MITSUBISHI MATERIALS

GY/GW Series

MONOBLOCK HOLDERS FOR SWISS-TYPE AUTOMATIC LATHES

NEW Holder Types

- Sub-Spindle
- Internal Coolant Thru
- Large-Diameter Cutting-Off





TOOL NEWS B255A-H

Cutting-Off and Grooving System

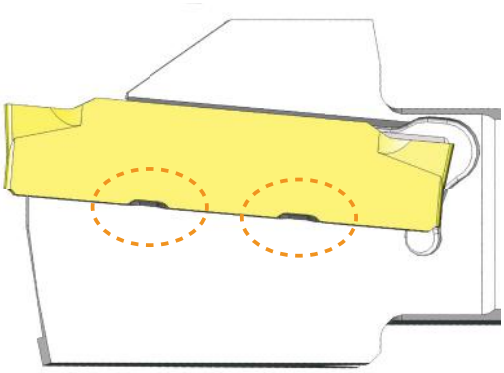
GY Series

Monoblock Holder for Swiss-Type Automatic Lathes

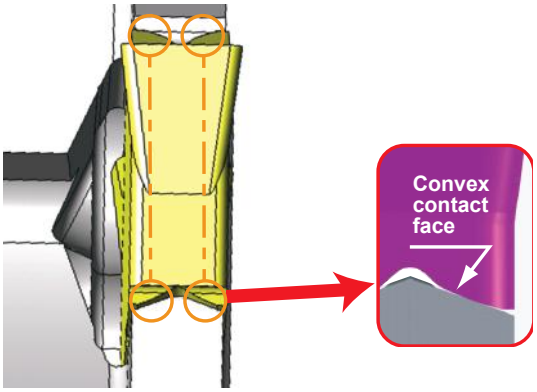


Highly Reliable Insert Clamp

The safety key locks the insert and prevents movement.



The convex geometry ensures high precision clamping.

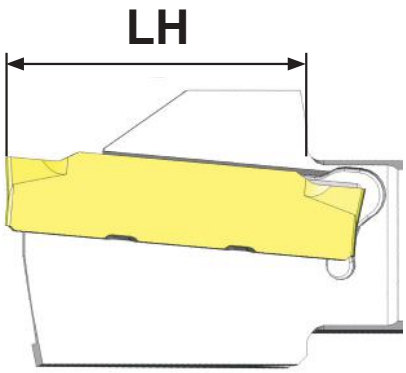


Monoblock Holder for Swiss-Type Automatic Lathes

The new geometry with greatly improved rigidity suppresses vibrations and dimensional changes, thereby solving problems during cutting-off and grooving operations.

Overhang Length Compatible with Swiss-Type Automatic Lathes

Head length corresponding to the maximum machining diameter of CNC Swiss-type automatic lathes and turret machines.

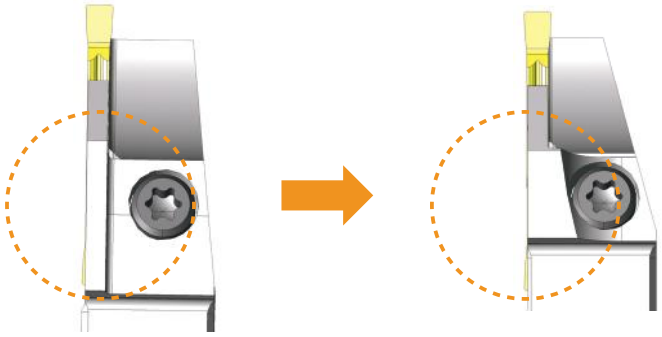




Features of High-Rigidity Holder

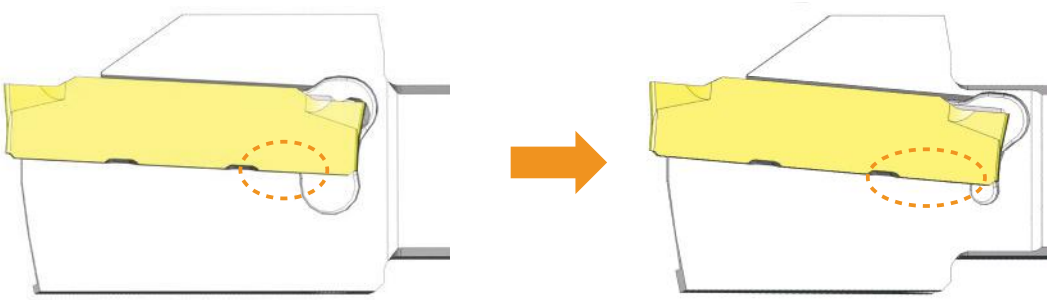
Strong Clamp Bridge

The strong design of the clamp bridge suppresses chatter and vibration.



Strengthening of the Insert Clamp

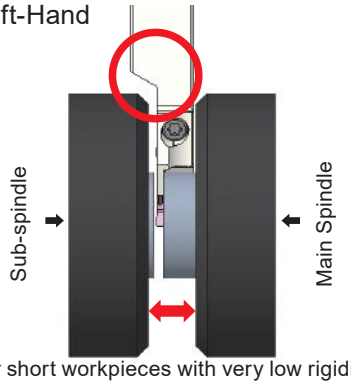
The seating face of the insert becomes wider, reducing the deformation of the workpiece material.



Holder for Sub-spindle Applications

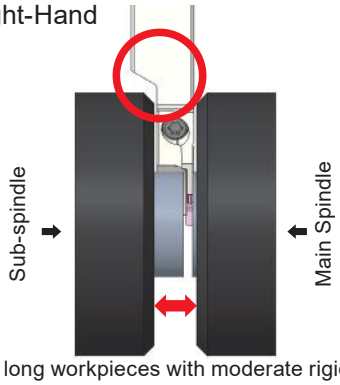
By incorporating a relief in the holder body, interference with the sub-spindle is avoided, enabling close-proximity machining with the main spindle.

Left-Hand



For short workpieces with very low rigidity.

Right-Hand

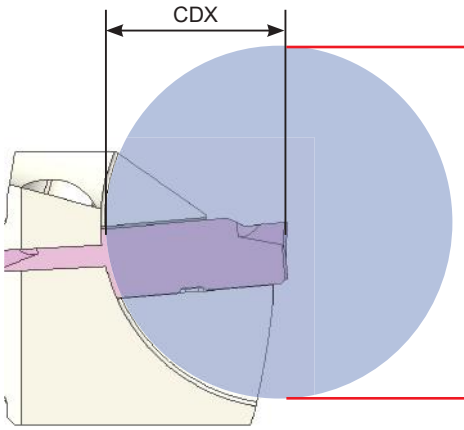


For long workpieces with moderate rigidity.

Addition of Holders Supporting Workpiece Diameters of ø1.496 in and ø1.654 in with High-Feed Cutting

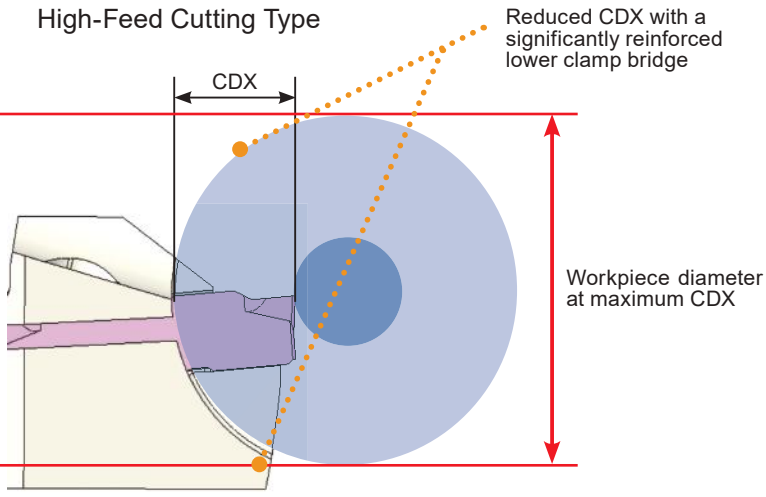
New holders supporting grooving and cutting-off for workpiece diameters up to ø1.654 in have been added, offering high-feed cutting-off performance with excellent machining stability for grooving operations where cutting to the workpiece center is not required. By reinforcing the lower clamp bridge, these holders offer greater resistance to chatter and vibration than standard types, enabling high-efficiency machining with higher feed rates.

Standard Type
(Workpiece Diameter: up to ø1.654 in)



Max. workpiece diameter: Grooving and parting possible

High-Feed Cutting Type



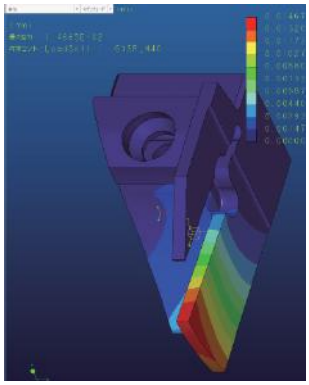
Max. workpiece diameter: Grooving possible

Fixed Lower Clamp Bridge (Large-diameter parting holder / High-Feed Cutting type)

Significantly reduces the tendency of the insert center to drop during machining under cutting loads (cutting resistance).

Conventional

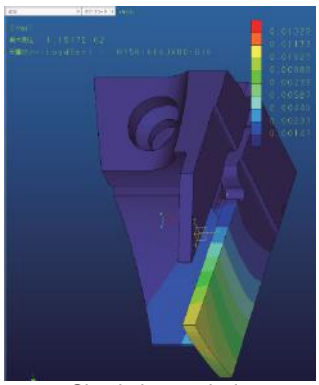




Simulation analysis
Lower clamp bridge displacement: .0006 in

New Products
Standard



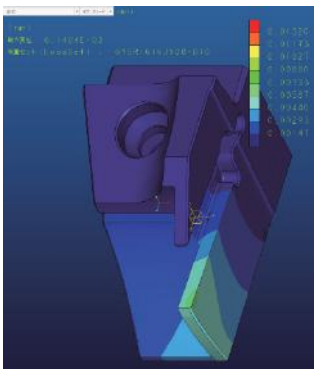


Simulation analysis
Lower clamp bridge displacement: .0005 in

New Products
High-feed type



Reinforced lower clamp bridge thickness



Simulation analysis
Lower clamp bridge displacement: .0002 in

Features of the Internal Coolant Through Holder

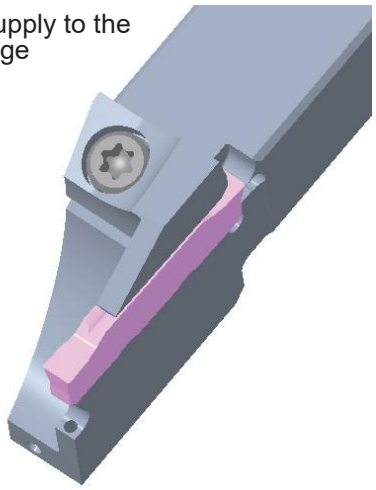
Direct coolant supply improves operational efficiency, while internal coolant delivery extends insert life.

Direct Coolant Supply



The hoseless direct coolant supply system reduces the time and effort required for setup and clean-up.
It improves operability and contributes to cost reduction.
Conventional hose-type coolant supply can also be used.

Coolant Supply to the Cutting Edge



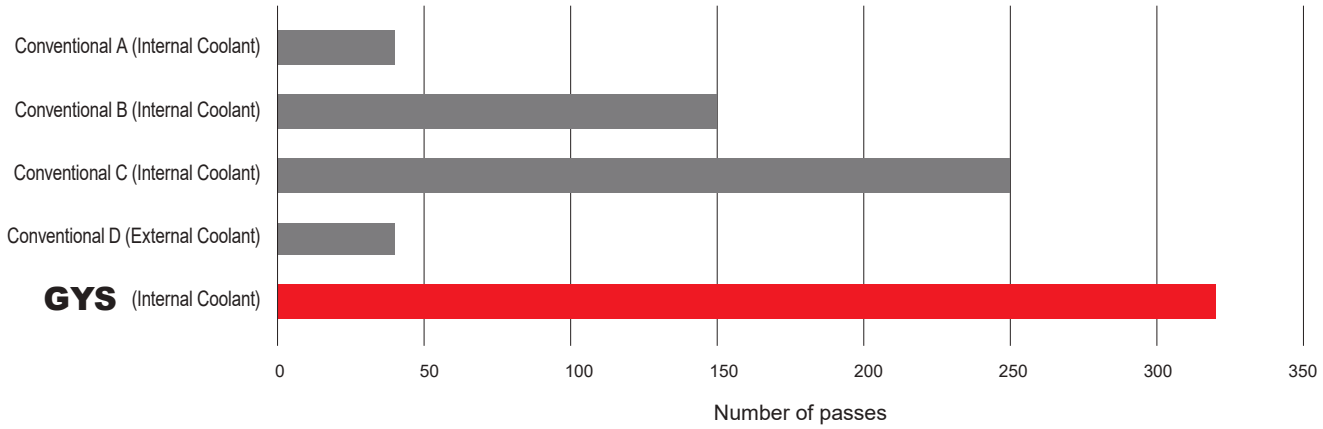
Coolant is supplied directly from the holder tip to the insert flank face and cutting edge.
This enhances cooling and lubrication performance, contributing to extended tool life.

Cutting Performance

304 Stainless Steel Internal Coolant Parting Tool Life Comparison

The effect of internal coolant enables stable machining even under high-speed cutting conditions.
Compared with a conventional external coolant holder, insert life is improved by more than five times.

Tool life was defined as the point at which flank wear reached .004 in or insert failure occurred.



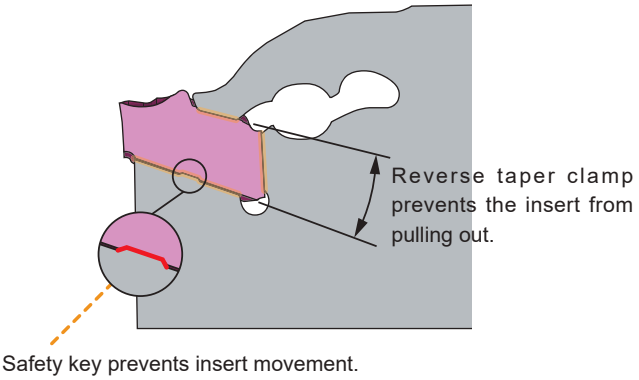
<Cutting Conditions>
Material : AISI 304 Stainless steel ø.630 in
Tool : Cutting Width CW=.079 in
RE=.008 in
.472 x .472 in
Cutting Speed : vc=330 SFM (Internal Coolant 290 psi)
260 SFM (External Coolant)
Feed per Rev. : f=.002 IPR
Cutting Mode : Wet Cutting

Cutting-Off and Grooving System

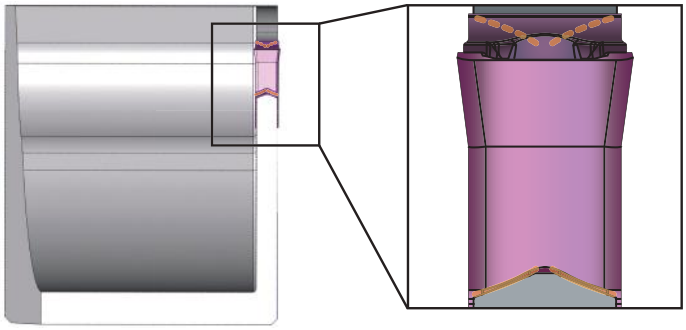
GW Series



Highly Reliable Insert Clamping

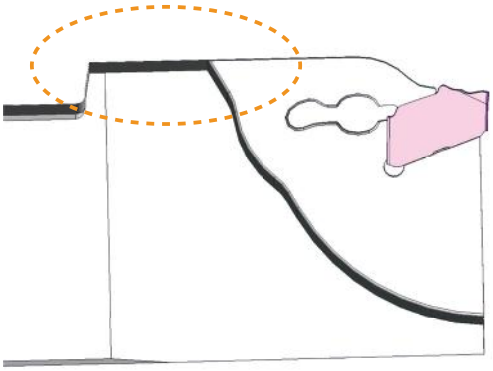


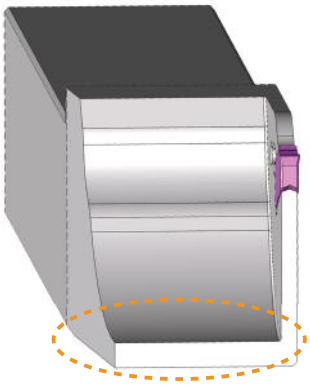
Convex geometry ensures high precision clamping.



High-Rigidity Holder

Tool deflection caused by cutting resistance and the remaining material in the center are greatly reduced.





New Low Resistance and High Lead Angle Inserts

New inserts with a lead angle of 8º have been added to the range to reduce burrs and the remaining material in the center.



Lead Angle 5°



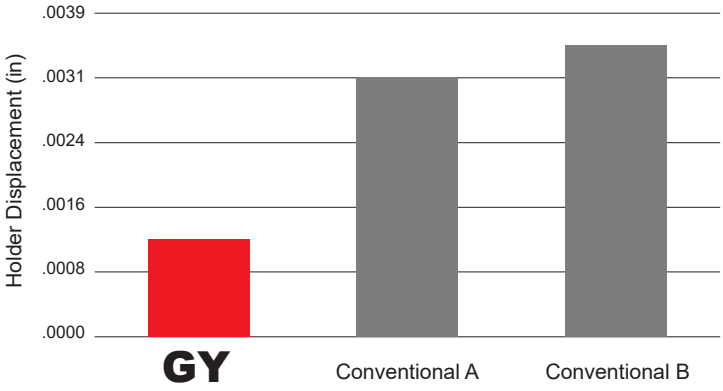
Lead Angle 8°

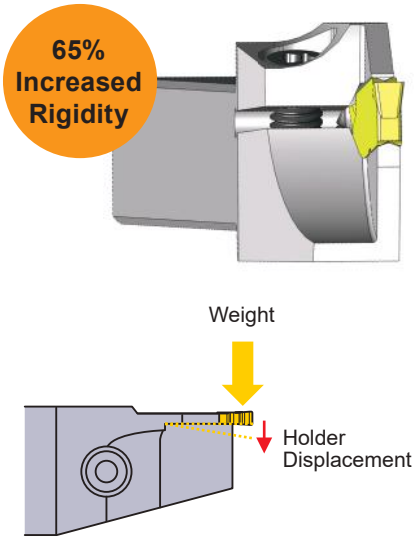
Cutting Performance

Tool Holder Deflection Comparison

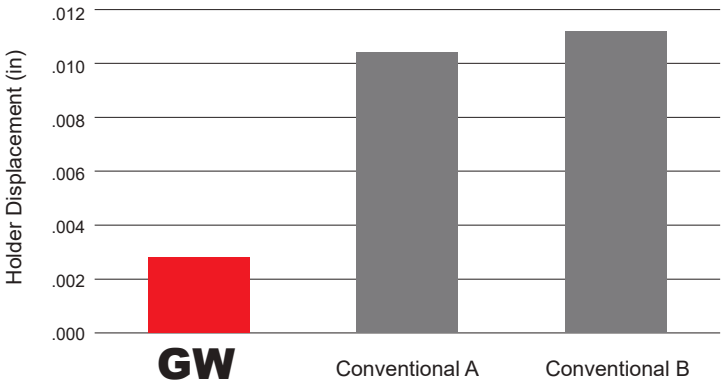
The high-rigidity of the tool reduces chatter and vibration, thereby improving the component surface finish and also reduces the remaining in the center.

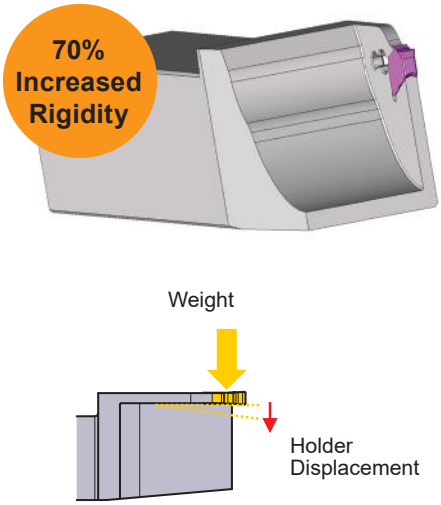
GY Holder





GW Holder



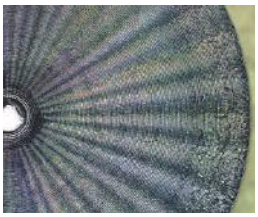


Surface Finish Comparison when Cutting-Off: 304 Stainless Steel

The high-rigidity holder suppresses chatter, vibration and tool deflection, improving the finished surface.

GY Holder

GY



Rz 71 µin

Conventional A



Rz 220 µin

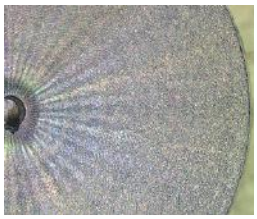
Excellent Surface Finish

Conventional B



Rz 161 µin

Conventional C

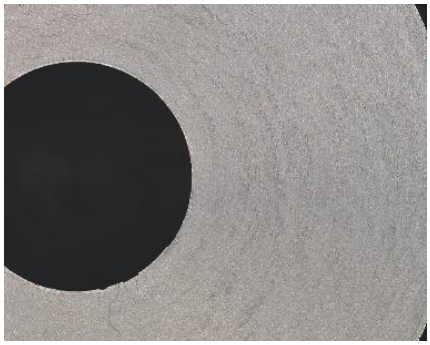


Rz 224 µin

<Cutting Conditions>
Material : AISI 304 Stainless Steel ø.984 in
Tool : Cutting Width CW=.079 in
RE=.008 in
.630 x .630 in
Cutting Speed: vc=395 SFM
Feed per Rev. : f=.0039 IPR
Cutting Mode : Wet Cutting

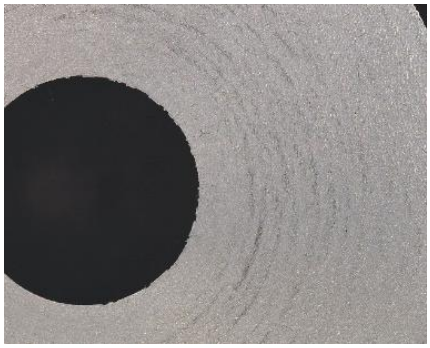
GW Holder

GW Lead Angle 8°



Rz 311 µin

Conventional Lead Angle 6°



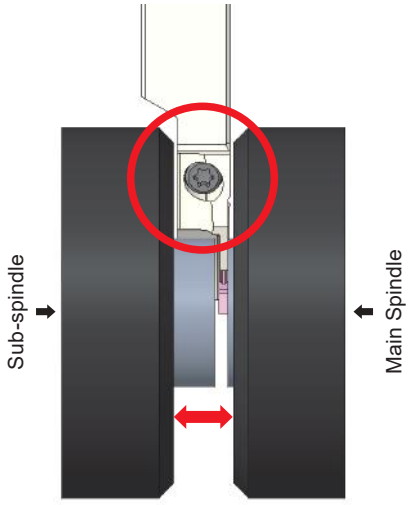
Rz 445 µin

High Lead Angle Effect

<Cutting Conditions>
Material : AISI 304 Stainless Steel ø1.496 in
Tool : Cutting Width CW=.079 in
Cutting Speed: vc=395 SFM
Feed per Rev. : f=.0043 IPR
Cutting Mode : Wet Cutting

304 Stainless Steel Sub-spindle Holder Parting Surface Finish Comparison

The shortened tip design allows the sub-spindle to be positioned closer to the main spindle, suppressing chatter, vibration and achieving a superior surface finish.





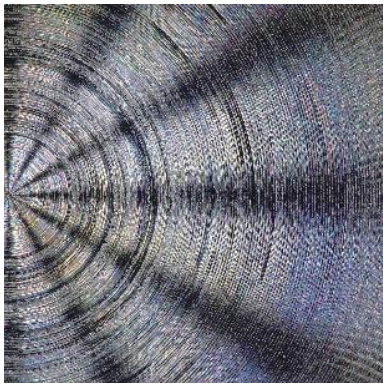
GYS

(Sub-spindle Holder)

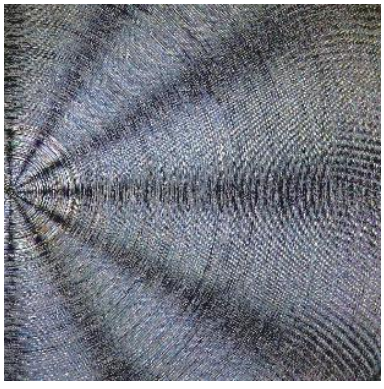


Excellent Surface Finish

Conventional A



Conventional B

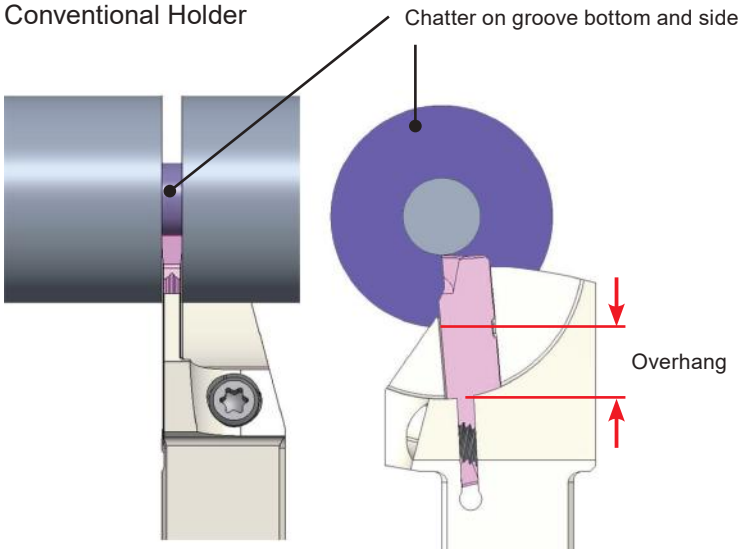


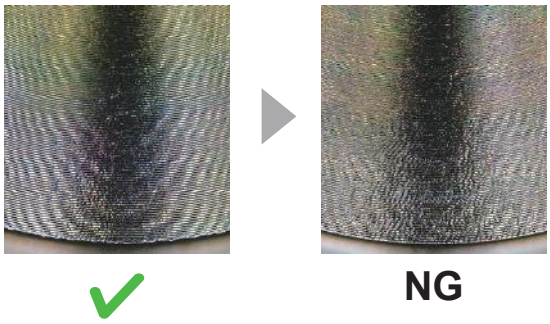
<Cutting Conditions>
Material : AISI 304 Stainless Steel ø.591 in
Tool : Cutting Width CW=.047 in
RE=.004 in
.630 ×.630 in
Cutting Speed : vc=330 SFM
Feed per Rev. : f=.002 IPR
Cutting Mode : Wet Cutting

304 Stainless Steel Large-diameter Holder (High-Feed Cutting Type) Deep Grooving Surface Finish Comparison

The high-rigidity holder suppresses chatter, vibration and deflection even at increased cutting speeds, resulting in an improved surface finish.

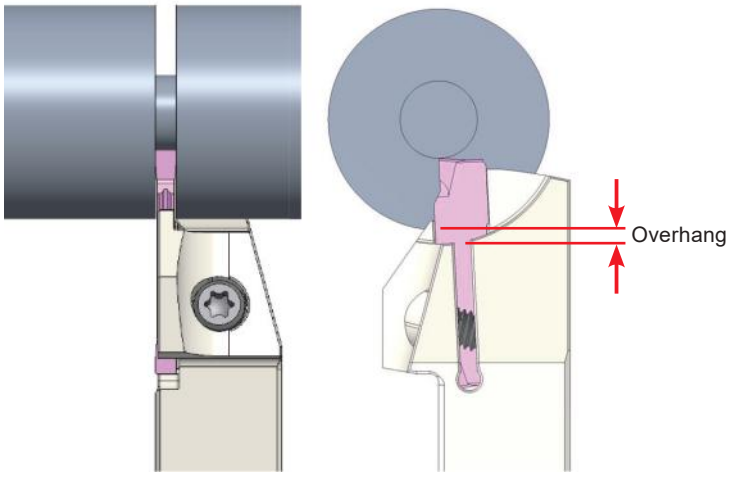
Conventional Holder

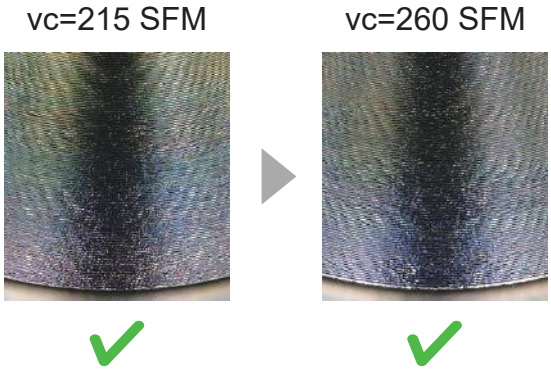




High-rigidity Holder

Shorter overhang increases holder rigidity





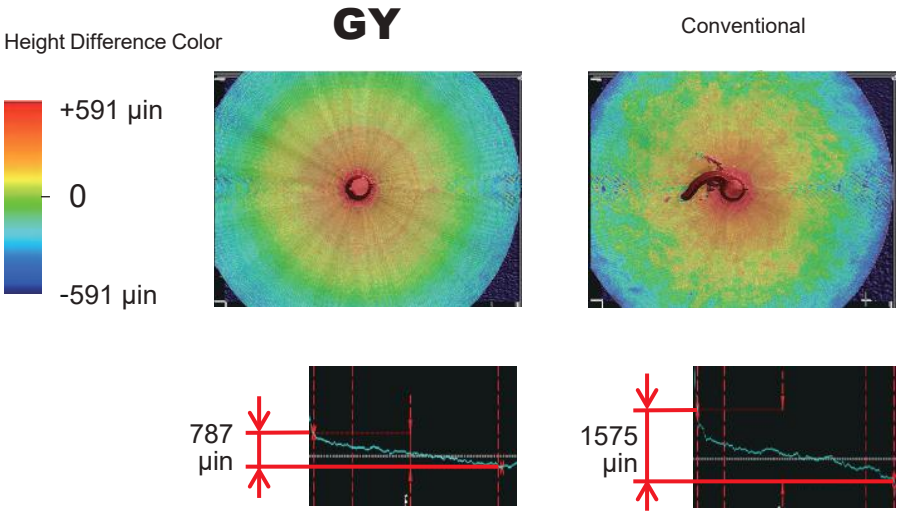
<Cutting Conditions>
Material : AISI 304 Stainless Steel ø1.260 in
Tool : Cutting Width CW=.079 in RE=.005 in .630 × .630 in
Cutting Speed : vc=215, 260 SFM
Feed per Rev. : f=.0028 IPR
Cutting Mode : Wet Cutting

High Productivity with Good Surface Finish

Comparison of the Accuracy of the Workpiece When Cutting-Off: 304 Stainless Steel

High-rigidity holder suppresses chatter, vibration, and deflection, improving the surface finish.

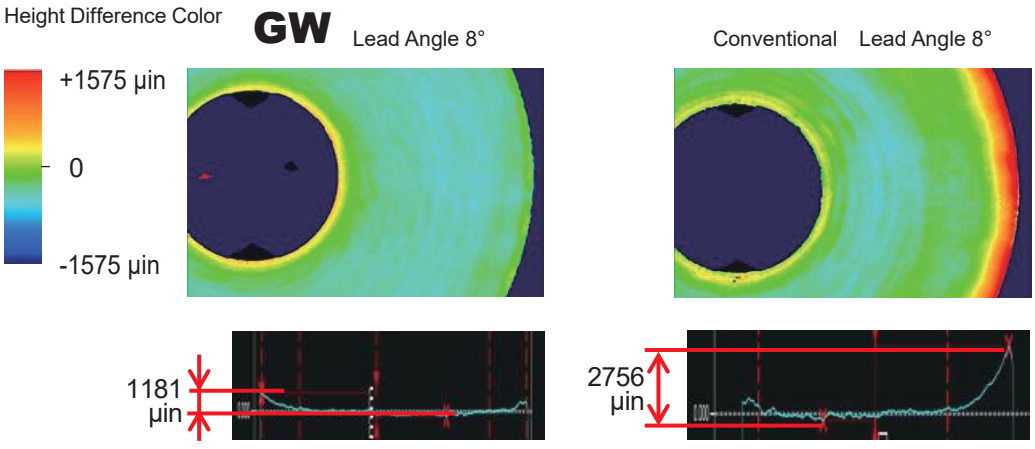
GY Holder



1/2 of Conventional Products

<Cutting Conditions>
Material : AISI 304 Stainless Steel ø.984 in
Tool : Cutting Width CW=.079 in RE=.008 in .630 x .630 in
Cutting Speed : vc=395 SFM
Feed per Rev. : f=.0039 IPR
Cutting Mode : Wet Cutting

GW Holder



High accuracy with same lead angle

<Cutting Conditions>
Material : AISI 304 Stainless Steel ø1.496 in
Tool : Cutting Width CW=.079 in
Cutting Speed : vc=395 SFM
Feed per Rev. : f=.0043 IPR
Cutting Mode : Wet Cutting

GY SERIES (External for Swiss-Type lathes)

Sub-spindle Holder (Metric) NEW

Fig. 1

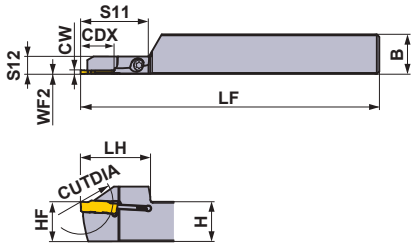
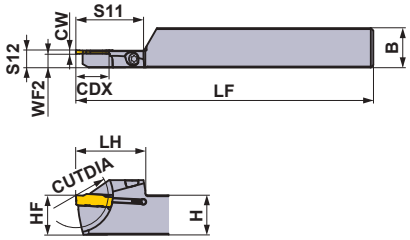


Fig. 2



Seat Size	CW (mm)	CDX *2 (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number	Stock	Fig.
B	1.20	10	20	Mono Block	R	GYSR1212G00-B10-SS	●	1
		10	20		L	GYSL1212G00-B10-SS	●	2
		13	26	Mono Block	R	GYSR1616JX00-B13-SS	●	1
		13	26		L	GYSL1616JX00-B13-SS	●	2
C	1.50	10	20	Mono Block	R	GYSR1212G00-C10-TS	●	1
		10	20		L	GYSL1212G00-C10-TS	●	2
		13	26	Mono Block	R	GYSR1616JX00-C13-SS	●	1
		13	26		L	GYSL1616JX00-C13-SS	●	2
D	2.00	10	20	Mono Block	R	GYSR1212G00-D10-SS	●	1
		10	20		L	GYSL1212G00-D10-SS	●	2
		16	32	Mono Block	R	GYSR1616JX00-D16-TS	●	1
		16	32		L	GYSL1616JX00-D16-TS	●	2

● = NEW

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cutting-Off Diameter

* 1 Dimensions shown are based on the standard insert (MIID).

* 2 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to pages 30 ─ 33.

● : USA Stock

Spare Parts

Tool Holder Type	 *	
	Clamp Screw	Wrench
GYSR/L1212G00-◌10-SS	CS350990T	TKY10R
GYSR/L1212G00-◌10-TS	CS350990T	TKY10R
GYSR/L1616JX00-◌13-SS	CS350990T	TKY10R
GYSR/L1616JX00-D16-TS	TS4SBL	TKY15R

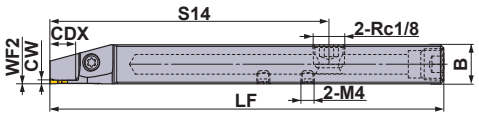
* Clamp Torque (lbf-in): CS350990T=22, TS4SBL=31

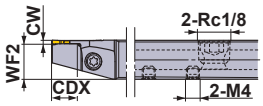
	Dimensions (mm) *1								MIID
	H	B	LF	LH	HF	WF2	S11	S12	
	12	12	90	22	12	0	26	7	**GY2M0120B010N-GS**
	12	12	90	22	12	5.8	26	7	**GY2M0120B010N-GS**
	16	16	120	28	16	0	27	7	**GY2M0120B010N-GS**
	16	16	120	28	16	5.8	27	7	**GY2M0120B010N-GS**
	12	12	90	22	12	0	26	7	**GY2M0150C020N-GM**
	12	12	90	22	12	5.5	26	7	**GY2M0150C020N-GM**
	16	16	120	28	16	0	27	7	**GY2M0150C020N-GM**
	16	16	120	28	16	5.5	27	7	**GY2M0150C020N-GM**
	12	12	90	22	12	0	26	9	**GY2M0200D020N-GM**
	12	12	90	22	12	7	26	9	**GY2M0200D020N-GM**
	16	16	120	28	16	0	27	10.15	**GY2M0200D020N-GM**
	16	16	120	28	16	8.15	27	10.15	**GY2M0200D020N-GM**

GY SERIES (External for Swiss-Type lathes)

Internal Coolant Through Holder (Inch) NEW

Right-hand tool holder shown.





Left-hand tool holder illustrated.

Fig. 1

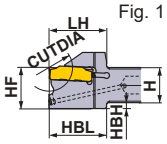
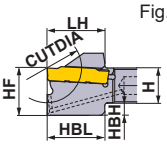
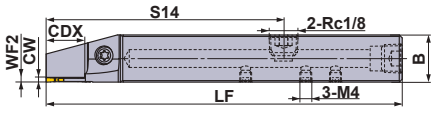
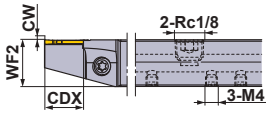


Fig. 2



Right-hand tool holder shown.





Left-hand tool holder illustrated.

Fig. 3

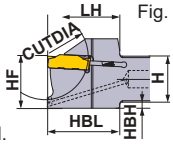
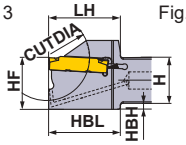


Fig. 4



Seat Size	CW (in)	CDX *2 (in)	CUTDIA (in)	Type	Hand (R/L)	Order Number	Stock	Fig.
B	.047	.315	.630	Mono Block	R	GYSRUS08B00-B08-C	●	1
					L	GYSLUS08B00-B08-C	●	1
		.472	.945	Mono Block	R	GYSRUS08B00-B12-C	●	1
					L	GYSLUS08B00-B12-C	●	1
		.315	.630	Mono Block	R	GYSRUS10B00-B08-C	●	3
					L	GYSLUS10B00-B08-C	●	3
		.512	1.024	Mono Block	R	GYSRUS10B00-B13-C	●	3
					L	GYSLUS10B00-B13-C	●	3
C	.059	.315	.630	Mono Block	R	GYSRUS08B00-C08-C	●	1
					L	GYSLUS08B00-C08-C	●	1
		.472	.945	Mono Block	R	GYSRUS08B00-C12-C	●	1
					L	GYSLUS08B00-C12-C	●	1
		.512	1.024	Mono Block	R	GYSRUS10B00-C13-C	●	3
					L	GYSLUS10B00-C13-C	●	3
D	.079 .088	.472	.945	Mono Block	R	GYSRUS08B00-D12-C	●	2
					L	GYSLUS08B00-D12-C	●	2
		.512	1.024	Mono Block	R	GYSRUS10B00-D13-C	●	4
					L	GYSLUS10B00-D13-C	●	4
		.630	1.260	Mono Block	R	GYSRUS10B00-D16-C	●	4
					L	GYSLUS10B00-D16-C	●	4
E	.094 .098 .108	.472	.945	Mono Block	R	GYSRUS08B00-E12-C	●	2
					L	GYSLUS08B00-E12-C	●	2
		.512	1.024	Mono Block	R	GYSRUS10B00-E13-C	●	4
					L	GYSLUS10B00-E13-C	●	4
		.630	1.260	Mono Block	R	GYSRUS10B00-E16-C	●	4
					L	GYSLUS10B00-E16-C	●	4
F	.118 .125 .128	.472	.945	Mono Block	R	GYSRUS08B00-F12-C	●	2
					L	GYSLUS08B00-F12-C	●	2
		.512	1.024	Mono Block	R	GYSRUS10B00-F13-C	●	4
					L	GYSLUS10B00-F13-C	●	4
		.630	1.260	Mono Block	R	GYSRUS10B00-F16-C	●	4
					L	GYSLUS10B00-F16-C	●	4

● = NEW

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cutting-Off Diameter

* 1 Dimensions shown are based on the standard insert (MIID).

* 2 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to pages 30 – 33.

● : **USA Stock**

Spare Parts

Tool Holder Type	 * Clamp Screw	 Direct Coolant Screw	 Plug Screw	 Wrench
GYSR/LUS08B00-○○○-C	CS350990T	HSS04004	HGM-PT1/8	TKY10R, HKY50R, HKY20R
GYSR/LUS10B00-○○○-C	TS4SBL	HSS04004	HGM-PT1/8	TKY15R, HKY50R, HKY20R

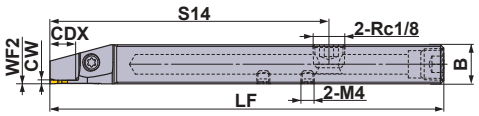
* Clamp Torque (lbf-in): CS350990T=22, TS4SBL=31

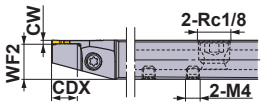
Dimensions (in) *1									MIID
H	B	LF	LH	HF	HBH	HBL	WF2	S14	
.500	.500	4.500	.768	.500	.079	.768	.000	3.346	**GY2M0120B010N-GS**
.500	.500	4.500	.768	.500	.079	.768	.453	3.346	**GY2M0120B010N-GS**
.500	.500	4.500	.768	.500	.157	.768	.000	3.346	**GY2M0120B010N-GS**
.500	.500	4.500	.768	.500	.157	.768	.453	3.346	**GY2M0120B010N-GS**
.625	.625	4.500	.984	.625	—	—	.000	3.150	**GY2M0120B010N-GS**
.625	.625	4.500	.984	.625	—	—	.578	3.150	**GY2M0120B010N-GS**
.625	.625	4.500	.984	.625	.079	.984	.000	3.150	**GY2M0120B010N-GS**
.625	.625	4.500	.984	.625	.079	.984	.578	3.150	**GY2M0120B010N-GS**
.500	.500	4.500	.768	.500	.079	.768	.000	3.346	**GY2M0150C020N-GM**
.500	.500	4.500	.768	.500	.079	.768	.441	3.346	**GY2M0150C020N-GM**
.500	.500	4.500	.768	.500	.157	.768	.000	3.346	**GY2M0150C020N-GM**
.500	.500	4.500	.768	.500	.157	.768	.441	3.346	**GY2M0150C020N-GM**
.625	.625	4.500	.984	.625	.079	.984	.000	3.150	**GY2M0150C020N-GM**
.625	.625	4.500	.984	.625	.079	.984	.566	3.150	**GY2M0150C020N-GM**
.500	.500	4.500	.768	.500	.157	.768	.000	3.346	**GY2M0200D020N-GM**
.500	.500	4.500	.768	.500	.157	.768	.421	3.346	**GY2M0200D020N-GM**
.625	.625	4.500	.984	.625	.079	.984	.000	3.150	**GY2M0200D020N-GM**
.625	.625	4.500	.984	.625	.079	.984	.546	3.150	**GY2M0200D020N-GM**
.625	.625	4.500	.984	.625	.157	.984	.000	3.150	**GY2M0200D020N-GM**
.625	.625	4.500	.984	.625	.157	.984	.546	3.150	**GY2M0200D020N-GM**
.500	.500	4.500	.768	.500	.157	.768	.000	3.346	**GY2M0250E020N-GM**
.500	.500	4.500	.768	.500	.157	.768	.402	3.346	**GY2M0250E020N-GM**
.625	.625	4.500	.984	.625	.079	.984	.000	3.150	**GY2M0250E020N-GM**
.625	.625	4.500	.984	.625	.079	.984	.527	3.150	**GY2M0250E020N-GM**
.625	.625	4.500	.984	.625	.157	.984	.000	3.150	**GY2M0250E020N-GM**
.625	.625	4.500	.984	.625	.157	.984	.527	3.150	**GY2M0250E020N-GM**
.500	.500	4.500	.768	.500	.157	.768	.000	3.346	**GY2M0300F030N-GM**
.500	.500	4.500	.768	.500	.157	.768	.378	3.346	**GY2M0300F030N-GM**
.625	.625	4.500	.984	.625	.079	.984	.000	3.150	**GY2M0300F030N-GM**
.625	.625	4.500	.984	.625	.079	.984	.502	3.150	**GY2M0300F030N-GM**
.625	.625	4.500	.984	.625	.157	.984	.000	3.150	**GY2M0300F030N-GM**
.625	.625	4.500	.984	.625	.157	.984	.502	3.150	**GY2M0300F030N-GM**

GY SERIES (External for Swiss-Type lathes)

Internal Coolant Through Holder (Metric) NEW

Right-hand tool holder shown.





Left-hand tool holder illustrated.

Fig. 1

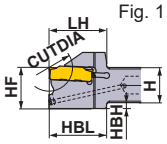
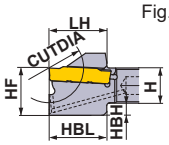
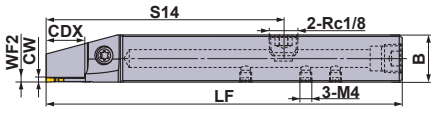
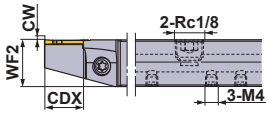


Fig. 2



Right-hand tool holder shown.





Left-hand tool holder illustrated.

Fig. 3

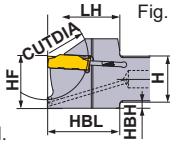
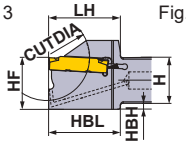


Fig. 4



Seat Size	CW (mm)	CDX *2 (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number	Stock	Fig.
B	1.20	8	16	Mono Block	R	GYSR1212JX00-B08-C	●	1
					L	GYSL1212JX00-B08-C	●	1
		12	24	Mono Block	R	GYSR1212JX00-B12-C	●	1
					L	GYSL1212JX00-B12-C	●	1
		8	16	Mono Block	R	GYSR1616JX00-B08-C	●	3
					L	GYSL1616JX00-B08-C	●	3
		13	26	Mono Block	R	GYSR1616JX00-B13-C	●	3
					L	GYSL1616JX00-B13-C	●	3
C	1.50	8	16	Mono Block	R	GYSR1212JX00-C08-C	●	1
					L	GYSL1212JX00-C08-C	●	1
		12	24	Mono Block	R	GYSR1212JX00-C12-C	●	1
					L	GYSL1212JX00-C12-C	●	1
		13	26	Mono Block	R	GYSR1616JX00-C13-C	●	3
					L	GYSL1616JX00-C13-C	●	3
D	2.00 2.24	12	24	Mono Block	R	GYSR1212JX00-D12-C	●	2
					L	GYSL1212JX00-D12-C	●	2
		13	26	Mono Block	R	GYSR1616JX00-D13-C	●	4
					L	GYSL1616JX00-D13-C	●	4
		16	32	Mono Block	R	GYSR1616JX00-D16-C	●	4
					L	GYSL1616JX00-D16-C	●	4
E	2.39 2.50 2.74	12	24	Mono Block	R	GYSR1212JX00-E12-C	●	2
					L	GYSL1212JX00-E12-C	●	2
		13	26	Mono Block	R	GYSR1616JX00-E13-C	●	4
					L	GYSL1616JX00-E13-C	●	4
		16	32	Mono Block	R	GYSR1616JX00-E16-C	●	4
					L	GYSL1616JX00-E16-C	●	4
F	3.00 3.18 3.24	12	24	Mono Block	R	GYSR1212JX00-F12-C	●	2
					L	GYSL1212JX00-F12-C	●	2
		13	26	Mono Block	R	GYSR1616JX00-F13-C	●	4
					L	GYSL1616JX00-F13-C	●	4
		16	32	Mono Block	R	GYSR1616JX00-F16-C	●	4
					L	GYSL1616JX00-F16-C	●	4

● = NEW

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cutting-Off Diameter

* 1 Dimensions shown are based on the standard insert (MIID).

* 2 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to pages 30 ─ 33.

● : USA Stock

Spare Parts

Tool Holder Type	 *			
	Clamp Screw	Direct Coolant Screw	Plug Screw	Wrench
GYSR/L1212JX00-○○○-C	CS350990T	HSS04004	HGM-PT1/8	TKY10R, HKY50R, HKY20R
GYSR/L1616JX00-○○○-C	TS4SBL	HSS04004	HGM-PT1/8	TKY15R, HKY50R, HKY20R

* Clamp Torque (lbf-in): CS350990T=22, TS4SBL=31

Dimensions (mm) *1									MIID
H	B	LF	LH	HF	HBH	HBL	WF2	S14	
12	12	120	19.5	12	2	19.5	0	85	**GY2M0120B010N-GS**
12	12	120	19.5	12	2	19.5	10.8	85	**GY2M0120B010N-GS**
12	12	120	19.5	12	4	19.5	0	85	**GY2M0120B010N-GS**
12	12	120	19.5	12	4	19.5	10.8	85	**GY2M0120B010N-GS**
16	16	120	25.0	16	—	—	0	80	**GY2M0120B010N-GS**
16	16	120	25.0	16	—	—	14.8	80	**GY2M0120B010N-GS**
16	16	120	25.0	16	2	25.0	0	80	**GY2M0120B010N-GS**
16	16	120	25.0	16	2	25.0	14.8	80	**GY2M0120B010N-GS**
12	12	120	19.5	12	2	19.5	0	85	**GY2M0150C020N-GM**
12	12	120	19.5	12	2	19.5	10.5	85	**GY2M0150C020N-GM**
12	12	120	19.5	12	4	19.5	0	85	**GY2M0150C020N-GM**
12	12	120	19.5	12	4	19.5	10.5	85	**GY2M0150C020N-GM**
16	16	120	25.0	16	2	25.0	0	80	**GY2M0150C020N-GM**
16	16	120	25.0	16	2	25.0	14.5	80	**GY2M0150C020N-GM**
12	12	120	19.5	12	4	19.5	0	85	**GY2M0200D020N-GM**
12	12	120	19.5	12	4	19.5	10	85	**GY2M0200D020N-GM**
16	16	120	25.0	16	2	25.0	0	80	**GY2M0200D020N-GM**
16	16	120	25.0	16	2	25.0	14	80	**GY2M0200D020N-GM**
16	16	120	25.0	16	4	25.0	0	80	**GY2M0200D020N-GM**
16	16	120	25.0	16	4	25.0	14	80	**GY2M0200D020N-GM**
12	12	120	19.5	12	4	19.5	0	85	**GY2M0250E020N-GM**
12	12	120	19.5	12	4	19.5	9.5	85	**GY2M0250E020N-GM**
16	16	120	25.0	16	2	25.0	0	80	**GY2M0250E020N-GM**
16	16	120	25.0	16	2	25.0	13.5	80	**GY2M0250E020N-GM**
16	16	120	25.0	16	4	25.0	0	80	**GY2M0250E020N-GM**
16	16	120	25.0	16	4	25.0	13.5	80	**GY2M0250E020N-GM**
12	12	120	19.5	12	4	19.5	0	85	**GY2M0300F030N-GM**
12	12	120	19.5	12	4	19.5	9	85	**GY2M0300F030N-GM**
16	16	120	25.0	16	2	25.0	0	80	**GY2M0300F030N-GM**
16	16	120	25.0	16	2	25.0	13	80	**GY2M0300F030N-GM**
16	16	120	25.0	16	4	25.0	0	80	**GY2M0300F030N-GM**
16	16	120	25.0	16	4	25.0	13	80	**GY2M0300F030N-GM**

GY SERIES (External for Swiss-Type lathes)

00º Type Holder (Inch)

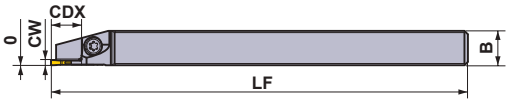


Fig. 1

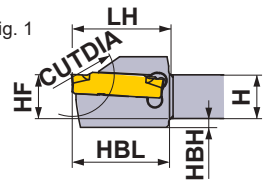
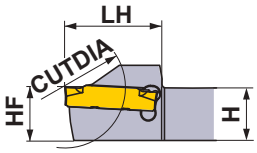


Fig. 2



Right-hand tool holder shown.

Seat Size	CW (mm)	CDX *2 (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number	Stock	Fig.
C	.059	.433	.866	Mono Block	R	GYSRUS06B00-C11	●	1
					L	GYSLUS06B00-C11	●	1
		.512	1.024	Mono Block	R	GYSRUS08B00-C13	●	2
					L	GYSLUS08B00-C13	●	2
		.669	1.338	Mono Block	R	GYSRUS10B00-C17	●	2
					L	GYSLUS10B00-C17	●	2
				Mono Block	R	GYSRUS12B00-C17	●	2
					L	GYSLUS12B00-C17	●	2
D	.079 .088	.433	.866	Mono Block	R	GYSRUS06B00-D11	●	1
					L	GYSLUS06B00-D11	●	1
		.512	1.024	Mono Block	R	GYSRUS08B00-D13	●	2
					L	GYSLUS08B00-D13	●	2
		.669	1.338	Mono Block	R	GYSRUS10B00-D17	●	2
					L	GYSLUS10B00-D17	●	2
				Mono Block	R	GYSRUS12B00-D17	●	2
					L	GYSLUS12B00-D17	●	2
E	.094 .098 .108	.433	.866	Mono Block	R	GYSRUS06B00-E11	●	1
					L	GYSLUS06B00-E11	●	1
		.512	1.024	Mono Block	R	GYSRUS08B00-E13	●	2
					L	GYSLUS08B00-E13	●	2
		.669	1.338	Mono Block	R	GYSRUS10B00-E17	●	2
					L	GYSLUS10B00-E17	●	2
				Mono Block	R	GYSRUS12B00-E17	●	2
					L	GYSLUS12B00-E17	●	2
		.787	1.574	Mono Block	R	GYSRUS10B00-E20	●	2
					L	GYSLUS10B00-E20	●	2
				Mono Block	R	GYSRUS12B00-E20	●	2
					L	GYSLUS12B00-E20	●	2
F	.118 .125 .128	.512	1.024	Mono Block	R	GYSRUS08B00-F13	●	2
					L	GYSLUS08B00-F13	●	2
		.669	1.338	Mono Block	R	GYSRUS10B00-F17	●	2
					L	GYSLUS10B00-F17	●	2
				Mono Block	R	GYSRUS12B00-F17	●	2
					L	GYSLUS12B00-F17	●	2
		.787	1.574	Mono Block	R	GYSRUS10B00-F20	●	2
					L	GYSLUS10B00-F20	●	2
				Mono Block	R	GYSRUS12B00-F20	●	2
					L	GYSLUS12B00-F20	●	2

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cuttig-Off Diameter

* 1 Dimensions shown are based on the standard insert (MIID).

* 2 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to pages 30 – 33.

● : USA Stock

Spare Parts

Tool Holder Type	 * Clamp Screw	 Wrench
GYSR/LUS06B00-○11	CS350990T	TKY10R
GYSR/LUS08B00-○13	CS350990T	TKY10R
GYSR/LUS10B00-○18	TS4SBL	TKY15R
GYSR/LUS12B00-○17	TS4SBL	TKY15R

* Clamp Torque (lbf-in): CS350990T=22, TS4SBL=31

Dimensions (in) *1							MIID
H	B	LF	LH	HF	HBH	HBL	
.375	.375	4.500	.866	.375	.125	.620	**GY2M0150C020N-GM**
.375	.375	4.500	.866	.375	.125	.620	**GY2M0150C020N-GM**
.500	.500	4.500	.866	.500	—	.620	**GY2M0150C020N-GM**
.500	.500	4.500	.866	.500	—	.620	**GY2M0150C020N-GM**
.625	.625	4.500	1.063	.625	—	.638	**GY2M0150C020N-GM**
.625	.625	4.500	1.063	.625	—	.638	**GY2M0150C020N-GM**
.750	.750	4.500	1.102	.750	—	.638	**GY2M0150C020N-GM**
.750	.750	4.500	1.102	.750	—	.638	**GY2M0150C020N-GM**
.375	.375	4.500	.866	.375	.125	.899	**GY2M0200D020N-GM**
.375	.375	4.500	.866	.375	.125	.899	**GY2M0200D020N-GM**
.500	.500	4.500	.866	.500	—	.899	**GY2M0200D020N-GM**
.500	.500	4.500	.866	.500	—	.899	**GY2M0200D020N-GM**
.625	.625	4.500	1.063	.625	—	.918	**GY2M0200D020N-GM**
.625	.625	4.500	1.063	.625	—	.918	**GY2M0200D020N-GM**
.750	.750	4.500	1.102	.750	—	.878	**GY2M0200D020N-GM**
.750	.750	4.500	1.102	.750	—	.878	**GY2M0200D020N-GM**
.375	.375	4.500	.866	.375	.125	.901	**GY2M0250E020N-GM**
.375	.375	4.500	.866	.375	.125	.901	**GY2M0250E020N-GM**
.500	.500	4.500	.866	.500	—	.901	**GY2M0250E020N-GM**
.500	.500	4.500	.866	.500	—	.901	**GY2M0250E020N-GM**
.625	.625	4.500	1.063	.625	—	.920	**GY2M0250E020N-GM**
.625	.625	4.500	1.063	.625	—	.920	**GY2M0250E020N-GM**
.750	.750	4.500	1.102	.750	—	.880	**GY2M0250E020N-GM**
.750	.750	4.500	1.102	.750	—	.880	**GY2M0250E020N-GM**
.625	.625	4.500	1.220	.625	—	.920	**GY2M0250E020N-GM**
.625	.625	4.500	1.220	.625	—	.920	**GY2M0250E020N-GM**
.750	.750	4.500	1.220	.750	—	.880	**GY2M0250E020N-GM**
.750	.750	4.500	1.220	.750	—	.880	**GY2M0250E020N-GM**
.500	.500	4.500	.866	.500	—	.903	**GY2M0300F030N-GM**
.500	.500	4.500	.866	.500	—	.903	**GY2M0300F030N-GM**
.625	.625	4.500	1.063	.625	—	.925	**GY2M0300F030N-GM**
.625	.625	4.500	1.063	.625	—	.925	**GY2M0300F030N-GM**
.750	.750	4.500	1.102	.750	—	.885	**GY2M0300F030N-GM**
.750	.750	4.500	1.102	.750	—	.885	**GY2M0300F030N-GM**
.625	.625	4.500	1.220	.625	—	.925	**GY2M0300F030N-GM**
.625	.625	4.500	1.220	.625	—	.925	**GY2M0300F030N-GM**
.750	.750	4.500	1.220	.750	—	.885	**GY2M0300F030N-GM**
.750	.750	4.500	1.220	.750	—	.885	**GY2M0300F030N-GM**

GY SERIES (External for Swiss-Type lathes)

00º Type Holder (Metric)

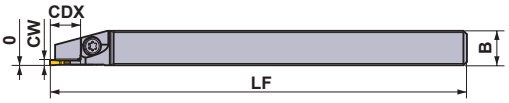


Fig. 1

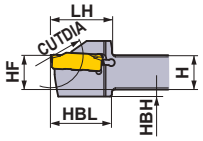


Fig. 2

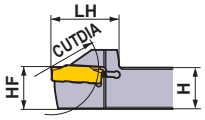


Fig. 3

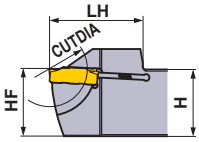


Fig. 4

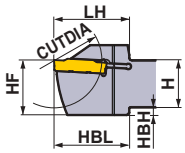


Fig. 5

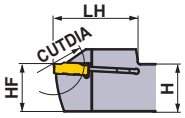
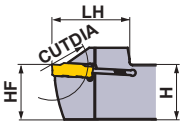


Fig. 6



Right-hand tool holder shown.

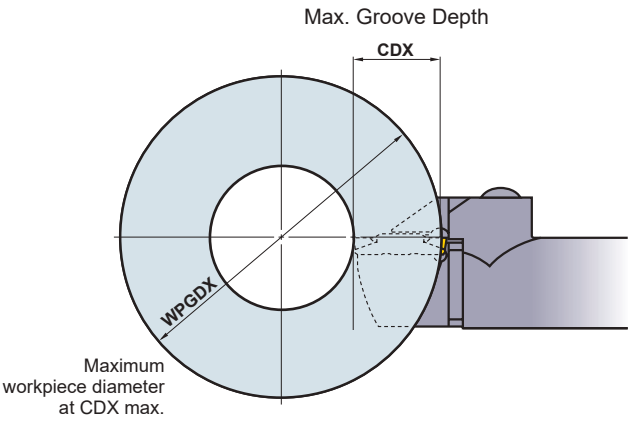
Seat Size	CW (mm)	CDX *2 (mm)	CUTDIA (mm)	Max. workpiece dia. at CDX max.	Type	Hand (R/L)	Order Number	Stock	Fig.
B	1.20	8	16	16	Mono Block	R	GYSR1010JX00-B08	★	1
						L	GYSL1010JX00-B08	★	1
					Mono Block	R	GYSR1212JX00-B08	●	2
						L	GYSL1212JX00-B08	●	2
					Mono Block	R	GYSR1616JX00-B08	●	2
						L	GYSL1616JX00-B08	●	2
		12	24	24	Mono Block	R	GYSR1212JX00-B12	●	1
						L	GYSL1212JX00-B12	●	1
		13	26	26	Mono Block	R	GYSR1616JX00-B13	●	2
						L	GYSL1616JX00-B13	★	2
C	1.50	8	16	16	Mono Block	R	GYSR1010JX00-C08	★	1
						L	GYSL1010JX00-C08	★	1
					Mono Block	R	GYSR1212JX00-C08	★	2
						L	GYSL1212JX00-C08	★	2
		12	24	24	Mono Block	R	GYSR1212JX00-C12	★	1
						L	GYSL1212JX00-C12	★	1
		13	26	26	Mono Block	R	GYSR1616JX00-C13	★	2
						L	GYSL1616JX00-C13	★	2
					Mono Block	R	GYSR2012JX00-C13*5	★	3
						L	GYSL2012JX00-C13*5	★	3
				34	Mono Block	R	GYSR2012JX00-C13A*3,5	●	6
						L	GYSL2012JX00-C13A*3,5	●	6
					Mono Block	R	GYSR2020K00-C13*3	●	5
						L	GYSL2020K00-C13*3	●	5
D	2.00 2.24	6.5	13	20	Mono Block	R	GYSR1212JX00-D07*3	●	5
						L	GYSL1212JX00-D07*3	●	5
		10	20		Mono Block	R	GYSR1010JX00-D10	★	1
						L	GYSL1010JX00-D10	★	1
				32	Mono Block	R	GYSR1616JX00-D10*3	●	5
						L	GYSL1616JX00-D10*3	●	5
		12	24	24	Mono Block	R	GYSR1212JX00-D12	●	1
						L	GYSL1212JX00-D12	●	1
		13	26	26	Mono Block	R	GYSR1616JX00-D13	●	2
						L	GYSL1616JX00-D13	●	2
		16	32	32	Mono Block	R	GYSR1616JX00-D16	●	2
						L	GYSL1616JX00-D16	●	2
		17	34	34	Mono Block	R	GYSR1915K00-D17	★	3
						L	GYSL1915K00-D17	★	3
					Mono Block	R	GYSR2012JX00-D17	●	3
						L	GYSL2012JX00-D17	★	3
					Mono Block	R	GYSR2020K00-D17	★	2
						L	GYSL2020K00-D17	★	2
					Mono Block	R	GYSR2525M00-D17	★	2
						L	GYSL2525M00-D17	★	2

● = NEW **CW =** Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cuttig-Off Diameter

* 1 Dimensions shown are based on the standard insert (MIID).

* 2 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to pages 30 – 33.

● : USA Stock, ★ : Stocked in Japan



Spare Parts

Tool Holder Type	Clamp Screw *	Wrench
GYSR/L1010JX00	CS350990T	TKY10R
GYSR/L1212JX00	CS350990T	TKY10R
GYSR/L1616JX00	TS4SBL	TKY15R
GYSR/L1915K00	TS4SBL	TKY15R
GYSR/L2012JX00	CS350990T	TKY10R
GYSR/L2020K00	HSC05018	HKY40R
GYSR/L2525K00	HSC05018	HKY40R

* Clamp Torque (lbf-in): CS350990T=22, TS4SBL=31, HSC05018=62

Dimensions (mm) *1							MIID
H	B	LF	LH	HF	HBH	HBL	
10	10	120	17.5	10	2	17.5	**GY2M0120B010N-GS**
10	10	120	17.5	10	2	17.5	**GY2M0120B010N-GS**
12	12	120	19.5	12	—	—	**GY2M0120B010N-GS**
12	12	120	19.5	12	—	—	**GY2M0120B010N-GS**
16	16	120	25	16	—	—	**GY2M0120B010N-GS**
16	16	120	25	16	—	—	**GY2M0120B010N-GS**
12	12	120	19.5	12	2	19.5	**GY2M0120B010N-GS**
12	12	120	19.5	12	2	19.5	**GY2M0120B010N-GS**
16	16	120	25	16	—	—	**GY2M0120B010N-GS**
16	16	120	25	16	—	—	**GY2M0120B010N-GS**
10	10	120	17.5	10	2	17.5	**GY2M0150C020N-GM**
10	10	120	17.5	10	2	17.5	**GY2M0150C020N-GM**
12	12	120	19.5	12	—	—	**GY2M0150C020N-GM**
12	12	120	19.5	12	—	—	**GY2M0150C020N-GM**
12	12	120	19.5	12	2	19.5	**GY2M0150C020N-GM**
12	12	120	19.5	12	2	19.5	**GY2M0150C020N-GM**
16	16	120	25	16	—	—	**GY2M0150C020N-GM**
16	16	120	25	16	—	—	**GY2M0150C020N-GM**
20	12	120	28	20	—	—	**GY2M0150C020N-GM**
20	12	120	28	20	—	—	**GY2M0150C020N-GM**
20	12	120	28	20	—	—	**GY2M0150C020N-GM**
20	12	120	28	20	—	—	**GY2M0150C020N-GM**
20	20	125	35	20	—	—	**GY2M0150C020N-GM**
20	20	125	35	20	—	—	**GY2M0150C020N-GM**
12	12	120	19.5	12	—	—	**GY2M0200D020N-GM**
12	12	120	19.5	12	—	—	**GY2M0200D020N-GM**
10	10	120	17.5	10	2	17.5	**GY2M0200D020N-GM**
10	10	120	17.5	10	2	17.5	**GY2M0200D020N-GM**
16	16	120	25	16	—	—	**GY2M0200D020N-GM**
16	16	120	25	16	—	—	**GY2M0200D020N-GM**
12	12	120	19.5	12	2	19.5	**GY2M0200D020N-GM**
12	12	120	19.5	12	2	19.5	**GY2M0200D020N-GM**
16	16	120	25	16	—	—	**GY2M0200D020N-GM**
16	16	120	25	16	—	—	**GY2M0200D020N-GM**
16	16	120	28	16	—	—	**GY2M0200D020N-GM**
16	16	120	28	16	—	—	**GY2M0200D020N-GM**
19.05	15.875	125	28	19.05	—	—	**GY2M0200D020N-GM**
19.05	15.875	125	28	19.05	—	—	**GY2M0200D020N-GM**
20	12	120	28	20	—	—	**GY2M0200D020N-GM**
20	12	120	28	20	—	—	**GY2M0200D020N-GM**
20	20	125	35	20	—	—	**GY2M0200D020N-GM**
20	20	125	35	20	—	—	**GY2M0200D020N-GM**
25	25	150	40	25	—	—	**GY2M0200D020N-GM**
25	25	150	40	25	—	—	**GY2M0200D020N-GM**

* 3 indicates the High-Feed Cutting type.
* 4 indicates a parting holder exclusively designed for large CITIZEN MACHINERY CO., LTD. Cincom machines such as L32 and M32.
* 5 indicates a parting holder exclusively designed for CITIZEN MACHINERY CO., LTD. Miyano machines BND34, BNA42, and ANX42.

GY SERIES (External for Swiss-Type lathes)

00º Type Holder (Metric)

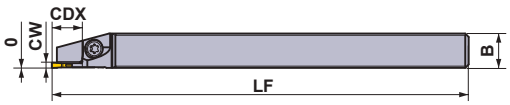


Fig. 1

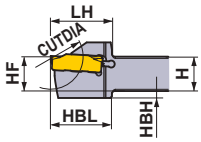


Fig. 2

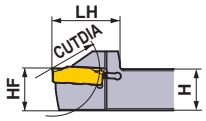


Fig. 3

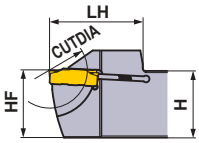


Fig. 4

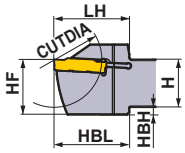


Fig. 5

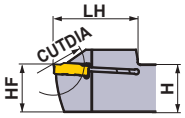
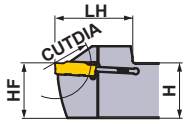


Fig. 6



Right-hand tool holder shown.

Seat Size	CW (mm)	CDX *2 (mm)	CUTDIA (mm)	Max. workpiece dia. at CDX max.	Type	Hand (R/L)	Order Number	Stock	Fig.
E	2.39 2.50 2.74	6.5	13	20	Mono Block	R	GYSR1212JX00-E07*3	●	5
						L	GYSL1212JX00-E07*3	●	5
		10	20		Mono Block	R	GYSR1010JX00-E10	●	1
						L	GYSL1010JX00-E10	●	1
				32	Mono Block	R	GYSR1616JX00-E10*3	●	5
						L	GYSL1616JX00-E10*3	●	5
		12	24	24	Mono Block	R	GYSR1212JX00-E12	●	1
						L	GYSL1212JX00-E12	●	1
		13	26	26	Mono Block	R	GYSR1616JX00-E13	●	2
						L	GYSL1616JX00-E13	●	2
		16	32	32	Mono Block	R	GYSR1616JX00-E16	●	2
						L	GYSL1616JX00-E16	●	2
		17	34	34	Mono Block	R	GYSR1915K00-E17*4	●	3
						L	GYSL1915K00-E17*4	●	3
					Mono Block	R	GYSR2012JX00-E17*5	●	3
						L	GYSL2012JX00-E17*5	●	3
					Mono Block	R	GYSR2020K00-E17	●	2
						L	GYSL2020K00-E17	●	2
					Mono Block	R	GYSR2525M00-E17	●	2
						L	GYSL2525M00-E17	●	2
F	3.00 3.18 3.24	6.5	13	20	Mono Block	R	GYSR1212JX00-F07*3	●	5
						L	GYSL1212JX00-F07*3	●	5
		10	20	32	Mono Block	R	GYSR1616JX00-F10*3	●	5
						L	GYSL1616JX00-F10*3	●	5
		12	24	24	Mono Block	R	GYSR1212JX00-F12	●	1
						L	GYSL1212JX00-F12	●	1
		13	26	26	Mono Block	R	GYSR1616JX00-F13	●	2
						L	GYSL1616JX00-F13	●	2
		16	32	32	Mono Block	R	GYSR1616JX00-F16	●	2
						L	GYSL1616JX00-F16	●	2
		17	34	34	Mono Block	R	GYSR1915K00-F17*4	●	3
						L	GYSL1915K00-F17*4	●	3
					Mono Block	R	GYSR2012JX00-F17*5	●	3
						L	GYSL2012JX00-F17*5	●	3
					Mono Block	R	GYSR2020K00-F17	●	5
						L	GYSL2020K00-F17	●	5
		19	38	38	Mono Block	R	GYSR1915K00-F19*4	●	4
						L	GYSL1915K00-F19*4	●	4
				42	Mono Block	R	GYSR2020K00-F19*3	●	4
						L	GYSL2020K00-F19*3	●	4
G	4.00 4.24	21	42	42	Mono Block	R	GYSR2020K00-G21	●	4
						L	GYSL2020K00-G21	●	4

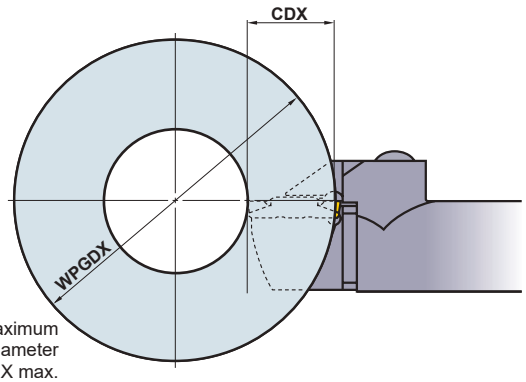
● = NEW **CW =** Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cutting-Off Diameter

* 1 Dimensions shown are based on the standard insert (MIID).

* 2 The maximum groove depth (CDX) is limited by the workpiece diameter. For details, please refer to pages 30 – 33.

● : USA Stock

Max. Groove Depth



Maximum workpiece diameter at CDX max.

Spare Parts

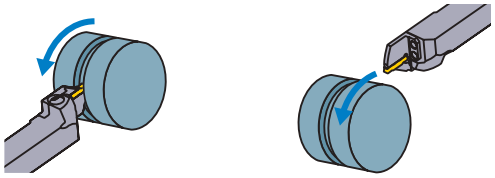
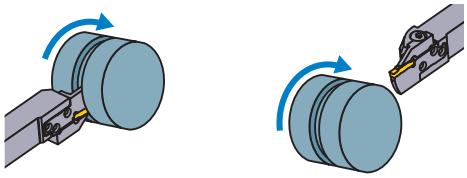
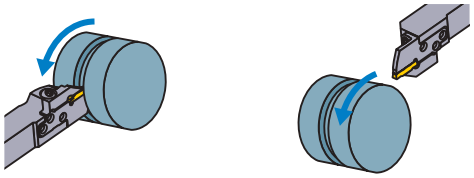
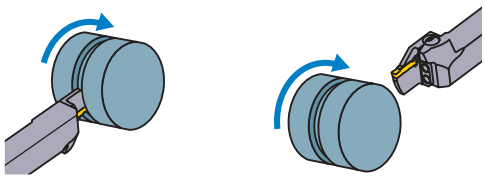
Tool Holder Type	* Clamp Screw	Wrench
GYSR/L1010JX00	CS350990T	TKY10R
GYSR/L1212JX00	CS350990T	TKY10R
GYSR/L1616JX00	TS4SBL	TKY15R
GYSR/L1915K00	TS4SBL	TKY15R
GYSR/L2012JX00	CS350990T	TKY10R
GYSR/L2020K00	HSC05018	HKY40R
GYSR/L2525K00	HSC05018	HKY40R

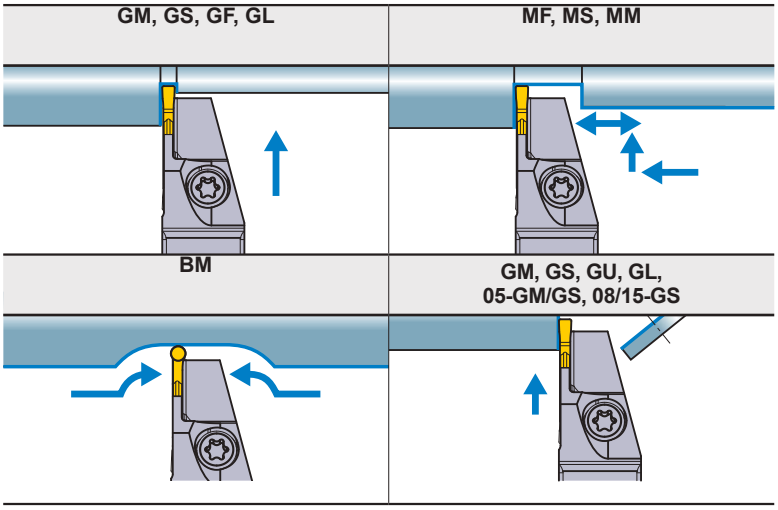
* Clamp Torque (lbf-in): CS350990T=22, TS4SBL=31, HSC05018=62

Dimensions (mm) *1							MIID
H	B	LF	LH	HF	HBH	HBL	
12	12	120	19.5	12	—	—	**GY2M0250E020N-GM**
12	12	120	19.5	12	—	—	**GY2M0250E020N-GM**
10	10	120	17.5	10	2	17.5	**GY2M0250E020N-GM**
10	10	120	17.5	10	2	17.5	**GY2M0250E020N-GM**
16	16	120	25	16	—	—	**GY2M0250E020N-GM**
16	16	120	25	16	—	—	**GY2M0250E020N-GM**
12	12	120	19.5	12	2	19.5	**GY2M0250E020N-GM**
12	12	120	19.5	12	2	19.5	**GY2M0250E020N-GM**
16	16	120	25	16	—	—	**GY2M0250E020N-GM**
16	16	120	25	16	—	—	**GY2M0250E020N-GM**
16	16	120	28	16	—	—	**GY2M0250E020N-GM**
16	16	120	28	16	—	—	**GY2M0250E020N-GM**
19.05	15.875	125	28	19.05	—	—	**GY2M0250E020N-GM**
19.05	15.875	125	28	19.05	—	—	**GY2M0250E020N-GM**
20	12	120	28	20	—	—	**GY2M0250E020N-GM**
20	12	120	28	20	—	—	**GY2M0250E020N-GM**
20	20	125	35	20	—	—	**GY2M0250E020N-GM**
20	20	125	35	20	—	—	**GY2M0250E020N-GM**
25	25	150	40	25	—	—	**GY2M0250E020N-GM**
25	25	150	40	25	—	—	**GY2M0250E020N-GM**
12	12	120	19.5	12	—	—	**GY2M0300F030N-GM**
12	12	120	19.5	12	—	—	**GY2M0300F030N-GM**
16	16	120	25	16	—	—	**GY2M0300F030N-GM**
16	16	120	25	16	—	—	**GY2M0300F030N-GM**
12	12	120	19.5	12	2	19.5	**GY2M0300F030N-GM**
12	12	120	19.5	12	2	19.5	**GY2M0300F030N-GM**
16	16	120	25	16	—	—	**GY2M0300F030N-GM**
16	16	120	25	16	—	—	**GY2M0300F030N-GM**
16	16	120	28	16	—	—	**GY2M0300F030N-GM**
16	16	120	28	16	—	—	**GY2M0300F030N-GM**
19.05	15.875	125	28	19.05	—	—	**GY2M0300F030N-GM**
19.05	15.875	125	28	19.05	—	—	**GY2M0300F030N-GM**
20	12	120	28	20	—	—	**GY2M0300F030N-GM**
20	12	120	28	20	—	—	**GY2M0300F030N-GM**
20	20	125	35	20	—	—	**GY2M0300F030N-GM**
20	20	125	35	20	—	—	**GY2M0300F030N-GM**
19.05	15.875	125	30	19.05	3	30	**GY2M0300F030N-GM**
19.05	15.875	125	30	19.05	3	30	**GY2M0300F030N-GM**
20	20	125	35	20	3	35	**GY2M0300F030N-GM**
20	20	125	35	20	3	35	**GY2M0300F030N-GM**
20	20	125	35	20	3	35	**GY2M0400G030N-GM**
20	20	125	35	20	3	35	**GY2M0400G030N-GM**

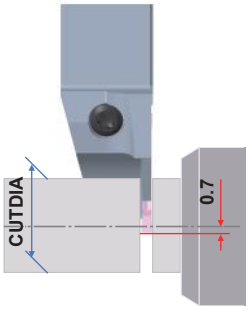
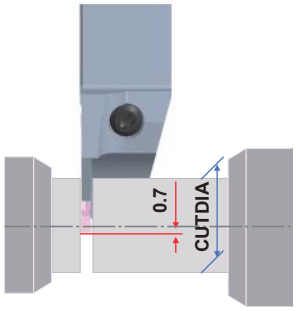
* 3 indicates the High-Feed Cutting type.
* 4 indicates a parting holder exclusively designed for large CITIZEN MACHINERY CO., LTD. Cincom machines such as L32 and M32.
* 5 indicates a parting holder exclusively designed for CITIZEN MACHINERY CO., LTD. Miyano machines BND34, BNA42, and ANX42.

Cutting Mode

	Clockwise	Counterclockwise
R		
L		



Regarding Cutting-Off Depth and Maximum Cutting-Off Diameter

Main Spindle Tooling	Sub-spindle Tooling
	

In case of cutting-off operations, when the cutting edge exceeds the center of the workpiece, keep it to .028 in, 0.7 mm or less.

CUTDIA = Maximum Cutting-Off Diameter

GW SERIES (External for Swiss-Type lathes)

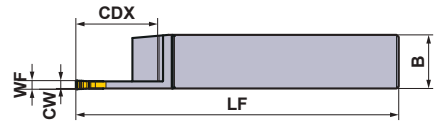
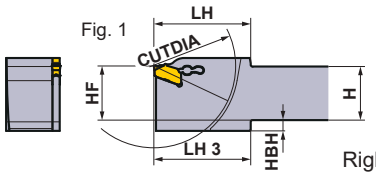


Fig. 1



Right-hand tool holder shown.

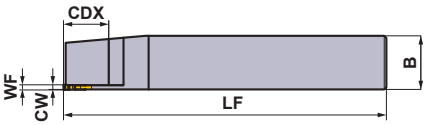
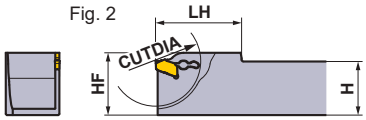


Fig. 2



Right-hand tool holder shown.

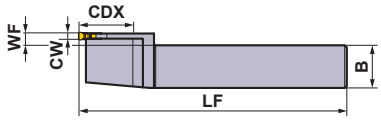
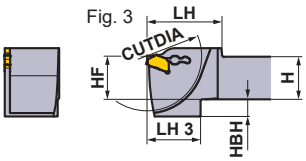


Fig. 3



Left-hand tool holder shown.

Spare Parts



Wrench
GWY39L

Seat Size	CW (mm)	CDX (mm)	CUTDIA (mm)	Type	Hand (R/L)	Order Number	Stock	Dimensions (mm)								Fig.
								H	B	LF	LH	HBL	HF	WF	HBH	
D	2.00	19	38	Mono Block	R	GWSR1616JX00-D38	●	16	16	120	30	30	16	0.3	6	1
		19	38		L	GWSL1616JX00-D38	●	16	16	120	30	30	16	0.3	6	1
		19	38	Mono Block	R	GWSR1915K00-D38	●	19.05	15.875	125	35	35	19.05	0.3	3	1
		19	38		L	GWSL1915K00-D38	●	19.05	15.875	125	35	35	19.05	0.3	3	1
		21	42	Mono Block	R	GWSR2020K00-D42	●	20	20	125	35	25	20	0.3	4	1
		21	42		L	GWSL2020K00-D42	●	20	20	125	35	25	20	0.3	4	1
		21	42	Mono Block	R	GWSR2012K00-D42*1	●	20	12	125	35	25	20	0.3	4	1
		21	42		L	GWSL2012K00-D42*1	●	20	12	125	35	25	20	0.3	4	1
		21	42	Mono Block	R	GWSR2525M00-D42	●	25	25	150	40	—	25	0.3	—	2
		21	42		L	GWSL2525M00-D42	●	25	25	150	40	—	25	0.3	—	2
E	2.39	19	38	Mono Block	R	GWSR1915K00-E38	●	19.05	15.875	125	35	35	19.05	0.2	3	1
		19	38		L	GWSL1915K00-E38	●	19.05	15.875	125	35	35	19.05	0.2	3	1
		21	42	Mono Block	R	GWSR2020K00-E42	●	20	20	125	35	25	20	0.2	4	1
		21	42		L	GWSL2020K00-E42	●	20	20	125	35	25	20	0.2	4	1
		21	42	Mono Block	L	GWSL2020K00-E42-M*2	●	20	20	125	35	25	20	5.7	8	3
		21	42	Mono Block	R	GWSR2012K00-E42*1	●	20	12	125	35	25	20	0.2	4	1
		21	42		L	GWSL2012K00-E42*1	●	20	12	125	35	25	20	0.2	4	1
		21	42	Mono Block	R	GWSR2525M00-E42	●	25	25	150	40	—	25	0.2	—	2
		21	42		L	GWSL2525M00-E42	●	25	25	150	40	—	25	0.2	—	2
F	3.00	19	38	Mono Block	R	GWSR1915K00-F38	●	19.05	15.875	125	35	35	19.05	0.3	3	1
		19	38		L	GWSL1915K00-F38	●	19.05	15.875	125	35	35	19.05	0.3	3	1
		21	42	Mono Block	R	GWSR2012K00-F42*1	●	20	12	125	35	25	20	0.3	4	1
		21	42		L	GWSL2012K00-F42*1	●	20	12	125	35	25	20	0.3	4	1
		21	42	Mono Block	R	GWSR2020K00-F42	●	20	20	125	35	25	20	0.3	4	1
		21	42		L	GWSL2020K00-F42	●	20	20	125	35	25	20	0.3	4	1
		21	42	Mono Block	L	GWSL2020K00-F42-M*2	●	20	20	125	35	25	20	5.8	8	3
		25.5	51	Mono Block	R	GWSR2020K00-F51	●	20	20	125	35	25	20	0.3	8	1
		25.5	51		L	GWSL2020K00-F51	●	20	20	125	35	25	20	0.3	8	1
		25.5	51	Mono Block	L	GWSL2020K00-F51-M*2	●	20	20	125	35	25	20	5.8	8	3
		25.5	51	Mono Block	R	GWSR2525M00-F51	●	25	25	150	40	40	25	0.3	3	1
		25.5	51		L	GWSL2525M00-F51	●	25	25	150	40	40	25	0.3	3	1
		32.5	65	Mono Block	R	GWSR2020M00-F65	●	20	20	150	40	33	20	0.3	10	1
		32.5	65		L	GWSL2020M00-F65	●	20	20	150	40	33	20	0.3	10	1
		38	76	Mono Block	R	GWSR2525M00-F76	●	25	25	150	45	45	25	0.3	5	1
		38	76		L	GWSL2525M00-F76	●	25	25	150	45	45	25	0.3	5	1
G	4.00	38	76	Mono Block	R	GWSR2525M00-G76	●	25	25	150	45	45	25	0.4	5	1
		38	76		L	GWSL2525M00-G76	●	25	25	150	45	45	25	0.4	5	1

CW = Cutting Width **CDX =** Max. Groove Depth **CUTDIA =** Max. Cutting-Off Diameter

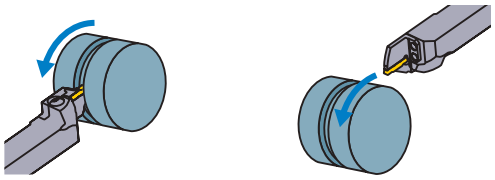
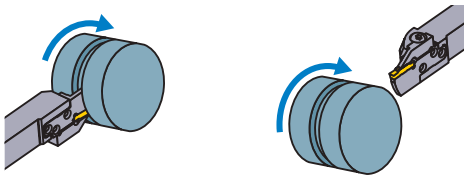
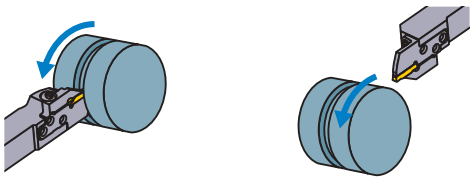
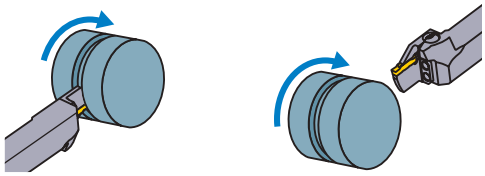
*1 indicates a parting holder exclusively designed for CITIZEN MACHINERY CO., LTD. Cincom machines such as BND34, BNA42 and ANX42.

*2 indicates a parting holder exclusively designed for CITIZEN MACHINERY CO., LTD. Miyano machines BNJ42/51, BNX51, and BNE42/51.

● : **USA Stock**

GW Series

Cutting Mode

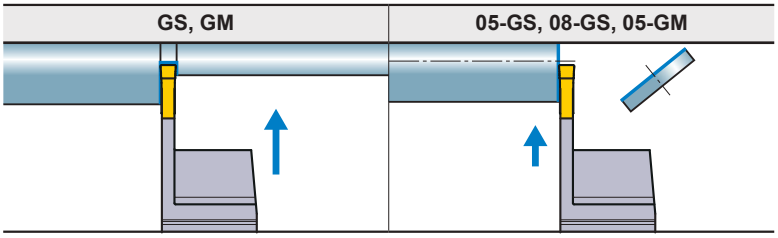
	Clockwise	Counterclockwise
R		
L		

Insert Selection

Seat Size	Insert Type
D	GW1M0200D
E	GW1M0239E
F	GW1M0300F
G	GW1M0400G

For grooving/cutting-off chipbreaker						
Seat Size	Chipbreaker / CW	GS (Low)	GM (Medium)	05-GS (Low)	08-GS (Low)	05-GM (Cutting off)
		Neutral	Neutral	R	R	R/L
D	.079", 2.00 mm	●	●	●	●	●
E	.094", 2.39 mm	●	●	●	●	●
F	.118", 3.00 mm	●	●	●	●	●
G	.157", 4.00 mm	●	●			●

● : Standard insert with dimensions



GY Series

Recommended Cutting Speed [For External Grooving / Cutting-Off]

	Material	Properties	Grade	Cutting Speed **vc** (SFM) 165 330 490 655 820 985
P	Mild Steel	Hardness ≤160HB	VP20RT	330–720
			VP10RT	360–755
			NX2525	295–690
	Carbon Steel Alloy Steel	Hardness 160–280HB	VP20RT	260–590
			VP10RT	295–620
			MY6125	525–985
			MY5015	360–820
			NX2525	230–560
		Hardness 280HB≤	VP20RT	195–460
			VP10RT	230–490
			MY6125	360–855
			MY5015	295–690
			NX2525	180–440
M	Stainless Steel	Hardness ≤270HB	VP20RT	195–460
			VP10RT	230–490
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT	260–590
			VP10RT	295–620
			MY5015	460–985
			MY6125	560–1150
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	195–460
			VP10RT	230–490
			MY5015	295–690
			MY6125	360–855
S	Heat Resistant Alloys Titanium Alloys	–	MP9025	100–295
			MP9015	130–330
			VP20RT	100–195
			VP10RT/ RT9010	130–230
H	Hardened Steel	Hardness 50HRC≤	BC8110	260–395

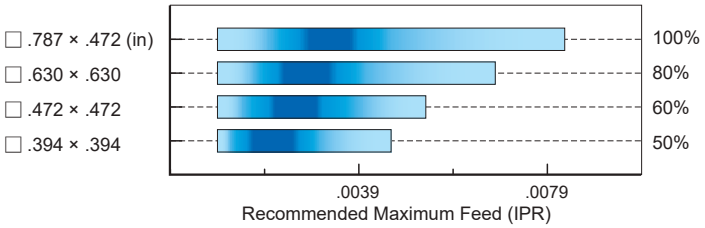
Note 1) For MP9015, MP9025, VP10RT, VP20RT and MY5015, wet cutting is recommended.

	Material	Properties	Grade	Cutting Speed **vc** (SFM) 165 330 655 985 1310 1640
N	Aluminum Alloys	Content Si<5%	RT9010	655–1640
	Aluminum Alloys	Content 5%≤Si≤10%	RT9010	655–1640
	Aluminum Alloys	Content Si>10%	RT9010	330–655

GY Series

RECOMMENDED CUTTING CONDITIONS [For External Grooving / Cutting-Off]

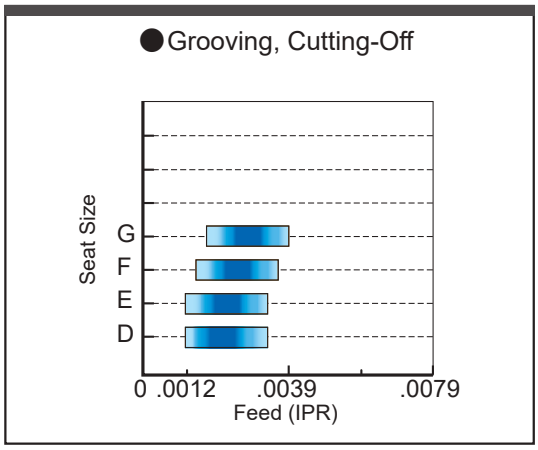
In the case of mono block type holder for Swiss-type lathes



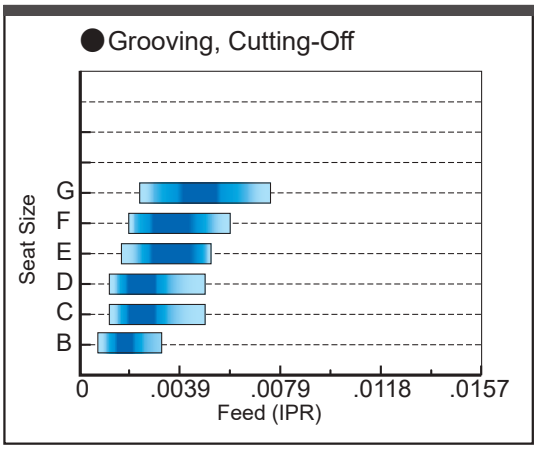
Please refer to the tables on recommended cutting conditions for external grooving and cutting-off.
Apply the percentage ratio shown on each shank size with the values in the table.

Recommended feed rate and depth of cut

GU Chipbreaker

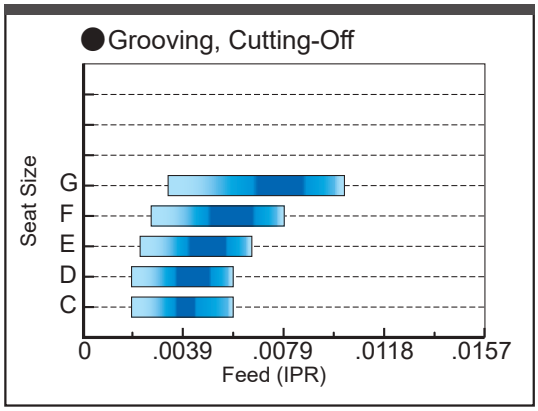


GS Chipbreaker

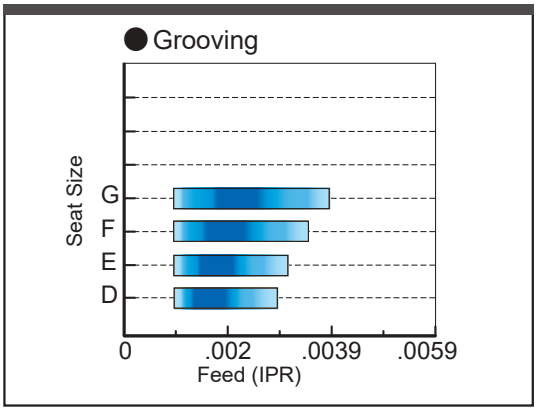


Seat Size	Insert Width
B	.047", 1.20 mm
C	.059", 1.50 mm
D	.079", 2.00 mm .088", 2.24 mm
E	.094", 2.39 mm .098", 2.50 mm .108", 2.74 mm
F	.118", 3.00 mm .125", 3.18 mm .128", 3.24 mm
G	.157", 4.00 mm .167", 4.24 mm

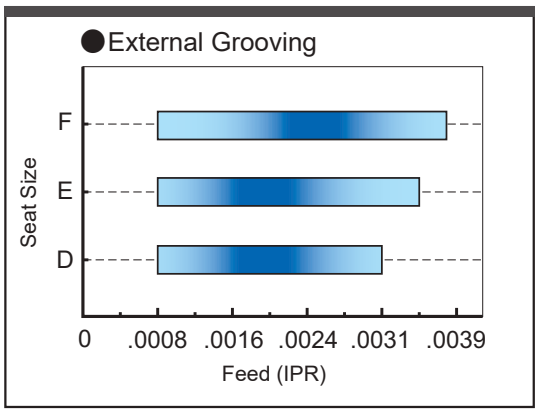
GM Chipbreaker



Flat Top GFGS (CBN)

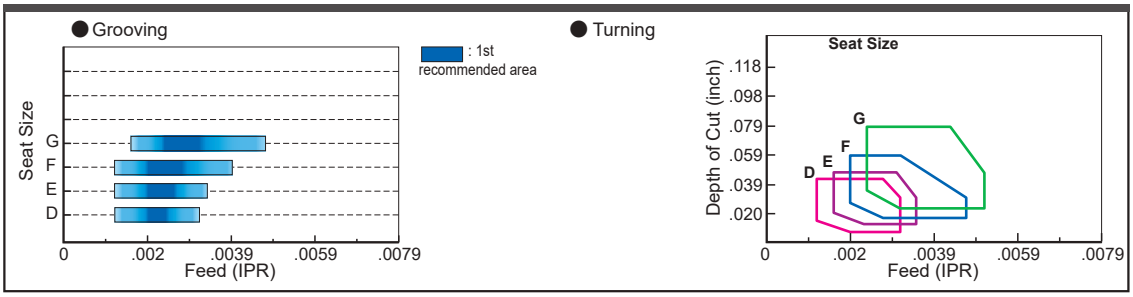


GL Chipbreaker



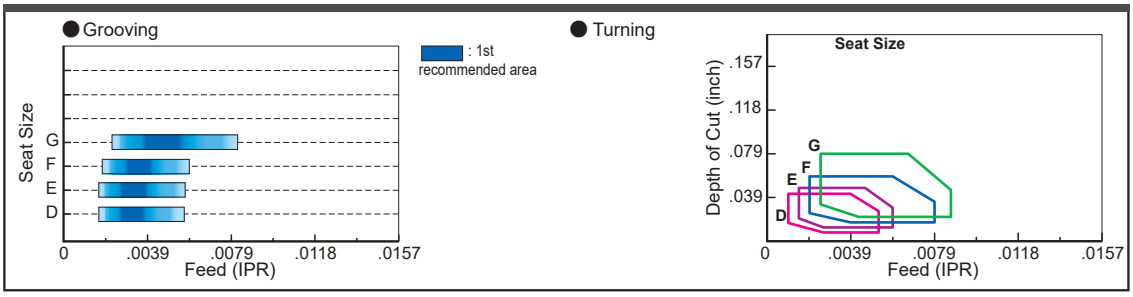
: 1st recommended area

MF Chipbreaker

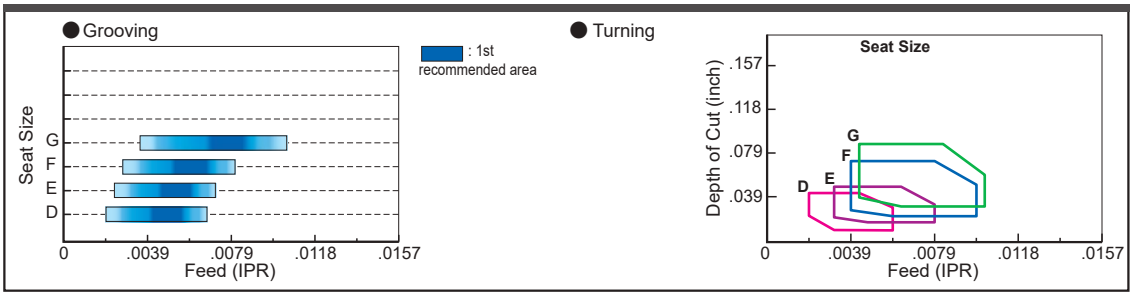


Seat Size	Insert Width
C	.059", 1.50 mm
D	.079", 2.00 mm .088", 2.24 mm
E	.094", 2.39 mm .098", 2.50 mm .108", 2.74 mm
F	.118", 3.00 mm .125", 3.18 mm .128", 3.24 mm
G	.157", 4.00 mm .167", 4.24 mm

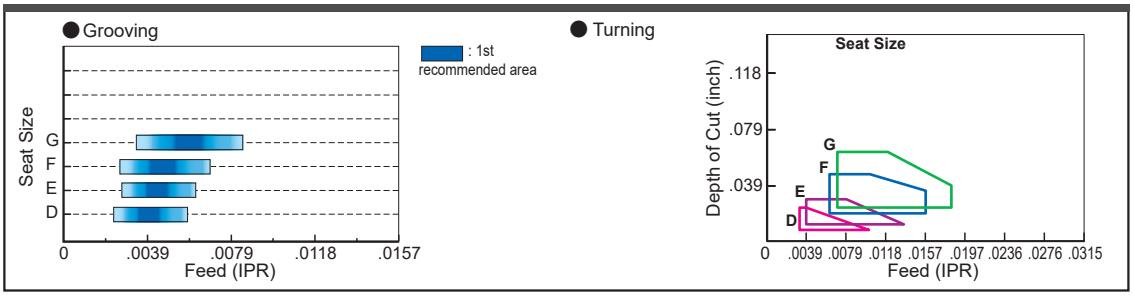
MS Chipbreaker



MM Chipbreaker



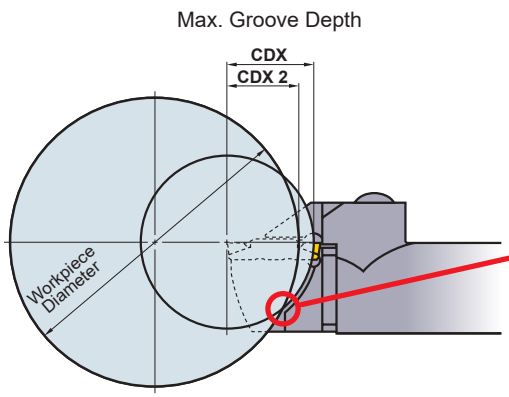
BM Chipbreaker



GY Series

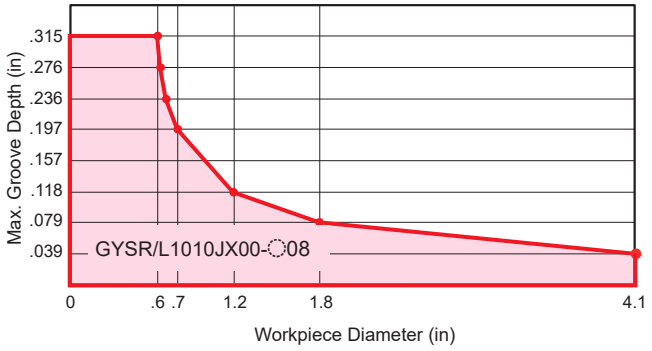
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

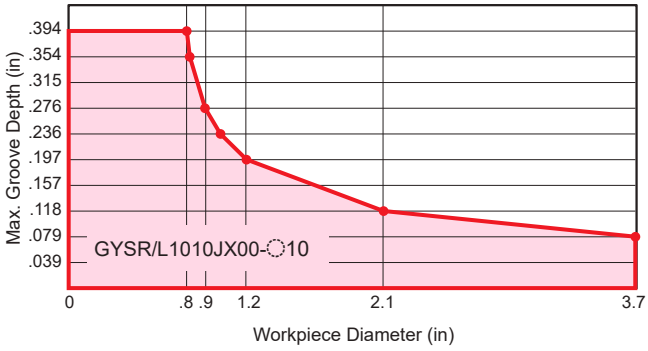
The maximum groove depth is limited by the workpiece diameter.

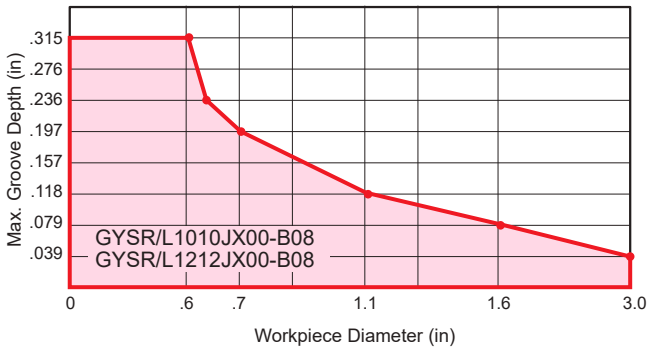


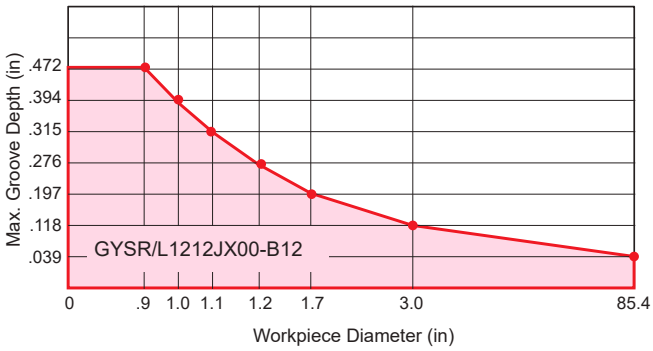


Due to interference, the maximum groove depth is limited by the workpiece diameter.

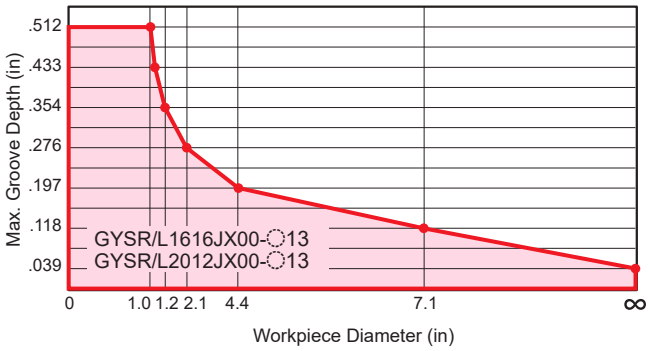


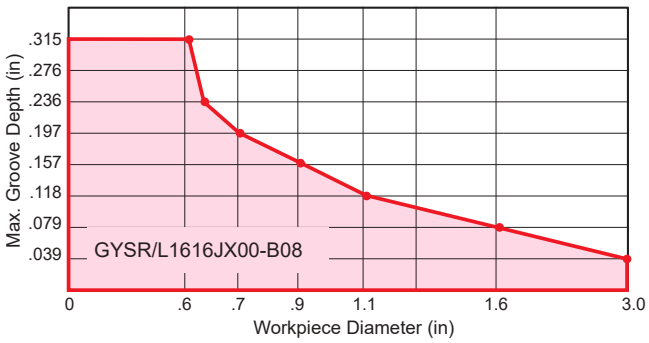


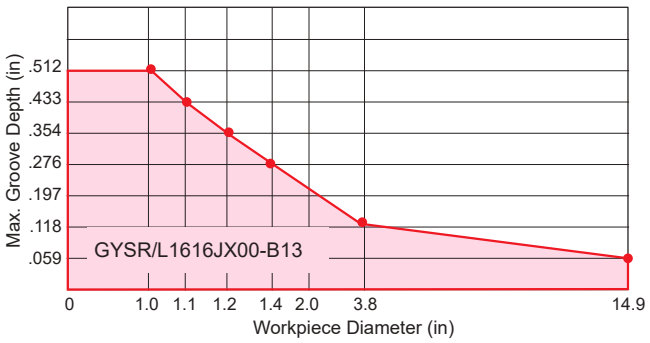


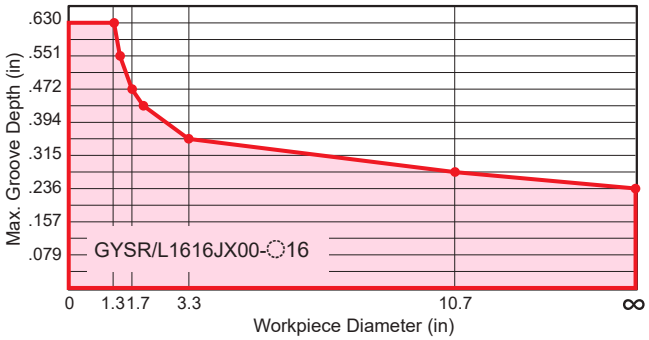


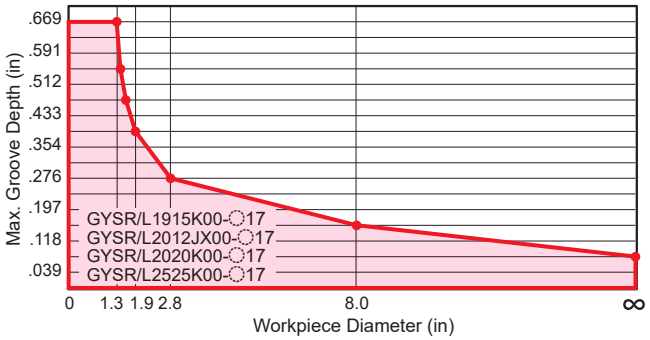


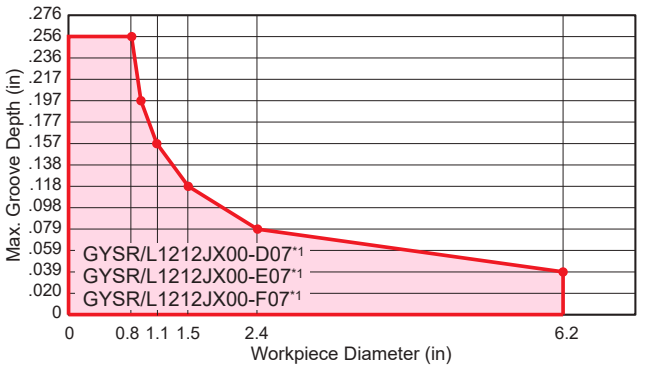


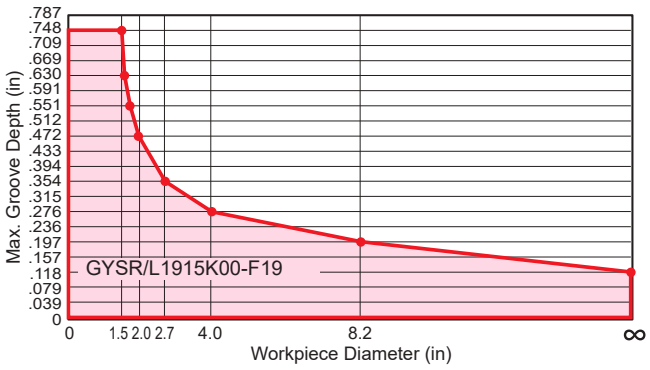

Max. Groove Depth (in)
.315
.276
.236
.197
.157
.118
.079
.039
GYSR/L1616JX00-B08
0
.6
.7
.9
1.1
1.6
3.0
Workpiece Diameter (in)

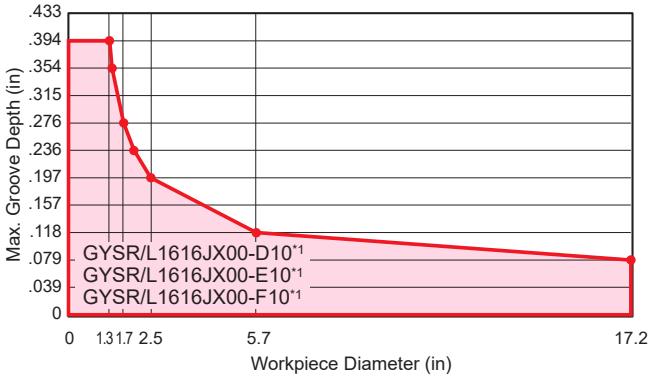

Max. Groove Depth (in)
.512
.433
.354
.276
.197
.118
.059
GYSR/L1616JX00-B13
0
1.0
1.1
1.2
1.4
2.0
3.8
14.9
Workpiece Diameter (in)

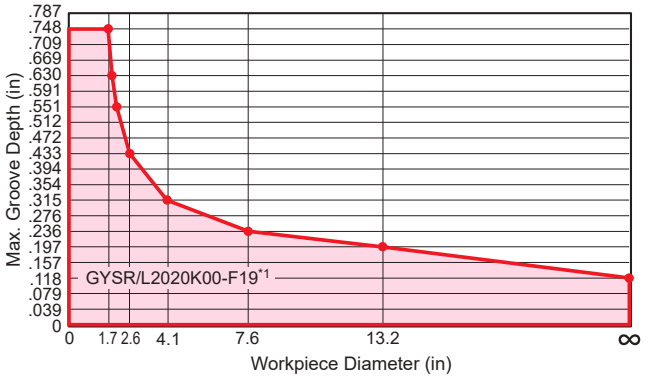

Max. Groove Depth (in)
.630
.551
.472
.394
.315
.236
.157
.079
GYSR/L1616JX00-○16
0
1.3
1.7
3.3
10.7
∞
Workpiece Diameter (in)

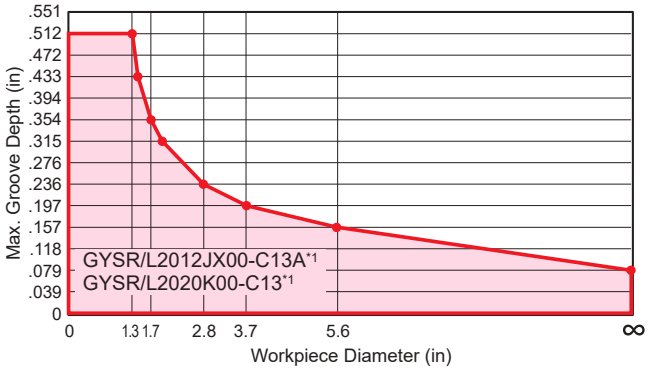

Max. Groove Depth (in)
.669
.591
.512
.433
.354
.276
.197
.118
.039
GYSR/L1915K00-○17
GYSR/L2012JX00-○17
GYSR/L2020K00-○17
GYSR/L2525K00-○17
0
1.3
1.9
2.8
8.0
∞
Workpiece Diameter (in)

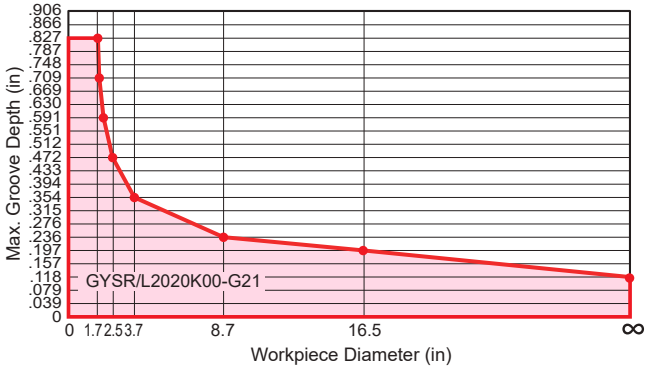

Max. Groove Depth (in)
.276
.256
.236
.217
.197
.177
.157
.138
.118
.098
.079
.059
.039
.020
0
GYSR/L1212JX00-D07*1
GYSR/L1212JX00-E07*1
GYSR/L1212JX00-F07*1
0
0.8
1.1
1.5
2.4
6.2
Workpiece Diameter (in)


Max. Groove Depth (in)
.787
.748
.709
.669
.630
.591
.551
.512
.472
.433
.394
.354
.315
.276
.236
.197
.157
.118
.079
.039
0
GYSR/L1915K00-F19
0
1.5
2.0
2.7
4.0
8.2
∞
Workpiece Diameter (in)


Max. Groove Depth (in)
.433
.394
.354
.315
.276
.236
.197
.157
.118
.079
.039
0
GYSR/L1616JX00-D10*1
GYSR/L1616JX00-E10*1
GYSR/L1616JX00-F10*1
0
1.3
1.7
2.5
5.7
17.2
Workpiece Diameter (in)

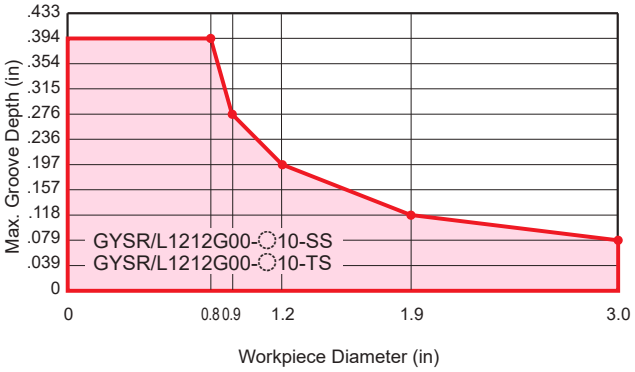

Max. Groove Depth (in)
.787
.748
.709
.669
.630
.591
.551
.512
.472
.433
.394
.354
.315
.276
.236
.197
.157
.118
.079
.039
0
GYSR/L2020K00-F19*1
0
1.7
2.6
4.1
7.6
13.2
∞
Workpiece Diameter (in)

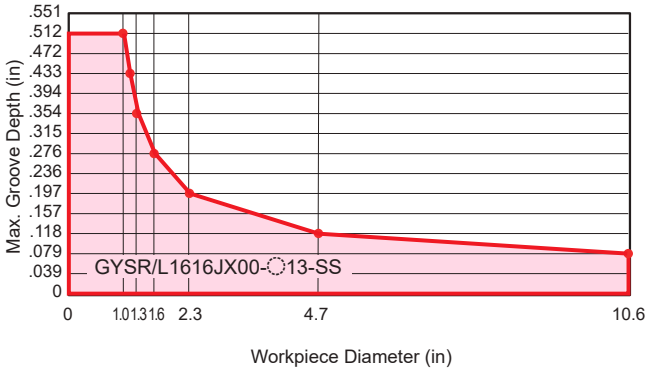

Max. Groove Depth (in)
.551
.512
.472
.433
.394
.354
.315
.276
.236
.197
.157
.118
.079
.039
0
GYSR/L2012JX00-C13A*1
GYSR/L2020K00-C13*1
0
1.3
1.7
2.8
3.7
5.6
∞
Workpiece Diameter (in)

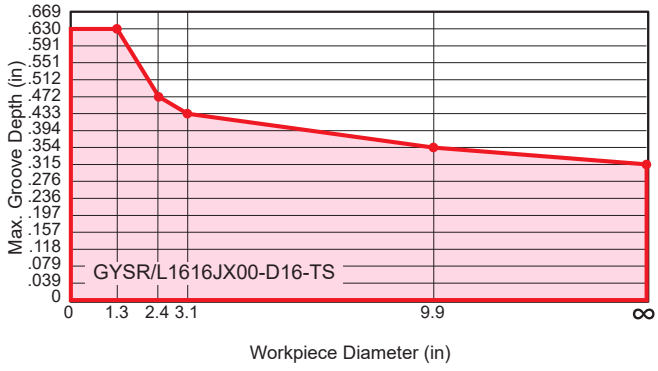

Max. Groove Depth (in)
.906
.866
.827
.787
.748
.709
.669
.630
.591
.551
.512
.472
.433
.394
.354
.315
.276
.236
.197
.157
.118
.079
.039
0
GYSR/L2020K00-G21
0
1.7
2.5
3.7
8.7
16.5
∞
Workpiece Diameter (in)

GY Series

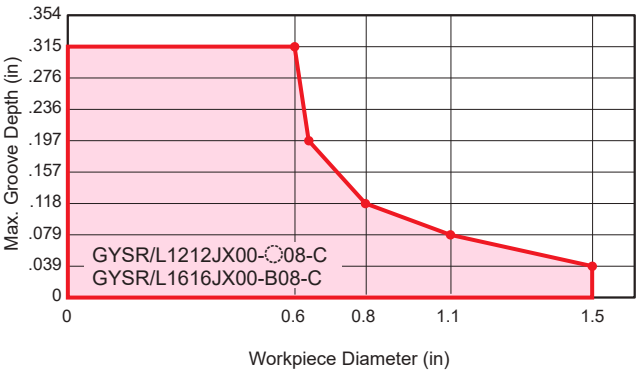
Sub-spindle Holder

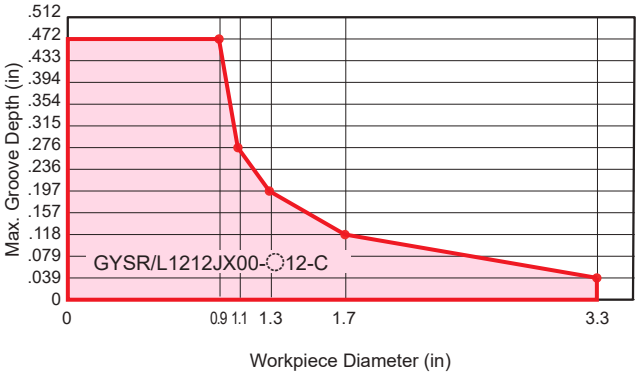


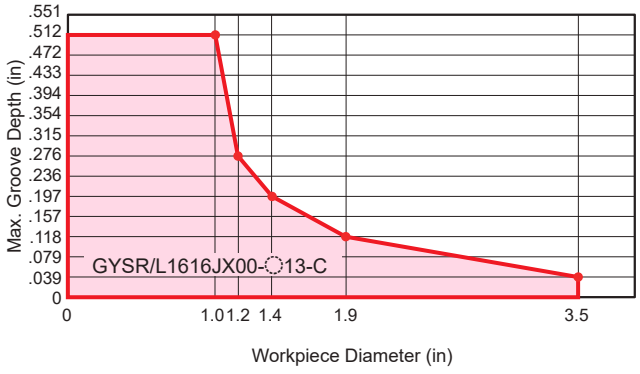


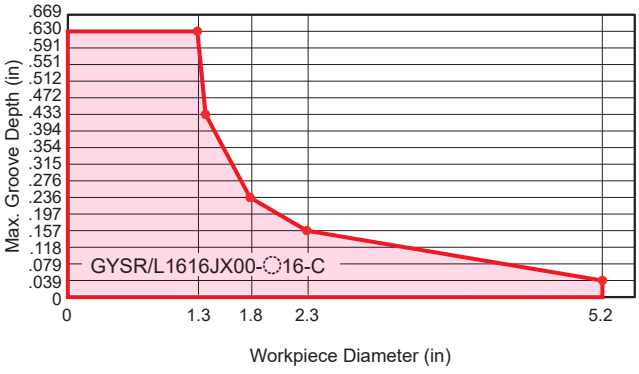


Internal Coolant Through Holder









GW Series

Recommended Cutting Conditions

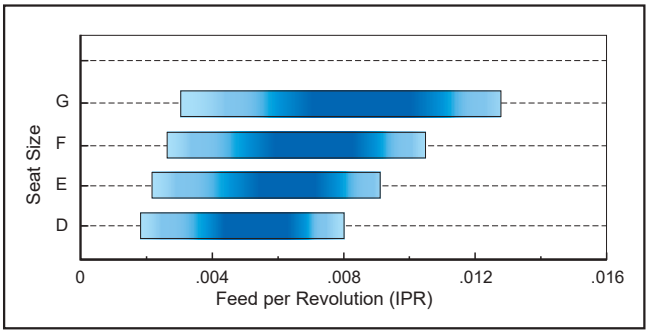
Cutting Speed

	Material	Properties	Grade	Cutting Speed **vc** (SFM) 165 330 490 655 820 985
P	Mild Steel	Hardness ≤160HB	VP20RT	330 – 785
			VP10RT	360 – 820
	Carbon Steel Alloy Steel	Hardness 160–280HB	VP20RT	260 – 655
			VP10RT	295 – 690
			VP30RT	195 – 590
			MY5015	360 – 820
		Hardness ≥280HB	VP20RT	195 – 525
			VP10RT	230 – 560
			VP30RT	130 – 460
			MY5015	295 – 690
M	Stainless Steel	Hardness ≤270HB	VP20RT	195 – 590
			VP10RT	230 – 620
			VP30RT	130 – 525
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT	260 – 655
			VP10RT	295 – 690
			MY5015	460 – 985
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	195 – 525
			VP10RT	230 – 560
			MY5015	295 – 690
S	Heat Resistant Alloys Titanium Alloys	–	VP20RT	100 – 195
			VP10RT	130 – 230

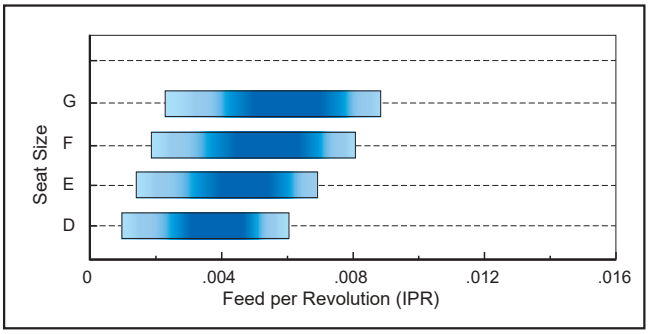
Note 1) VP20RT is the first recommended grade.
Note 2) For VP10RT, VP20RT, VP30RT and MY5015, wet cutting is recommended.

Feed per Revolution

GM Chipbreaker



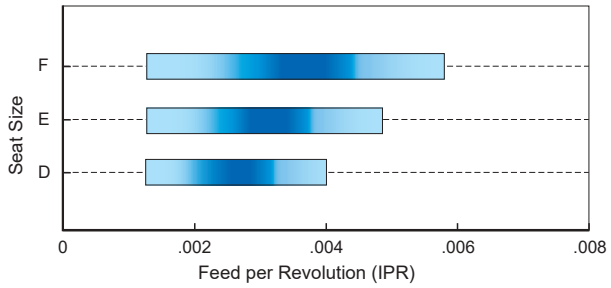
GS Chipbreaker



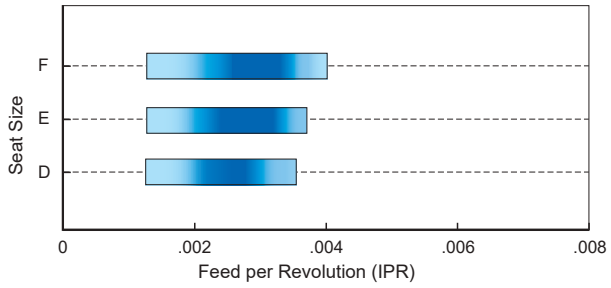
Chipbreaker	Feed per Revolution (IPR)			
	Seat Size D	Seat Size E	Seat Size F	Seat Size G
GM	.0020 – .0079	.0024 – .0091	.0028 – .0102	.0031 – .0126
GS	.0012 – .0059	.0016 – .0067	.0020 – .0079	.0024 – .0087

Cutting-Off Feed per Revolution

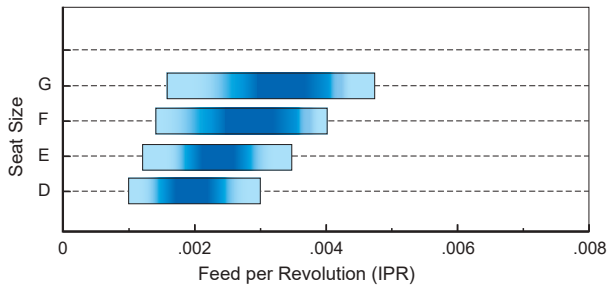
R05-GS Chipbreaker



R08-GS Chipbreaker



R/L05-GM Chipbreaker

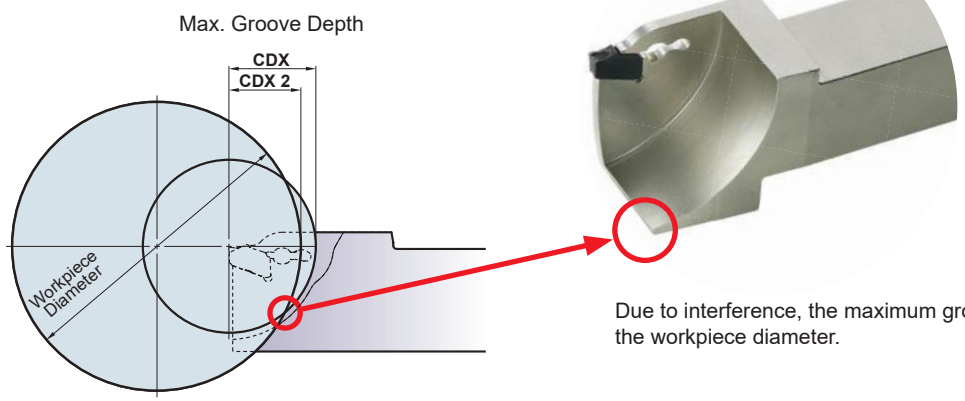


Chipbreaker	PSIPR	Hand	Feed per Revolution (IPR)			
			Seat Size D	Seat Size E	Seat Size F	Seat Size G
R05-GS	5°	R	.0012 – .0039	.0012 – .0047	.0012 – .0055	–
R08-GS	8°	R	.0012 – .0031	.0012 – .0035	.0012 – .0055	–
R05-GM	5°	R/L	.0020 – .0059	.0024 – .0067	.0028 – .0079	.0031 – .0091

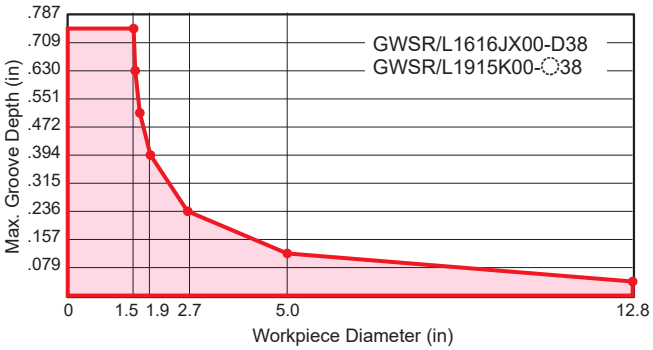
GW Series

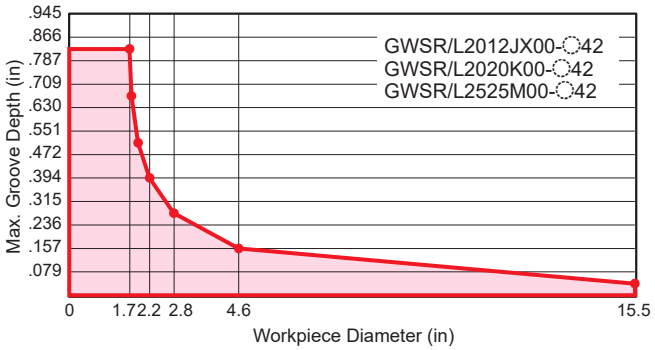
LIMITATION OF THE MAXIMUM GROOVE DEPTH [For External Grooving]

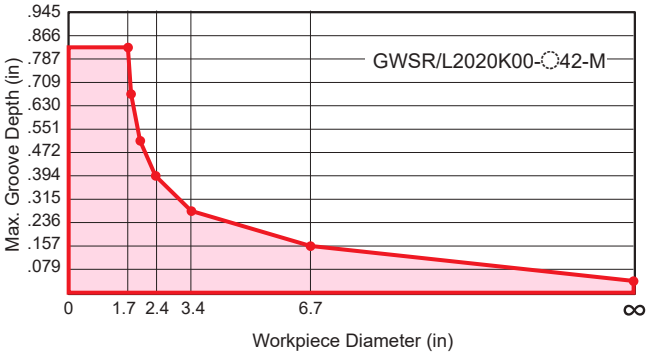
The maximum groove depth is limited by the workpiece diameter.

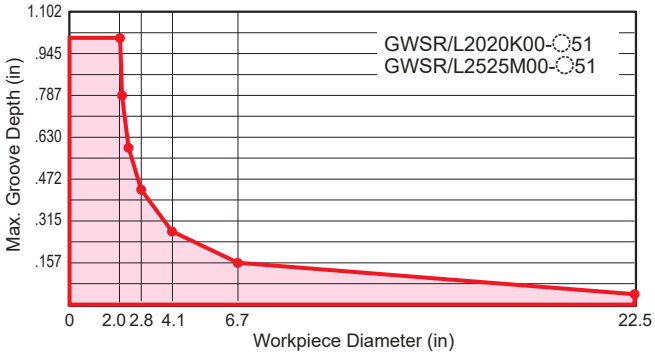


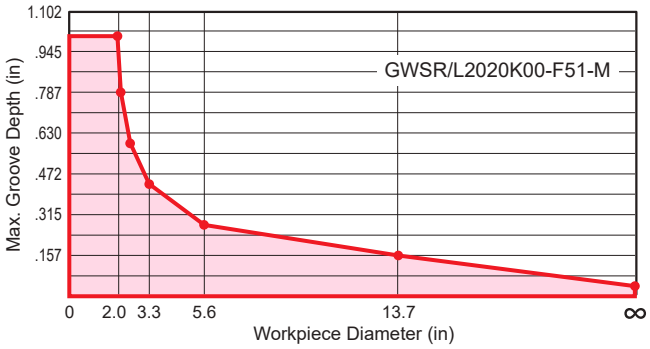
Due to interference, the maximum groove depth is limited by the workpiece diameter.

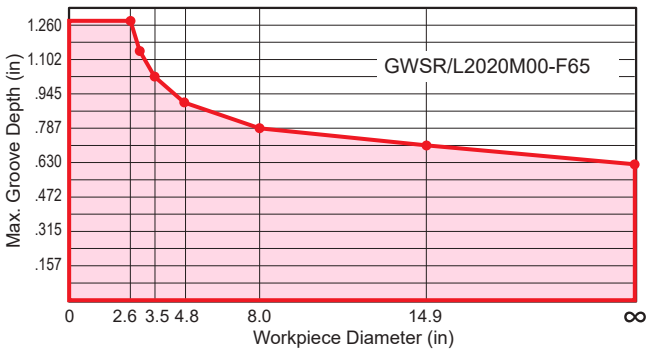


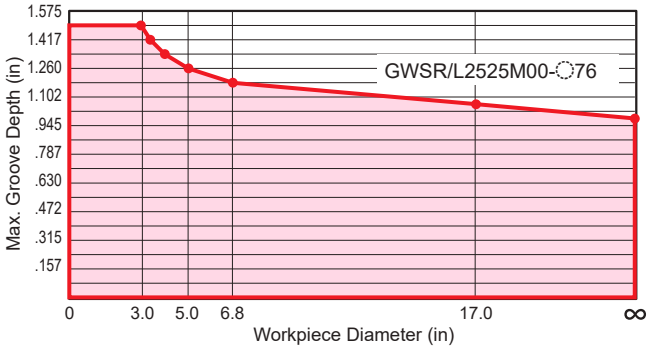







GWSR/L2020K00-F51-M
Max. Groove Depth (in)
1.102
.945
.787
.630
.472
.315
.157
0
2.0
3.3
5.6
13.7
∞
Workpiece Diameter (in)


GWSR/L2020M00-F65
Max. Groove Depth (in)
1.260
1.102
.945
.787
.630
.472
.315
.157
0
2.6
3.5
4.8
8.0
14.9
∞
Workpiece Diameter (in)

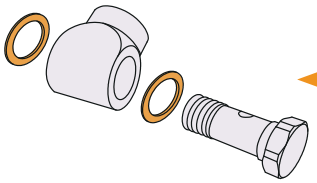

GWSR/L2525M00-◌76
Max. Groove Depth (in)
1.575
1.417
1.260
1.102
.945
.787
.630
.472
.315
.157
0
3.0
5.0
6.8
17.0
∞
Workpiece Diameter (in)

Hose Kit

Hose kit is available for easy installation on automatic lathes.
Hoses and adapters can be freely selected according to connection specifications and setup conditions on machine side and tool side, supporting a wide range of lubrication layouts.
Push-in fitting hoses enable quick and secure connection by simple insertion, helping ensure smooth setup operations.

Machine-side Connector

Straight Connection G1/8"

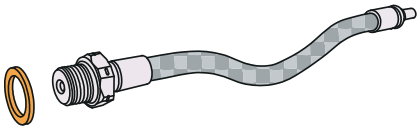


Banjo Bolt Connection G1/8"
BJ-G1/8-G1/8-QC

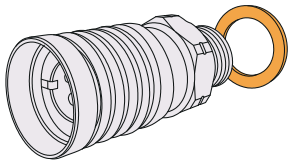
Hose

Hose (Separate sales of individual components available)

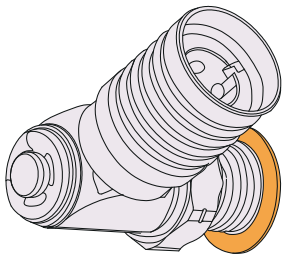
Order Number	Hose Length (in)	Copper Washer	QTY.
HOSE-G1/8-100-QC	4.016	WA-M10	1
HOSE-G1/8-200-QC	7.992	WA-M10	1



Tool-side Connector Push-in Fitting



Quick Coupler M8×1 Straight
CPLR-M8-01-QC



Quick Coupler M8×1 Elbow (Swivel Type)
CPLR-M8-02-QC

Hose Kit

Items in the table are supplied as a set with hose shown above.

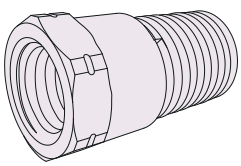
Order Number	Hose Length (in)	Machine-side Connector	Banjo Bolt Set	QTY.	Copper Washer	QTY.	Tool-side Connector	Push-in Fitting	QTY.	Copper Washer	QTY.
QC-G1/8-M8-100BS	4.016	Straight·Banjo	BJ-G1/8-G1/8-QC	1	WA-M10	2	Straight	CPLR-M8-01-QC	1	WA-M8	1
QC-G1/8-M8-200BS	7.992	Straight·Banjo	BJ-G1/8-G1/8-QC	1	WA-M10	2	Straight	CPLR-M8-01-QC	1	WA-M8	1
QC-G1/8-M8-100BB	4.016	Straight·Banjo	BJ-G1/8-G1/8-QC	1	WA-M10	2	Elbow	CPLR-M8-02-QC	1	WA-M8	1
QC-G1/8-M8-200BB	7.992	Straight·Banjo	BJ-G1/8-G1/8-QC	1	WA-M10	2	Elbow	CPLR-M8-02-QC	1	WA-M8	1

Tool-side Connector (Single Item Sale)

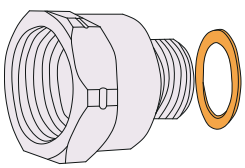
Conversion Adapter

Compatible with other series from our company.

Order Number	Copper Washer	QTY.	Conversion Type	Tool Series Name
AD-M8-R1/8	—	—	M8→R1/8"	GYS
AD-M8-M5	WA-M5	1	M8→M5	MIcro-Mini Plus
AD-M8-M6	WA-M6	1	M8→M6	MIcro-Mini Plus



AD-M8-R1/8



AD-M8-M5, AD-M8-M6

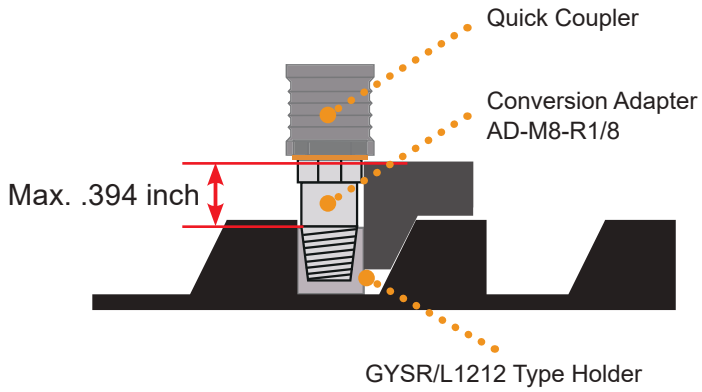
One-touch Fitting

G1/8" one-touch fitting available for single-item purchase.

Order Number	Tool-side Connector	Copper Washer	QTY.
CPLR-G1/8-01-QC	Straight	WA-M10	1
CPLR-G1/8-02-QC	Elbow	WA-M10	1

Conversion Adapter Installation

When installing the GYSR/L1212 type holder, ensure that, with the conversion adapter attached, the step between the holder and the top surface of the wedge on the gang tool post does not exceed .394 in.



GW Hose Kit

Coolant Hose Kit

(in)

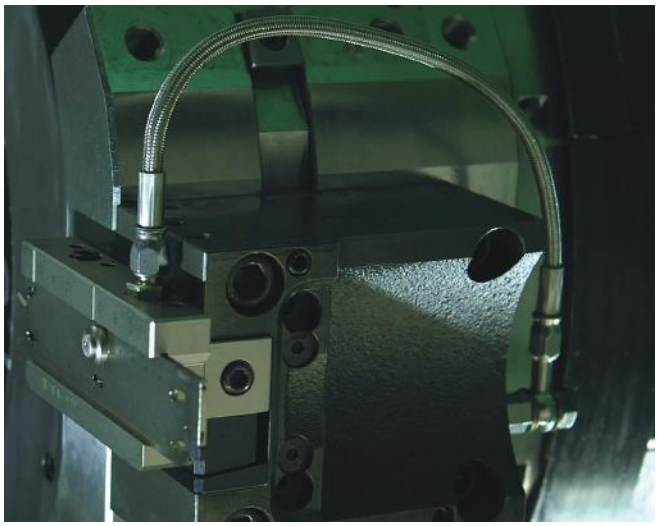
Connector Type	Order Number	Stock	Hose Length	Kit Details								
				Hose	Banjo Adapter		Banjo Bolt		Adapter		Washer	
				Code No.	Code No.	QTY.	Code No.	QTY.	Code No.	QTY.	Code No.	QTY.
Straight	**CS-1/8-150SS**	●	5.906	HOSE-1/8-150	—	—	—	—	AD-G1/8	2	WA-M10	2
Straight	**CS-1/8-200SS**	●	7.874	HOSE-1/8-200	—	—	—	—	AD-G1/8	2	WA-M10	2
Straight	**CS-1/8-250SS**	●	9.843	HOSE-1/8-250	—	—	—	—	AD-G1/8	2	WA-M10	2
Straight	**CS-1/8-300SS**	●	11.811	HOSE-1/8-300	—	—	—	—	AD-G1/8	2	WA-M10	2
Elbow Straight	**CS-1/8-150BS**	●	5.906	HOSE-1/8-150	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	**CS-1/8-200BS**	●	7.874	HOSE-1/8-200	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	**CS-1/8-250BS**	●	9.843	HOSE-1/8-250	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow Straight	**CS-1/8-300BS**	●	11.811	HOSE-1/8-300	AD-BM10	1	BB-G1/8	1	AD-G1/8	1	WA-M10	3
Elbow	**CS-1/8-150BB**	●	5.906	HOSE-1/8-150	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4
Elbow	**CS-1/8-200BB**	●	7.874	HOSE-1/8-200	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4
Elbow	**CS-1/8-250BB**	●	9.843	HOSE-1/8-250	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4
Elbow	**CS-1/8-300BB**	●	11.811	HOSE-1/8-300	AD-BM10	2	BB-G1/8	2	—	—	WA-M10	4

● = NEW

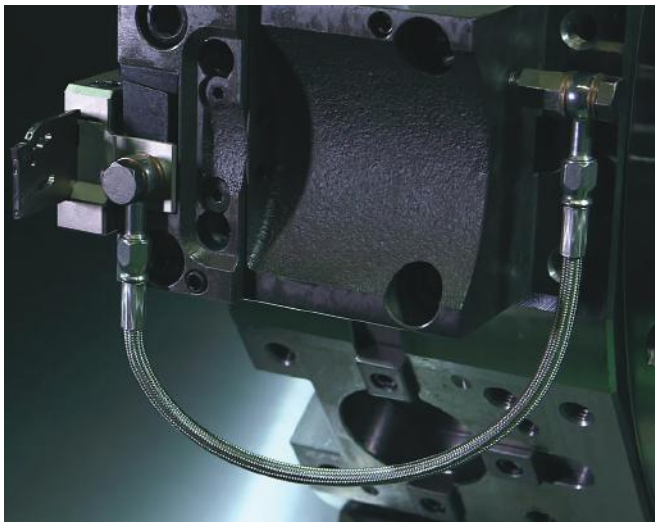
Connection Thread: G1/8"

Mounting Example

Elbow Straight Type



Elbow Type



● : **USA Stock**

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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 driver.
- When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

www.mmc-carbide.com/us

Tools specifications subject to change without notice.

B255A-H-US-2026.11