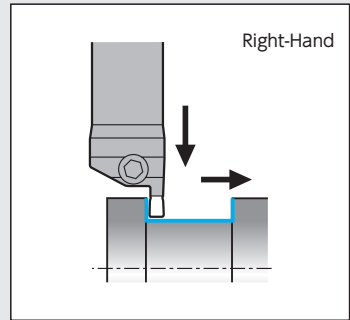
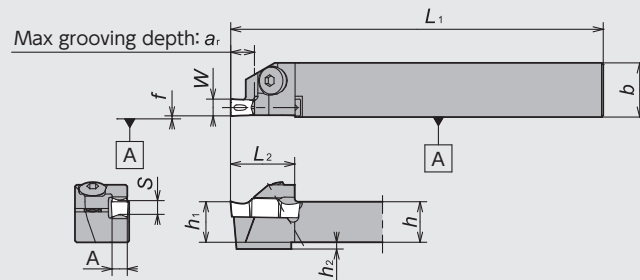


Grooving / Side Turning

GTW (SCRUM DUO) Series

GTWP

Side Turning Capable
For Swiss Machine

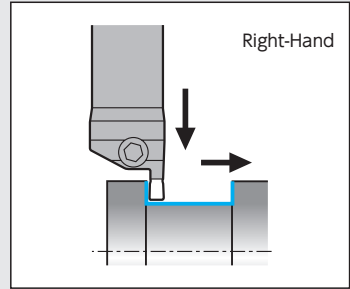
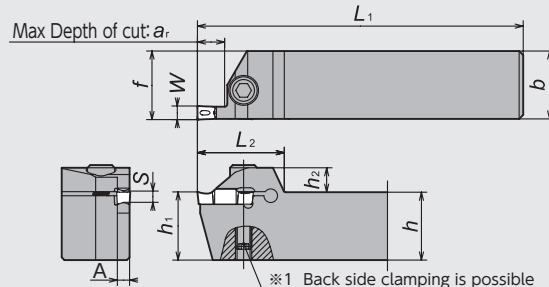


● Right-Hand style shown

Figure-1

GTWP

Side Turning Capable
For Mono-shank style



Recommended tightening torque 7.0[N · m]
● Right-Hand style shown

Figure-2

GTW Series - Toolholders

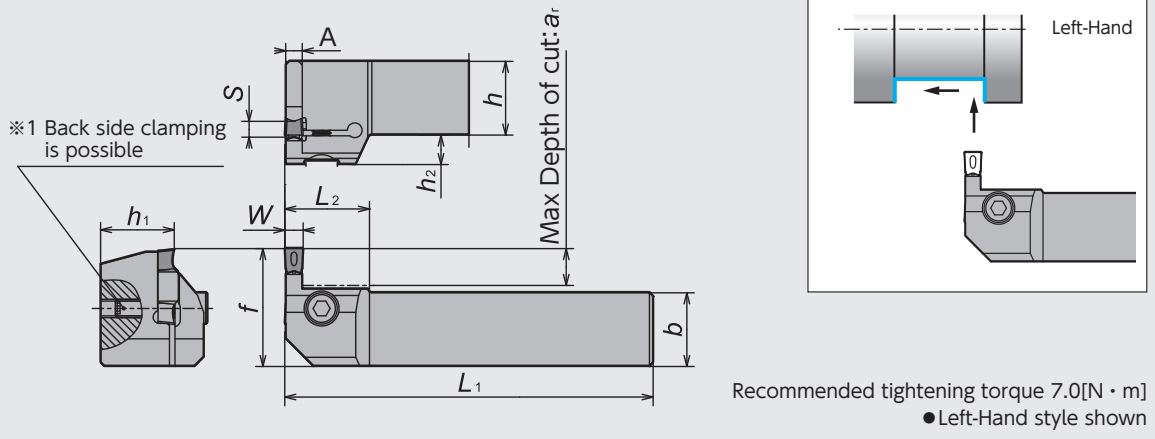
Figure	Code No.		Item Number	Stock		Groove Width (mm) w	Max Depth of cut ar	Dimensions (mm)							Seat Size S	Gage insert	Spare Parts			
	R	L		R	L			h	b	h ₁	h ₂	f	L ₁	L ₂			A	Clamp Bolt	Wrench	Wrench ^{※1}
1	5875125		GTWP [℞] 1016-3D07	●	●	3	7	10		12	2	0.3	120	19	D	GWPO300	AOB-5*14	LW-3S	—	
	5849054	5852280	1216-3D07	●	●			12	16	19.5	2.6			22						
	5849070	5852306	1616-3D09	●	●			9	16	16	0			22						
	5875133		1016-4E07	●	●	4	7	10		12	2	0.3	120	19	E	GWPO400	AOB-5*14			
	5849088	5852314	1216-4E07	●	●			12	16	19.5	3.5			22						
	5849096	5852322	1616-4E09	●	●			9	16	16	0			22						
	5875141		1016-5F07	●	●	5	7	10		12	2	0.3	120	19	F	GWPO500	AOB-5*14			
	5849104	5852355	1216-5F07	●	●			12	16	19.5	4.5			22						
	5849112	5852371	1616-5F09	●	●			9	16	16	0			22						
	5893565		1020-6G07	●	●	6	7	10	20	10	2	0.3	120	22	G	GWPO600	AOB-5*14			
5893573		1220-6G07	●	●	12			20	12	0	22.5									
5893581	5893599	1620-6G09	●	●	9			16	20	16	25									
2	5849120	5852397	GTWP [℞] 2020K-3D10	●	●	3	10	20	20	20	8	20.2	125	29	D	GWPO300	CS0520W	LW-4	LW-2.5	
	5849138	5852405	2525M-3D10	●	●			25	25	25	9	25.2	150	32			2.6	CS0625W	LW-5	LW-3
	5849146	5852421	2020K-3D20	●	●			20	20	20	8	20.2	125	41			3.5	CS0520W	LW-4	LW-2.5
	5849153	5852439	2525M-3D20	●	●	25	25	25	9	25.2	150	44	4.5	CS0625W	LW-5	LW-3				
	5849161	5852447	2020K-4E10	●	●	4	10	20	20	20	8	20.3	125	29	E	GWPO400	CS0520W	LW-4	LW-2.5	
	5849179	5852454	2525M-4E10	●	●			25	25	25	9	25.3	150	32			3.5	CS0625W	LW-5	LW-3
	5849187	5852470	2020K-4E20	●	●			20	20	20	8	20.3	125	41			4.5	CS0520W	LW-4	LW-2.5
	5849195	5852488	2525M-4E20	●	●	25	25	25	9	25.3	150	44	5.3	CS0625W	LW-5	LW-3				
	5849203	5852496	2020K-5F10	●	●	5	10	20	20	20	8	20.3	125	29	F	GWPO500	CS0520W	LW-4	LW-2.5	
	5849211	5852512	2525M-5F10	●	●			25	25	25	9	25.3	150	32			4.5	CS0625W	LW-5	LW-3
	5849229	5852520	2020K-5F20	●	●			20	20	20	8	20.3	125	41			5.3	CS0520W	LW-4	LW-2.5
	5849237	5852538	2525M-5F20	●	●	25	25	25	9	25.3	150	44	5.3	CS0625W	LW-5	LW-3				
	5849245	5852546	2020K-6G12	●	●	6	12	20	20	20	8	20.35	125	34	G	GWPO600	CS0520W	LW-4	LW-2.5	
	5849252	5852553	2525M-6G12	●	●			25	25	25	9	25.35	150	37			5.3	CS0625W	LW-5	LW-3
	5849260	5852561	2020K-6G25	●	●			20	20	20	8	20.35	125	49			5.3	CS0520W	LW-4	LW-2.5
	5849278	5852587	2525M-6G25	●	●	25	25	25	9	25.35	150	52	5.3	CS0625W	LW-5	LW-3				

※1 Back side clamping wrench is not included

※Do not tighten clamp screw without installing insert as it may damage the insert pocket.

GKW (SCRUM DUO) Series

GKWP



GKW Series - Toolholders

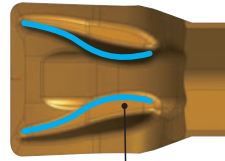
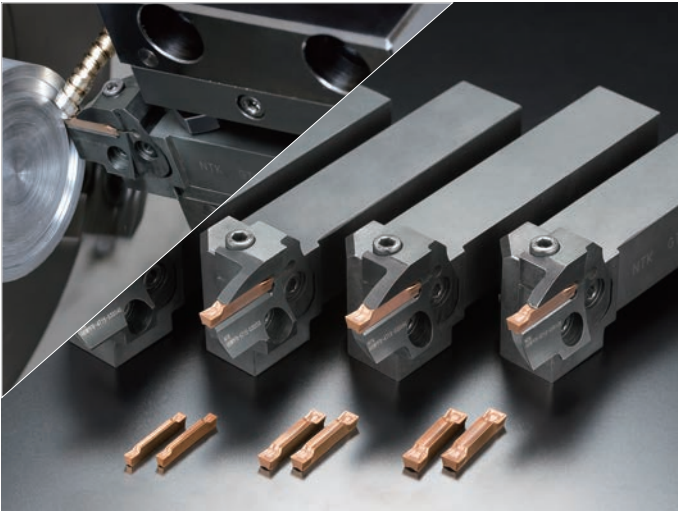
Code No.		Item Number	Stock		Groove Width (mm) W	Max Depth of cut a_r	Dimensions (mm)							Seat Size S	Gage insert 	Spare Parts			
R	L		R	L			h	b	h_1	h_2	f	L_1	L_2			A	Clamp Bolt	Wrench	Wrench #1
	5893607	GKWP 2020K-3D10	●		3	10						2.6	D	GWPO300	CS0520W	LW-4	LW-2.5		
	5893615	2020K-4E10	●		4		20	20	20	8	32	125	23	3.5				E	GWPO400
	5893623	2020K-5F10	●		5									4.5				F	GWPO500
	5893631	2020K-6G12	●		6	12								5.3				G	GWPO600

※1 Back side clamping wrench is not included
※Do not tighten clamp screw without installing insert as it may damage the insert pocket.

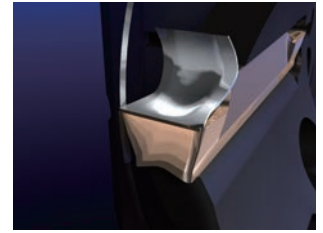
GTW/GKW Series - Inserts

Shape	Item Number	Dimensions (mm)					Seat Size S	PVD Coated Carbide			
		W		r_e	M	L		DM4	Stock		
		Groove Width	Tolerance								
<p>GWPG: Outside ground GWPM: Full-molded</p> <ul style="list-style-type: none"> ● Excellent chip control ● Best for side turning 	GW	GWPG300N02D-GW	3.0	±0.025	0.2	2.5	20.6	D	5848023	●	
		300N04D-GW			0.4				5848031	●	
		GWPG400N02E-GW			0.2				3.4	E	5848064
		400N04E-GW	0.4	5848072	●						
		400N08E-GW	0.8	5852868	●						
		GWPG500N02F-GW	0.2	4.3	F	5848106	●				
		500N04F-GW	0.4			5848114	●				
		500N08F-GW	0.8			5852876	●				
		GWPG600N02G-GW	0.2	5.2	25.6	G	5848148	●			
		600N04G-GW	0.4				5848155	●			
		600N08G-GW	0.8				5852900	●			
		GW	GWPM300N04D-GW	3.0	±0.05	0.4	20.6	D	5848171	●	
		400N04E-GW	3.4						E	5848197	●
		500N04F-GW	4.3						F	5848213	●
		600N04G-GW	5.2						G	5848239	●
<ul style="list-style-type: none"> ● Less tool pressure design 		GV	GWPG300N02D-GV	3.0	±0.025	0.2	2.5	20.6	D	5848262	●
			300N04D-GV			0.4				5848270	●
			GWPG400N02E-GV	0.2	3.4	E	5848353	●			
			400N04E-GV	0.4			5848361	●			
		GWPG500N02F-GV	0.2	4.3	F	5848395	●				
		500N04F-GV	0.4			5848403	●				
		GWPG600N02G-GV	0.2	5.2	25.6	G	5848437	●			
		600N04G-GV	0.4				5848445	●			

SCRUM DUO BLADE - Carbide Face Grooving Tool



Unique S-shape design

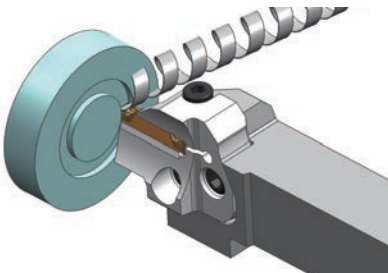


Features



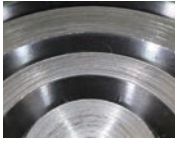

- **New GT Chipbreaker designed for face-grooving**
- **The best rigidity in a Modular system**
- **Excellent chip-control and great finish**

Excellent Chip Control

• Grooving

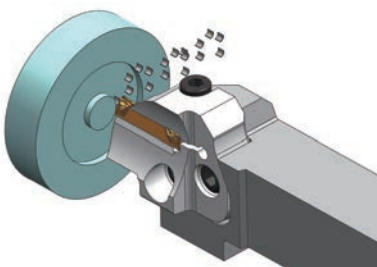


- **Excellent chip control and superior surface finish**
- **Good chip control without a peck cycle**

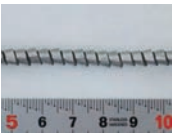

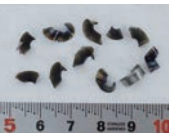


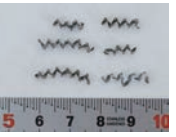

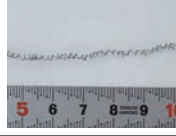

	NTK:GT chipbreaker	Competitor
Chip		 Tangled chips during deep grooving
Surface finish		 Scratches inside bottom

Material : SCM415, $V_c=150\text{m/min}$, $f=0.1\text{mm/rev}$, $\Phi 50$ diameter, 1.0mm depth, No step feed, WET
 Insert : GWPFM500N04-GT DM4 Holder : GBWPFM-5T15-050120

• Side-turning



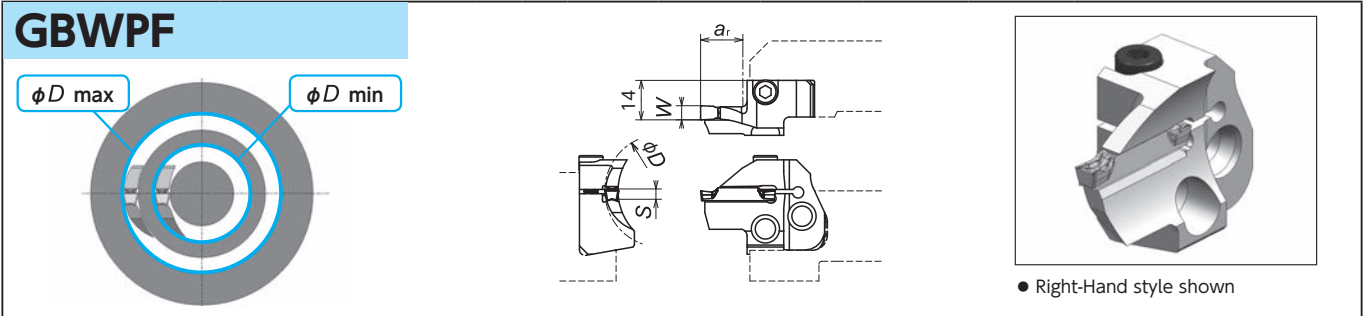
- **Excellent chip control for side-turning process**
- **Shiny surface finish**

		feed (mm/rev)		
		0.05	0.1	0.2
Depth of cut (mm)	3.0			
	1.0			
	0.2			

Material : SCM415, $V_c=150\text{m/min}$, WET
 Insert : GWPFM500N04-GT DM4 Holder : GBWPFM-5T15-050120

SCRUM DUO BLADE Series

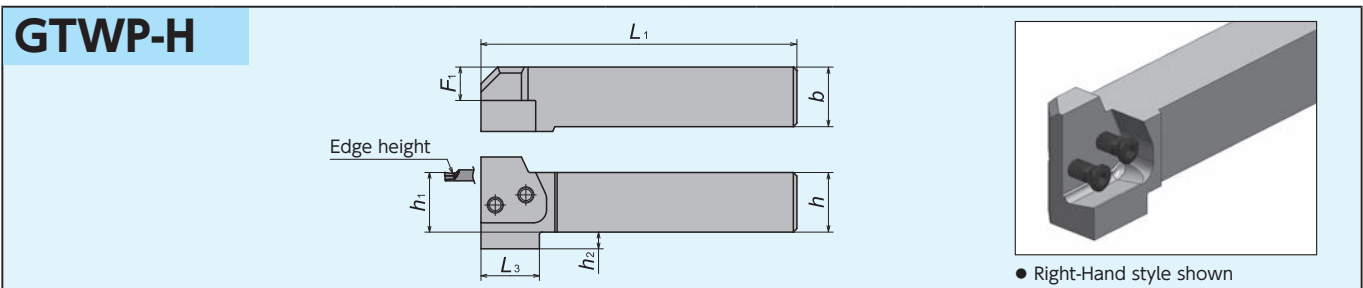
Blade



Code No.		Blade Number	Stock		Groove Width W (mm)	Face grooving OD		Max. Grooving depth a _r	Seat Size S	Gage insert	Clamp Bolt
R	L		R	L		φD min	φD max				
5963335	5963491	GBWPF ¼ -3T13-029035	●	●	3	29	35	13	C	GWPFM300	CS0515
5963343	5963509	-3T13-035045	●	●		35	45				
5963350	5963517	-3T15-045060	●	●		45	60				
5963368	5963525	-3T15-060100	●	●		60	100				
5963376	5963533	-3T15-100250	●	●	4	100	250	15	C	GWPFM400	CS0515
5963392	5963558	-4T15-030040	●	●		30	40				
5963426	5963566	-4T15-040060	●	●		40	60				
5963434	5963574	-4T15-060120	●	●		60	120				
5963442	5963582	-4T15-120300	●	●	5	120	300	15	C	GWPFM500	CS0515
5963707	5963715	-5T15-030050	●	●		30	50				
5963459	5963608	-5T15-050120	●	●		50	120				
5963467	5963616	-5T15-120999	●	●		120	∞				
5963475	5963632	-6T15-035080	●	●	6	35	80	15	C	GWPFM600	CS0515
5963483	5963640	-6T15-080999	●	●		80	∞				

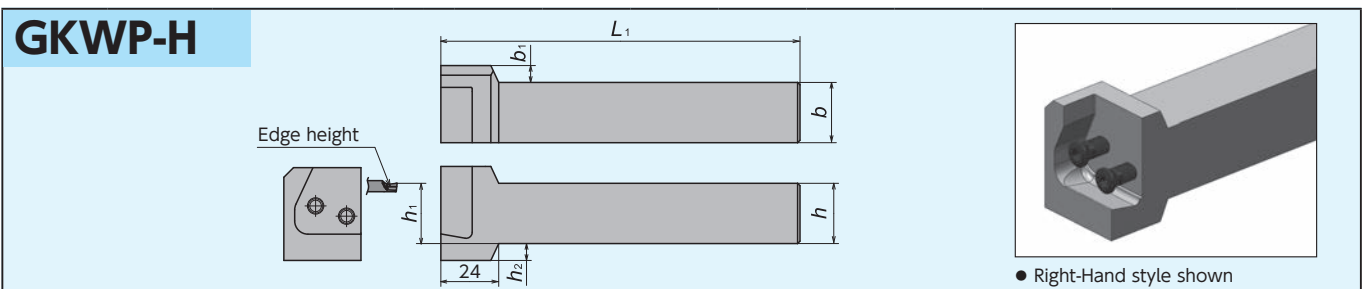
※Do not tighten clamp screw without installing insert as it may damage the insert pocket.

Toolholders Body (0° Straight style)



Code No.		Holder Number	Stock		Dimensions (mm)							Gage insert	Spare Parts	
R	L		R	L	h	b	h ₁	L ₁	F ₁	h ₂	L ₃		Clamp Screw	Wrench
5923784	5923792	GTWP ¼ 2020-H	●	●	20	20	20	107.5	9	8	28.5	GBWPF ¼	FSI28-6.0 * 18	LW-4
5923800	5923818	¼ 2525-H	●	●	25	25	25	132.5	14	7	24.5			
5963657	5963673	¼ 3232-H	●	●	32	32	32	152.5	21	-	-			

Toolholders Body (90° L- style)



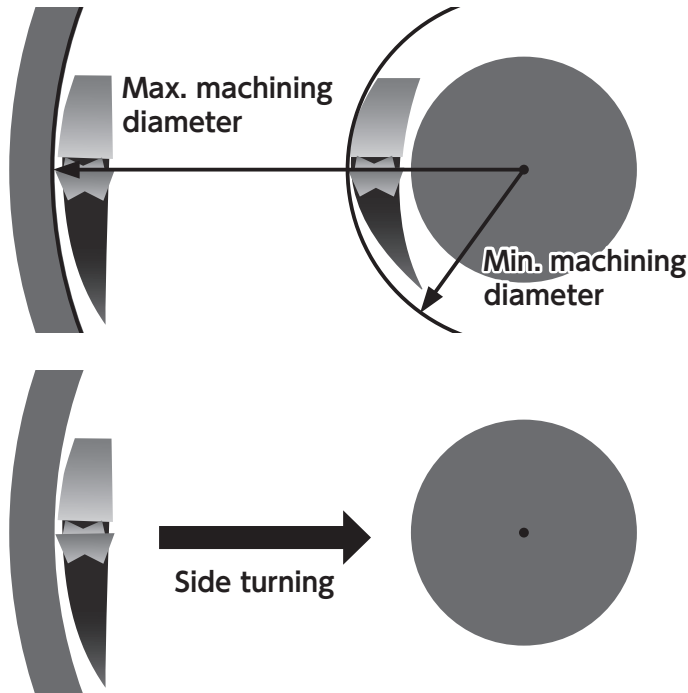
Code No.		Holder Number	Stock		Dimensions (mm)							Gage insert	Spare Parts	
R	L		R	L	h	b	h ₁	L ₁	b ₁	h ₂	Clamp Screw		Wrench	
5923826	5923834	GKWP ¼ 2020-H	●	●	20	20	20	124	12	12	GBWPF ¼	FSI28-6.0 * 18	LW-4	
5923842	5923859	¼ 2525-H	●	●	25	25	25	149	7	7				
5963681	5963699	¼ 3232-H	●	●	32	32	32	169	-	-				

New Products
 Tool Materials / Selection Guide
 Micrograin Carbide, BIDE/MCS, PCD, CBN and Ceramics
 PVD/CVD-coated Carbide
 Insert Item List
 General Turning Toolholders
 Unique Swiss Tooling
 Grooving / Side Turning
 Threading
 Shaper
 ID Tooling
 Application Introduction
 Endmills
 Rotating Tools
 Information
 Index

SCRUM DUO BLADE Series - Inserts

Shape	Item Number	Dimensions (mm)				Seat Size S	PVD Coated Carbide	
		W	r_ϵ (mm)	M (mm)	L (mm)		DM4	Stock
	GWPFM300N02-GT	3.0	0.2	2.2	24.5	C	5963251	●
	GWPFM300N04-GT		0.4				5963269	●
	GWPFM400N04-GT	4.0	0.4	3.2			5963277	●
	GWPFM400N08-GT		0.8				5963285	●
	GWPFM500N04-GT	5.0	0.4	3.7			5963293	●
	GWPFM500N08-GT		0.8				5963301	●
	GWPFM600N04-GT	6.0	0.4	4.7			5963319	●
	GWPFM600N08-GT		0.8				5963327	●

Guidelines



- Choose a blade so that your first target grooving max. OD is between the max. OD and min. OD of the blade.

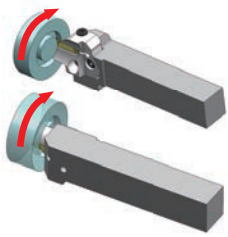
- To make the groove wide, side turn from outside to inside (direction to the center of the work piece)

■ Combination of toolholder and blade for Face Grooving

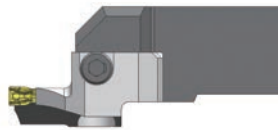
GTWP-H

Straight style toolholder

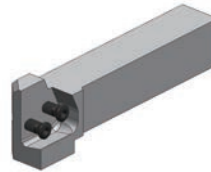
Right-hand system



Clockwise rotation (M4 command)



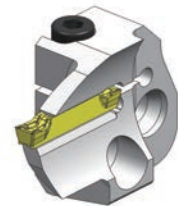
Toolholder



GTWP R-H



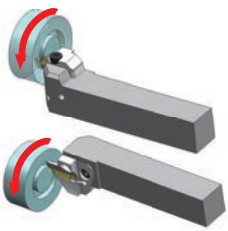
Blade



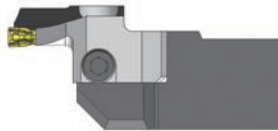
GBWPF R

* Right-hand toolholder takes Right-hand blade.

Left-hand system



Counter clockwise rotation (M3 command)



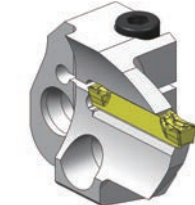
Toolholder



GTWP L-H



Blade



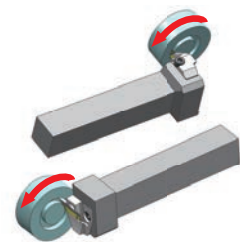
GBWPF L

* Left-hand toolholder takes Left-hand blade.

GKWP-H

L-style toolholder

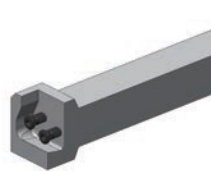
Right-hand system



Counter clockwise rotation (M3 command)



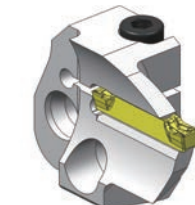
Toolholder



GKWP R-H



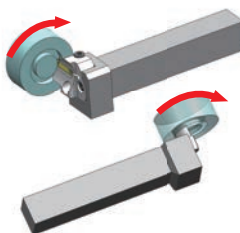
Blade



GBWPF L

* Right-hand toolholder takes Left-hand blade.

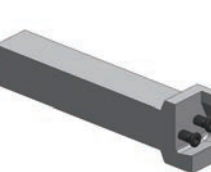
Left-hand system



Clockwise rotation (M4 command)



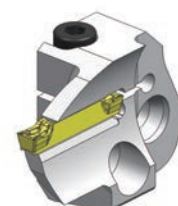
Toolholder



GKWP L-H



Blade

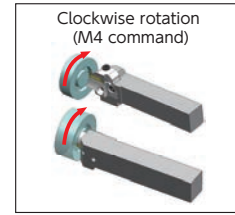
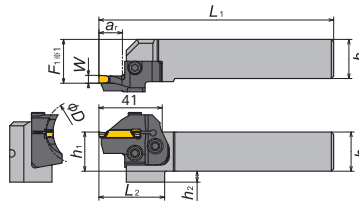
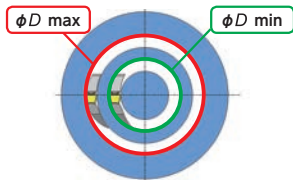


GBWPF R

* Left-hand toolholder takes Right-hand blade.

Grooving / Side Turning

Combination (0° Straight style holder and GBWPFR Blade)

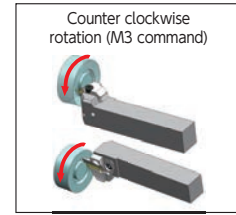
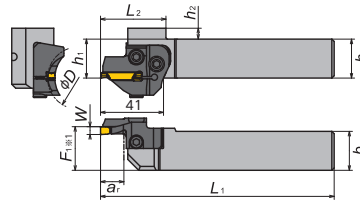
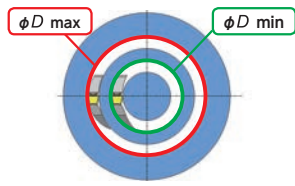


●Right-Hand style shown

Right-hand toolholder takes Right-hand blade.

Hand	Groove Width W (mm)	Face grooving OD		Max.grooving depth a _r (mm)	Holder Number	Blade Number	Dimensions (mm)							Gage insert	
		φD min (mm)	φD max (mm)				h	b	L ₁	h ₁	F ₁	L ₂	h ₂		
R	3	29	35	13	GTWPR2020-H	GBWPFR-3T13-029035	20	20	125	20	23	42.5	8	GWPFM300	
		35	45			-3T13-035045									
		45	60			-3T15-045060									
		60	100			-3T15-060100									
		100	250			-3T15-100250									
	4	30	40	15		-4T15-030040									
		40	60			-4T15-040060									
		60	120			-4T15-060120									
	5	120	300	-4T15-120300											
		30	50	15		-5T15-030050									
		50	120		-5T15-050120										
	120	∞	-5T15-120999												
	6	35	80	15	-6T15-035080										
		80	∞		-6T15-080999										
	3	29	35	13	GTWPR2525-H	-3T13-029035	25	25	150	25	28	38.5	7	GWPFM300	
		35	45			-3T13-035045									
		45	60			-3T15-045060									
		60	100			-3T15-060100									
		100	250			-3T15-100250									
		4	30	40		15									-4T15-030040
			40	60											-4T15-040060
			60	120											-4T15-060120
		5	120	300		-4T15-120300									
			30	50		15									-5T15-030050
50	120		-5T15-050120												
120	∞	-5T15-120999													
6	35	80	15	-6T15-035080											
	80	∞		-6T15-080999											
4	29	35	13	GTWPR3232-H	-3T13-029035	32	32	170	32	35	-	-	GWPFM300		
	35	45			-3T13-035045										
	45	60			-3T15-045060										
	60	100			-3T15-060100										
	100	250			-3T15-100250										
	5	30	40		15									-4T15-030040	
		40	60											-4T15-040060	
		60	120											-4T15-060120	
	6	120	300		-4T15-120300										
		30	50		15									-5T15-030050	
50		120	-5T15-050120												
120	∞	-5T15-120999													
6	35	80	15	-6T15-035080											
	80	∞		-6T15-080999											

Combination (0° Straight style holder and GBWPFL Blade)



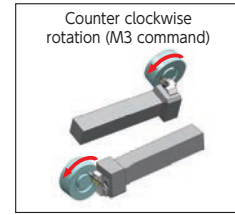
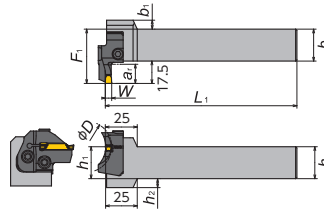
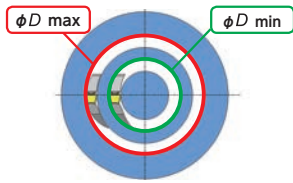
●Left-Hand style shown

Left-hand toolholder takes Left-hand blade.

Hand	Groove Width W (mm)	Face grooving OD		Max.grooving depth ar (mm)	Holder Number	Blade Number	Dimensions (mm)							Gage insert											
		ϕD min (mm)	ϕD max (mm)				h	b	L1	h1	F1	L2	h2												
L	3	29	35	13	GTWPL2020-H	GBWPFL-3T13-029035	20	20	125	20	23	42.5	8	GWPFM300											
		35	45			-3T13-035045																			
		45	60			-3T15-045060																			
		60	100			-3T15-060100																			
		100	250			-3T15-100250																			
	4	30	40	15		-4T15-030040																			
		40	60			-4T15-040060																			
		60	120			-4T15-060120																			
	5	30	50	15		-5T15-030050																			
		50	120			-5T15-050120																			
		120	∞			-5T15-120999																			
	6	35	80	15		-6T15-035080																			
		80	∞			-6T15-080999																			
	L	3	29	35		13									GTWPL2525-H	-3T13-029035	25	25	150	25	28	38.5	7	GWPFM300	
			35	45												-3T13-035045									
			45	60	-3T15-045060																				
			60	100	-3T15-060100																				
			100	250	-3T15-100250																				
		4	30	40	15	-4T15-030040																			
			40	60		-4T15-040060																			
			60	120		-4T15-060120																			
		5	30	50	15	-5T15-030050																			
			50	120		-5T15-050120																			
			120	∞		-5T15-120999																			
		6	35	80	15	-6T15-035080																			
			80	∞		-6T15-080999																			
		L	3	29	35	13	GTWPL3232-H	-3T13-029035	32	32	170	32	35	-		-									GWPFM300
				35	45			-3T13-035045																	
	45			60	-3T15-045060																				
	60			100	-3T15-060100																				
	100			250	-3T15-100250																				
	4		30	40	15	-4T15-030040																			
			40	60		-4T15-040060																			
			60	120		-4T15-060120																			
	5		30	50	15	-5T15-030050																			
			50	120		-5T15-050120																			
120			∞	-5T15-120999																					
6	35		80	15	-6T15-035080																				
	80		∞		-6T15-080999																				

Grooving / Side Turning

Combination (90° L style holder and GBWPFL Blade)

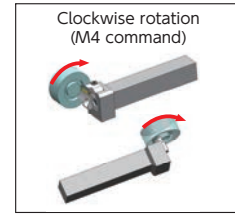
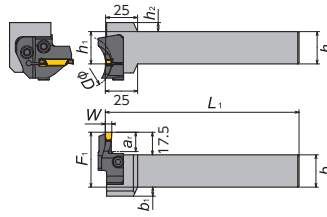
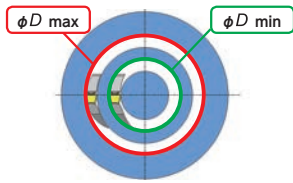


● Right-Hand style shown

Right-hand toolholder takes Left-hand blade.

Hand	Groove Width W (mm)	Face grooving OD		Max.grooving depth a (mm)	Holder Number	Blade Number	Dimensions (mm)							Gage insert	
		φD min (mm)	φD max (mm)				h	b	L ₁	h ₁	F ₁	L ₂	h ₂		
R	3	29	35	13	GKWPR2020-H	GBWPFL-3T13-029035	20	20	125	20	37.5	12	8	GWPFM300	
		35	45			-3T13-035045									
		45	60			-3T15-045060									
		60	100			-3T15-060100									
		100	250			-3T15-100250									
	4	30	40	15		-4T15-030040									
		40	60			-4T15-040060									
		60	120			-4T15-060120									
	5	120	300	-4T15-120300											
		30	50	15		-5T15-030050									
		50	120		-5T15-050120										
	120	∞	-5T15-120999												
	6	35	80	15	-6T15-035080										
		80	∞		-6T15-080999										
	R	3	29	35	13	GKWPR2525-H	-3T13-029035	25	25	150	25	42.5	7	7	GWPFM300
			35	45			-3T13-035045								
			45	60			-3T15-045060								
			60	100			-3T15-060100								
			100	250			-3T15-100250								
		4	30	40	15		-4T15-030040								
			40	60			-4T15-040060								
			60	120			-4T15-060120								
		5	120	300	-4T15-120300										
			30	50	15		-5T15-030050								
50	120		-5T15-050120												
120	∞	-5T15-120999													
6	35	80	15	-6T15-035080											
	80	∞		-6T15-080999											
R	3	29	35	13	GKWPR3232-H	-3T13-029035	32	32	170	32	49.5	-	-	GWPFM300	
		35	45			-3T13-035045									
		45	60			-3T15-045060									
		60	100			-3T15-060100									
		100	250			-3T15-100250									
	4	30	40	15		-4T15-030040									
		40	60			-4T15-040060									
		60	120			-4T15-060120									
	5	120	300	-4T15-120300											
		30	50	15		-5T15-030050									
50		120	-5T15-050120												
120	∞	-5T15-120999													
6	35	80	15	-6T15-035080											
	80	∞		-6T15-080999											

Combination (90° L style holder and GBWPFR Blade)



●Left-Hand style shown

Left-hand toolholder takes Right-hand blade.

Hand	Groove Width W (mm)	Face grooving OD		Max.grooving depth a (mm)	Holder Number	Blade Number	Dimensions (mm)							Gage insert	
		φD min (mm)	φD max (mm)				h	b	L ₁	h ₁	F ₁	L ₂	h ₂		
L	3	29	35	13	GKWPL2020-H	GBWPFR-3T13-029035	20	20	125	20	37.5	12	8	GWPFM300	
		35	45			-3T13-035045									
		45	60			-3T15-045060									
		60	100			-3T15-060100									
		100	250			-3T15-100250									
	4	30	40	15		-4T15-030040									
		40	60			-4T15-040060									
		60	120			-4T15-060120									
	5	30	50	15		-5T15-030050									
		50	120			-5T15-050120									
		120	∞		-5T15-120999										
	6	35	80	15	-6T15-035080										
		80	∞		-6T15-080999										
	L	3	29	35	13	GKWPL2525-H	-3T13-029035	25	25	150	25	42.5	7	7	GWPFM300
			35	45			-3T13-035045								
			45	60			-3T15-045060								
			60	100			-3T15-060100								
			100	250			-3T15-100250								
		4	30	40	15		-4T15-030040								
			40	60			-4T15-040060								
			60	120			-4T15-060120								
		5	30	50	15		-5T15-030050								
			50	120			-5T15-050120								
			120	∞		-5T15-120999									
6		35	80	15	-6T15-035080										
		80	∞		-6T15-080999										
L		3	29	35	13	GKWPL3232-H	-3T13-029035	32	32	170	32	49.5	-	-	GWPFM300
			35	45			-3T13-035045								
	45		60	-3T15-045060											
	60		100	-3T15-060100											
	100		250	-3T15-100250											
	4	30	40	15	-4T15-030040										
		40	60		-4T15-040060										
		60	120		-4T15-060120										
	5	30	50	15	-5T15-030050										
		50	120		-5T15-050120										
		120	∞		-5T15-120999										
	6	35	80	15	-6T15-035080										
		80	∞		-6T15-080999										

New Products
 Tool Materials / Selection Guide
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Grooving / Side Turning

GFV/GSV Series (Face Grooving)

GFV

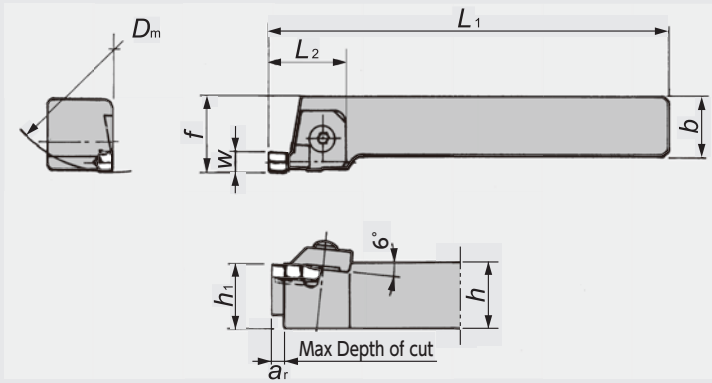
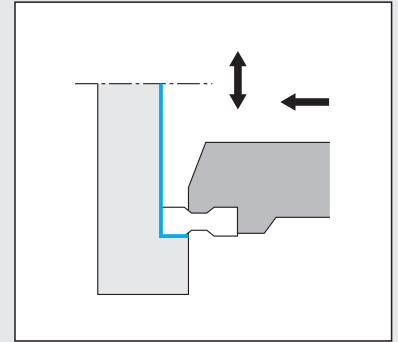


Figure-1



● Right-Hand style shown

GSV

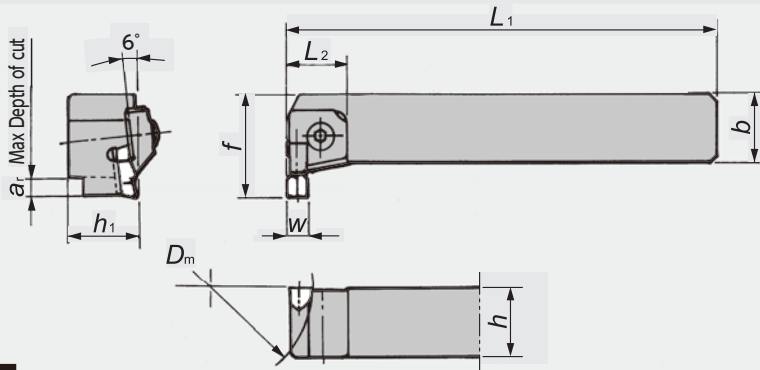
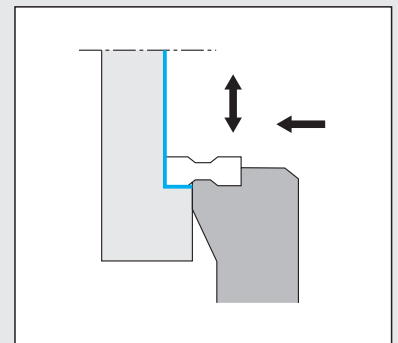


Figure-2



● Right-Hand style shown

GFV/GSV Series - Toolholders

Figure	Code No.		Item Number	Stock		Dimensions (mm)							Groove Width (mm) w	Gage insert	Spare Parts				
	R	L		R	L	h	b	L ₁	h ₁	f	L ₂	a _r			D _m	Clamp	Clamp Bolt	Spring	Wrench
1	5657887	5657895	GFV ^R /L20-6	●	●	20	20	125	20	25	32	6	38	6.0	GFV	CVR/L6	AOB-6C	ASG-6	LW-4
	5655220	5657903	25-6	●	●	25	25	150	25	30									
2	5657911	5657929	GSV ^R /L20-6	●	●	20	20	125	20	33	23.5	6	38	6.0	GFV	CVR/L6 ※	AOB-6C	ASG-6	LW-4
	5645965	5657937	25-6	●	●	25	25	150	25	38									

※Left-Hand clamp with should be used with right-hand holder
Right-Hand clamp with should be used with left-hand holder

GFV/GSV Series - Inserts

Shape	Item Number	Dimensions (mm)		PVD Coated Carbide	
		w	r _ε	QM3	Stock
	GFV600N	6.0	0.15	5027594	●
	600N04		0.4	5068218	●