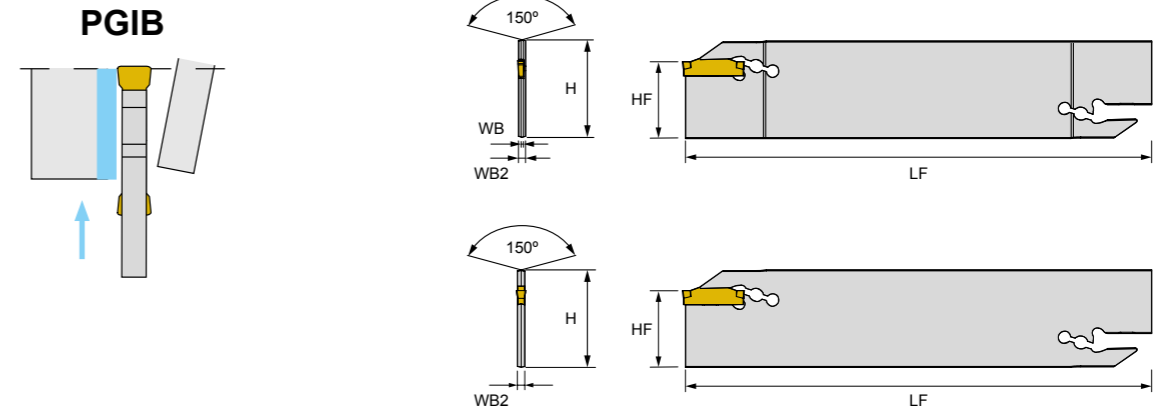


EDP Code	Description	R	L	DAXIN	DAXX	CDX	H	HF	B	LF	WF	Insert	Screw	Key			
PGH0013L	GTFL 320 29/40	○	●	29	40	10	20	20	20	140	19	TDP3 TDN3 TDY3	M6X20IMB	HA5			
PGH0014L	GTFL 320 34/50	○	●	34	50	10	20	20	20	140	19						
PGH0015L	GTFL 320 44/70	○	●	44	70	15	20	20	20	140	19						
PGH0016L	GTFL 320 64/100	○	●	64	100	15	20	20	20	140	19						
PGH0017L	GTFL 325 29/40	○	●	29	40	10	25	25	25	150	24						
PGH0018L	GTFL 325 34/50	○	●	34	50	10	25	25	25	150	24						
PGH0019L	GTFL 325 44/70	○	●	44	70	15	25	25	25	150	24						
PGH0020L	GTFL 325 64/100	○	●	64	100	15	25	25	25	150	24						
PGH0021L	GTFL 420 28/42	○	●	28	42	16	20	20	20	140	18.6				TDP4 TDN4 TDY4	M6X20IMB	HA5
PGH0022L	GTFL 420 34/50	○	●	34	50	16	20	20	20	140	18.6						
PGH0023L	GTFL 420 42/70	○	●	42	70	16	20	20	20	140	18.6						
PGH0024L	GTFL 420 62/120	○	●	62	120	16	20	20	20	140	18.6						
PGH0025L	GTFL 425 28/42	○	●	28	42	19	25	25	25	150	23.6						
PGH0026L	GTFL 425 34/50	○	●	34	50	19	25	25	25	150	23.6						
PGH0027L	GTFL 425 42/70	○	●	42	70	19	25	25	25	150	23.6						
PGH0028L	GTFL 425 62/120	○	●	62	120	19	25	25	25	150	23.6						

● : Stock ○ : Available to order

To order right hand remove L from EDP code. Example: GTFR 320 29/40 = PGH0013

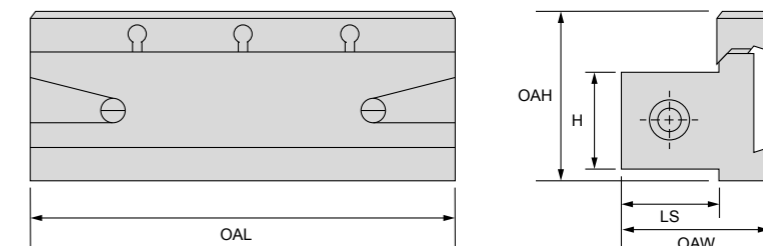
BLADE FOR PARTING



EDP Code	Description	H	HF	LF	WB2	WB	Insert	Block	Extractor	
PGH0033	PGIB 32-2	●	32	25	150	2.4	1.6	TDP2 TDN2	2020-32 2525-32	PGET32 (PGH0037)
PGH0034	PGIB 32-3	●	32	25	150	2.4	-	TDP3 TDN3		

BLOCK FOR PARTING BLADES

PGTB



EDP Code	Description	H	LS	OAL	OAH	OAW	Blade	Top Clamp	Screw	Key
PGH0035	PGTB 2020-32	●	20	19	100	50	38	32-2 32-3	ABK03	M6X30IMB HA7
PGH0036	PGTB 2525-32	●	25	23	110	50	42	32-2 32-3	ABK04	

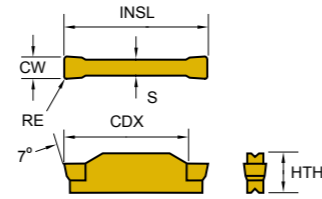
GROOVING



GROOVING



INSERT	CW	INSL	HTH	S
TD.. 2	2.0	20	4.7	1.7
TD.. 3	3.0	20	4.7	2.4
TD.. 4	4.0	20	4.7	3.0
TD.. 5	5.0	20	4.7	

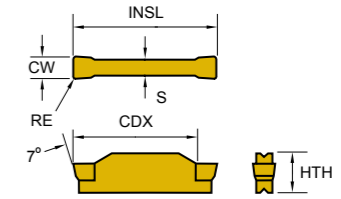


► EDP Code PG..... Example: TDP 2002 ET602 = PG00017

P	●	●
M	●	●
K	○	●
N	●	●
S	●	●
H		

TDP TDN TDY	ISO DESIGNATION	RE (mm)	CDX (mm)	f _n (mm/rev)	a _p (mm)	ET602	
						ET602	ET602
	TDP 2002	0.2	19	0.04 - 0.12	-	●	●
	TDP 3002	0.2	19	0.05 - 0.16	-	●	●
	TDP 4003	0.3	19	0.06 - 0.18	-	●	●
	TDN 2002	0.2	19	0.06 - 0.18	-		●
	TDN 3002	0.2	19	0.07 - 0.22	-		●
	TDN 4003	0.3	19	0.08 - 0.25	-		●
	TDN 5003	0.3	19	0.09 - 0.29	-		●
	TDY 3E-0.4	0.4	19	0.10 - 0.20	0.5 - 2.2	●	
	TDY 4E-0.4	0.4	19	0.15 - 0.26	0.5 - 2.8	●	

INSERT	CW	INSL	HTH	S
TD.. 2	2.0	20	4.7	1.7
TD.. 3	3.0	20	4.7	2.4



► EDP Code PG..... Example: TDPR 2002 ET602 = PG00026

P	●	●
M	●	●
K	○	●
N	●	●
S	●	●
H		

TDPR/L TDNR/L	ISO DESIGNATION	RE (mm)	CDX (mm)	f _n (mm/rev)	a _p (mm)	ET602	
						ET602	ET602
	TDPR 2002	0.2	19	0.04 - 0.12	-	●	●
	TDPR 3002	0.2	19	0.05 - 0.16	-	●	●
	TDPL 2002	0.2	19	0.04 - 0.12	-	●	●
	TDPL 3002	0.2	19	0.05 - 0.16	-	●	●
	TDNR 2002	0.2	19	0.06 - 0.18	-		●
	TDNR 3002	0.2	19	0.07 - 0.22	-		●
	TDNL 2002	0.3	19	0.06 - 0.18	-		●
	TDNL 3002	0.2	19	0.07 - 0.22	-		●

ISO	P			M		K		N	S	H
MATERIAL	Non-alloy steel	Low alloy steel	High alloy steel	Ferritic / Martensitic Stainless steel	Austenitic Stainless steel	Grey Cast iron	Nodular Cast iron	Aluminium & Non-ferrous material	Heat Resistant and Super Alloys	Hardened steel
VDI GROUP	1-5	6-9	10-11	12-13	14	15-16	17-20	21-30	31-37	38
V _c (m/min)	ET602	90 - 180	80 - 120	80 - 110	70 - 160	55 - 140	110 - 185	110 - 140	250 - 440	25 - 45

ISO	P			M		K		N	S	H
MATERIAL	Non-alloy steel	Low alloy steel	High alloy steel	Ferritic / Martensitic Stainless steel	Austenitic Stainless steel	Grey Cast iron	Nodular Cast iron	Aluminium & Non-ferrous material	Heat Resistant and Super Alloys	Hardened steel
VDI GROUP	1-5	6-9	10-11	12-13	14	15-16	17-20	21-30	31-37	38
V _c (m/min)	ET602	90 - 180	80 - 120	80 - 110	70 - 160	55 - 140	110 - 185	110 - 140	250 - 440	25 - 45