

# Grooving, Profiling, and Cut-Off

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## Grooving, Profiling and Cut-Off Inserts

Greenleaf offers one of the most comprehensive lines of grooving, profiling, and cut-off inserts in the industry. The single-ended V-bottom grooving systems allow greater depth of cut and optimal transfer of cutting forces for carbide and ceramic inserts.

Our advanced MT-CVD-coated and PVD-coated grades have the strength and wear resistance needed for higher cutting speeds and tool life.

Greenleaf is the industry leader in the development and manufacture of ceramic and coated ceramic inserts, including WG-600® and WG-700™ – second-generation, coated ceramic-composite cutting tools using whisker reinforcement. The coatings protect the already heat-resistant substrate from additional heat encountered in grooving applications and appreciably extend tool life.



# Insert Grades

## Carbide

### CVD Coated

#### GA5025

A high-speed MT-CVD coated grade developed primarily for turning, GA5025 excels in light roughing and finishing applications of carbon and alloy steels, including select stainless steels. GA5025 is preferred in grooving and profiling applications where tool life and wear resistance are essential.

#### GA5026

A high-performance grade specifically developed for finish-turning in nickel- and cobalt-based super-alloys, stainless steels, hardened steels, and refractory metals. The combination of an advanced MT-CVD coating over a hard, sub-micron grain carbide offers outstanding wear resistance while maintaining exceptional resistance to notching and deformation common in turning of high-strength materials. GA5026 is best applied at high speeds and low feed rates.

#### GA5035

A high-performance MT-CVD coated grade for turning in all types of steels, GA5035 can be used from rough to finish-turning applications that require resistance to heat deformation and abrasion. GA5035 is the primary choice for steel grooving and profiling applications, and should be applied at high speeds and moderate feed rates.

#### GA5036

A high-speed MT-CVD coated grade developed primarily for milling, GA5036 excels in grooving and profiling applications of forged and cast steels, as well as select stainless steels where toughness and heat resistance are required. GA5036 is best applied at high cutting speeds and moderate feed rates.

#### GA5125

A high-performance MT-CVD coated carbide grade developed specifically for milling manganese steel, GA5125 can also be applied to interrupted and continuous grooving and profiling applications in chrome-moly steel, tool steel and similar high alloy steels. GA5125 offers excellent wear, built-up edge, thermal shock and deformation resistance, and is best applied at high cutting speeds with moderate feed rates.

### PVD Coated

#### G-915

A tough PVD-coated grade, G-915 is exceptional for milling and interrupted turning of heat-resistant alloys, stainless steels and low-carbon steels. The multi-layer PVD coating provides heat and abrasion resistance to the tough substrate, making G-915 a versatile grade choice that performs well in a variety of materials and grooving, profiling and cut-off applications. G-915 is best applied at moderate speeds and moderate-to-high feed rates.

#### G-920

A high-speed PVD-coated grade for light-to-medium turning applications of heat-resistant alloys and select stainless steels, G-920 is also an excellent grade option for machining aluminum and refractory metals. The resistance to deformation and notching which allows the use of high cutting speeds makes G-920 well-suited to grooving and finish profiling applications in heat-resistant alloys.

#### G-925

A high-performance multi-layered PVD-coated grade, G-925 is specifically designed for machining abrasive and difficult-to-machine materials. Typical applications include grooving and profiling of heat-resistant alloys, titanium, and other refractory metals, stainless steels, and ductile cast irons. G-925 exhibits excellent resistance to notching and deformation, and should be applied at moderate-to-high speeds and moderate feed rates.

#### G-935

A multi-layer PVD-coated grade primarily for steel milling and turning applications requiring additional resistance to mechanical and thermal shock. These properties make G-935 an ideal choice in grooving and profiling applications where toughness is essential. G-935 is best applied at high cutting speeds and moderate feed rates.

#### G-9610

An advanced PVD-coated grade, G-9610 is specifically designed for turning, grooving and profiling applications in all grades of titanium. The high-tech coating provides wear-resistance, chemical stability and a smooth, lubricious outer layer which protects the hard, sub-micron grain substrate and enables high cutting speeds and extended tool life for continuous cuts in non-ferrous alloys.

### Uncoated

#### G-10

A medium grain carbide grade suited for the medium-to-heavy roughing of titanium and Heat-Resistant Super Alloys.

#### G-20M

A sub-micron C-2 carbide grade suited for use in light-to-medium turning, grooving and profiling of titanium and heat-resistant super alloys. G-20M has the edge strength and edge wear characteristics necessary to resist notching when grooving high-strength materials.





## Ceramic

### WG-300®

A SiC whisker-reinforced  $Al_2O_3$  ceramic that is very effective at machining nickel- and cobalt-based super alloys, alloyed cast iron, and hardened steels at metal removal rates up to 10 times higher than carbide. Excellent chemical stability and wear resistance at very high cutting speeds make WG-300® the first choice worldwide for grooving difficult materials.

### WG-600®

A coated SiC whisker-reinforced  $Al_2O_3$  ceramic that offers higher tool life and speed capabilities than uncoated whisker-reinforced ceramics due to the additional barrier to heat and mechanical abrasion. Application areas for WG-600® include rough and finish turning of alloys in the M, K, S, and H ISO material classes, as well as grooving of hardened steels and select stainless steels. WG-600® is particularly well-suited for finish-turning and grooving of Heat-Resistant Super Alloys and is unmatched in both grooving and milling of steels with a hardness above 60 HRC.

### WG-700™

A SiC whisker-reinforced  $Al_2O_3$  ceramic featuring improved toughness and a unique low-friction coating. WG-700™ is ideal for turning, grooving, and profiling nickel- and cobalt-based super alloys that other ceramics may struggle in. WG-700™ exhibits exceptional tool life and productivity in next-generation formulations or novel heat treatments of heat-resistant super alloys lower, and long-reach or thin-walled applications with lower rigidity.

### XSYTIN®-1

A phase-toughened ceramic grade capable of sustaining extreme cutting forces. The unprecedented strength, impact toughness, and resistance to thermal shock of XSYTIN®-1 make it ideal for use in interrupted turning, forging scale removal and milling. In continuous cuts, the strength of XSYTIN®-1 allows the use of significantly higher feed rates or depths of cut. In machining environments with severe interruptions and scale, the edge strength of XSYTIN®-1 allows the use of very light edge preparations, minimizing the force of impact and making for a much smoother cut.

### GSN100™

An engineered blend of hot-pressed silicon nitride and proprietary toughening agents that excels in the machining of cast iron. GSN100™ delivers superior wear and toughness for turning, grooving, and milling applications. It is available in all standard geometries and engineered specials.

### GEM-8™

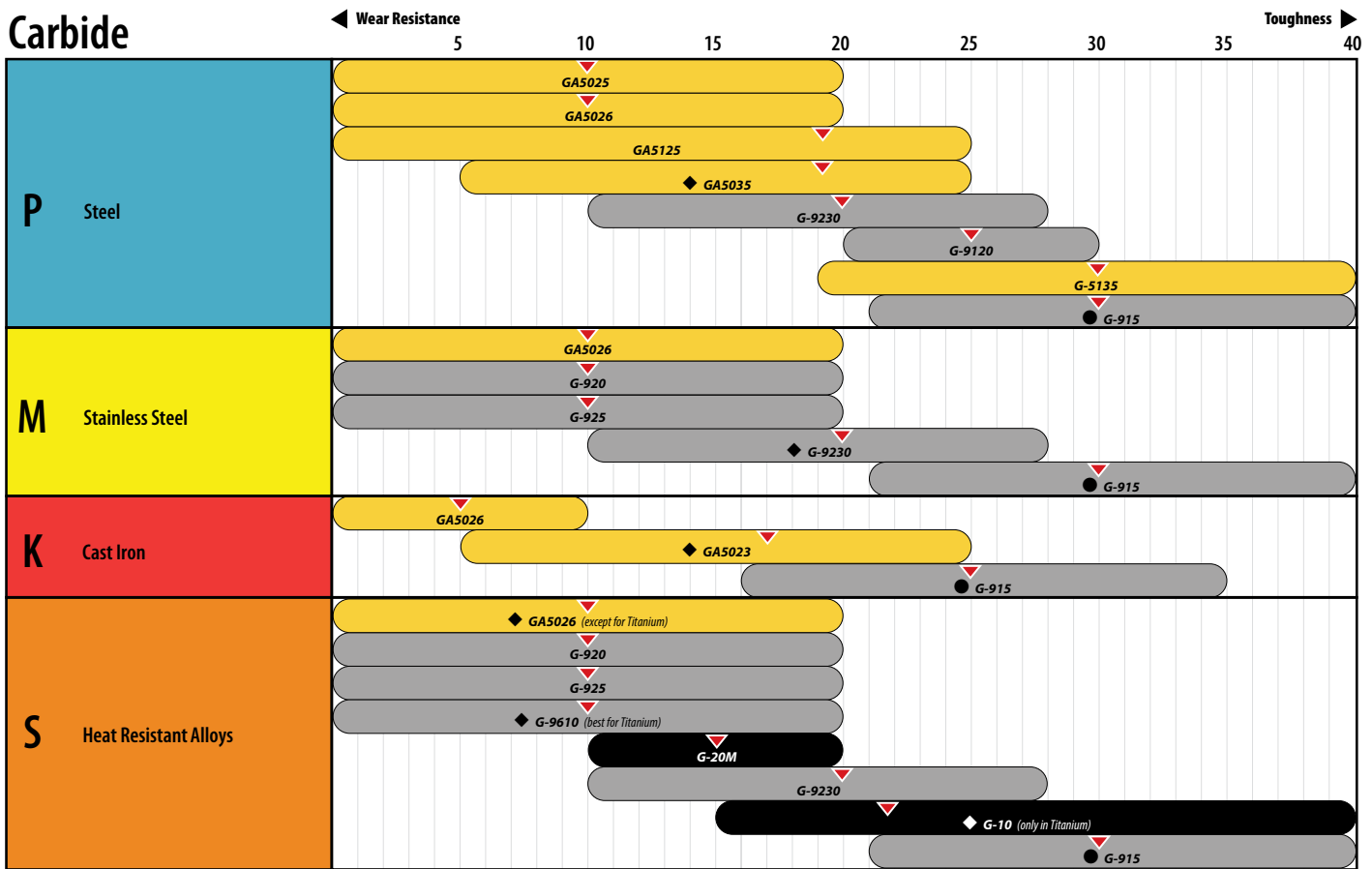
An  $Al_2O_3 + TiC$  composite ceramic exhibiting excellent hardness and strength at elevated temperatures. GEM-8™ offers a high degree of predictability in roll turning and continuous cuts in ferrous alloys.



# Insert Grade Reference for Grooving, Profiling, and Cut-Off

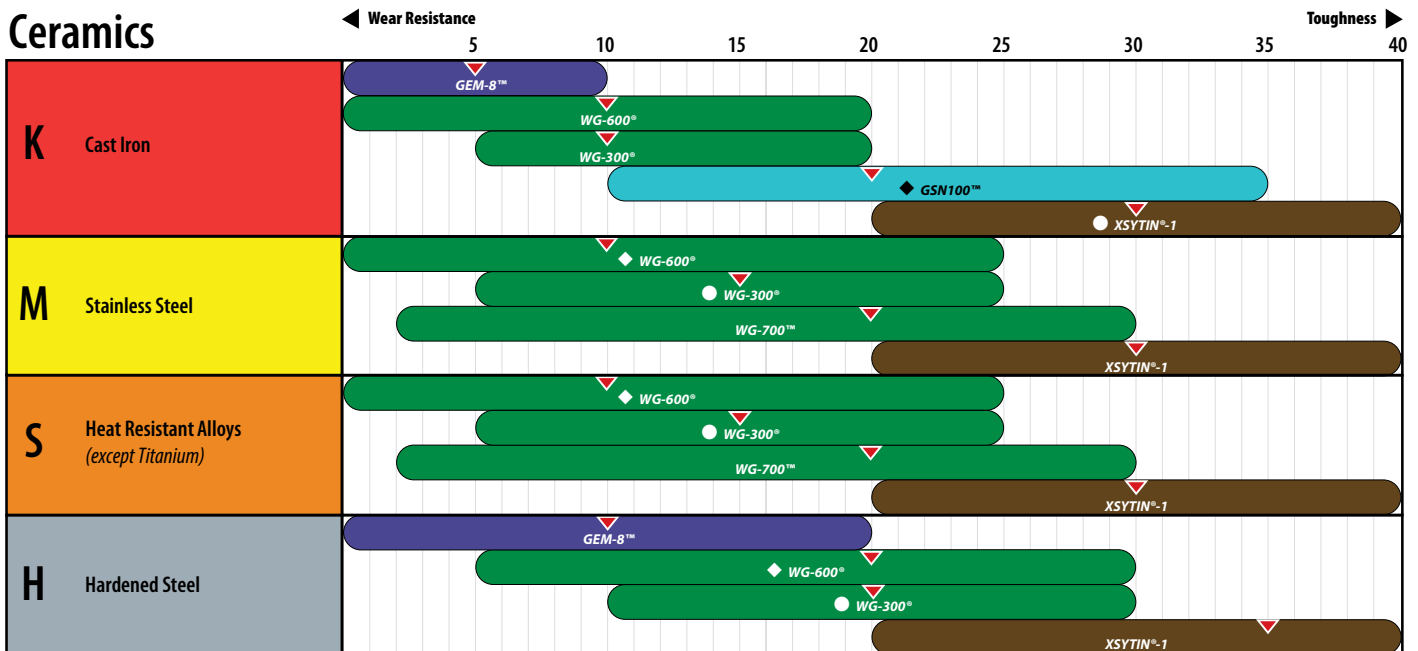
GROOVING, PROFILING, and CUT-OFF

## Carbide



CARBIDE COATINGS: MT-CVD Coated (Yellow), PVD Coated (Grey), Uncoated (Black). First Choice (Diamond), Second Choice (Circle).

## Ceramics



CERAMIC CLASSIFICATION: Whisker Ceramic (Purple), Phase-Toughened (Green), Silicon Nitride (Cyan), Alumina TiC (Brown). First Choice (Diamond), Second Choice (Circle).

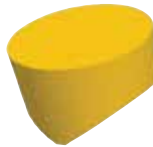
# Pictorial Index

## Greenleaf Cut-Off System

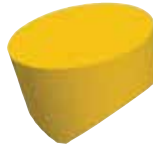


COS  
page: GP 08

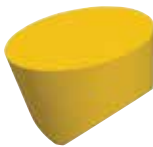
## V-Bottom Round Inserts



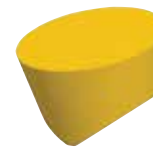
RCGN  
Positive: Carbide  
page: GP 14



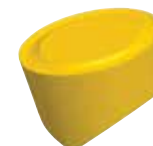
RCGN  
Positive: Ceramic  
page: GP 14



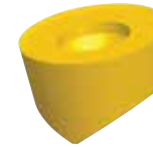
RPGN  
Positive: Carbide  
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RPGN  
Positive: Ceramic  
page: GP 15



RCGR/RPGR  
Positive Chipform  
V-Bottom  
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RCGT/RPGT  
Positive Chipform  
V-Bottom  
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## 35° and 55° V-Bottom Diamond Inserts



VPG  
35°  
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VCGN  
35°  
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DPGN  
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## Single-Ended Groovers



GTS Style  
Full Nose  
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GTS Style  
Flat Nose  
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WG-Style  
Full Nose  
page: GP 10



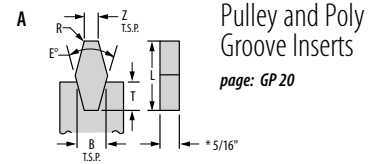
WG-Style  
Flat Nose  
page: GP 11



WGC  
Full Nose  
page: GP 12

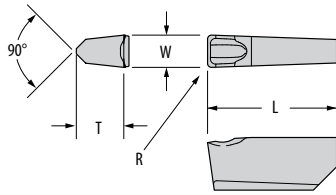


WGC  
Flat Nose  
page: GP 13

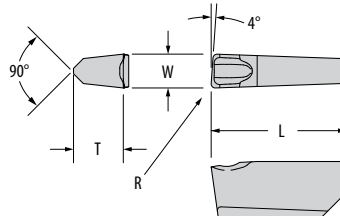


Pulley and Poly  
Groove Inserts  
page: GP 20

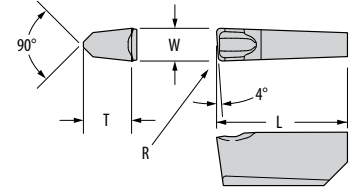
# Greenleaf Cut-Off System



0° Lead



4° Left Hand



4° Right Hand

Shape: Groove/Turn	Part Number ANSI	G-915	Part Number ISO	Dimensions (inches)			
				W	L	T	R
	COS-4094-0	◆	COS-4094-0	0.094	0.500	0.187	0.010
	COS-4125-0	◆	COS-4125-0	0.125	0.500	0.187	0.010
	COS-4187-0	◆	COS-4187-0	0.187	0.500	0.187	0.010
	COS-4094-4L	◆	COS-4094-4L	0.094	0.500	0.187	0.010
	COS-4125-4L	◆	COS-4125-4L	0.125	0.500	0.187	0.010
	COS-4187-4L	◆	COS-4187-4L	0.187	0.500	0.187	0.010
	COS-4094-4R	◆	COS-4094-4R	0.094	0.500	0.187	0.010
	COS-4125-4R	◆	COS-4125-4R	0.125	0.500	0.187	0.010
	COS-4187-4R	◆	COS-4187-4R	0.187	0.500	0.187	0.010

CARBIDE COATINGS: ■ MF-CVD Coated ■ PVD Coated ■ Uncoated

First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ✦

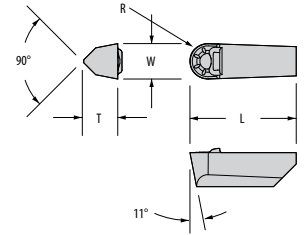
Grade descriptions — pages GP 04

See pages GP 31, GP 34 and GP 39 for toolholders.

GROOVING, PROFILING, and CUT-OFF



# GTS Style, Full Nose Grooving Inserts



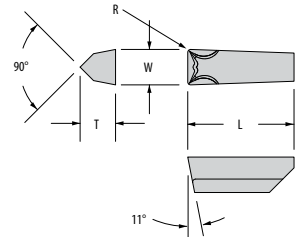
Shape: Groove/Turn	Part Number ANSI	Steel		Stainless Steel		Cast Iron		Heat Resistant Super Alloys		Part Number ISO	Dimensions (inches)			
		P		M		K		S			W	L	T	R
		GA5035	G-915	G-935	GA5026	G-915	G-915	GA5026	G-925					
	GTS-4125	▲	◆	●	◆	●	◆	●	◆	GTS-4125	0.125	0.500	0.187	Full
	GTS-4187	▲	◆	●	◆	●	◆	●	◆	GTS-4187	0.187	0.500	0.187	Full
	GTS-6250	▲	◆	●	◆	●	◆	●	◆	GTS-6250	0.250	0.750	0.250	Full

CARBIDE COATINGS: MF-CVD Coated PVD Coated Uncoated

First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ◇

Grade descriptions — pages GP 04

# GTS Style, Flat Nose Grooving Inserts



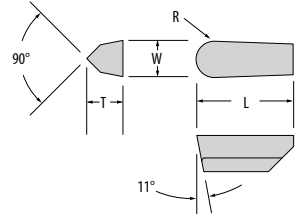
Shape: Groove/Turn	Part Number ANSI	Steel		Stainless Steel		Cast Iron		Heat Resistant Super Alloys		Part Number ISO	Dimensions (inches)			
		P		M		K		S			W	L	T	R
		GA5035	G-915	G-935	GA5026	G-915	G-915	GA5026	G-925					
	GTS-4125-1	▲	◆	●	◆	●	◆	●	◆	GTS-4125-1	0.125	0.500	0.187	0.015
	GTS-4125-2	▲	◆	●	◆	●	◆	●	◆	GTS-4125-2	0.125	0.500	0.187	0.031
	GTS-4187-1	▲	◆	●	◆	●	◆	●	◆	GTS-4187-1	0.187	0.500	0.187	0.015
	GTS-4187-2	▲	◆	●	◆	●	◆	●	◆	GTS-4187-2	0.187	0.500	0.187	0.031
	GTS-6250-1	▲	◆	●	◆	●	◆	●	◆	GTS-6250-1	0.250	0.750	0.250	0.015
	GTS-6250-2	▲	◆	●	◆	●	◆	●	◆	GTS-6250-2	0.250	0.750	0.250	0.031

CARBIDE COATINGS: MF-CVD Coated PVD Coated Uncoated

First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ◇

Grade descriptions — pages GP 04

GROOVING, PROFILING, and CUT-OFF



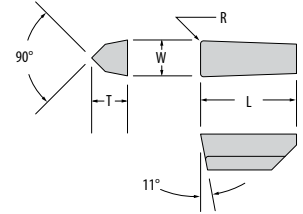
# WG-Style, Full Nose Grooving Inserts

Shape: Groover	Part Number ANSI	S Steel		Cast Iron		Heat-Resistant Super Alloys				Hardened Steel				Part Number ISO	Dimensions (inches)			
		M	K	S				H				W	L		T	R		
		WG-600	GSN100	XSYTIN-1	WG-600	WG-300	WG-600	WG-700	XSYTIN-1	WG-300	WG-600	XSYTIN-1	GEM-8					
	WG-4094	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WG-4094	0.094	0.500	0.187	Full
	WG-4125	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WG-4125	0.125	0.500	0.187	Full
	WG-4156	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WG-4156	0.156	0.500	0.187	Full
	WG-4187	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WG-4187	0.187	0.500	0.187	Full
	WG-6218	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WG-6218	0.218	0.750	0.250	Full
	WG-6250	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WG-6250	0.250	0.750	0.250	Full
	WG-6281	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WG-6281	0.281	0.750	0.250	Full
	WG-8312	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WG-8312	0.312	1.000	0.337	Full
	WG-8344	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WG-8344	0.344	1.000	0.337	Full
	WG-8375	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WG-8375	0.375	1.000	0.337	Full

CERAMIC CLASSIFICATION: Whisker Ceramic Phase-Toughened Silicon Nitride Alumina TiC First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ❖ Grade descriptions — pages GP 05

GROOVING, PROFILING, and CUT-OFF

# WG-Style, Flat Nose Grooving Inserts



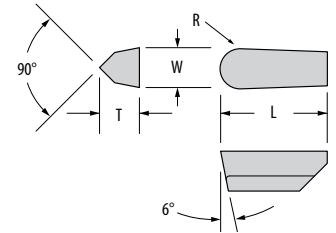
Shape: Groover	Part Number ANSI	S Steel	Cast Iron				Heat-Resistant Super Alloys				Hardened Steel				Part Number ISO	Dimensions (inches)			
		M	K			S				H				W		L	T	R	
		WG-600	GSN100	XSYTIN-1	WG-600	WG-300	WG-600	WG-700	XSYTIN-1	WG-300	WG-600	XSYTIN-1	GEM-8						
WG-4094-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-4094-1	0.094	0.500	0.187	0.015		
WG-4094-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-4094-2	0.094	0.500	0.187	0.031		
WG-4125-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-4125-1	0.125	0.500	0.187	0.015		
WG-4125-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-4125-2	0.125	0.500	0.187	0.031		
WG-4156-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-4156-1	0.156	0.500	0.187	0.015		
WG-4156-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-4156-2	0.156	0.500	0.187	0.031		
WG-4156-3	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-4156-3	0.156	0.500	0.187	0.046		
WG-4187-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-4187-1	0.187	0.500	0.187	0.015		
WG-4187-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-4187-2	0.187	0.500	0.187	0.031		
WG-6218-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-6218-1	0.218	0.750	0.250	0.015		
WG-6218-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-6218-2	0.218	0.750	0.250	0.031		
WG-6250-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-6250-1	0.250	0.750	0.250	0.015		
WG-6250-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-6250-2	0.250	0.750	0.250	0.031		
WG-6250-3	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-6250-3	0.250	0.750	0.250	0.046		
WG-6250-4	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-6250-4	0.250	0.750	0.250	0.062		
WG-6281-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-6281-1	0.281	0.750	0.250	0.015		
WG-6281-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-6281-2	0.281	0.750	0.250	0.031		
WG-6281-3	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-6281-3	0.281	0.750	0.250	0.046		
WG-8312-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8312-1	0.312	1.000	0.337	0.015		
WG-8312-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8312-2	0.312	1.000	0.337	0.031		
WG-8312-3	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8312-3	0.312	1.000	0.337	0.046		
WG-8312-4	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8312-4	0.312	1.000	0.337	0.062		
WG-8344-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8344-1	0.344	1.000	0.337	0.015		
WG-8344-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8344-2	0.344	1.000	0.337	0.031		
WG-8344-3	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8344-3	0.344	1.000	0.337	0.046		
WG-8344-4	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8344-4	0.344	1.000	0.337	0.062		
WG-8375-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8375-1	0.375	1.000	0.337	0.015		
WG-8375-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8375-2	0.375	1.000	0.337	0.031		
WG-8375-3	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8375-3	0.375	1.000	0.337	0.046		
WG-8375-4	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WG-8375-4	0.375	1.000	0.337	0.062		



CERAMIC CLASSIFICATION: Whisker Ceramic Phase-Toughened Silicon Nitride Alumina TiC First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ◆ Grade descriptions — pages GP 05

GROOVING, PROFILING, and CUT-OFF

# WGC, Full Nose Grooving Inserts



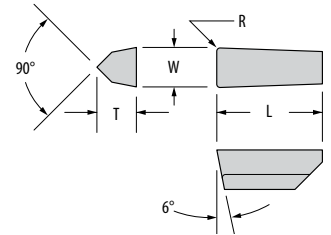
Shape: Groover	Part Number ANSI	S Steel		Cast Iron		Heat-Resistant Super Alloys				Hardened Steel				Part Number ISO	Dimensions (inches)			
		M	K	S				H				W	L		T	R		
		WG-600	GSN100	XSYTIN-1	WG-600	WG-300	WG-600	WG-700	XSYTIN-1	WG-300	WG-600	XSYTIN-1	GEM-8					
	WGC-4094	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WGC-4094	0.094	0.500	0.187	Full
	WGC-4125	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WGC-4125	0.125	0.500	0.187	Full
	WGC-4156	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WGC-4156	0.156	0.500	0.187	Full
	WGC-4187	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WGC-4187	0.187	0.500	0.187	Full
	WGC-6218	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WGC-6218	0.218	0.750	0.250	Full
	WGC-6250	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WGC-6250	0.250	0.750	0.250	Full
	WGC-6281	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WGC-6281	0.281	0.750	0.250	Full
	WGC-8312	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WGC-8312	0.312	1.000	0.337	Full
	WGC-8344	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WGC-8344	0.344	1.000	0.337	Full
	WGC-8375	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	WGC-8375	0.375	1.000	0.337	Full

CERAMIC CLASSIFICATION: Whisker Ceramic Phase-Toughened Silicon Nitride Alumina TiC First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ❖ Grade descriptions — pages GP 05

GROOVING, PROFILING, and CUT-OFF



# WGC, Flat Nose Grooving Inserts



Shape: Groover	Part Number ANSI	S Steel	Cast Iron				Heat-Resistant Super Alloys				Hardened Steel				Part Number ISO	Dimensions (inches)			
		M	K			S				H				W		L	T	R	
		WG-600	GSN 100	XSXTIN-1	WG-600	WG-300	WG-600	WG-700	XSXTIN-1	WG-300	WG-600	XSXTIN-1	GEM-8						
WGC-4094-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-4094-1	0.094	0.500	0.187	0.015		
WGC-4094-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-4094-2	0.094	0.500	0.187	0.031		
WGC-4125-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-4125-1	0.125	0.500	0.187	0.015		
WGC-4125-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-4125-2	0.125	0.500	0.187	0.031		
WGC-4156-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-4156-1	0.156	0.500	0.187	0.015		
WGC-4156-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-4156-2	0.156	0.500	0.187	0.031		
WGC-4187-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-4187-1	0.187	0.500	0.187	0.015		
WGC-4187-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-4187-2	0.187	0.500	0.187	0.031		
WGC-6218-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-6218-1	0.218	0.750	0.250	0.015		
WGC-6218-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-6218-2	0.218	0.750	0.250	0.031		
WGC-6250-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-6250-1	0.250	0.750	0.250	0.015		
WGC-6250-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-6250-2	0.250	0.750	0.250	0.031		
WGC-6250-3	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-6250-3	0.250	0.750	0.250	0.046		
WGC-6281-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-6281-1	0.281	0.750	0.250	0.015		
WGC-6281-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-6281-2	0.281	0.750	0.250	0.031		
WGC-6281-3	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-6281-3	0.281	0.750	0.250	0.046		
WGC-8312-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8312-1	0.312	1.000	0.337	0.015		
WGC-8312-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8312-2	0.312	1.000	0.337	0.031		
WGC-8312-3	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8312-3	0.312	1.000	0.337	0.046		
WGC-8312-4	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8312-4	0.312	1.000	0.337	0.062		
WGC-8344-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8344-1	0.344	1.000	0.337	0.015		
WGC-8344-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8344-2	0.344	1.000	0.337	0.031		
WGC-8344-3	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8344-3	0.344	1.000	0.337	0.046		
WGC-8344-4	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8344-4	0.344	1.000	0.337	0.062		
WGC-8375-1	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8375-1	0.375	1.000	0.337	0.015		
WGC-8375-2	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8375-2	0.375	1.000	0.337	0.031		
WGC-8375-3	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8375-3	0.375	1.000	0.337	0.046		
WGC-8375-4	◆	◆	▲	●	●	◆	▲	▲	●	●	◆	▲	WGC-8375-4	0.375	1.000	0.337	0.062		

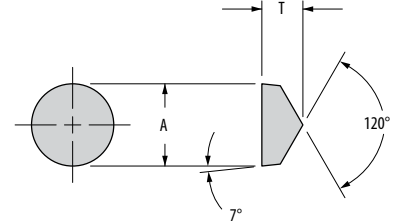



CERAMIC CLASSIFICATION: Whisker Ceramic Phase-Toughened Silicon Nitride Alumina TiC First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ◆ Grade descriptions — pages GP 05

GROOVING, PROFILING, and CUT-OFF

# Round Positive V-Bottom Inserts

RCGN-V — Carbide



Shape: Round V-Bottom	Part Number ANSI	Steel				Stainless Steel		Cast Iron	Heat-Resistant Super Alloys						Part Number ISO	Dimensions (inches)			
		P				M		K	S							A	T		
		GA5025	GA5035	GA5125	GA5036	GA5026	G-925	G-915	GA5023	G-915	G-10	GA5026	G-9610	G-925				G-920	G-20M
	RCGN-2V	●	◆	▲	❖	●	◆	❖	◆	❖	❖	●	▲	◆	▲	▲	RCGX-060400	0.250	0.187
	RCGX-102	●	◆	▲	❖	●	◆	❖	◆	❖	❖	●	▲	◆	▲	▲	RCGX-060600	0.250	0.250
	RCGN-3V	●	◆	▲	❖	●	◆	❖	◆	❖	❖	●	▲	◆	▲	▲	RCGX-090700	0.375	0.312
	RCGN-4V	●	◆	▲	❖	●	◆	❖	◆	❖	❖	●	▲	◆	▲	▲	RCGX-120700	0.500	0.312

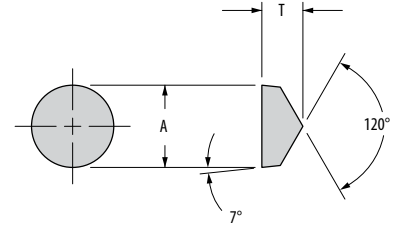
CARBIDE COATINGS: MF-CVD Coated PVD Coated Uncoated


First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ❖

Grade descriptions — pages GP 04

# Round Positive V-Bottom Inserts

RCGN-V — Ceramic



Shape: Round V-Bottom	Part Number ANSI	S Steel	Cast Iron		Heat-Resistant Super Alloys				Hardened Steel				Part Number ISO	Dimensions (inches)		
		M	K		S				H					A	T	
		WG-600	GSNT100	XSYTIN-1	WG-600	WG-300	WG-600	WG-700	XSYTIN-1	WG-300	WG-600	XSYTIN-1				GEM-8
	RCGN-2V	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	RCGX-060400	0.250	0.187
	RCGX-102	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	RCGX-060600	0.250	0.250
	RCGN-3V	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	RCGX-090700	0.375	0.312
	RCGN-4V	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	RCGX-120700	0.500	0.312

CERAMIC CLASSIFICATION: Whisker Ceramic Phase-Toughened Silicon Nitride Alumina TiC First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ❖

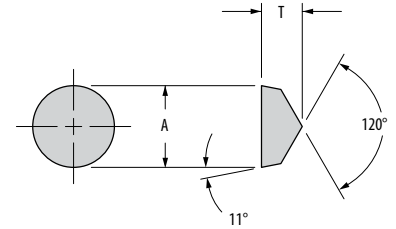
Grade descriptions — pages GP 05

See pages AT1 22-23 for information on edge preps. For availability and any application concerns, please contact Greenleaf Technical Service.

GROOVING, PROFILING, and CUT-OFF

# Round Positive V-Bottom Inserts

RPGN-V — Carbide



Shape: Round V-Bottom	Part Number ANSI	Steel				Stainless Steel		Cast Iron	Heat-Resistant Super Alloys						Part Number ISO	Dimensions (inches)			
		P				M		K	S							A	T		
		GA5025	GA5035	GA5125	GA5036	GA5026	G-925	G-915	GA5023	G-915	G-10	GA5026	G-9610	G-925				G-920	G-20M
	RPGN-2V	●	◆	▲	❖	●	◆	❖	◆	❖	❖	●	▲	◆	▲	▲	RPGX-060400	0.250	0.187
	RPGN-3V	●	◆	▲	❖	●	◆	❖	◆	❖	❖	●	▲	◆	▲	▲	RPGX-090700	0.375	0.312
	RPGN-4V	●	◆	▲	❖	●	◆	❖	◆	❖	❖	●	▲	◆	▲	▲	RPGX-120700	0.500	0.312

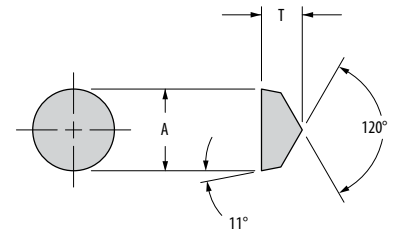
CARBIDE COATINGS: MF-CVD Coated PVD Coated Uncoated

First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ❖

Grade descriptions — pages GP 04

# Round Positive V-Bottom Inserts

RPGN-V — Ceramic



Shape: Round V-Bottom	Part Number ANSI	S Steel	Cast Iron		Heat-Resistant Super Alloys				Hardened Steel				Part Number ISO	Dimensions (inches)		
		M	K		S				H					A	T	
		WG-600	GSNT100	XSYTIN-1	WG-600	WG-300	WG-600	WG-700	XSYTIN-1	WG-300	WG-600	XSYTIN-1				GEM-8
	RPGN-2V	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	RPGX-060400	0.250	0.187
	RPGN-3V	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	RPGX-090700	0.375	0.312
	RPGN-4V	◆	◆	▲	●	●	◆	▲	▲	●	●	❖	▲	RPGX-120700	0.500	0.312

CERAMIC CLASSIFICATION: Whisker Ceramic Phase-Toughened Silicon Nitride Alumina TiC

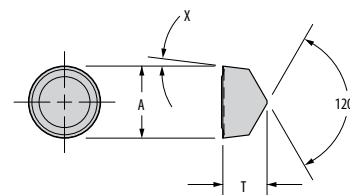
First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ❖

Grade descriptions — pages GP 05

See pages AT1 22-23 for information on edge preps. For availability and any application concerns, please contact Greenleaf Technical Service.

# Round Positive Chipform V-Bottom Inserts

RCGR-V/RPGR-V — Carbide



Shape: Round V-Bottom	Part Number ANSI	Steel				Stainless Steel		Cast Iron	Heat-Resistant Super Alloys						Part Number ISO	Dimensions (inches)				
		P				M		K	S							A	T	X		
		GA5025	GA5035	GA5125	GA5036	GA5026	G-925	G-915	GA5023	G-915	G-10	GA5026	G-9610	G-925					G-920	G-20M
	RCGR-2V-TF					●	◆					●	▲	◆	▲	▲	RCGR-060400V-TF	0.250	0.187	7°
	RCGR-3V-TF					●	◆					●	▲	◆	▲	▲	RCGR-090700V-TF	0.375	0.312	7°
	RCGR-4V-TF					●	◆					●	▲	◆	▲	▲	RCGR-120700V-TF	0.500	0.312	7°
	RPGR-2V-TF					●	◆					●	▲	◆	▲	▲	RPGX-060400V-TF	0.250	0.187	11°
	RPGR-3V-TF					●	◆					●	▲	◆	▲	▲	RPGX-090700V-TF	0.375	0.312	11°
	RPGR-4V-TF					●	◆					●	▲	◆	▲	▲	RPGX-120700V-TF	0.500	0.312	11°

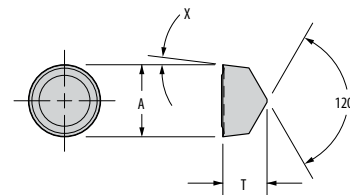
CARBIDE COATINGS: MF-CVD Coated PVD Coated Uncoated

First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ◇

Grade descriptions — pages GP 04

# Round Positive Chipform V-Bottom Inserts

RCGR-V/RPGR-V — Ceramic



Shape: Round V-Bottom	Part Number ANSI	S Steel		Cast Iron	Heat-Resistant Super Alloys				Hardened Steel				Part Number ISO	Dimensions (inches)			
		M		K	S				H					A	T	X	
		WG-600	GSNT100	XSYTIN-1	WG-600	WG-300	WG-600	WG-700	XSYTIN-1	WG-300	WG-600	XSYTIN-1					GEM-8
	RCGR-2V-GF1	◆		▲	●	●	◆	▲	▲	●	●	◆		RCGR-060400V-GF1	0.250	0.187	7°
	RCGR-3V-GF1	◆		▲	●	●	◆	▲	▲	●	●	◆		RCGR-090700V-GF1	0.375	0.312	7°
	RCGR-4V-GF1	◆		▲	●	●	◆	▲	▲	●	●	◆		RCGR-120700V-GF1	0.500	0.312	7°
	RPGR-2V-GF1	◆		▲	●	●	◆	▲	▲	●	●	◆		RPGR-060400V-GF1	0.250	0.187	11°
	RPGR-3V-GF1	◆		▲	●	●	◆	▲	▲	●	●	◆		RPGR-090700V-GF1	0.375	0.312	11°

CERAMIC CLASSIFICATION: Whisker Ceramic Phase-Toughened Silicon Nitride Alumina TiC

First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ◇

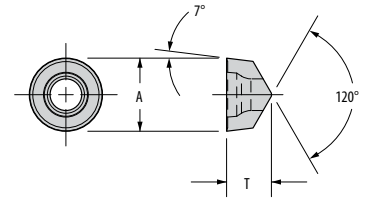
Grade descriptions — pages GP 05

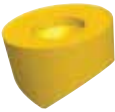
GROOVING, PROFILING, and CUT-OFF



# Round Positive Chipform V-Bottom Inserts

RCGT-V — Carbide



Shape: Round V-Bottom	Part Number ANSI	Steel				Stainless Steel		Cast Iron	Heat-Resistant Super Alloys						Part Number ISO	Dimensions (inches)			
		P				M		K	S							A i.c.	T		
		GA5025	GA5035	GA5125	GA5036	GA5026	G-925	G-915	GA5023	G-915	G-10	GA5026	G-9610	G-925				G-920	G-20M
	RCGT-2V-TF					●	◆					●	▲	◆	▲	▲	RCGT-060400V-TF	0.250	0.187
	RCGT-3V-TF					●	◆					●	▲	◆	▲	▲	RCGT-090700V-TF	0.375	0.312
	RCGT-4V-TF					●	◆					●	▲	◆	▲	▲	RCGT-120700V-TF	0.500	0.312

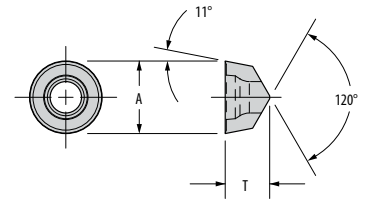
CARBIDE COATINGS: MF-CVD Coated PVD Coated Uncoated


First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ◇

Grade descriptions — pages GP 04

# Round Positive Chipform V-Bottom Inserts

RPGT-V — Carbide



Shape: Round V-Bottom	Part Number ANSI	Steel				Stainless Steel		Cast Iron	Heat-Resistant Super Alloys						Part Number ISO	Dimensions (inches)			
		P				M		K	S							A i.c.	T		
		GA5025	GA5035	GA5125	GA5036	GA5026	G-925	G-915	GA5023	G-915	G-10	GA5026	G-9610	G-925				G-920	G-20M
	RPGT-2V-TF					●	◆					●	▲	◆	▲	▲	RPGT-060400V-TF	0.250	0.187
	RPGT-3V-TF					●	◆					●	▲	◆	▲	▲	RPGT-090700V-TF	0.375	0.312
	RPGT-4V-TF					●	◆					●	▲	◆	▲	▲	RPGT-120700V-TF	0.500	0.312

CARBIDE COATINGS: MF-CVD Coated PVD Coated Uncoated

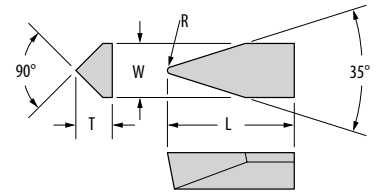
First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ◇

Grade descriptions — pages GP 04

GROOVING, PROFILING, and CUT-OFF

# 35° V-Bottom Inserts

(VPG-V)

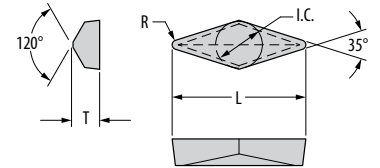


Shape: 35° V-Bottom	Part Number ANSI	S Steel		Cast Iron		Heat-Resistant Super Alloys				Hardened Steel				Part Number ISO	Dimensions (inches)			
		M		K		S				H					W	L	T	R
		WG-600	GSN100	XSYTIN-1	WG-600	WG-300	WG-600	WG-700	XSYTIN-1	WG-300	WG-600	XSYTIN-1	GEM-8					
	VPG-33.542V	◆		▲	●	●	◆	▲	▲	●	●	◆		VPG-33.542V	0.375	0.875	0.250	0.031
	VPG-33.543V	◆		▲	●	●	◆	▲	▲	●	●	◆		VPG-33.543V	0.375	0.875	0.250	0.046

CERAMIC CLASSIFICATION: Whisker Ceramic Phase-Toughened Silicon Nitride Alumina TiC First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ◆ Grade descriptions — pages GP 05  
See pages ATI 22-23 for information on edge preps. For availability and any application concerns, please contact Greenleaf Technical Service.

# 35° V-Bottom Inserts

(VCGN-V)

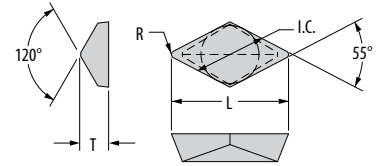


Shape: 35° V-Bottom	Part Number ANSI	S Steel		Cast Iron		Heat-Resistant Super Alloys				Hardened Steel				Part Number ISO	Dimensions (inches)			
		M		K		S				H					I.C.	L	T	R
		WG-600	GSN100	XSYTIN-1	WG-600	WG-300	WG-600	WG-700	XSYTIN-1	WG-300	WG-600	XSYTIN-1	GEM-8					
	VCGN-2.532V	◆		▲	●	●	◆	▲	▲	●	●	◆		VCGN-2.532V	0.312	0.892	0.187	0.031
	VCGN-2.533V	◆		▲	●	●	◆	▲	▲	●	●	◆		VCGN-2.533V	0.312	0.819	0.187	0.047

CERAMIC CLASSIFICATION: Whisker Ceramic Phase-Toughened Silicon Nitride Alumina TiC First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ◆ Grade descriptions — pages GP 05  
See pages ATI 22-23 for information on edge preps. For availability and any application concerns, please contact Greenleaf Technical Service.

GROOVING, PROFILING, and CUT-OFF

# 55° V-Bottom Inserts (DPGN-V)



Shape: 55° V-Bottom	Part Number ANSI	S Steel		Cast Iron		Heat-Resistant Super Alloys				Hardened Steel				Part Number ISO	Dimensions (inches)			
		M	K	S				H				I.C.	L		T	R		
		WG-600	GSN100	XSYTIN-1	WG-600	WG-300	WG-600	WG-700	XSYTIN-1	WG-300	WG-600						XSYTIN-1	GEM-8
	DPGN-442V	◆		▲	●	●	◆	▲	▲	●	●	◆		DPGN-442V	0.500	1.010	0.250	0.031
	DPGN-443V	◆		▲	●	●	◆	▲	▲	●	●	◆		DPGN-443V	0.500	0.973	0.250	0.047

CERAMIC CLASSIFICATION: Whisker Ceramic Phase-Toughened Silicon Nitride Alumina TiC First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ✦ Grade descriptions — pages GP 05

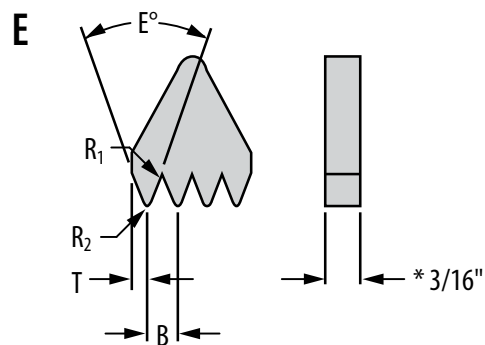
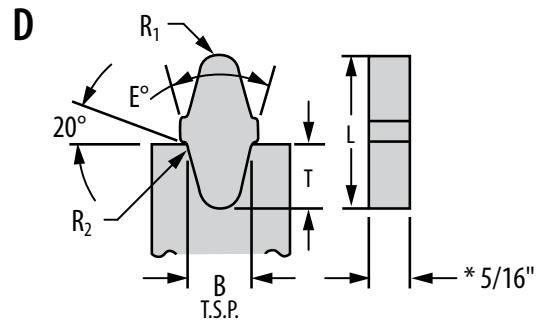
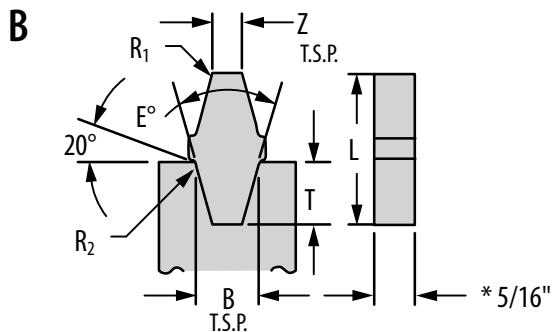
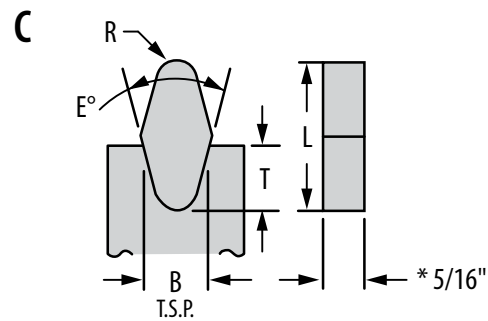
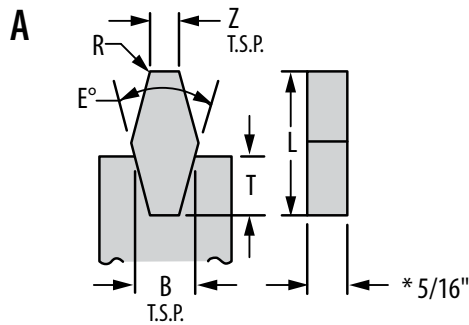
See pages ATI 22-23 for information on edge preps. For availability and any application concerns, please contact Greenleaf Technical Service.

# Pulley and Poly Grooving Inserts

When ordering or requesting quotations, you should provide a part print and a sketch with dimensions as indicated in the following format:

Insert Style	B	E°	L
R <sub>1</sub>	R <sub>2</sub>	T	Z

\* Recommended – other specifications available upon request.



**Z** NUMBER OF TEETH  
REQUIRED ON INSERT

GROOVING, PROFILING, and CUT-OFF



## Grooving, Profiling and Cut-Off Toolholders

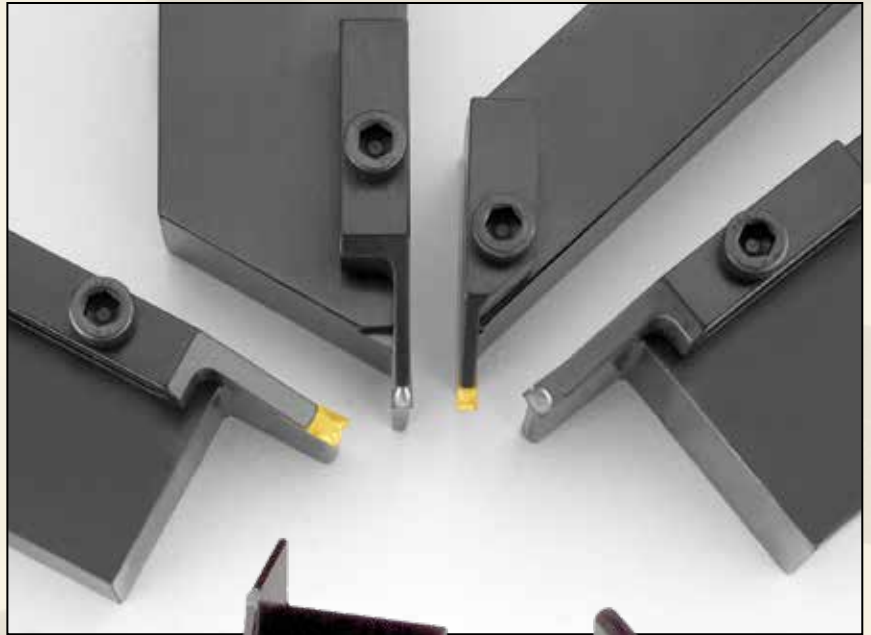
The Greenleaf tooling system for grooving, profiling, and cut-off provides every specific application with unsurpassed support to ensure the greatest tool life and highest material-removal rates with both carbide and ceramic inserts. All the tools in this system are designed to use Greenleaf carbide or ceramic inserts interchangeably for maximum versatility.

Toolholders are offered with both milled-nest and replaceable-nest designs to provide further options for your tooling requirements.

Using the most rigid holder that fits the application will make the process more reliable and repeatable, reducing the likelihood of irregular wear.

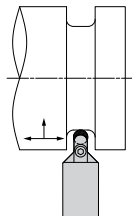
### Greenleaf Tune-Up Kits

A Tune-Up Kit consists of all the standard hardware to refurbish a particular toolholder, boring bar, or milling cutter. A toolholder will have a readily visible, laser-inscribed Tune-Up Kit number on it for ease in ordering. This number will prevent any confusion created by searching a catalog for hardware, and it will help reduce downtime.

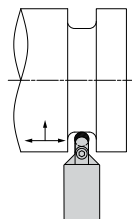


# Pictorial Index

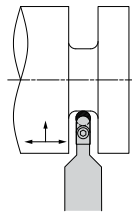
## V-Bottom Round Toolholders



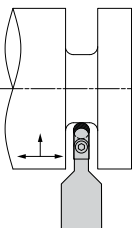
**CRDPN-VS**  
Replaceable Nest  
Shallow D.O.C.  
*page: GP 24*



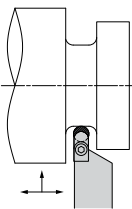
**CRDPN-V**  
Replaceable Nest  
Deep D.O.C.  
*page: GP 24*



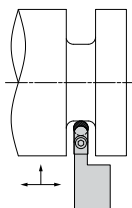
**CRDPN-VMS**  
Milled Nest  
Shallow D.O.C.  
*page: GP 25*



**CRDPN-VM**  
Milled Nest  
Deep D.O.C.  
*page: GP 25*

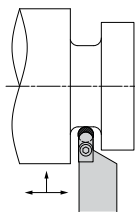


**O.D. G/P Toolholder**  
Replaceable Nest  
Shallow D.O.C.  
*page: GP 26*

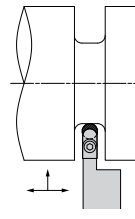


**O.D. G/P Toolholder**  
Replaceable Nest  
Deep D.O.C.  
*page: GP 26*

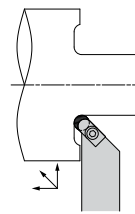
## V-Bottom Round Toolholders *continued*



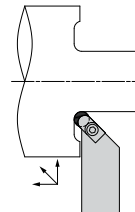
**O.D. G/P Toolholder**  
Milled Nest  
Shallow D.O.C.  
*page: GP 27*



**O.D. G/P Toolholder**  
Milled Nest  
Deep D.O.C.  
*page: GP 27*

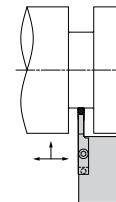


**CRGPR-V**  
**CRGPL-V**  
45°  
Replaceable Nest  
*page: GP 28*

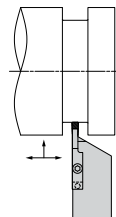


**CRGPR-VM**  
**CRGPL-VM**  
45°  
Milled Nest  
*page: GP 28*

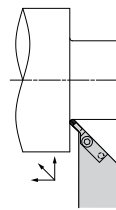
## Single-Ended Groovers



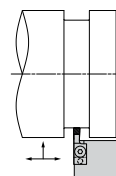
**Deep D.O.C.**  
*page: GP 29-30*



**Shallow D.O.C.**  
*page: GP 31-32*



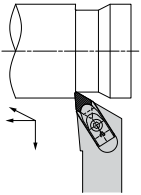
**45° G/P Toolholder**  
*page: GP 33*



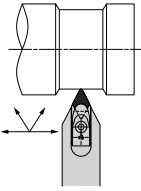
**90° G/P Toolholder**  
*page: GP 34-35*

GROOVING, PROFILING, and CUT-OFF

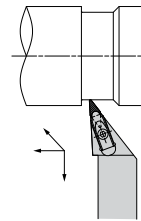
**35° and 55° V-Bottom**



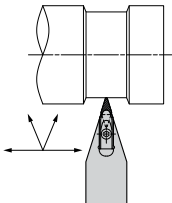
**CDJOR-V  
CDJOL-V**  
Double Ended  
55° Diamond  
*page: GP 36*



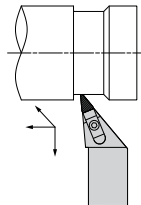
**CDPON-V**  
Double Ended  
55° Diamond  
*page: GP 36*



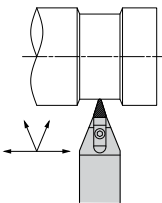
**CVJOR-V  
CVJOL-V**  
Double Ended  
35° Diamond  
*page: GP 37*



**CVVON-V**  
Double Ended  
35° Diamond  
*page: GP 37*

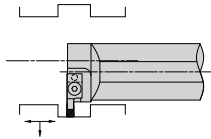


**VJOR-V  
VJOL-V**  
Single Ended  
35° Diamond  
*page: GP 38*

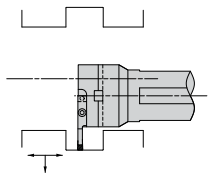


**VVON-V**  
Single Ended  
35° Diamond  
*page: GP 38*

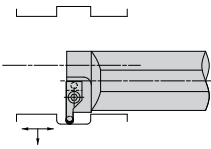
**Grooving, Profiling,  
and Cut-Off Bars**



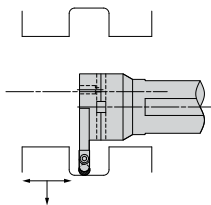
**Cut-Off  
Grooving Bar**  
*page: GP 39*



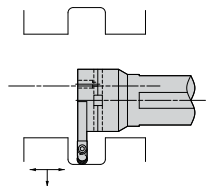
**Cut-Off  
Grooving  
Support Blade**  
For Single-Ended,  
V-Bottom Inserts  
*page: GP 40*



**Profiling Bar**  
Round V-Bottom Insert  
Milled Nest  
*page: GP 41*

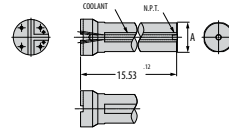


**Profiling Support  
Blade**  
Round V-Bottom Insert  
Milled Nest  
*page: GP 42*

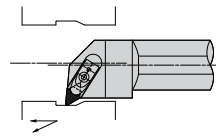


**Profiling Support  
Blade**  
Round V-Bottom Insert  
Replaceable Nest  
*page: GP 43*

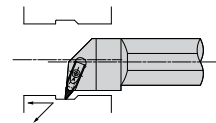
**Grooving, Profiling,  
and Cut-Off Bars *continued***



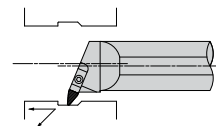
**Shank Options**  
For Bolt-On  
Support Blades  
*page: GP 44*



**Profiling Bar**  
Double Ended  
55° Diamond  
*page: GP 45*



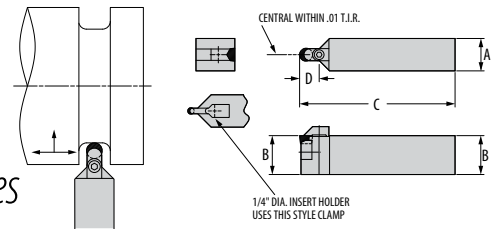
**Profiling Bar**  
Double Ended  
35° Diamond  
*page: GP 45*



**Profiling Bar**  
Single Ended  
35° Diamond  
*page: GP 46*

# CRDPN-VS Toolholder

Round V-Bottom Insert / Replaceable Nest / Shallow D.O.C. (D) Series



Part Number	Gage Inserts	D.O.C.	Dimensions (inches)				Standard Components				*Tune-Up Kit
		D	A	B	C	Nest	Nest Screw	Clamp	Clamp Screw	Includes all Standard Components	
CRDPN-162VS	** RPGN-2V	0.375	1.000	1.000	6.000	410631	#3-48 x 3/8 B.H.C.S	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00524	
CRDPN-202VS	** RPGN-2V	0.375	1.250	1.250	6.000	410631	#3-48 x 3/8 B.H.C.S	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00524	
CRDPN-242VS	** RPGN-2V	0.375	1.500	1.500	8.000	410631	#3-48 x 3/8 B.H.C.S	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00524	
CRDPN-163VS	** RPGN-3V	0.562	1.000	1.000	6.000	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525	
CRDPN-203VS	** RPGN-3V	0.562	1.250	1.250	6.000	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525	
CRDPN-243VS	** RPGN-3V	0.562	1.500	1.500	8.000	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525	
CRDPN-164VS	** RPGN-4V	0.750	1.000	1.000	6.000	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526	
CRDPN-204VS	** RPGN-4V	0.750	1.250	1.250	6.000	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526	
CRDPN-244VS	** RPGN-4V	0.750	1.500	1.500	8.000	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526	

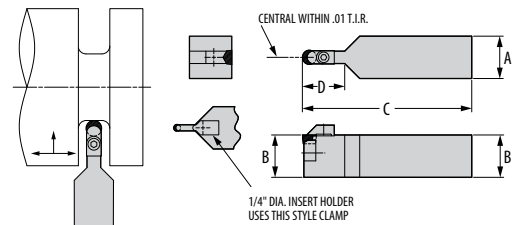
NOTE: See page GP 14 for ceramic and carbide inserts.

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

\*\* RCGN can be used in place of RPGN.

# CRDPN-V Toolholder

Round V-Bottom Insert / Replaceable Nest / Deep D.O.C. (D) Series



Part Number	Gage Inserts	D.O.C.	Dimensions (inches)				Standard Components				*Tune-Up Kit
		D	A	B	C	Nest	Nest Screw	Clamp	Clamp Screw	Includes all Standard Components	
CRDPN-162V	** RPGN-2V	0.750	1.000	1.000	6.000	410631	#3-48 x 3/8 B.H.C.S	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00524	
CRDPN-202V	** RPGN-2V	0.750	1.250	1.250	6.000	410631	#3-48 x 3/8 B.H.C.S	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00524	
CRDPN-242V	** RPGN-2V	0.750	1.500	1.500	8.000	410631	#3-48 x 3/8 B.H.C.S	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00524	
CRDPN-163V	** RPGN-3V	1.125	1.000	1.000	6.000	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525	
CRDPN-203V	** RPGN-3V	1.125	1.250	1.250	6.000	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525	
CRDPN-243V	** RPGN-3V	1.125	1.500	1.500	8.000	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525	
CRDPN-164V	** RPGN-4V	1.500	1.000	1.000	6.000	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526	
CRDPN-204V	** RPGN-4V	1.500	1.250	1.250	6.000	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526	
CRDPN-244V	** RPGN-4V	1.500	1.500	1.500	8.000	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526	

NOTE: See page GP 14 for ceramic and carbide inserts.

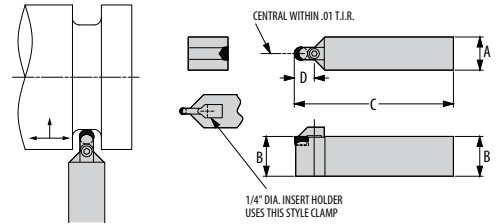
\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

\*\* RCGN can be used in place of RPGN.

GROOVING, PROFILING, and CUT-OFF

# CRDPN-VMS Toolholder

Round V-Bottom Insert / Milled Nest / Shallow D.O.C. (D) Series



Part Number	Gage Inserts	D.O.C.	Dimensions (inches)				Standard Components		*Tune-Up Kit	Opt. Component
			D	A	B	C	Clamp	Clamp Screw		
CRDPN-162VS	** RPGN-2V	0.375	1.000	1.000	6.000	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00803	PT-542T	
CRDPN-202VS	** RPGN-2V	0.375	1.250	1.250	6.000	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00803	PT-542T	
CRDPN-242VS	** RPGN-2V	0.375	1.500	1.500	8.000	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00803	PT-542T	
CRDPN-163VS	** RPGN-3V	0.562	1.000	1.000	6.000	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T	
CRDPN-203VS	** RPGN-3V	0.562	1.250	1.250	6.000	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T	
CRDPN-243VS	** RPGN-3V	0.562	1.500	1.500	8.000	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T	
CRDPN-164VS	** RPGN-4V	0.750	1.000	1.000	6.000	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018	
CRDPN-204VS	** RPGN-4V	0.750	1.250	1.250	6.000	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018	
CRDPN-244VS	** RPGN-4V	0.750	1.500	1.500	8.000	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018	

NOTE: See page GP 14 for ceramic and carbide inserts.

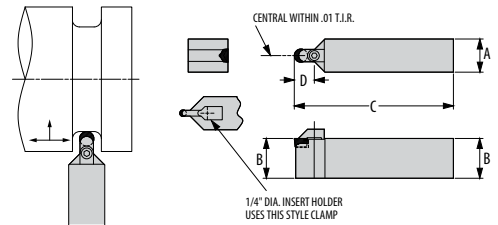
NOTE: Use carbide inserts RCGT and RPGT with optional insert screw for finishing.

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

\*\* RCGN can be used in place of RPGN.

# CRDPN-VM Toolholder

Round V-Bottom Insert / Milled Nest / Deep D.O.C. (D) Series



Part Number	Gage Inserts	D.O.C.	Dimensions (inches)				Standard Components		*Tune-Up Kit	Opt. Component
			D	A	B	C	Clamp	Clamp Screw		
CRDPN-162VM	** RPGN-2V	0.750	1.000	1.000	6.000	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00803	PT-542T	
CRDPN-202VM	** RPGN-2V	0.750	1.250	1.250	6.000	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00803	PT-542T	
CRDPN-242VM	** RPGN-2V	0.750	1.500	1.500	8.000	411910-250VRC	1/4-20 x 3/4 B.H.C.S.	TK-00803	PT-542T	
CRDPN-163VM	** RPGN-3V	1.125	1.000	1.000	6.000	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T	
CRDPN-203VM	** RPGN-3V	1.125	1.250	1.250	6.000	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T	
CRDPN-243VM	** RPGN-3V	1.125	1.500	1.500	8.000	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T	
CRDPN-164VM	** RPGN-4V	1.500	1.000	1.000	6.000	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018	
CRDPN-204VM	** RPGN-4V	1.500	1.250	1.250	6.000	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018	
CRDPN-244VM	** RPGN-4V	1.500	1.500	1.500	8.000	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018	

NOTE: See page GP 14 for ceramic and carbide inserts.

NOTE: Use carbide inserts RCGT and RPGT with optional insert screw for finishing.

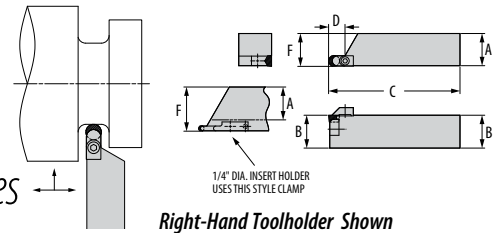
\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

\*\* RCGN can be used in place of RPGN.

GROOVING, PROFILING, and CUT-OFF

# O.D. Grooving/Profiling Toolholder

Round V-Bottom Insert / Replaceable Nest / Shallow D.O.C. (D) Series



Right-Hand Toolholder Shown

Part Number		Gage	D.O.C.	Dimensions (inches)				Standard Components				*Tune-Up Kit
Right	Left	Inserts	D	A†	B	C	F	Nest	Nest Screw	Clamp	Clamp Screw	Includes all Standard Components
415419-2VRS	-	** RPN-2V	0.375	1.000	1.000	6.000	1.500	410631	#3-48 x 3/8 B.H.C.S.	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00590
-	415420-2VRS	** RPN-2V	0.375	1.000	1.000	6.000	1.500	410631	#3-48 x 3/8 B.H.C.S.	411906-250VRC	1/4-20 x 1 S.H.C.S.	TK-00591
415421-2VRS	-	** RPN-2V	0.375	1.250	1.250	6.000	1.750	410631	#3-48 x 3/8 B.H.C.S.	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00590
-	415422-2VRS	** RPN-2V	0.375	1.250	1.250	6.000	1.750	410631	#3-48 x 3/8 B.H.C.S.	411906-250VRC	1/4-20 x 1 S.H.C.S.	TK-00591
415423-2VRS	-	** RPN-2V	0.375	1.500	1.500	8.000	2.000	410631	#3-48 x 3/8 B.H.C.S.	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00590
-	415424-2VRS	** RPN-2V	0.375	1.500	1.500	8.000	2.000	410631	#3-48 x 3/8 B.H.C.S.	411906-250VRC	1/4-20 x 1 S.H.C.S.	TK-00591
415427-3VRS	415428-3VRS	** RPN-3V	0.562	1.000	1.000	6.000	1.000	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525
415429-3VRS	415430-3VRS	** RPN-3V	0.562	1.250	1.250	6.000	1.250	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525
415431-3VRS	415432-3VRS	** RPN-3V	0.562	1.500	1.500	8.000	1.500	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525
415435-4VRS	415436-4VRS	** RPN-4V	0.750	1.000	1.000	6.000	1.000	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526
415437-4VRS	415438-4VRS	** RPN-4V	0.750	1.250	1.250	6.000	1.250	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526
415439-4VRS	415440-4VRS	** RPN-4V	0.750	1.500	1.500	8.000	1.500	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526

NOTE: See page GP 14 for ceramic and carbide inserts.

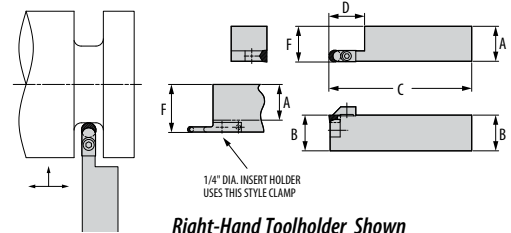
† "A" indicates width of shank available for clamping, (not necessarily overall shank width).

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

\*\* RCGN can be used in place of RPN.

# O.D. Grooving/Profiling Toolholder

Round V-Bottom Insert / Replaceable Nest / Deep D.O.C. (D) Series



Right-Hand Toolholder Shown

Part Number		Gage	D.O.C.	Dimensions (inches)				Standard Components				*Tune-Up Kit
Right	Left	Inserts	D	A†	B	C	F	Nest	Nest Screw	Clamp	Clamp Screw	Includes all Standard Components
411149-2VRS	-	** RPN-2V	0.750	1.000	1.000	6.000	1.500	410631	#3-48 x 3/8 B.H.C.S.	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00590
-	411150-2VRS	** RPN-2V	0.750	1.000	1.000	6.000	1.500	410631	#3-48 x 3/8 B.H.C.S.	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00591
411151-2VRS	-	** RPN-2V	0.750	1.250	1.250	6.000	1.750	410631	#3-48 x 3/8 B.H.C.S.	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00590
-	411956-2VRS	** RPN-2V	0.750	1.250	1.250	6.000	1.750	410631	#3-48 x 3/8 B.H.C.S.	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00591
411957-2VRS	-	** RPN-2V	0.750	1.500	1.500	8.000	2.000	410631	#3-48 x 3/8 B.H.C.S.	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00590
-	411958-2VRS	** RPN-2V	0.750	1.500	1.500	8.000	2.000	410631	#3-48 x 3/8 B.H.C.S.	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00591
411157-3VRS	411158-3VRS	** RPN-3V	1.125	1.000	1.000	6.000	1.000	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525
411159-3VRS	411160-3VRS	** RPN-3V	1.125	1.250	1.250	6.000	1.250	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525
411161-3VRS	411162-3VRS	** RPN-3V	1.125	1.500	1.500	8.000	1.500	413970	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00525
411165-4VRS	411166-4VRS	** RPN-4V	1.500	1.000	1.000	6.000	1.000	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526
411167-4VRS	411168-4VRS	** RPN-4V	1.500	1.250	1.250	6.000	1.250	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526
411169-4VRS	411170-4VRS	** RPN-4V	1.500	1.500	1.500	8.000	1.500	414007	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00526

NOTE: See page GP 14 for ceramic and carbide inserts.

† "A" indicates width of shank available for clamping, (not necessarily overall shank width).

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

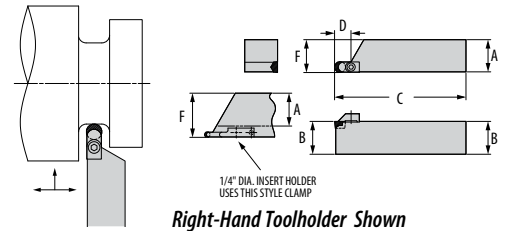
\*\* RCGN can be used in place of RPN.



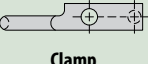

GROOVING, PROFILING, and CUT-OFF



# O.D. Grooving/Profiling Toolholder

## Round V-Bottom Insert / Milled Nest / Shallow D.O.C. (D) Series

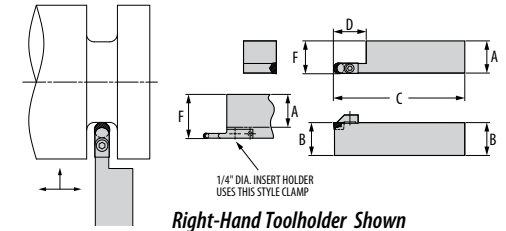




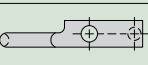

Part Number		Gage 	D.O.C. D	Dimensions (inches)				Standard Components		*Tune-Up Kit Includes all Standard Components	Opt. Component 
Right	Left			A†	B	C	F				
421450-2VMRS	—	** RPGN-2V	0.375	1.000	1.000	6.000	1.500	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00765	PT-542T
—	421451-2VMRS	** RPGN-2V	0.375	1.000	1.000	6.000	1.500	411906-250VRC	1/4-20 x 1 S.H.C.S.	TK-00799	PT-542T
421452-2VMRS	—	** RPGN-2V	0.375	1.250	1.250	6.000	1.750	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00765	PT-542T
—	421453-2VMRS	** RPGN-2V	0.375	1.250	1.250	6.000	1.750	411906-250VRC	1/4-20 x 1 S.H.C.S.	TK-00799	PT-542T
421454-2VMRS	—	** RPGN-2V	0.375	1.500	1.500	8.000	2.000	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00765	PT-542T
—	421455-2VMRS	** RPGN-2V	0.375	1.500	1.500	8.000	2.000	411906-250VRC	1/4-20 x 1 S.H.C.S.	TK-00799	PT-542T
421458-3VMRS	421459-3VMRS	** RPGN-3V	0.562	1.000	1.000	6.000	1.000	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T
421460-3VMRS	421461-3VMRS	** RPGN-3V	0.562	1.250	1.250	6.000	1.250	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T
421462-3VMRS	421463-3VMRS	** RPGN-3V	0.562	1.500	1.500	8.000	1.500	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T
421466-4VMRS	421467-4VMRS	** RPGN-4V	0.750	1.000	1.000	6.000	1.000	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018
421468-4VMRS	421469-4VMRS	** RPGN-4V	0.750	1.250	1.250	6.000	1.250	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018
421470-4VMRS	421471-4VMRS	** RPGN-4V	0.750	1.500	1.500	8.000	1.500	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018

NOTE: See page GP 14 for ceramic and carbide inserts.  
 NOTE: Use carbide inserts RCGT and RPGT with optional insert screw for finishing.  
 † "A" indicates width of shank available for clamping, (not necessarily overall shank width).  
 \* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.  
 \*\* RCGN can be used in place of RPGN.

# O.D. Grooving/Profiling Toolholder

## Round V-Bottom Insert / Milled Nest / Deep D.O.C. (D) Series



Part Number		Gage 	D.O.C. D	Dimensions (inches)				Standard Components		*Tune-Up Kit Includes all Standard Components	Opt. Component 
Right	Left			A†	B	C	F				
421498-2VMRS	—	** RPGN-2V	0.750	1.000	1.000	6.000	1.500	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00765	PT-542T
—	421499-2VMRS	** RPGN-2V	0.750	1.000	1.000	6.000	1.500	411906-250VRC	1/4-20 x 1 S.H.C.S.	TK-00799	PT-542T
421500-2VMRS	—	** RPGN-2V	0.750	1.250	1.250	6.000	1.750	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00765	PT-542T
—	421501-2VMRS	** RPGN-2V	0.750	1.250	1.250	6.000	1.750	411906-250VRC	1/4-20 x 1 S.H.C.S.	TK-00799	PT-542T
421502-2VMRS	—	** RPGN-2V	0.750	1.500	1.500	8.000	2.000	411905-250VRC	1/4-20 x 1 S.H.C.S.	TK-00765	PT-542T
—	421503-2VMRS	** RPGN-2V	0.750	1.500	1.500	8.000	2.000	411906-250VRC	1/4-20 x 1 S.H.C.S.	TK-00799	PT-542T
421504-3VMRS	421505-3VMRS	** RPGN-3V	1.125	1.000	1.000	6.000	1.000	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T
421506-3VMRS	421507-3VMRS	** RPGN-3V	1.125	1.250	1.250	6.000	1.250	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T
421508-3VMRS	421509-3VMRS	** RPGN-3V	1.125	1.500	1.500	8.000	1.500	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T
421510-4VMRS	421511-4VMRS	** RPGN-4V	1.500	1.000	1.000	6.000	1.000	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018
421512-4VMRS	421513-4VMRS	** RPGN-4V	1.500	1.250	1.250	6.000	1.250	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018
421514-4VMRS	421515-4VMRS	** RPGN-4V	1.500	1.500	1.500	8.000	1.500	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018

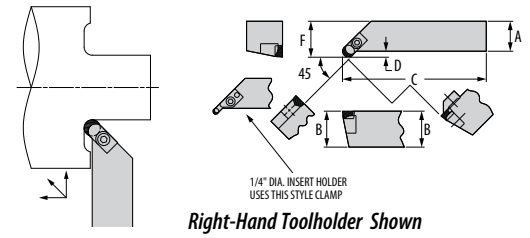
NOTE: See page GP 14 for ceramic and carbide inserts.  
 NOTE: Use carbide inserts RCGT and RPGT with optional insert screw for finishing.  
 † "A" indicates width of shank available for clamping, (not necessarily overall shank width).  
 \* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.  
 \*\* RCGN can be used in place of RPGN.

GROOVING, PROFILING, and CUT-OFF



# CRGPR-V/CRGPL-V

45° Grooving/Profiling Toolholder  
Round V-Bottom Insert; Replaceable Nest



Right-Hand Toolholder Shown

Part Number		Gage	D.O.C.	Dimensions (inches)				Standard Components				*Tune-Up Kit
Right	Left	Inserts	D	A†	B	C	F	Nest	Nest Screw	Clamp	Clamp Screw	Includes all Standard Components
CRGPR-162V	—	** RPGN-2V	0.250	1.000	1.000	6.000	1.250	411108	#3-48 x 3/8 B.H.C.S.	412131-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00530
—	CRGPL-162V	** RPGN-2V	0.250	1.000	1.000	6.000	1.250	411108	#3-48 x 3/8 B.H.C.S.	412132-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00527
CRGPR-202V	—	** RPGN-2V	0.250	1.250	1.250	6.000	1.500	411108	#3-48 x 3/8 B.H.C.S.	412131-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00530
—	CRGPL-202V	** RPGN-2V	0.250	1.250	1.250	6.000	1.500	411108	#3-48 x 3/8 B.H.C.S.	412132-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00527
CRGPR-242V	—	** RPGN-2V	0.250	1.500	1.500	8.000	1.750	411108	#3-48 x 3/8 B.H.C.S.	412131-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00530
—	CRGPL-242V	** RPGN-2V	0.250	1.500	1.500	8.000	1.750	411108	#3-48 x 3/8 B.H.C.S.	412132-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00527
CRGPR-163V	CRGPL-163V	** RPGN-3V	0.250	1.000	1.000	6.000	1.250	414009	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00528
CRGPR-203V	CRGPL-203V	** RPGN-3V	0.250	1.250	1.250	6.000	1.500	414009	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00528
CRGPR-243V	CRGPL-243V	** RPGN-3V	0.250	1.500	1.500	8.000	1.750	414009	#6-32 x 1/2 B.H.C.S.	308063	#10-32 x 1/2 S.H.C.S.	TK-00528
CRGPR-164V	CRGPL-164V	** RPGN-4V	0.250	1.000	1.000	6.000	1.250	414008	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00529
CRGPR-204V	CRGPL-204V	** RPGN-4V	0.250	1.250	1.250	6.000	1.500	414008	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00529
CRGPR-244V	CRGPL-244V	** RPGN-4V	0.250	1.500	1.500	8.000	1.750	414008	#10-32 x 5/8 B.H.C.S.	308136	1/4-20 x 5/8 S.H.C.S.	TK-00529

NOTE: See page GP 14 for ceramic and carbide inserts.

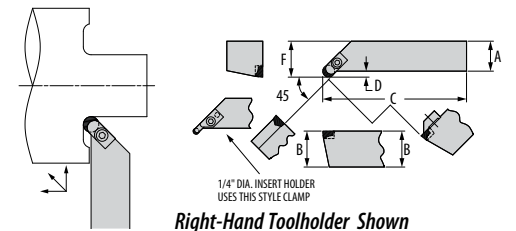
† "A" indicates width of shank available for clamping, (not necessarily overall shank width).

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

\*\* RCGN can be used in place of RPGN.

# CRGPR-VM/CRGPL-VM

45° Grooving/Profiling Toolholder  
Round V-Bottom Insert; Milled Nest



Right-Hand Toolholder Shown

Part Number		Gage	D.O.C.	Dimensions (inches)				Standard Components		*Tune-Up Kit	Optional Component
Right	Left	Inserts	D	A†	B	C	F	Clamp	Clamp Screw	Includes all Standard Components	Insert Screw
CRGPR-162VM	—	** RPGN-2V	0.250	1.000	1.000	6.000	1.250	412131-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00795	PT-542T
—	CRGPL-162VM	** RPGN-2V	0.250	1.000	1.000	6.000	1.250	412132-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00836	PT-542T
CRGPR-202VM	—	** RPGN-2V	0.250	1.250	1.250	6.000	1.500	412131-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00795	PT-542T
—	CRGPL-202VM	** RPGN-2V	0.250	1.250	1.250	6.000	1.500	412132-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00836	PT-542T
CRGPR-242VM	—	** RPGN-2V	0.250	1.500	1.500	8.000	1.750	412131-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00795	PT-542T
—	CRGPL-242VM	** RPGN-2V	0.250	1.500	1.500	8.000	1.750	412132-250GC	1/4-20 x 3/4 S.H.C.S.	TK-00836	PT-542T
CRGPR-163VM	CRGPL-163VM	** RPGN-3V	0.250	1.000	1.000	6.000	1.250	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T
CRGPR-203VM	CRGPL-203VM	** RPGN-3V	0.250	1.250	1.250	6.000	1.500	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T
CRGPR-243VM	CRGPL-243VM	** RPGN-3V	0.250	1.500	1.500	8.000	1.750	308063	#10-32 x 1/2 S.H.C.S.	TK-00764	PT-545T
CRGPR-164VM	CRGPL-164VM	** RPGN-4V	0.250	1.000	1.000	6.000	1.250	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018
CRGPR-204VM	CRGPL-204VM	** RPGN-4V	0.250	1.250	1.250	6.000	1.500	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018
CRGPR-244VM	CRGPL-244VM	** RPGN-4V	0.250	1.500	1.500	8.000	1.750	308136	1/4-20 x 3/4 S.H.C.S.	TK-00763	CO-5018

NOTE: See page GP 14 for ceramic and carbide inserts.

NOTE: Use carbide inserts RCGT and RPGT with optional insert screw for finishing.

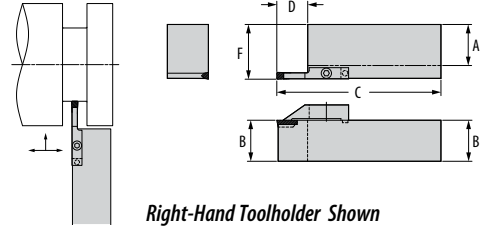
† "A" indicates width of shank available for clamping, (not necessarily overall shank width).

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

\*\* RCGN can be used in place of RPGN.

# Grooving/Profiling/Cut-Off Toolholder

Deep D.O.C. Series



Right-Hand Toolholder Shown

Part Number		Groove Width	D.O.C.	Dimensions (inches)				Standard Components		*Tune-Up Kit	Optional Components	
Right	Left		D	A†	B	C	F	Insert	Clamp	Includes all Standard Components	Insert	Clamp
427635-094VGS	—	0.094	0.750	1.000	1.000	6.000	1.500	WGC-4094 WG-4094	427651-094GC	TK-00881	COS-4094-0 COS-4094-4L COS-4094-4R	429524-094GC
—	427636-094VGS	0.094	0.750	1.000	1.000	6.000	1.500		427652-094GC	TK-00882		429525-094GC
427637-094VGS	—	0.094	0.750	1.250	1.250	6.000	1.750		427651-094GC	TK-00881		429524-094GC
—	427638-094VGS	0.094	0.750	1.250	1.250	6.000	1.750		427652-094GC	TK-00882		429525-094GC
427639-094VGS	—	0.094	0.750	1.500	1.500	8.000	2.000		427651-094GC	TK-00881		429524-094GC
—	427640-094VGS	0.094	0.750	1.500	1.500	8.000	2.000		427652-094GC	TK-00882		429525-094GC
411173-125VGS	—	0.125	0.750	1.000	1.000	6.000	1.500	WGC-4125	411966-125GC	TK-00592	GTS-4125	429512-125GC
—	411961-125VGS	0.125	0.750	1.000	1.000	6.000	1.500		411967-125GC	TK-00596		429513-125GC
411250-125VGS	—	0.125	0.750	1.250	1.250	6.000	1.750	WG-4125	411966-125GC	TK-00592	COS-4125-0	429512-125GC
—	411251-125VGS	0.125	0.750	1.250	1.250	6.000	1.750	GTS-4125-1	411967-125GC	TK-00596	COS-4125-4L	429513-125GC
411962-125VGS	—	0.125	0.750	1.500	1.500	8.000	2.000	GTS-4125-2	411966-125GC	TK-00592	COS-4125-4R	429512-125GC
—	411963-125VGS	0.125	0.750	1.500	1.500	8.000	2.000		411967-125GC	TK-00596		429513-125GC
411964-156VGS	—	0.156	0.750	1.000	1.000	6.000	1.500	WGC-4156 WG-4156	411968-156GC	TK-00580	GTS-4156	436373-156GC
—	411965-156VGS	0.156	0.750	1.000	1.000	6.000	1.500		411969-156GC	TK-00597		436374-156GC
411256-156VGS	—	0.156	0.750	1.250	1.250	6.000	1.750		411968-156GC	TK-00580		436373-156GC
—	411257-156VGS	0.156	0.750	1.250	1.250	6.000	1.750		411969-156GC	TK-00597		436374-156GC
411258-156VGS	—	0.156	0.750	1.500	1.500	8.000	2.000		411968-156GC	TK-00580		436373-156GC
—	411259-156VGS	0.156	0.750	1.500	1.500	8.000	2.000		411969-156GC	TK-00597		436374-156GC
411970-187VGS	—	0.187	0.750	1.000	1.000	6.000	1.500	WGC-4187	411977-187GC	TK-00581	GTS-4187	429518-187GC
—	411178-187VGS	0.187	0.750	1.000	1.000	6.000	1.500		411978-187GC	TK-00593		429519-187GC
411262-187VGS	—	0.187	0.750	1.250	1.250	6.000	1.750	WG-4187	411977-187GC	TK-00581	COS-4187-0	429518-187GC
—	411263-187VGS	0.187	0.750	1.250	1.250	6.000	1.750	GTS-4187-1	411978-187GC	TK-00593	COS-4187-4L	429519-187GC
411971-187VGS	—	0.187	0.750	1.500	1.500	8.000	2.000	GTS-4187-2	411977-187GC	TK-00581	COS-4187-4R	429518-187GC
—	411972-187VGS	0.187	0.750	1.500	1.500	8.000	2.000		411978-187GC	TK-00593		429519-187GC
411179-218VGS	—	0.218	1.125	1.000	1.000	6.000	1.500	WGC-6218 WG-6218	411979-218GC	TK-00582	—	—
—	411180-218VGS	0.218	1.125	1.000	1.000	6.000	1.500		411130-218GC	TK-00583		—
411268-218VGS	—	0.218	1.125	1.250	1.250	6.000	1.750		411979-218GC	TK-00582		—
—	411269-218VGS	0.218	1.125	1.250	1.250	6.000	1.750		411130-218GC	TK-00583		—
411270-218VGS	—	0.218	1.125	1.500	1.500	8.000	2.000		411979-218GC	TK-00582		—
—	411271-218VGS	0.218	1.125	1.500	1.500	8.000	2.000		411130-218GC	TK-00583		—

† "A" indicates width of shank available for clamping, (not necessarily overall shank width).

\* All toolholders include standard clamp and 1/4-20 x 1 SHCS.

GTS is Greenleaf's groove/turn system insert with chip control. Page GP 09.

COS is Greenleaf's cut-off system insert. Page GP 08.

WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.

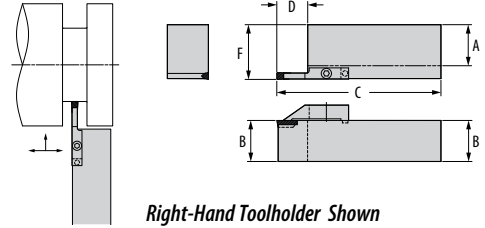
WGC is Greenleaf's flat-top groover with a 6° nose clearance. Pages GP 12 and GP 13.

Continued on next page.

GROOVING, PROFILING, and CUT-OFF

# Grooving/Profiling/Cut-Off Toolholder

Deep D.O.C. Series (Continued)



Part Number		Groove Width	D.O.C.	Dimensions (inches)				Standard Components		*Tune-Up Kit	Optional Components	
Right	Left			D	A†	B	C	F	Insert		Clamp	Insert
411973-250VGS	–	0.250	1.125	1.000	1.000	6.000	1.500	WGC-6250	411980-250GC	TK-00617	–	–
–	411974-250VGS	0.250	1.125	1.000	1.000	6.000	1.500				WG-6250	411981-250GC
411975-250VGS	–	0.250	1.125	1.250	1.250	6.000	1.750	GTS-6250	411980-250GC	TK-00617	–	–
–	411275-250VGS	0.250	1.125	1.250	1.250	6.000	1.750				GTS-6250-1	411981-250GC
411276-250VGS	–	0.250	1.125	1.500	1.500	8.000	2.000	GTS-6250-2	411980-250GC	TK-00617	–	–
–	411277-250VGS	0.250	1.125	1.500	1.500	8.000	2.000				411981-250GC	TK-00598
411183-281VGS	–	0.281	1.125	1.000	1.000	6.000	1.500	WGC-6281	411133-281GC	TK-00584	–	–
–	411184-281VGS	0.281	1.125	1.000	1.000	6.000	1.500				WG-6281	411134-281GC
411280-281VGS	–	0.281	1.125	1.250	1.250	6.000	1.750	WGC-6281	411133-281GC	TK-00584	–	–
–	411281-281VGS	0.281	1.125	1.250	1.250	6.000	1.750				WG-6281	411134-281GC
411282-281VGS	–	0.281	1.125	1.500	1.500	8.000	2.000	WGC-6281	411133-281GC	TK-00584	–	–
–	411283-281VGS	0.281	1.125	1.500	1.500	8.000	2.000				WG-6281	411134-281GC
411982-312VGS	–	0.312	1.500	1.000	1.000	6.000	1.500	WGC-8312	411985-312GC	TK-00586	–	–
–	411186-312VGS	0.312	1.500	1.000	1.000	6.000	1.500				WG-8312	411136-312GC
411286-312VGS	–	0.312	1.500	1.250	1.250	6.000	1.750	WGC-8312	411985-312GC	TK-00586	–	–
–	411287-312VGS	0.312	1.500	1.250	1.250	6.000	1.750				WG-8312	411136-312GC
411288-312VGS	–	0.312	1.500	1.500	1.500	8.000	2.000	WGC-8312	411985-312GC	TK-00586	–	–
–	411289-312VGS	0.312	1.500	1.500	1.500	8.000	2.000				WG-8312	411136-312GC
411187-344VGS	–	0.344	1.500	1.000	1.000	6.000	1.500	WGC-8344	411137-344GC	TK-00594	–	–
–	411188-344VGS	0.344	1.500	1.000	1.000	6.000	1.500				WG-8344	411138-344GC
411292-344VGS	–	0.344	1.500	1.250	1.250	6.000	1.750	WGC-8344	411137-344GC	TK-00594	–	–
–	411293-344VGS	0.344	1.500	1.250	1.250	6.000	1.750				WG-8344	411138-344GC
411294-344VGS	–	0.344	1.500	1.500	1.500	8.000	2.000	WGC-8344	411137-344GC	TK-00594	–	–
–	411295-344VGS	0.344	1.500	1.500	1.500	8.000	2.000				WG-8344	411138-344GC
411189-375VGS	–	0.375	1.500	1.000	1.000	6.000	1.500	WGC-8375	411986-375GC	TK-00595	–	–
–	411190-375VGS	0.375	1.500	1.000	1.000	6.000	1.500				WG-8375	411987-375GC
411983-375VGS	–	0.375	1.500	1.250	1.250	6.000	1.750	WGC-8375	411986-375GC	TK-00595	–	–
–	411984-375VGS	0.375	1.500	1.250	1.250	6.000	1.750				WG-8375	411987-375GC
411300-375VGS	–	0.375	1.500	1.500	1.500	8.000	2.000	WGC-8375	411986-375GC	TK-00595	–	–
–	411301-375VGS	0.375	1.500	1.500	1.500	8.000	2.000				WG-8375	411987-375GC

† "A" indicates width of shank available for clamping, (not necessarily overall shank width).

\* All toolholders include standard clamp and 1/4-20 x 1 SHCS.

GTS is Greenleaf's groove/turn system insert with chip control. Page GP 09.

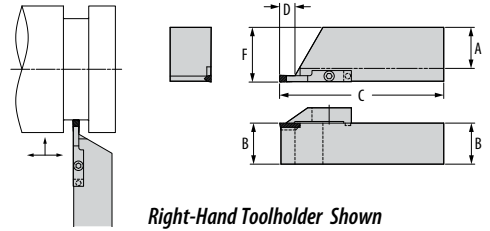
COS is Greenleaf's cut-off system insert. Page GP 08.

WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.

WGC is Greenleaf's flat-top groover with a 6° nose clearance. Pages GP 12 and GP 13.

# Grooving/Profiling/Cut-Off Toolholder

## Shallow D.O.C. Series



Part Number		Groove Width	D.O.C.		Dimensions (inches)				Standard Components		*Tune-Up Kit	Optional Components			
Right	Left		D	A†	B	C	F	Insert	Clamp	Includes all Standard Components	Insert	Clamp			
427641-094VGS	—	0.094	0.375	1.000	1.000	6.000	1.500	WG-4094	427651-094GC	TK-00881	COS-4094-0	429524-094GC			
—	427642-094VGS	0.094	0.375	1.000	1.000	6.000	1.500					427652-094GC	TK-00882	429525-094GC	
427643-094VGS	—	0.094	0.375	1.250	1.250	6.000	1.750					427651-094GC	TK-00881	COS-4094-4L	429524-094GC
—	427644-094VGS	0.094	0.375	1.250	1.250	6.000	1.750					427652-094GC	TK-00882	COS-4094-4R	429525-094GC
427645-094VGS	—	0.094	0.375	1.500	1.500	8.000	2.000					427651-094GC	TK-00881	—	429524-094GC
—	427646-094VGS	0.094	0.375	1.500	1.500	8.000	2.000					427652-094GC	TK-00882	—	429525-094GC
415316-125VGS	—	0.125	0.375	1.000	1.000	6.000	1.500	GTS-4125-1	411966-125GC	TK-00592	GTS-4125	429512-125GC			
—	415317-125VGS	0.125	0.375	1.000	1.000	6.000	1.500		411967-125GC	TK-00596		429513-125GC			
415318-125VGS	—	0.125	0.375	1.250	1.250	6.000	1.750	GTS-4125-2	411966-125GC	TK-00592	COS-4125-0	429512-125GC			
—	415319-125VGS	0.125	0.375	1.250	1.250	6.000	1.750	WG-4125	411967-125GC	TK-00592	COS-4125-4L	429513-125GC			
415320-125VGS	—	0.125	0.375	1.500	1.500	8.000	2.000	WGC-4125	411966-125GC	TK-00596	COS-4125-4R	429512-125GC			
—	415321-125VGS	0.125	0.375	1.500	1.500	8.000	2.000		411967-125GC	TK-00596		429513-125GC			
415324-156VGS	—	0.156	0.375	1.000	1.000	6.000	1.500	WG-4156	411968-156GC	TK-00580	GTS-4156	436373-156GC			
—	415325-156VGS	0.156	0.375	1.000	1.000	6.000	1.500		411969-156GC	TK-00597		436374-156GC			
415326-156VGS	—	0.156	0.375	1.250	1.250	6.000	1.750		411968-156GC	TK-00580		436373-156GC			
—	415327-156VGS	0.156	0.375	1.250	1.250	6.000	1.750		411969-156GC	TK-00597		436374-156GC			
415328-156VGS	—	0.156	0.375	1.500	1.500	8.000	2.000		411968-156GC	TK-00580		436373-156GC			
—	415329-156VGS	0.156	0.375	1.500	1.500	8.000	2.000		411969-156GC	TK-00597		436374-156GC			
415332-187VGS	—	0.187	0.375	1.000	1.000	6.000	1.500	GTS-4187-1	411977-187GC	TK-00581	GTS-4187	429518-187GC			
—	415333-187VGS	0.187	0.375	1.000	1.000	6.000	1.500		411978-187GC	TK-00593		429519-187GC			
415334-187VGS	—	0.187	0.375	1.250	1.250	6.000	1.750	GTS-4187-2	411977-187GC	TK-00581	COS-4187-0	429519-187GC			
—	415335-187VGS	0.187	0.375	1.250	1.250	6.000	1.750	WG-4187	411978-187GC	TK-00593	COS-4187-4L	429518-187GC			
415336-187VGS	—	0.187	0.375	1.500	1.500	8.000	2.000	WGC-4187	411977-187GC	TK-00581	COS-4187-4R	429519-187GC			
—	415337-187VGS	0.187	0.375	1.500	1.500	8.000	2.000		411978-187GC	TK-00593		429518-187GC			
415340-218VGS	—	0.218	0.562	1.000	1.000	6.000	1.500	WG-6218	411979-218GC	TK-00582	—	—			
—	415341-218VGS	0.218	0.562	1.000	1.000	6.000	1.500		411130-218GC	TK-00583		—			
415342-218VGS	—	0.218	0.562	1.250	1.250	6.000	1.750		411979-218GC	TK-00582		—			
—	415343-218VGS	0.218	0.562	1.250	1.250	6.000	1.750		411130-218GC	TK-00583		—			
415344-218VGS	—	0.218	0.562	1.500	1.500	8.000	2.000		411979-218GC	TK-00582		—			
—	415345-218VGS	0.218	0.562	1.500	1.500	8.000	2.000		411130-218GC	TK-00583		—			

† "A" indicates width of shank available for clamping, (not necessarily overall shank width).

\* All toolholders include standard clamp and 1/4-20 x 1 SHCS.

GTS is Greenleaf's groove/turn system insert with chip control. Page GP 09.

COS is Greenleaf's cut-off system insert. Page GP 08.

WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.

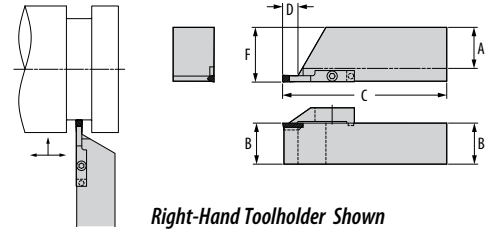
WGC is Greenleaf's flat-top groover with a 6° nose clearance. Pages GP 12 and GP 13.

Continued on next page.

GROOVING, PROFILING, and CUT-OFF

# Grooving/Profiling/Cut-Off Toolholder

Shallow D.O.C. Series (Continued)



Right-Hand Toolholder Shown

Part Number		Groove Width	D.O.C.	Dimensions (inches)				Standard Components		*Tune-Up Kit	Optional Components	
Right	Left			D	A†	B	C	F	Insert		Clamp	Insert
415348-250VGS	–	0.25	0.562	1.000	1.000	6.000	1.500	GTS-6250	411980-250GC	TK-00617	–	–
–	415349-250VGS	0.25	0.562	1.000	1.000	6.000	1.500				GTS-6250-1	411981-250GC
415350-250VGS	–	0.25	0.562	1.250	1.250	6.000	1.750	GTS-6250-2	411980-250GC	TK-00617	–	–
–	415351-250VGS	0.25	0.562	1.250	1.250	6.000	1.750				WG-6250	411981-250GC
415352-250VGS	–	0.25	0.562	1.500	1.500	8.000	2.000	WGC-6250	411980-250GC	TK-00617	–	–
–	415353-250VGS	0.25	0.562	1.500	1.500	8.000	2.000				411981-250GC	TK-00598
415356-281VGS	–	0.281	0.562	1.000	1.000	6.000	1.500	WG-6281	411133-281GC	TK-00584	–	–
–	415357-281VGS	0.281	0.562	1.000	1.000	6.000	1.500				411134-281GC	TK-00585
415358-281VGS	–	0.281	0.562	1.250	1.250	6.000	1.750	WGC-6281	411133-281GC	TK-00584	–	–
–	415359-281VGS	0.281	0.562	1.250	1.250	6.000	1.750				411134-281GC	TK-00585
415360-281VGS	–	0.281	0.562	1.500	1.500	8.000	2.000	WG-8312	411133-281GC	TK-00584	–	–
–	415361-281VGS	0.281	0.562	1.500	1.500	8.000	2.000				411134-281GC	TK-00585
415364-312VGS	–	0.312	0.750	1.000	1.000	6.000	1.500	WG-8312	411985-312GC	TK-00586	–	–
–	415365-312VGS	0.312	0.750	1.000	1.000	6.000	1.500				411136-312GC	TK-00587
415366-312VGS	–	0.312	0.750	1.250	1.250	6.000	1.750	WGC-8312	411985-312GC	TK-00586	–	–
–	415367-312VGS	0.312	0.750	1.250	1.250	6.000	1.750				411136-312GC	TK-00587
415368-312VGS	–	0.312	0.750	1.500	1.500	8.000	2.000	WG-8344	411985-312GC	TK-00586	–	–
–	415369-312VGS	0.312	0.750	1.500	1.500	8.000	2.000				411136-312GC	TK-00587
415372-344VGS	–	0.344	0.750	1.000	1.000	6.000	1.500	WG-8344	411137-344GC	TK-00594	–	–
–	415373-344VGS	0.344	0.750	1.000	1.000	6.000	1.500				411138-344GC	TK-00588
415374-344VGS	–	0.344	0.750	1.250	1.250	6.000	1.750	WGC-8344	411137-344GC	TK-00594	–	–
–	415375-344VGS	0.344	0.750	1.250	1.250	6.000	1.750				411138-344GC	TK-00588
415376-344VGS	–	0.344	0.750	1.500	1.500	8.000	2.000	WG-8375	411137-344GC	TK-00594	–	–
–	415377-344VGS	0.344	0.750	1.500	1.500	8.000	2.000				411138-344GC	TK-00588
415380-375VGS	–	0.375	0.750	1.000	1.000	6.000	1.500	WG-8375	411986-375GC	TK-00595	–	–
–	415381-375VGS	0.375	0.750	1.000	1.000	6.000	1.500				411987-375GC	TK-00589
415382-375VGS	–	0.375	0.750	1.250	1.250	6.000	1.750	WG-8375	411986-375GC	TK-00595	–	–
–	415383-375VGS	0.375	0.750	1.250	1.250	6.000	1.750				411987-375GC	TK-00589
415384-375VGS	–	0.375	0.750	1.500	1.500	8.000	2.000	WG-8375	411986-375GC	TK-00595	–	–
–	415385-375VGS	0.375	0.750	1.500	1.500	8.000	2.000				411987-375GC	TK-00589

† "A" indicates width of shank available for clamping, (not necessarily overall shank width).

\* All toolholders include standard clamp and 1/4-20 x 1 SHCS.

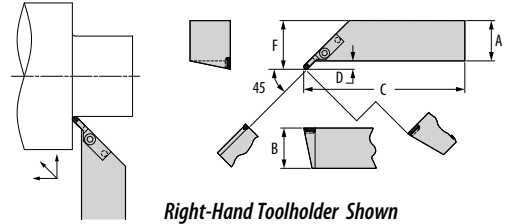
GTS is Greenleaf's groove/turn system insert with chip control. Page GP 09.


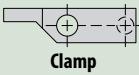

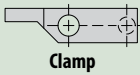
COS is Greenleaf's cut-off system insert. Page GP 08.

WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.

WGC is Greenleaf's flat-top groover with a 6° nose clearance. Pages GP 12 and GP 13.

# 45° Grooving/Profiling Toolholder



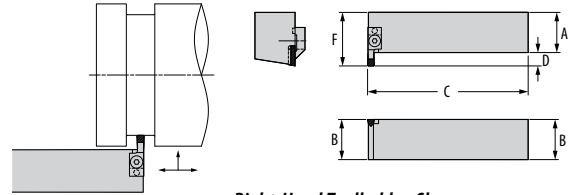
Part Number		Gage 	D.O.C. D	Dimensions (inches)				Std Component 	*Tune-Up Kit Includes all Standard Components	Optional Components	
Right	Left			A	B	C	F				
415293-45VGS	415294-45VGS	GTS-4125-1	0.313	1.000	1.000	6.020	1.332	415305-GC 415306-GC	TK-00618 TK-00709	GTS-4125	429514-GC 429515-GC
		GTS-4125-2	0.313	1.000	1.000	6.013	1.325				
		WG-4125	0.313	1.000	1.000	6.000	1.312				
		WG-4125-1	0.313	1.000	1.000	6.020	1.332				
		WG-4125-2	0.313	1.000	1.000	6.013	1.325				
		WG-4156	0.313	1.000	1.000	6.005	1.317				
		WG-4156-1	0.313	1.000	1.000	6.031	1.343				
WG-4156-2	0.313	1.000	1.000	6.024	1.336						
415295-45VGS	415296-45VGS	GTS-4125-1	0.313	1.250	1.250	6.020	1.582	415305-GC 415306-GC	TK-00618 TK-00709	GTS-4125	429514-GC 429515-GC
		GTS-4125-2	0.313	1.250	1.250	6.013	1.575				
		WG-4125	0.313	1.250	1.250	6.000	1.562				
		WG-4125-1	0.313	1.250	1.250	6.020	1.582				
		WG-4125-2	0.313	1.250	1.250	6.013	1.575				
		WG-4156	0.313	1.250	1.250	6.005	1.567				
		WG-4156-1	0.313	1.250	1.250	6.031	1.593				
WG-4156-2	0.313	1.250	1.250	6.024	1.586						
415297-45VGS	415298-45VGS	GTS-4125-1	0.313	1.500	1.500	8.020	1.832	415305-GC 415306-GC	TK-00618 TK-00709	GTS-4125	429514-GC 429515-GC
		GTS-4125-2	0.313	1.500	1.500	8.013	1.825				
		WG-4125	0.313	1.500	1.500	8.000	1.812				
		WG-4125-1	0.313	1.500	1.500	8.020	1.832				
		WG-4125-2	0.313	1.500	1.500	8.013	1.825				
		WG-4156	0.313	1.500	1.500	8.005	1.817				
		WG-4156-1	0.313	1.500	1.500	8.031	1.843				
WG-4156-2	0.313	1.500	1.500	8.024	1.836						
415299-45VGS	415300-45VGS	GTS-4187-1	0.313	1.000	1.000	6.033	1.345	415307-GC 415308-GC	TK-00619 TK-00708	GTS-4187	429520-GC 429521-GC
		GTS-4187-2	0.313	1.000	1.000	6.026	1.338				
		WG-4187	0.313	1.000	1.000	6.000	1.312				
		WG-4187-1	0.313	1.000	1.000	6.033	1.345				
		WG-4187-2	0.313	1.000	1.000	6.026	1.338				
415301-45VGS	415302-45VGS	GTS-4187-1	0.313	1.250	1.250	6.033	1.595	415307-GC 415308-GC	TK-00619 TK-00708	GTS-4187	429520-GC 429521-GC
		GTS-4187-2	0.313	1.250	1.250	6.026	1.588				
		WG-4187	0.313	1.250	1.250	6.000	1.562				
		WG-4187-1	0.313	1.250	1.250	6.033	1.595				
		WG-4187-2	0.313	1.250	1.250	6.026	1.588				
415303-45VGS	415304-45VGS	GTS-4187-1	0.313	1.500	1.500	8.033	1.845	415307-GC 415308-GC	TK-00619 TK-00708	GTS-4187	429520-GC 429521-GC
		GTS-4187-2	0.313	1.500	1.500	8.026	1.838				
		WG-4187	0.313	1.500	1.500	8.000	1.812				
		WG-4187-1	0.313	1.500	1.500	8.033	1.845				
		WG-4187-2	0.313	1.500	1.500	8.026	1.838				

\* All toolholders include standard clamp and 1/4-20 x 1 SHCS.  
 GTS is Greenleaf's groove/turn system insert with chip control. Page GP 09.  
 COS is Greenleaf's cut-off system insert. Page GP 08.  
 WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.  
 WGC is Greenleaf's flat-top groover with a 6° nose clearance. Pages GP 12 and GP 13.

GROOVING, PROFILING, and CUT-OFF



# 90° Grooving/Profiling Toolholder



Right-Hand Toolholder Shown

Part Number		Groove Width	D.O.C.		Dimensions (inches)				Standard Components		*Tune-Up Kit	Optional Components	
Right	Left		D	D	A	B	C	F	Insert	Clamp	Includes all Standard Components	Insert	Clamp
411693-125VGS	-	0.125	0.375	1.000	1.000	6.000	1.375	GTS-4125-1 GTS-4125-2 WG-4125 WGC-4125	411765-125GC 411766-125GC 411765-125GC 411766-125GC 411765-125GC 411766-125GC	TK-00599 TK-00600 TK-00599 TK-00600 TK-00599 TK-00600	GTS-4125 COS-4125-0 COS-4125-4R COS-4125-4L	429516-125GC 429517-125GC 429516-125GC 429517-125GC 429516-125GC 429517-125GC	
-	411694-125VGS	0.125	0.375	1.000	1.000	6.000	1.375						
411695-125VGS	-	0.125	0.375	1.250	1.250	6.000	1.625						
-	411696-125VGS	0.125	0.375	1.250	1.250	6.000	1.625						
411697-125VGS	-	0.125	0.375	1.500	1.500	8.000	1.875						
-	411698-125VGS	0.125	0.375	1.500	1.500	8.000	1.875						
411701-156VGS	-	0.156	0.375	1.000	1.000	6.000	1.375	WG-4156 WGC-4156	411767-156GC 411768-156GC 411767-156GC 411768-156GC 411767-156GC 411768-156GC	TK-00601 TK-00602 TK-00601 TK-00602 TK-00601 TK-00602	-	-	
-	411702-156VGS	0.156	0.375	1.000	1.000	6.000	1.375						
411703-156VGS	-	0.156	0.375	1.250	1.250	6.000	1.625						
-	411704-156VGS	0.156	0.375	1.250	1.250	6.000	1.625						
411705-156VGS	-	0.156	0.375	1.500	1.500	8.000	1.875						
-	411706-156VGS	0.156	0.375	1.500	1.500	8.000	1.875						
411709-187VGS	-	0.187	0.375	1.000	1.000	6.000	1.375	GTS-4187-1 GTS-4187-2 WG-4187 WGC-4187	411769-187GC 411770-187GC 411769-187GC 411770-187GC 411769-187GC 411770-187GC	TK-00603 TK-00604 TK-00603 TK-00604 TK-00603 TK-00604	GTS-4187 COS-4187-0 COS-4187-4R COS-4187-4L	429522-187GC 429523-187GC 429522-187GC 429523-187GC 429522-187GC 429523-187GC	
-	411710-187VGS	0.187	0.375	1.000	1.000	6.000	1.375						
411711-187VGS	-	0.187	0.375	1.250	1.250	6.000	1.625						
-	411712-187VGS	0.187	0.375	1.250	1.250	6.000	1.625						
411713-187VGS	-	0.187	0.375	1.500	1.500	8.000	1.875						
-	411714-187VGS	0.187	0.375	1.500	1.500	8.000	1.875						
411717-218VGS	-	0.218	0.500	1.000	1.000	6.000	1.500	WG-6218 WGC-6218	411771-218GC 411772-218GC 411771-218GC 411772-218GC 411771-218GC 411772-218GC	TK-00605 TK-00606 TK-00605 TK-00606 TK-00605 TK-00606	-	-	
-	411718-218VGS	0.218	0.500	1.000	1.000	6.000	1.500						
411719-218VGS	-	0.218	0.500	1.250	1.250	6.000	1.750						
-	411720-218VGS	0.218	0.500	1.250	1.250	6.000	1.750						
411721-218VGS	-	0.218	0.500	1.500	1.500	8.000	2.000						
-	411722-218VGS	0.218	0.500	1.500	1.500	8.000	2.000						
411725-250VGS	-	0.250	0.500	1.000	1.000	6.000	1.500	GTS-6250 GTS-6250-1 GTS-6250-2 WG-6250 WGC-6250	411773-250GC 411774-250GC 411773-250GC 411774-250GC 411773-250GC 411774-250GC	TK-00608 TK-00607 TK-00608 TK-00607 TK-00608 TK-00607	-	-	
-	411726-250VGS	0.250	0.500	1.000	1.000	6.000	1.500						
411727-250VGS	-	0.250	0.500	1.250	1.250	6.000	1.750						
-	411728-250VGS	0.250	0.500	1.250	1.250	6.000	1.750						
411729-250VGS	-	0.250	0.500	1.500	1.500	8.000	2.000						
-	411730-250VGS	0.250	0.500	1.500	1.500	8.000	2.000						

\* All toolholders include standard clamp and 1/4-20 x 1 SHCS.

GTS is Greenleaf's groove/turn system insert with chip control. Page GP 09.

COS is Greenleaf's cut-off system insert. Page GP 08.

WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.

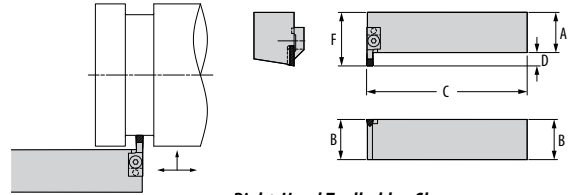
WGC is Greenleaf's flat-top groover with a 6° nose clearance. Pages GP 12 and GP 13.

Continued on next page.



# 90° Grooving/Profiling Toolholder

(Continued)



Right-Hand Toolholder Shown

Part Number		Groove Width	D.O.C.	Dimensions (inches)				Standard Components		*Tune-Up Kit	Optional Components		
Right	Left			D	A	B	C	F	Insert		Clamp	Insert	Clamp
411733-281VGS	-	0.281	0.500	1.000	1.000	6.000	1.500	WG-6281	411775-281GC	TK-00609	-	-	
-	411734-281VGS	0.281	0.500	1.000	1.000	6.000	1.500			411776-281GC	TK-00610	-	-
411735-281VGS	-	0.281	0.500	1.250	1.250	6.000	1.750			411775-281GC	TK-00609	-	-
-	411736-281VGS	0.281	0.500	1.250	1.250	6.000	1.750			411776-281GC	TK-00610	-	-
411737-281VGS	-	0.281	0.500	1.500	1.500	8.000	2.000			411775-281GC	TK-00609	-	-
-	411738-281VGS	0.281	0.500	1.500	1.500	8.000	2.000			411776-281GC	TK-00610	-	-
411743-312VGS	-	0.312	0.625	1.250	1.250	6.000	1.875	WG-8312	411777-312GC	TK-00611	-	-	
-	411744-312VGS	0.312	0.625	1.250	1.250	6.000	1.875			411778-312GC	TK-00612	-	-
411745-312VGS	-	0.312	0.625	1.500	1.500	8.000	2.125			411777-312GC	TK-00611	-	-
-	411746-312VGS	0.312	0.625	1.500	1.500	8.000	2.125			411778-312GC	TK-00612	-	-
411751-344VGS	-	0.344	0.625	1.250	1.250	6.000	1.875	WG-8344	411779-344GC	TK-00613	-	-	
-	411752-344VGS	0.344	0.625	1.250	1.250	6.000	1.875			411780-344GC	TK-00614	-	-
411753-344VGS	-	0.344	0.625	1.500	1.500	8.000	2.125			411779-344GC	TK-00613	-	-
-	411754-344VGS	0.344	0.625	1.500	1.500	8.000	2.125			411780-344GC	TK-00614	-	-
411759-375VGS	-	0.375	0.625	1.250	1.250	6.000	1.875	WG-8375	411781-375GC	TK-00615	-	-	
-	411760-375VGS	0.375	0.625	1.250	1.250	6.000	1.875			411782-375GC	TK-00616	-	-
411761-375VGS	-	0.375	0.625	1.500	1.500	8.000	2.125			411781-375GC	TK-00615	-	-
-	411762-375VGS	0.375	0.625	1.500	1.500	8.000	2.125			411782-375GC	TK-00616	-	-

\* All toolholders include standard clamp and 1/4-20 x 1 SHCS.

GTS is Greenleaf's groove/turn system insert with chip control. Page GP 09.

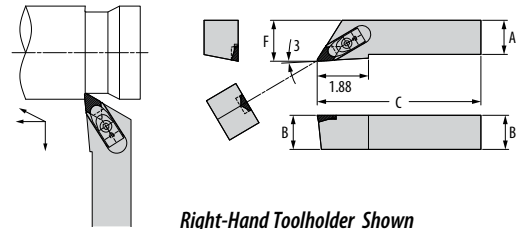
COS is Greenleaf's cut-off system insert. Page GP 08.






WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.

WGC is Greenleaf's flat-top groover with a 6° nose clearance. Pages GP 12 and GP 13.

# CDJOR-V/CDJOL-V

Double Ended / 55° Diamond Insert

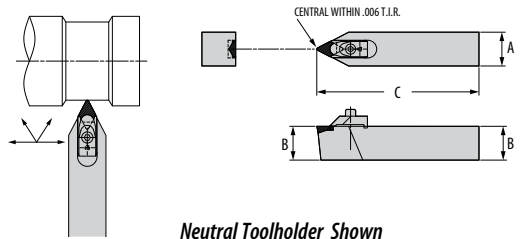







Part Number		Gage  Inserts	Dimensions (inches)				Standard Components				*Tune-Up Kit
Right	Left		A	B	C	F	 Back-Up Plate	 Plate Screw	 Clamp	 Clamp Screw	Includes all Standard Components
CDJOR-164V	CDJOL-164V	DPGN-443V	1.000	1.000	6.000	1.250	418101	#6-32x3/8S.H.C.S.	418100	1/4-20x1S.H.C.S.	TK-00754
CDJOR-204V	CDJOL-204V	DPGN-443V	1.250	1.250	6.000	1.500	418101	#6-32x3/8S.H.C.S.	418100	1/4-20x1S.H.C.S.	TK-00754
CDJOR-244V	CDJOL-244V	DPGN-443V	1.500	1.500	8.000	2.000	418101	#6-32x3/8S.H.C.S.	418100	1/4-20x1S.H.C.S.	TK-00754

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

# CDPON-V

Double Ended / 55° Diamond Insert

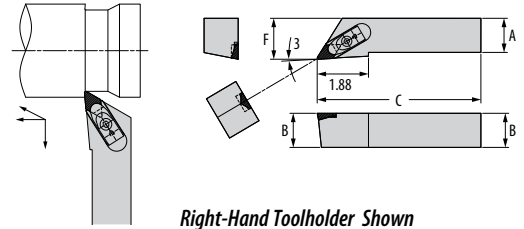


Part Number	Gage  Inserts	Dimensions (inches)			Standard Components				*Tune-Up Kit
		A	B	C	 Back-Up Plate	 Plate Screw	 Clamp	 Clamp Screw	Includes all Standard Components
CDPON-164V	DPGN-443V	1.000	1.000	6.000	418101	#6-32 x 3/8 S.H.C.S.	418100	1/4-20 x 1 S.H.C.S.	TK-00754
CDPON-204V	DPGN-443V	1.250	1.250	6.000	418101	#6-32 x 3/8 S.H.C.S.	418100	1/4-20 x 1 S.H.C.S.	TK-00754
CDPON-244V	DPGN-443V	1.500	1.500	8.000	418101	#6-32 x 3/8 S.H.C.S.	418100	1/4-20 x 1 S.H.C.S.	TK-00754






\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

# CVJOR-V/CVJOL-V

Double Ended / 35° Diamond Insert



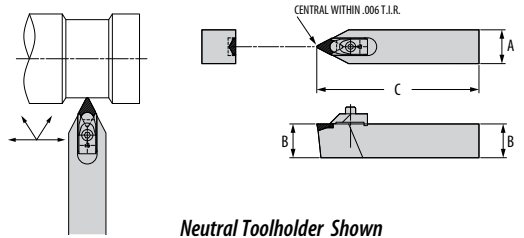
Right-Hand Toolholder Shown

Part Number		Gage  Inserts	Dimensions (inches)				Standard Components				*Tune-Up Kit
Right	Left		A	B	C	F	 Back-Up Plate	 Plate Screw	 Clamp	 Clamp Screw	Includes all Standard Components
CVJOR-122.5VC	CVJOL-122.5VC	VCGN-2.532V	0.750	0.750	5.000	1.000	418525	#4-40x1/4S.H.C.S.	418524	#10-32x3/4S.H.C.S.	TK-00756
CVJOR-162.5V	CVJOL-162.5V	VCGN-2.532V	1.000	1.000	6.000	1.250	418525	#4-40x1/4S.H.C.S.	418524	#10-32x3/4S.H.C.S.	TK-00756
CVJOR-202.5V	CVJOL-202.5V	VCGN-2.532V	1.250	1.250	6.000	1.500	418525	#4-40x1/4S.H.C.S.	418524	#10-32x3/4S.H.C.S.	TK-00756
CVJOR-242.5V	CVJOL-242.5V	VCGN-2.532V	1.500	1.500	8.000	2.000	418525	#4-40x1/4S.H.C.S.	418524	#10-32x3/4S.H.C.S.	TK-00756






\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

# CVVON-V

Double Ended / 35° Diamond Insert



Neutral Toolholder Shown

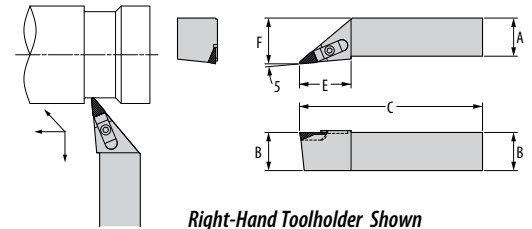
Part Number	Gage  Inserts	Dimensions (inches)			Standard Components				*Tune-Up Kit
		A	B	C	 Back-Up Plate	 Plate Screw	 Clamp	 Clamp Screw	Includes all Standard Components
CVVON-122.5VC	VCGN-2.532V	0.750	0.750	5.000	418525	#4-40x1/4S.H.C.S.	418524	#10-32x3/4S.H.C.S.	TK-00756
CVVON-162.5V	VCGN-2.532V	1.000	1.000	6.000	418525	#4-40x1/4S.H.C.S.	418524	#10-32x3/4S.H.C.S.	TK-00756
CVVON-202.5V	VCGN-2.532V	1.250	1.250	6.000	418525	#4-40x1/4S.H.C.S.	418524	#10-32x3/4S.H.C.S.	TK-00756
CVVON-242.5V	VCGN-2.532V	1.500	1.500	8.000	418525	#4-40x1/4S.H.C.S.	418524	#10-32x3/4S.H.C.S.	TK-00756

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.


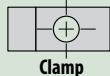

GROOVING, PROFILING, and CUT-OFF

# VJOR-V/VJOL-V

Single Ended / 35° Diamond Insert



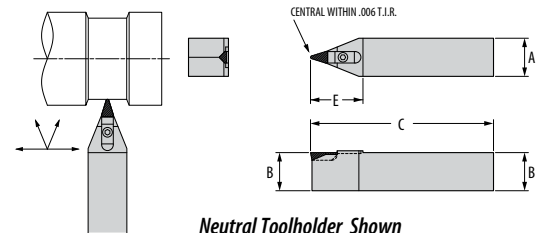
Right-Hand Toolholder Shown

Part Number		Gage  Inserts	Dimensions (inches)					Standard Components		*Tune-Up Kit
Right	Left		A	B	C	E	F	 Clamp	 Clamp Screw	Includes all Standard Components
VJOR-164V	VJOL-164V	VPG-33.543V	1.000	1.000	6.000	1.688	1.250	3386	#10-32 x 5/8 S.H.C.S.	TK-00578
VJOR-204V	VJOL-204V	VPG-33.543V	1.250	1.250	6.000	1.688	1.500	3386	#10-32 x 5/8 S.H.C.S.	TK-00578
VJOR-244V	VJOL-244V	VPG-33.543V	1.500	1.500	8.000	1.688	2.000	3386	#10-32 x 5/8 S.H.C.S.	TK-00578


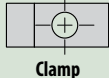

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

# VVON-V

Single Ended / 35° Diamond Insert



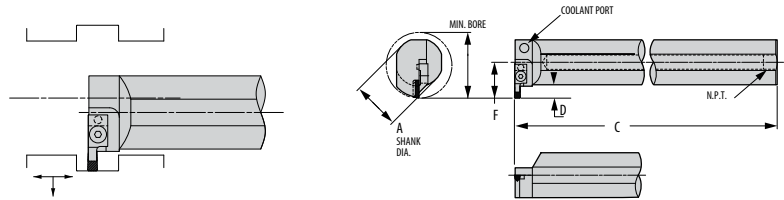
Neutral Toolholder Shown

Part Number		Gage  Inserts	Dimensions (inches)				Standard Components		*Tune-Up Kit
			A	B	C	E	 Clamp	 Clamp Screw	Includes all Standard Components
VVON-164V		VPG-33.543V	1.000	1.000	6.000	1.719	3386	#10-32 x 5/8 S.H.C.S.	TK-00578
VVON-204V		VPG-33.543V	1.250	1.250	6.000	1.719	3386	#10-32 x 5/8 S.H.C.S.	TK-00578
VVON-244V		VPG-33.543V	1.500	1.500	8.000	1.719	3386	#10-32 x 5/8 S.H.C.S.	TK-00578

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

GROOVING, PROFILING, and CUT-OFF

# Cut-Off Grooving Bar



Right-Hand Grooving Bar Shown

Part Number		Groove Width	D.O.C.		Dimensions (inches)			Standard Components		*Tune-Up Kit	Optional Components	
Right	Left		D	Min. Bore	A	C	F	Insert	Clamp	Includes all Standard Components	Insert	Clamp
512074-125VGS	—	0.125	0.375	2.500	2.000	16.000	1.375	GTS-4125-1	411765-125GC	TK-00599	GTS-4125	429516-125GC
—	512075-125VGS	0.125	0.375	2.500	2.000	16.000	1.375	GTS-4125-2	411766-125GC	TK-00600	COS-4125-0	429517-125GC
								WG-4125			COS-4125-4R	
								WGC-4125			COS-4125-4L	
512086-156VGS	—	0.156	0.375	2.500	2.000	16.000	1.375	WG-4156	411767-156GC	TK-00601	—	—
—	512087-156VGS	0.156	0.375	2.500	2.000	16.000	1.375	WGC-4156	411768-156GC	TK-00602	—	—
512098-187VGS	—	0.187	0.375	2.500	2.000	16.000	1.375	GTS-4187-1	411769-187GC	TK-00603	GTS-4187	429522-187GC
—	512099-187VGS	0.187	0.375	2.500	2.000	16.000	1.375	GTS-4187-2	411770-187GC	TK-00604	COS-4187-0	429523-187GC
								WG-4187			COS-4187-4R	
								WGC-4187			COS-4187-4L	
512106-218VGS	—	0.218	0.500	2.750	2.000	16.000	1.500	WG-6218	411771-218GC	TK-00605	—	—
—	512107-218VGS	0.218	0.500	2.750	2.000	16.000	1.500	WGC-6218	411772-218GC	TK-00606	—	—
512116-250VGS	—	0.250	0.500	2.750	2.000	16.000	1.500	GTS-6250	411773-250GC	TK-00608	—	—
—	512117-250VGS	0.250	0.500	2.750	2.000	16.000	1.500	GTS-6250-1	411774-250GC	TK-00607	—	—
								GTS-6250-2				
								WG-6250				
								WGC-6250				
512126-281VGS	—	0.281	0.500	2.750	2.000	16.000	1.500	WG-6281	411775-281GC	TK-00609	—	—
—	512127-281VGS	0.281	0.500	2.750	2.000	16.000	1.500	WGC-6281	411776-281GC	TK-00610	—	—
512132-312VGS	—	0.312	0.625	3.000	2.000	16.000	1.625	WG-8312	411777-312GC	TK-00611	—	—
—	512133-312VGS	0.312	0.625	3.000	2.000	16.000	1.625	WGC-8312	411778-312GC	TK-00612	—	—
512138-344VGS	—	0.344	0.625	3.000	2.000	16.000	1.625	WG-8344	411779-344GC	TK-00613	—	—
—	512139-344VGS	0.344	0.625	3.000	2.000	16.000	1.625	WGC-8344	411780-344GC	TK-00614	—	—
512144-375VGS	—	0.375	0.625	3.000	2.000	16.000	1.625	WG-8375	411781-375GC	TK-00615	—	—
—	512145-375VGS	0.375	0.625	3.000	2.000	16.000	1.625	WGC-8375	411782-375GC	TK-00616	—	—

\* All toolholders include standard clamp and 1/4-20 x 1 SHCS.

GTS is Greenleaf's groove/turn system insert with chip control. Page GP 09.

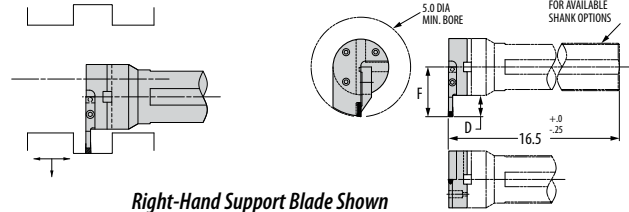
COS is Greenleaf's cut-off system insert. Page GP 08.

WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.

WGC is Greenleaf's flat-top groover with a 6° nose clearance. Pages GP 12 and GP 13.

# Cut-Off Grooving Support Blade

For Single-Ended V-Bottom Inserts



Right-Hand Support Blade Shown

Part Number		Groove Width	D.O.C. D	Dimensions (inches) F	Standard Components		*Tune-Up Kit Includes all Std Components and *Clamp Screw	Optional Components	
Right	Left				Insert	Clamp		Insert	Clamp
511309-125VGB	-	0.125	0.750	2.250	GTS-4125-1	411967-125GC	TK-00596	GTS-4125	429513-125GC
-	512228-125VGB	0.125	0.750	2.250	GTS-4125-2	411966-125GC	TK-00592	COS-4125-0	429512-125GC
					WG-4125			COS-4125-4R	
					WGC-4125			COS-4125-4L	
511311-156VGB	-	0.156	0.750	2.250	WG-4156	411969-156GC	TK-00597	-	-
-	511312-156VGB	0.156	0.750	2.250	WGC-4156	411968-156GC	TK-00580	-	-
511313-187VGB	-	0.187	0.750	2.250	GTS-4187-1	411978-187GC	TK-00593	GTS-4187	429519-187GC
-	511314-187VGB	0.187	0.750	2.250	GTS-4187-2	411977-187GC	TK-00581	COS-4187-0	429518-187GC
					WG-4187			COS-4187-4R	
					WGC-4187			COS-4187-4L	
511315-218VGB	-	0.218	1.125	2.625	WG-6218	411130-218GC	TK-00583	-	-
-	512229-218VGB	0.218	1.125	2.625	WGC-6218	411979-218GC	TK-00582	-	-
512230-250VGB	-	0.250	1.125	2.625	GTS-6250	411981-250GC	TK-00598	-	-
-	511318-250VGB	0.250	1.125	2.625	GTS-6250-1	411980-250GC	TK-00617	-	-
					GTS-6250-2				
					WG-6250				
					WGC-6250				
511319-281VGB	-	0.281	1.125	2.625	WG-6281	411134-281GC	TK-00585	-	-
-	511320-281VGB	0.281	1.125	2.625	WGC-6281	411133-281GC	TK-00584	-	-
511321-312-VGB	-	0.312	1.500	3.000	WG-8312	411136-312GC	TK-00587	-	-
-	511322-312VGB	0.312	1.500	3.000	WGC-8312	411985-312GC	TK-00586	-	-
511323-344VGB	-	0.344	1.500	3.000	WG-8344	411138-344GC	TK-00588	-	-
-	511324-344VGB	0.344	1.500	3.000	WGC-8344	411137-344GC	TK-00594	-	-
511325-375VGB	-	0.375	1.500	3.000	WG-8375	411987-375GC	TK-00589	-	-
-	511326-375VGB	0.375	1.500	3.000	WGC-8375	411986-375GC	TK-00595	-	-

NOTE: See page GP 44 for available shank options

\* All toolholders include standard clamp and 1/4-20 x 1 SHCS.

GTS is Greenleaf's groove/turn system insert with chip control. Page GP 09.

COS is Greenleaf's cut-off system insert. Page GP 08.

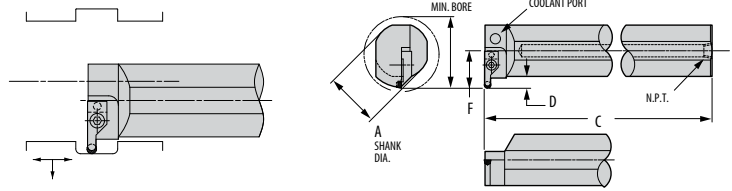
WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.

WGC is Greenleaf's flat-top groover with a 6° nose clearance. Pages GP 12 and GP 13.

GROOVING, PROFILING, and CUT-OFF

# Profiling Bar

Round V-Bottom Insert / Milled Nest



Right-Hand Profiling Bar Shown

Part Number		Gage - Opt 1		Gage - Opt 2		D.O.C.	Dimensions (inches)				Standard Components		*Tune-Up Kit	Opt. Component
Right	Left	Insert	Min. Bore	Insert	Min. Bore		D	A	C	F	Clamp	Clamp Screw	Includes all Standard Components	Insert Screw
519700-2VMRB	—	RPGN-2V	1.500	RCGN-2V	3.500	3/8	1.000	12.00	0.875	412131-250GC	1/4-20x3/4S.H.C.S.	TK-00795	PT-542T	
—	519701-2VMRB	RPGN-2V	1.500	RCGN-2V	3.500	3/8	1.000	12.00	0.875	412132-250GC	1/4-20x3/4S.H.C.S.	TK-00836	PT-542T	
519702-2VMRB	—	RPGN-2V	1.750	RCGN-2V	3.500	3/8	1.250	13.75	1.000	412131-250GC	1/4-20x1S.H.C.S.	TK-00798	PT-542T	
—	519703-2VMRB	RPGN-2V	1.750	RCGN-2V	3.500	3/8	1.250	13.75	1.000	412132-250GC	1/4-20x1S.H.C.S.	TK-00848	PT-542T	
519704-2VMRB	—	RPGN-2V	2.000	RCGN-2V	3.500	3/8	1.500	13.75	1.125	412131-250GC	1/4-20x1S.H.C.S.	TK-00798	PT-542T	
—	519705-2VMRB	RPGN-2V	2.000	RCGN-2V	3.500	3/8	1.500	13.75	1.125	412132-250GC	1/4-20x1S.H.C.S.	TK-00848	PT-542T	
519706-2VMRB	—	RPGN-2V	2.500	RCGN-2V	3.500	3/8	2.000	16.00	1.375	412131-250GC	1/4-20x1S.H.C.S.	TK-00798	PT-542T	
—	519707-2VMRB	RPGN-2V	2.500	RCGN-2V	3.500	3/8	2.000	16.00	1.375	412132-250GC	1/4-20x1S.H.C.S.	TK-00848	PT-542T	
519708-3VMRB	519709-3VMRB	RPGN-3V	2.250	RCGN-3V	4.500	1/2	1.250	13.75	1.125	308063	#10-32x1/2S.H.C.S.	TK-00764	PT-545T	
519710-3VMRB	519711-3VMRB	RPGN-3V	2.500	RCGN-3V	4.500	1/2	1.500	13.75	1.250	308063	#10-32x1/2S.H.C.S.	TK-00764	PT-545T	
519712-3VMRB	519713-3VMRB	RPGN-3V	2.750	RCGN-3V	4.500	1/2	2.000	16.00	1.500	308063	#10-32x1/2S.H.C.S.	TK-00764	PT-545T	
519714-4VMRB	519715-4VMRB	RPGN-4V	2.250	RCGN-4V	4.500	5/8	1.250	13.75	1.250	308136	1/4-20x3/4S.H.C.S.	TK-00763	CO-5018	
519716-4VMRB	519717-4VMRB	RPGN-4V	2.500	RCGN-4V	4.500	5/8	1.500	13.75	1.375	308136	1/4-20x3/4S.H.C.S.	TK-00763	CO-5018	
519718-4VMRB	519719-4VMRB	RPGN-4V	2.750	RCGN-4V	4.500	5/8	2.000	16.00	1.625	308136	1/4-20x3/4S.H.C.S.	TK-00763	CO-5018	

NOTE: See page GP 14 for ceramic and carbide inserts.

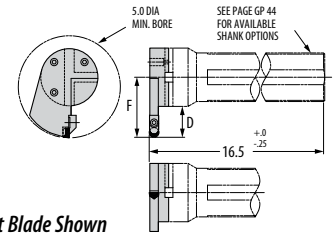
NOTE: Use carbide inserts RCGT and RPGT with optional insert screw for finishing.

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the profiling bar.


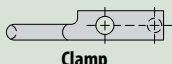

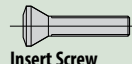


# Profiling Support Blade

Round V-Bottom Insert / Milled Nest



Right-Hand Support Blade Shown

Part Number		Gage	D.O.C.	Dimensions (inches)		Standard Components		*Tune-Up Kit	Opt. Component
Right	Left		D	F			Includes all Standard Components		
519740-2VMRB	–	**RPGN-2V	0.750	2.375	411906-250VRC	1/4-20x1S.H.C.S.	TK-00799	PT-542T	
–	519741-2VMRB	**RPGN-2V	0.750	2.375	411905-250VRC	1/4-20x1S.H.C.S.	TK-00765	PT-542T	
519742-3VMRB	–	**RPGN-3V	1.125	2.750	308063	#10-32x1/2S.H.C.S.	TK-00764	PT-545T	
–	519743-3VMRB	**RPGN-3V	1.125	2.750	308063	#10-32x1/2S.H.C.S.	TK-00764	PT-545T	
519744-4VMRB	–	**RPGN-4V	1.500	3.125	308136	1/4-20x3/4S.H.C.S.	TK-00763	CO-5018	
–	519745-4VMRB	**RPGN-4V	1.500	3.125	308136	1/4-20x3/4S.H.C.S.	TK-00763	CO-5018	

NOTE: See page GP 14 for ceramic and carbide inserts.

NOTE: See page GP 44 for available shank options.

NOTE: Use carbide inserts RCGT and RPGT with optional insert screw for finishing.

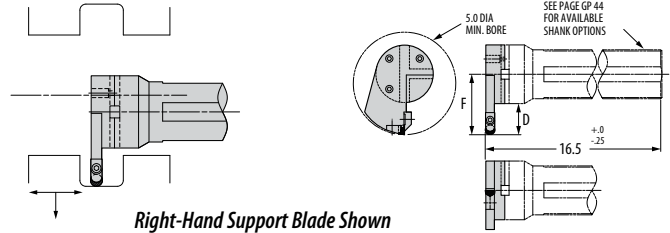
\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade.

\*\* RCGN can be used in place of RPGN.




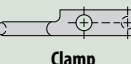

GROOVING, PROFILING, and CUT-OFF

# Profiling Support Blade

## Round V-Bottom Insert / Replaceable Nest



Right-Hand Support Blade Shown

Part Number		Gage  Insert	D.O.C.  D	Dimensions (inches)  F		Standard Components				*Tune-Up Kit  Includes all Standard Components
Right	Left			 Nest	 Nest Screw	 Clamp	 Clamp Screw			
512227-2VRB	—	**RPGN-2V	0.750	2.375	411108	#3-48x3/8B.H.C.S.	411906-250VRC	1/4-20x1S.H.C.S.	TK-00685	
—	511287-2VRB	**RPGN-2V	0.750	2.375	411108	#3-48x3/8B.H.C.S.	411905-250VRC	1/4-20x1S.H.C.S.	TK-00683	
511288-3VRB	—	**RPGN-3V	1.125	2.750	414009	#6-32x1/2B.H.C.S.	308063	#10-32x1/2S.H.C.S.	TK-00528	
—	511289-3VRB	**RPGN-3V	1.125	2.750	414009	#6-32x1/2B.H.C.S.	308063	#10-32x1/2S.H.C.S.	TK-00528	
511290-4VRB	—	**RPGN-4V	1.500	3.125	414008	#10-32x5/8B.H.C.S.	308136	1/4-20x5/8S.H.C.S.	TK-00529	
—	511291-4VRB	**RPGN-4V	1.500	3.125	414008	#10-32x5/8B.H.C.S.	308136	1/4-20x5/8S.H.C.S.	TK-00529	

NOTE: See page GP 14 for ceramic and carbide inserts.

NOTE: See page GP 44 for available shank options.

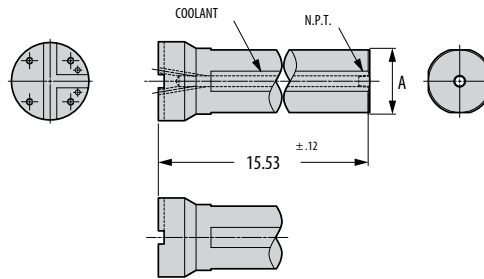
\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade.

\*\* RCGN can be used in place of RPGN.

# Shank Options

For Bolt-On Support Blades

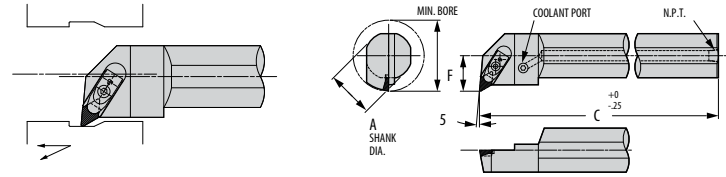
Part Number	Dimensions (inches)
511296	2.000
511297	2.250
511292	2.500
511298	3.000



GROOVING, PROFILING, and CUT-OFF

# Profiling Bar

## Double-Ended 55° Diamond



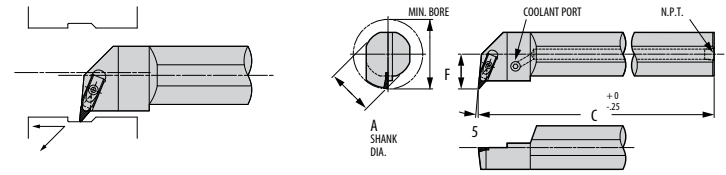
Right-Hand Profiling Bar Shown

Part Number		Gage	Min. Bore	Dimensions (inches)			Standard Components				*Tune-Up Kit
Right	Left	Insert		A	C	F	Back-Up Plate	Plate Screw	Clamp	Clamp Screw	Includes all Standard Components
518560-32-5 VR	518561-32-55VL	DPGN-443V	2-3/4	2.000	16.000	1.500	418101	#6-32 x 3/8 S.H.C.S.	418100	1/4-20 x 1 S.H.C.S.	TK-00754
518562-40-55VR	518563-40-55VL	DPGN-443V	3-1/4	2.500	16.000	2.000	418101	#6-32 x 3/8 S.H.C.S.	418100	1/4-20 x 1 S.H.C.S.	TK-00754

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade profiling bar.

# Profiling Bar

## Double-Ended 35° Diamond

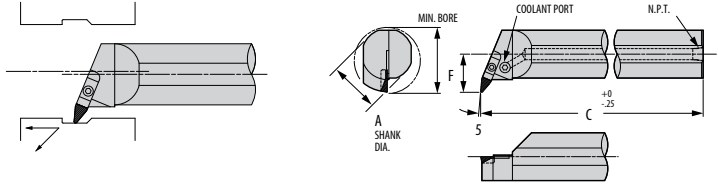


Right-Hand Profiling Bar Shown

Part Number		Gage	Min. Bore	Dimensions (inches)			Standard Components				*Tune-Up Kit
Right	Left	Insert		A	C	F	Back-Up Plate	Plate Screw	Clamp	Clamp Screw	Includes all Standard Components
518554-24-35VR	518555-24-35VL	VCGN-2.532V	2	1.500	14.000	1.000	418525	#4-40 x 1/4 S.H.C.S.	418524	#10-32 x 3/4 S.H.C.S.	TK-00756
518556-32-35VR	518557-32-35VL	VCGN-2.532V	2-3/4	2.000	16.000	1.500	418525	#4-40 x 1/4 S.H.C.S.	418524	#10-32 x 3/4 S.H.C.S.	TK-00756
518558-40-35VR	518559-40-35VL	VCGN-2.532V	3-1/4	2.500	16.000	2.000	418525	#4-40 x 1/4 S.H.C.S.	418524	#10-32 x 3/4 S.H.C.S.	TK-00756

NOTE: See page GP 18 for inserts

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade profiling bar.



# Profiling Bar

## Single-Ended 35° Diamond

Right-Hand Profiling Bar Shown

Part Number		Gage	Min. Bore	Dimensions (inches)			Standard Components		*Tune-Up Kit
Right	Left	Insert		A	C	F	Clamp	Clamp Screw	Includes all Standard Components
511339-B244VR	511340-B244VL	VPG-33.543V	2	1.500	14.000	1.000	3386	#10-32 x 5/8 S.H.C.S.	TK-00578
511343-B324VR	511344-B324VL	VPG-33.543V	2-3/4	2.000	16.000	1.500	3386	#10-32 x 5/8 S.H.C.S.	TK-00578
511347-B404VR	511348-B404VL	VPG-33.543V	3-1/4	2.500	16.000	2.000	3386	#10-32 x 5/8 S.H.C.S.	TK-00578

NOTE: See page GP 18 for inserts

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade profiling bar.

## Grooving, Profiling and Cut-Off Support Blades

The Greenleaf tooling system for grooving, profiling, and cut-off is complemented by a support blade system that combines qualified shanks and support blades to expand the application range of each toolholder or bar. Greenleaf tools can be coupled with 248 support blades holding cut-off, V-bottom round profilers, and grooving inserts to meet your every need.

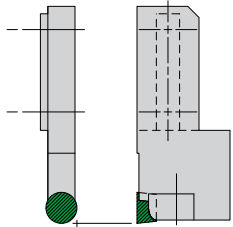
Quick-change shanks such as CAPTO or KM, as well as straight shank holders and bars, are all part of this tooling system. Custom solutions for particular features not addressable with standard tools can be readily designed with your input and Greenleaf's extensive experience.

### Greenleaf Tune-Up Kits

A Tune-Up Kit consists of all the standard hardware to refurbish a particular toolholder, boring bar, or milling cutter. A toolholder will have a readily visible, laser-inscribed Tune-Up Kit number on it for ease in ordering. This number will prevent any confusion created by searching a catalog for hardware, and it will help reduce downtime.



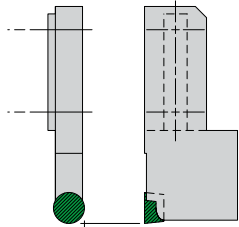
# Support Blade Overview



**Round V-Bottom Insert with Replaceable Nest**

3 sizes available  
using 12 insert combinations

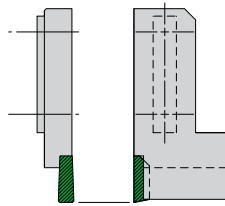
page GP 50



**Round V-Bottom Insert with Milled Nest**

3 sizes available  
using 18 insert combinations

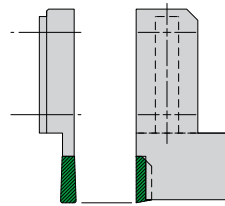
page GP 50



**O.D. Grooving/Profiling Shallow Series**

10 sizes available  
using 56 insert combinations

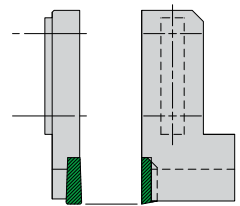
page GP 51



**O.D. Grooving/Profiling Deep Series**

10 sizes available  
using 56 insert combinations

page GP 51

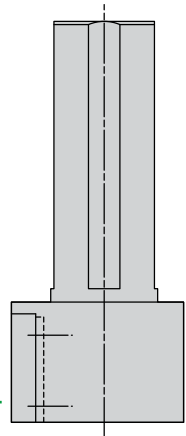


**Face Grooving B Shallow Series**

25 sizes available  
using 47 insert combinations

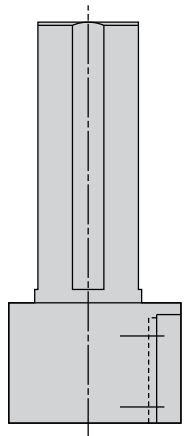
page GP 54

## RIGHT HAND



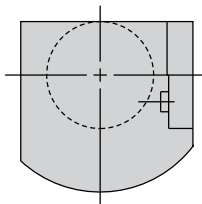
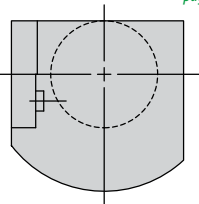
**Round Shanks**  
6 sizes available

page GP 60

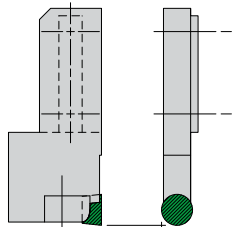


**Straight Shanks**  
6 sizes available

page GP 60

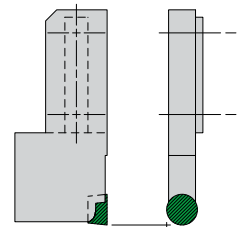


## LEFT HAND



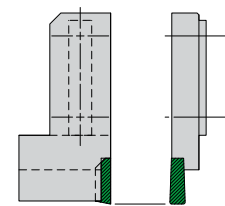
**Round V-Bottom Insert with Replaceable Nest**  
3 sizes available  
using 12 insert combinations

page GP 50



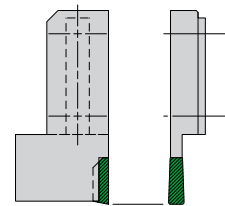
**Round V-Bottom Insert with Milled Nest**  
3 sizes available  
using 18 insert combinations

page GP 50



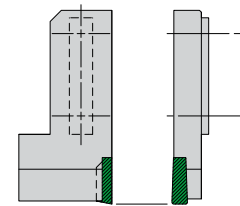
**O.D. Grooving/Profiling Shallow Series**  
10 sizes available  
using 56 insert combinations

page GP 52



**O.D. Grooving/Profiling Deep Series**  
10 sizes available  
using 56 insert combinations

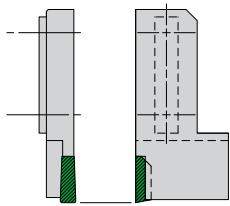
page GP 52



**Face Grooving C Shallow Series**  
25 sizes available  
using 47 insert combinations

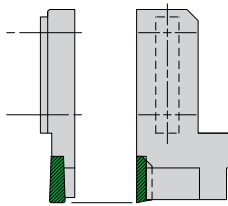
page GP 55





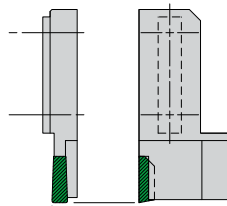
**Face Grooving B Deep Series**  
25 sizes available using 47 insert combinations

page GP 54



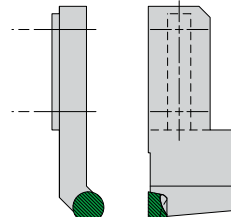
**Face Grooving A Shallow Series**  
25 sizes available using 47 insert combinations

page GP 53



**Face Grooving A Deep Series**  
25 sizes available using 47 insert combinations

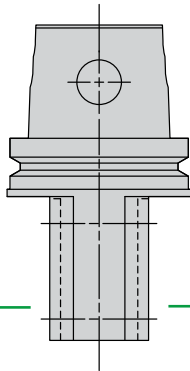
page GP 53



**Special Designs to Fit Customer's Parts**

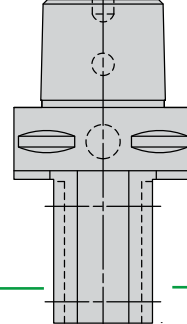
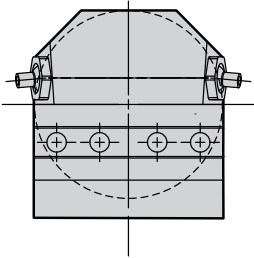
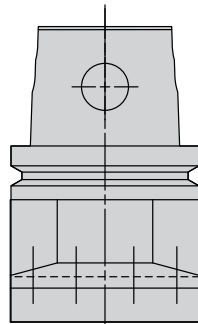
page GP 58-59

**RIGHT HAND**



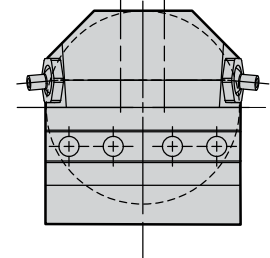
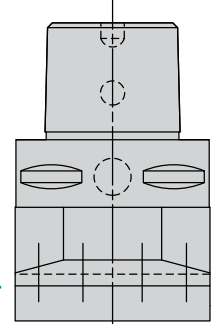
**KM Tool Shanks**  
4 sizes available

page GP 61

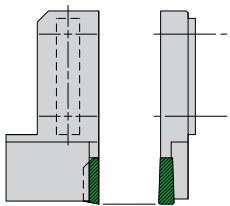


**ISO 26623 Shanks**  
4 sizes available

page GP 61

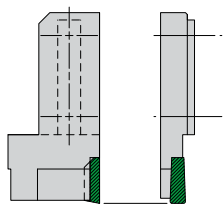


**LEFT HAND**



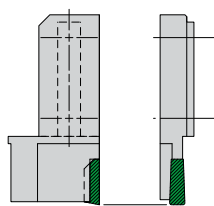
**Face Grooving C Deep Series**  
25 sizes available using 47 insert combinations

page GP 55



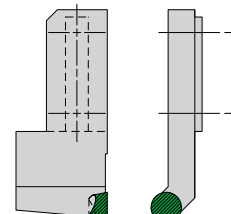
**Face Grooving D Shallow Series**  
25 sizes available using 47 insert combinations

page GP 56



**Face Grooving D Deep Series**  
25 sizes available using 47 insert combinations

page GP 56

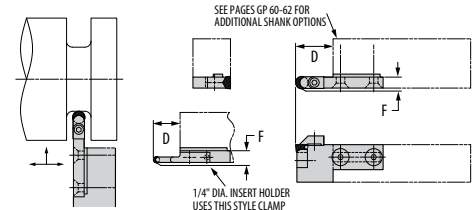


**Special Designs to Fit Customer's Parts**


page GP 58-59

# O.D. Grooving/Profiling Support Blade

Round V-Bottom Insert Replaceable Nest



Right-Hand Support Blade Shown

Part Number		Gage 	D.O.C. D	Dimensions (inches)		Standard Components				*Tune-Up Kit
Right	Left			F	Back-Up Plate	Plate Screw	Clamp	Clamp Screw	Includes all Standard Components	
411959-2VR	-	**RPGN-2V	0.750							0.469
-	411960-2VR	**RPGN-2V	0.750	0.469	410631	#3-48x3/8B.H.C.S.	411906-250VRC	1/4-20x1S.H.C.S.	TK-00591	
411011-3VR	411012-3VR	**RPGN-3V	1.125	0.469	413970	#6-32x1/2B.H.C.S.	308063	#10-32x1/2S.H.C.S.	TK-00525	
411009-4VR	411010-4VR	**RPGN-4V	1.500	0.469	414007	#10-32x5/8B.H.C.S.	308136	1/4-20x5/8S.H.C.S.	TK-00526	

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade.

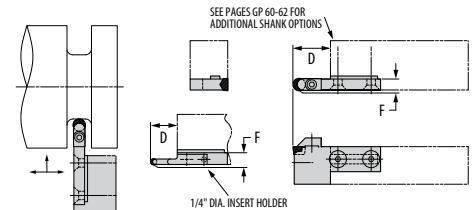
\*\* RCGN can be used in place of RPGN.

See pages GP 60-62 for additional shank options.


See page GP 14 for ceramic and carbide insert.

# O.D. Grooving/Profiling Support Blade

Round V-Bottom Insert Milled Nest



Right-Hand Support Blade Shown

Part Number		Gage 	D.O.C. D	Dimensions (inches)		Standard Components		*Tune-Up Kit	Optional Component
Right	Left			F	Clamp	Clamp Screw	Includes all Standard Components	Insert Screw	
421534-2VMR	-	**RPGN-2V	0.750						0.469
-	421535-2VMR	**RPGN-2V	0.750	0.469	411906-250VRC	1/4-20x1S.H.C.S.	TK-00799	PT-542T	
421536-3VMR	421537-3VMR	**RPGN-3V	1.125	0.469	308063	#10-32x1/2S.H.C.S.	TK-00764	PT-545T	
421538-4VMR	421539-4VMR	**RPGN-4V	1.500	0.469	308136	1/4-20x3/4S.H.C.S.	TK-00763	CO-5018	

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade.

\*\* RCGN can be used in place of RPGN.

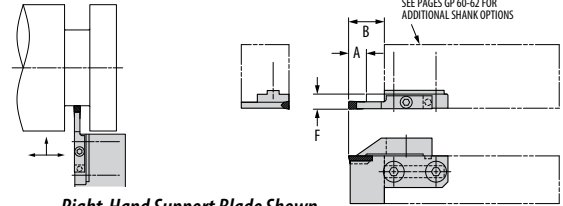
See pages GP 60-62 for additional shank options.

See page GP 14 for ceramic and carbide insert.

NOTE: Use carbide inserts RCGT and RPGT with optional insert screw for finishing.

GROOVING, PROFILING, and CUT-OFF

# O.D. Grooving/Profiling/ Cut-Off Support Blade *Right Hand*



Right-Hand Support Blade Shown

Part Number		Groove Width	Dimensions (inches)			Standard Components		*Tune-Up Kit	Optional Components	
Shallow Series	Deep Series		A	B	F	Insert	Clamp	Includes all Std Components and *Clamp Screw	Insert	Clamp
427647-094VG		0.094	0.380	–	0.469	WG-4094	427651-094GC	TK-00881	COS-4094-0	429524-094GC
	427648-094VG	0.094	–	0.750	0.469	WGC-4094	427651-094GC	TK-00881	COS-4094-4L COS-4094-4R	429524-094GC
421109-125VG		0.125	0.380	–	0.469	GTS-4125-1	411966-125GC	TK-00592	GTS-4125	429512-125GC
	411988-125VG	0.125	–	0.750	0.469	GTS-4125-2 WG-4125 WGC-4125	411966-125GC	TK-00592	COS-4125-0 COS-4125-4R COS-4125-4L	429512-125GC
421110-156VG		0.156	0.380	–	0.469	WG-4156		TK-00580	–	–
	411066-156VG	0.156	–	0.750	0.469	WGC-4156	411968-156GC	TK-00580	–	–
421111-187VG		0.187	0.380	–	0.469	GTS-4187-1	411977-187GC	TK-00581	GTS-4187	429518-187GC
	411068-187VG	0.187	–	0.750	0.469	GTS-4187-2 WG-4187 WGC-4187	411977-187GC	TK-00581	COS-4187-0 COS-4187-4R COS-4187-4L	429518-187GC
421112-218VG		0.218	0.560	–	0.469	WG-6218	411979-218GC	TK-00582	–	–
	411081-218VG	0.218	–	1.130	0.469	WGC-6218	411979-218GC	TK-00582	–	–
421113-250VG		0.250	0.560	–	0.469	WG-6250	411980-250GC	TK-00617	–	–
	411992-250VG	0.250	–	1.130	0.469	WGC-6250 GTS-6250 GTS-6250-1 GTS-6250-2	411980-250GC	TK-00617	–	–
421114-281VG		0.281	0.560	–	0.469	WG-6281	411133-281GC	TK-00584	–	–
	411085-281VG	0.281	–	1.130	0.469	WGC-6281	411133-281GC	TK-00584	–	–
421115-312VG		0.312	0.750	–	0.469	WG-8312	411985-312GC	TK-00586	–	–
	411087-312VG	0.312	–	1.500	0.469	WGC-8312	411985-312GC	TK-00586	–	–
421116-344VG		0.344	0.750	–	0.469	WG-8344	411137-344GC	TK-00594	–	–
	411089-344VG	0.344	–	1.500	0.469	WGC-8344	411137-344GC	TK-00594	–	–
421117-375VG		0.375	0.750	–	0.469	WG-8375	411986-375GC	TK-00595	–	–
411994-375VG		0.375	–	1.500	0.469	WGC-8375	411986-375GC	TK-00595	–	–

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade.

All support blades include Standard Clamp and 1/4-20 x 1 SHCS.

GTS is Greenleaf's groove/turn system insert with chip control. Page GP 09.

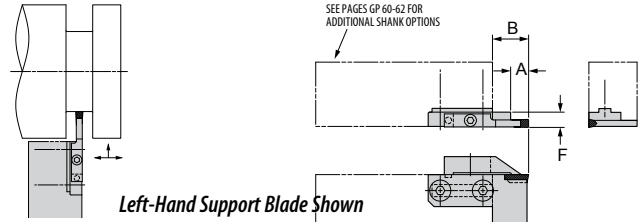
COS is Greenleaf's cut-off system insert. Page GP 08.

WG is Greenleaf flat-top groover with an 11° nose clearance. See pages GP 10 and GP 11.

WGC is Greenleaf's flat-top groover with a 6° nose clearance. See pages GP 12 and GP 13.

See pages GP 60-62 for additional shank options.

# O.D. Grooving/Profiling/ Cut-Off Support Blade *Left Hand*



Part Number		Groove Width	Dimensions (inches)			Standard Components		*Tune-Up Kit	Optional Components	
Shallow Series	Deep Series		A	B	F	Insert	Clamp	Includes all Std Components and *Clamp Screw	Insert	Clamp
427649-094VG		0.094	0.380	–	0.469	WG-4094	427652-094GC	TK-00882	COS-4094-0	429525-094GC
	427650-094VG	0.094	–	0.750	0.469	WGC-4094	427652-094GC	TK-00882	COS-4094-4L COS-4094-4R	429525-094GC
421100-125VG		0.125	0.380	–	0.469	GTS-4125-1	411967-125GC	TK-00596	GTS-4125	429513-125GC
	411989-125VG	0.125	–	0.750	0.469	GTS-4125-2 WG-4125 WGC-4125	411967-125GC	TK-00596	COS-4125-0 COS-4125-4R COS-4125-4L	429513-125GC
421101-156VG		0.156	0.380	–	0.469	WG-4156	411969-156GC	TK-00597	–	–
	411990-156VG	0.156	–	0.750	0.469	WGC-4156	411969-156GC	TK-00597	–	–
421102-187VG		0.187	0.380	–	0.469	GTS-4187-1	411978-187GC	TK-00593	GTS-4187	429519-187GC
	411991-187VG	0.187	–	0.750	0.469	GTS-4187-2 WG-4187 WGC-4187	411978-187GC	TK-00593	COS-4187-0 COS-4187-4R COS-4187-4L	429519-187GC
421103-218VG		0.218	0.560	–	0.469	WG-6218	411130-218GC	TK-00583	–	–
	411082-218VG	0.218	–	1.130	0.469	WGC-6218	411130-218GC	TK-00583	–	–
421104-250VG		0.250	0.560	–	0.469	WG-6250	411981-250GC	TK-00598	–	–
	411993-250VG	0.250	–	1.130	0.469	WGC-6250 GTS-6250 GTS-6250-1 GTS-6250-2	411981-250GC	TK-00598	–	–
421105-281VG		0.281	0.560	–	0.469	WG-6281	411134-281GC	TK-00585	–	–
	411086-281VG	0.281	–	1.130	0.469	WGC-6281	411134-281GC	TK-00585	–	–
421106-312VG		0.312	0.750	–	0.469	WG-8312	411136-312GC	TK-00587	–	–
	411088-312VG	0.312	–	1.500	0.469	WGC-8312	411136-312GC	TK-00587	–	–
421107-344VG		0.344	0.750	–	0.469	WG-8344	411138-344GC	TK-00588	–	–
	411090-344VG	0.344	–	1.500	0.469	WGC-8344	411138-344GC	TK-00588	–	–
421108-375VG		0.375	0.750	–	0.469	WG-8375	411987-375GC	TK-00589	–	–
	411122-375VG	0.375	–	1.500	0.469	WGC-8375	411987-375GC	TK-00589	–	–

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade.

All support blades include Standard Clamp and 1/4-20 x 1 SHCS.

GTS is Greenleaf's groove/turn system insert with chip control. Page GP 09.

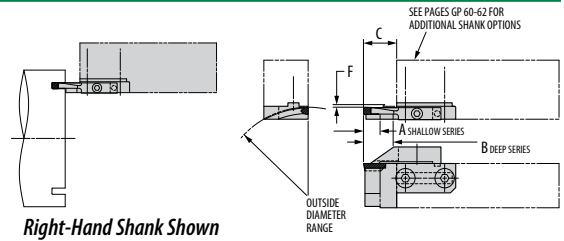
COS is Greenleaf's cut-off system insert. Page GP 08.

WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.

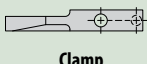
WGC is Greenleaf's flat-top groover with a 6° nose clearance. Pages GP 12 and GP 13.

See pages GP 60-62 for additional shank options.

# Face Grooving Support Blade A

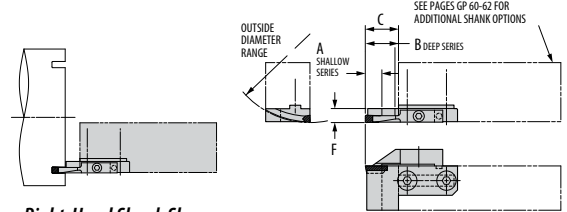


Right-Hand Shank Shown


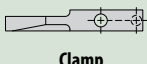
Part Number		Gage 	Outside Diameter Range	Dimensions (inches)				Standard Components		*Tune-Up Kit
Shallow Series	Deep Series			A	B	C	F			Includes all Standard Components
421218-1255-030	421243-125L-030	WG-4125	3.00 / 3.50	0.380	0.630	0.750	0.031	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421219-1255-035	421244-125L-035	WG-4125	3.50 / 4.25	0.380	0.630	0.750	0.031	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421220-1255-0425	421245-125L-0425	WG-4125	4.25 / 5.50	0.380	0.630	0.750	0.031	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421221-1255-055	421246-125L-055	WG-4125	5.50 / 7.50	0.380	0.630	0.750	0.031	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421222-1255-075	421247-125L-075	WG-4125	7.50 / 12.50	0.380	0.630	0.750	0.031	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421223-1255-125	421248-125L-125	WG-4125	12.50 / 40.00	0.380	0.630	0.750	0.031	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421224-1875-030	421249-187L-030	WG-4187	3.00 / 3.50	0.380	0.630	0.750	0.031	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421225-1875-035	421250-187L-035	WG-4187	3.50 / 4.25	0.380	0.630	0.750	0.031	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421226-1875-0425	421251-187L-0425	WG-4187	4.25 / 5.50	0.380	0.630	0.750	0.031	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421227-1875-055	421252-187L-055	WG-4187	5.50 / 7.50	0.380	0.630	0.750	0.031	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421228-1875-075	421253-187L-075	WG-4187	7.50 / 12.50	0.380	0.630	0.750	0.031	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421229-1875-125	421254-187L-125	WG-4187	12.50 / 40.00	0.380	0.630	0.750	0.031	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421230-2505-030	421255-250L-030	WG-6250	3.00 / 4.25	0.560	1.000	1.125	0.031	421325-250GC	1/4-20 x 1 S.H.C.S.	TK-00808
421231-2505-0425	421256-250L-0425	WG-6250	4.25 / 6.00	0.560	1.000	1.125	0.031	421325-250GC	1/4-20 x 1 S.H.C.S.	TK-00808
421232-2505-060	421257-250L-060	WG-6250	6.00 / 8.50	0.560	1.000	1.125	0.031	421325-250GC	1/4-20 x 1 S.H.C.S.	TK-00808
421233-2505-085	421258-250L-085	WG-6250	8.50 / 15.50	0.560	1.000	1.125	0.031	421325-250GC	1/4-20 x 1 S.H.C.S.	TK-00808
421234-2505-155	421259-250L-155	WG-6250	15.50 / 40.00	0.560	1.000	1.125	0.031	421325-250GC	1/4-20 x 1 S.H.C.S.	TK-00808
421235-3125-030	421260-312L-030	WG-8312	3.00 / 5.00	0.750	1.310	1.500	0.031	421326-312GC	1/4-20 x 1 S.H.C.S.	TK-00823
421236-3125-050	421261-312L-050	WG-8312	5.00 / 9.00	0.750	1.310	1.500	0.031	421326-312GC	1/4-20 x 1 S.H.C.S.	TK-00823
421237-3125-090	421262-312L-090	WG-8312	9.00 / 19.00	0.750	1.310	1.500	0.031	421326-312GC	1/4-20 x 1 S.H.C.S.	TK-00823
421238-3125-190	421263-312L-190	WG-8312	19.00 and up	0.750	1.310	1.500	0.031	421326-312GC	1/4-20 x 1 S.H.C.S.	TK-00823
421239-3755-030	421264-375L-030	WG-8375	3.00 / 5.00	0.750	1.310	1.500	0.031	421327-375GC	1/4-20 x 1 S.H.C.S.	TK-00839
421240-3755-050	421265-375L-050	WG-8375	5.00 / 9.00	0.750	1.310	1.500	0.031	421327-375GC	1/4-20 x 1 S.H.C.S.	TK-00839
421241-3755-090	421266-375L-090	WG-8375	9.00 / 19.00	0.750	1.310	1.500	0.031	421327-375GC	1/4-20 x 1 S.H.C.S.	TK-00839
421242-3755-190	421267-375L-190	WG-8375	19.00 and up	0.750	1.310	1.500	0.031	421327-375GC	1/4-20 x 1 S.H.C.S.	TK-00839

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade.  
See pages GP 60-62 for additional shank options.  
See pages GP 10 and GP 11 for inserts.

# Face Grooving Support Blade B



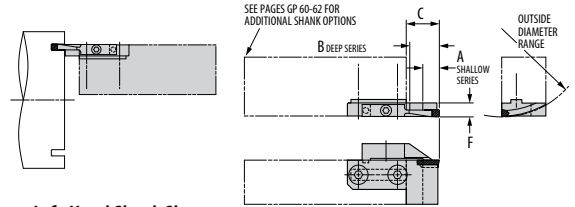
Right-Hand Shank Shown

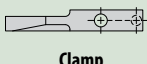
Part Number		Gage  Insert	Outside Diameter Range	Dimensions (inches)				Standard Components		*Tune-Up Kit Includes all Standard Components
Shallow Series	Deep Series			A	B	C	F	 Clamp	 Clamp Screw	
421118-1255-030	421143-125L-030	WG-4125	3.00 / 3.50	0.380	0.630	0.750	0.469	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421119-1255-035	421144-125L-035	WG-4125	3.50 / 4.25	0.380	0.630	0.750	0.469	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421120-1255-0425	421145-125L-0425	WG-4125	4.25 / 5.50	0.380	0.630	0.750	0.469	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421121-1255-055	421146-125L-055	WG-4125	5.50 / 7.50	0.380	0.630	0.750	0.469	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421122-1255-075	421147-125L-075	WG-4125	7.50 / 12.50	0.380	0.630	0.750	0.469	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421123-1255-125	421148-125L-125	WG-4125	12.50 / 40.00	0.380	0.630	0.750	0.469	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421124-1875-030	421149-187L-030	WG-4187	3.00 / 3.50	0.380	0.630	0.750	0.469	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421125-1875-035	421150-187L-035	WG-4187	3.50 / 4.25	0.380	0.630	0.750	0.469	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421126-1875-0425	421151-187L-0425	WG-4187	4.25 / 5.50	0.380	0.630	0.750	0.469	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421127-1875-055	421152-187L-055	WG-4187	5.50 / 7.50	0.380	0.630	0.750	0.469	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421128-1875-075	421153-187L-075	WG-4187	7.50 / 12.50	0.380	0.630	0.750	0.469	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421129-1875-125	421154-187L-125	WG-4187	12.50 / 40.00	0.380	0.630	0.750	0.469	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421130-2505-030	421155-250L-030	WG-6250	3.00 / 4.25	0.560	1.000	1.125	0.469	421320-250GC	1/4-20 x 1 S.H.C.S.	TK-00802
421131-2505-0425	421156-250L-0425	WG-6250	4.25 / 6.00	0.560	1.000	1.125	0.469	421320-250GC	1/4-20 x 1 S.H.C.S.	TK-00802
421132-2505-060	421157-250L-060	WG-6250	6.00 / 8.50	0.560	1.000	1.125	0.469	421320-250GC	1/4-20 x 1 S.H.C.S.	TK-00802
421133-2505-085	421158-250L-085	WG-6250	8.50 / 15.50	0.560	1.000	1.125	0.469	421320-250GC	1/4-20 x 1 S.H.C.S.	TK-00802
421134-2505-155	421159-250L-155	WG-6250	15.50 / 40.00	0.560	1.000	1.125	0.469	421320-250GC	1/4-20 x 1 S.H.C.S.	TK-00802
421135-3125-030	421160-312L-030	WG-8312	3.00 / 5.00	0.750	1.310	1.500	0.469	421321-312GC	1/4-20 x 1 S.H.C.S.	TK-00849
421136-3125-050	421161-312L-050	WG-8312	5.00 / 9.00	0.750	1.310	1.500	0.469	421321-312GC	1/4-20 x 1 S.H.C.S.	TK-00849
421137-3125-090	421162-312L-090	WG-8312	9.00 / 19.00	0.750	1.310	1.500	0.469	421321-312GC	1/4-20 x 1 S.H.C.S.	TK-00849
421138-3125-190	421163-312L-190	WG-8312	19.00 and up	0.750	1.310	1.500	0.469	421321-312GC	1/4-20 x 1 S.H.C.S.	TK-00849
421139-3755-030	421164-375L-030	WG-8375	3.00 / 5.00	0.750	1.310	1.500	0.469	421322-375GC	1/4-20 x 1 S.H.C.S.	TK-00797
421140-3755-050	421165-375L-050	WG-8375	5.00 / 9.00	0.750	1.310	1.500	0.469	421322-375GC	1/4-20 x 1 S.H.C.S.	TK-00797
421141-3755-090	421166-375L-090	WG-8375	9.00 / 19.00	0.750	1.310	1.500	0.469	421322-375GC	1/4-20 x 1 S.H.C.S.	TK-00797
421142-3755-190	421167-375L-190	WG-8375	19.00 and up	0.750	1.310	1.500	0.469	421322-375GC	1/4-20 x 1 S.H.C.S.	TK-00797

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade.  
See pages GP 60-62 for additional shank options.  
See pages GP 10 and GP 11 for inserts.

GROOVING, PROFILING, and CUT-OFF

# Face Grooving Support Blade C



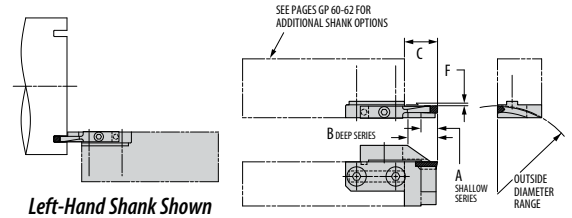
Part Number		Gage 	Outside Diameter Range	Dimensions (inches)				Standard Components		*Tune-Up Kit
Shallow Series	Deep Series			A	B	C	F	 Clamp	 Clamp Screw	Includes all Standard Components
421168-1255-030	421193-125L-030	WG-4125	3.00 / 3.50	0.380	0.630	0.750	0.469	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421169-1255-035	421194-125L-035	WG-4125	3.50 / 4.25	0.380	0.630	0.750	0.469	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421170-1255-0425	421195-125L-0425	WG-4125	4.25 / 5.50	0.380	0.630	0.750	0.469	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421171-1255-055	421196-125L-055	WG-4125	5.50 / 7.50	0.380	0.630	0.750	0.469	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421172-1255-075	421197-125L-075	WG-4125	7.50 / 12.50	0.380	0.630	0.750	0.469	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421173-1255-125	421198-125L-125	WG-4125	12.50 / 40.00	0.380	0.630	0.750	0.469	421323-125GC	1/4-20 x 1 S.H.C.S.	TK-00801
421174-1875-030	421199-187L-030	WG-4187	3.00 / 3.50	0.380	0.630	0.750	0.469	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421175-1875-035	421200-187L-035	WG-4187	3.50 / 4.25	0.380	0.630	0.750	0.469	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421176-1875-0425	421201-187L-0425	WG-4187	4.25 / 5.50	0.380	0.630	0.750	0.469	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421177-1875-055	421202-187L-055	WG-4187	5.50 / 7.50	0.380	0.630	0.750	0.469	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421178-1875-075	421203-187L-075	WG-4187	7.50 / 12.50	0.380	0.630	0.750	0.469	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421179-1875-125	421204-187L-125	WG-4187	12.50 / 40.00	0.380	0.630	0.750	0.469	421324-187GC	1/4-20 x 1 S.H.C.S.	TK-00762
421180-2505-030	421205-250L-030	WG-6250	3.00 / 4.25	0.560	1.000	1.125	0.469	421325-250GC	1/4-20 x 1 S.H.C.S.	TK-00808
421181-2505-0425	421206-250L-0425	WG-6250	4.25 / 6.00	0.560	1.000	1.125	0.469	421325-250GC	1/4-20 x 1 S.H.C.S.	TK-00808
421182-2505-060	421207-250L-060	WG-6250	6.00 / 8.50	0.560	1.000	1.125	0.469	421325-250GC	1/4-20 x 1 S.H.C.S.	TK-00808
421183-2505-085	421208-250L-085	WG-6250	8.50 / 15.50	0.560	1.000	1.125	0.469	421325-250GC	1/4-20 x 1 S.H.C.S.	TK-00808
421184-2505-155	421209-250L-155	WG-6250	15.50 / 40.00	0.560	1.000	1.125	0.469	421325-250GC	1/4-20 x 1 S.H.C.S.	TK-00808
421185-3125-030	421210-312L-030	WG-8312	3.00 / 5.00	0.750	1.310	1.500	0.469	421326-312GC	1/4-20 x 1 S.H.C.S.	TK-00823
421186-3125-050	421211-312L-050	WG-8312	5.00 / 9.00	0.750	1.310	1.500	0.469	421326-312GC	1/4-20 x 1 S.H.C.S.	TK-00823
421187-3125-090	421212-312L-090	WG-8312	9.00 / 19.00	0.750	1.310	1.500	0.469	421326-312GC	1/4-20 x 1 S.H.C.S.	TK-00823
421188-3125-190	421213-312L-190	WG-8312	19.00 and up	0.750	1.310	1.500	0.469	421326-312GC	1/4-20 x 1 S.H.C.S.	TK-00823
421189-3755-030	421214-375L-030	WG-8375	3.00 / 5.00	0.750	1.310	1.500	0.469	421327-375GC	1/4-20 x 1 S.H.C.S.	TK-00839
421190-3755-050	421215-375L-050	WG-8375	5.00 / 9.00	0.750	1.310	1.500	0.469	421327-375GC	1/4-20 x 1 S.H.C.S.	TK-00839
421191-3755-090	421216-375L-090	WG-8375	9.00 / 19.00	0.750	1.310	1.500	0.469	421327-375GC	1/4-20 x 1 S.H.C.S.	TK-00839
421192-3755-190	421217-375L-190	WG-8375	19.00 and up	0.750	1.310	1.500	0.469	421327-375GC	1/4-20 x 1 S.H.C.S.	TK-00839

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See pages GP 60-62 for additional shank options.  
See pages GP 10 and GP 11 for inserts.

GROOVING, PROFILING, and CUT-OFF



# Face Grooving Support Blade D



Part Number		Gage 	Outside Diameter Range	Dimensions (inches)				Standard Components		*Tune-Up Kit Includes all Standard Components
Shallow Series	Deep Series			A	B	C	F			
421268-1255-030	421293-125L-030	WG-4125	3.00 / 3.50	0.380	0.630	0.750	0.031	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421269-1255-035	421294-125L-035	WG-4125	3.50 / 4.25	0.380	0.630	0.750	0.031	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421270-1255-0425	421295-125L-0425	WG-4125	4.25 / 5.50	0.380	0.630	0.750	0.031	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421271-1255-055	421296-125L-055	WG-4125	5.50 / 7.50	0.380	0.630	0.750	0.031	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421272-1255-075	421297-125L-075	WG-4125	7.50 / 12.50	0.380	0.630	0.750	0.031	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421273-1255-125	421298-125L-125	WG-4125	12.50 / 40.00	0.380	0.630	0.750	0.031	421318-125GC	1/4-20 x 1 S.H.C.S.	TK-00800
421274-1875-030	421299-187L-030	WG-4187	3.00 / 3.50	0.380	0.630	0.750	0.031	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421275-1875-035	421300-187L-035	WG-4187	3.50 / 4.25	0.380	0.630	0.750	0.031	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421276-1875-0425	421301-187L-0425	WG-4187	4.25 / 5.50	0.380	0.630	0.750	0.031	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421277-1875-055	421302-187L-055	WG-4187	5.50 / 7.50	0.380	0.630	0.750	0.031	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421278-1875-075	421303-187L-075	WG-4187	7.50 / 12.50	0.380	0.630	0.750	0.031	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421279-1875-125	421304-187L-125	WG-4187	12.50 / 40.00	0.380	0.630	0.750	0.031	421319-187GC	1/4-20 x 1 S.H.C.S.	TK-00794
421280-2505-030	421305-250L-030	WG-6250	3.00 / 4.25	0.560	1.000	1.125	0.031	421320-250GC	1/4-20 x 1 S.H.C.S.	TK-00802
421281-2505-0425	421306-250L-0425	WG-6250	4.25 / 6.00	0.560	1.000	1.125	0.031	421320-250GC	1/4-20 x 1 S.H.C.S.	TK-00802
421282-2505-060	421307-250L-060	WG-6250	6.00 / 8.50	0.560	1.000	1.125	0.031	421320-250GC	1/4-20 x 1 S.H.C.S.	TK-00802
421283-2505-085	421308-250L-085	WG-6250	8.50 / 15.50	0.560	1.000	1.125	0.031	421320-250GC	1/4-20 x 1 S.H.C.S.	TK-00802
421284-2505-155	421309-250L-155	WG-6250	15.50 / 40.00	0.560	1.000	1.125	0.031	421320-250GC	1/4-20 x 1 S.H.C.S.	TK-00802
421285-3125-030	421310-312L-030	WG-8312	3.00 / 5.00	0.750	1.310	1.500	0.031	421321-312GC	1/4-20 x 1 S.H.C.S.	TK-00849
421286-3125-050	421311-312L-050	WG-8312	5.00 / 9.00	0.750	1.310	1.500	0.031	421321-312GC	1/4-20 x 1 S.H.C.S.	TK-00849
421287-3125-090	421312-312L-090	WG-8312	9.00 / 19.00	0.750	1.310	1.500	0.031	421321-312GC	1/4-20 x 1 S.H.C.S.	TK-00849
421288-3125-190	421313-312L-190	WG-8312	19.00 and up	0.750	1.310	1.500	0.031	421321-312GC	1/4-20 x 1 S.H.C.S.	TK-00849
421289-3755-030	421314-375L-030	WG-8375	3.00 / 5.00	0.750	1.310	1.500	0.031	421322-375GC	1/4-20 x 1 S.H.C.S.	TK-00797
421290-3755-050	421315-375L-050	WG-8375	5.00 / 9.00	0.750	1.310	1.500	0.031	421322-375GC	1/4-20 x 1 S.H.C.S.	TK-00797
421291-3755-090	421316-375L-090	WG-8375	9.00 / 19.00	0.750	1.310	1.500	0.031	421322-375GC	1/4-20 x 1 S.H.C.S.	TK-00797
421292-3755-190	421317-375L-190	WG-8375	19.00 and up	0.750	1.310	1.500	0.031	421322-375GC	1/4-20 x 1 S.H.C.S.	TK-00797

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See pages GP 60-62 for additional shank options.  
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GROOVING, PROFILING, and CUT-OFF



# Technical Data

## Face Grooving Tools - Ordering Instructions

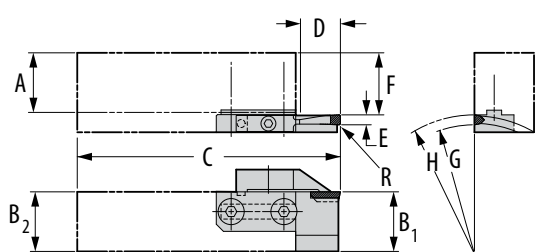
Face grooving tools must be matched to a specific radius and are, therefore, manufactured to order for your particular application.

We offer tools either with integral support blades (SFG) or with separate replaceable blades (AFG). Four combinations are available relative to hand of tool and hand of radius.

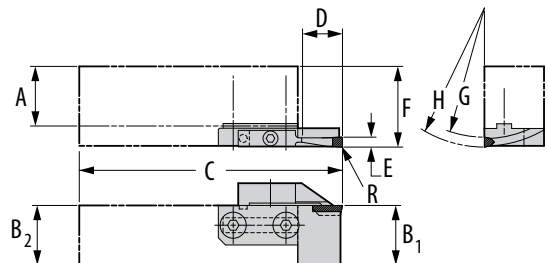
When ordering replaceable blade styles, we suggest the purchase of additional back-up blades at time of original order.

For your convenience in ordering or request for quotation, we have published sample blank engineering data forms. You must provide ALL of the dimensional data listed to ensure the correct tool being manufactured.

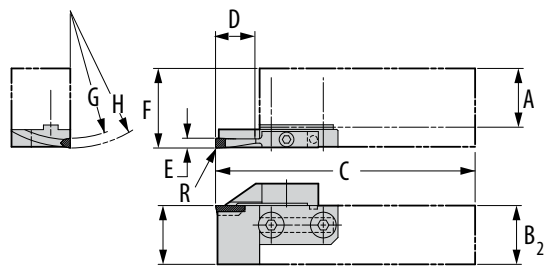
*Note: Tools will be quoted either with radius relieved blades or angular relieved blades, according to groove diameter. Radius relieved blades are illustrated.*



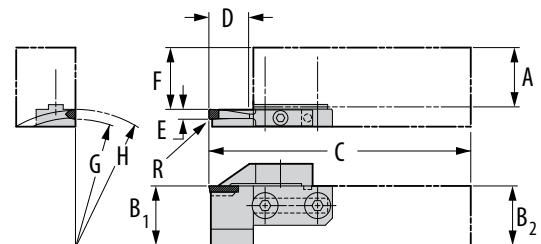
AFGVLL



AFGVLR



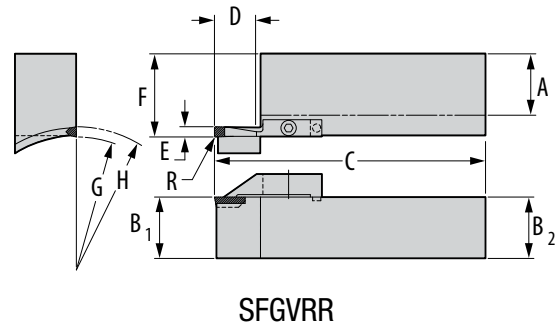
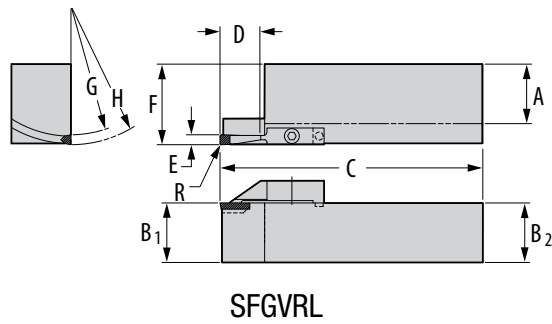
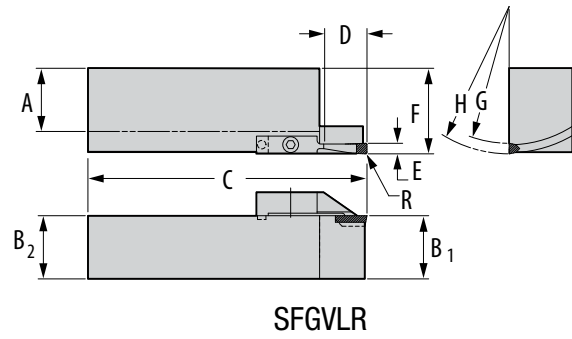
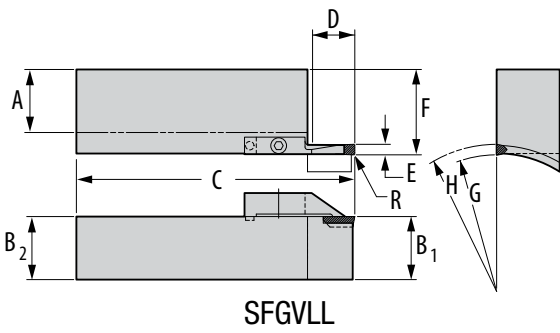
AFGVRL



AFGVRR

<b>AFGV__</b>	A	C	F
Drawing #	B <sub>1</sub>	D (depth of cut)	G (radius)
R (radius)	B <sub>2</sub>	E	H (radius)

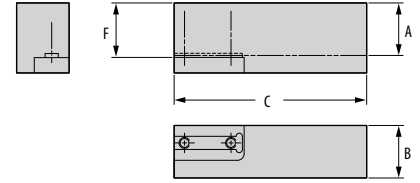
GROOVING, PROFILING, and CUT-OFF



<b>SFGV__</b>	A	C	F
Drawing #	B <sub>1</sub>	D (depth of cut)	G (radius)
R (radius)	B <sub>2</sub>	E	H (radius)

# Straight Shank Holder

For Support Blades

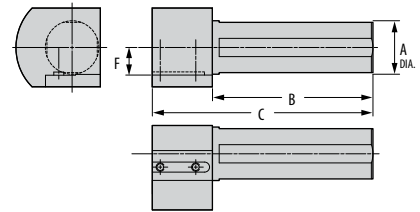


Part Number		Dimensions (inches)				Standard Components	*Tune-Up Kit
Right	Left	A	B	C	F	Mounting Screw	Includes all Standard Components
411055	411056	1.000	1.000	4.500	1.031	5/16-18 x 1 F.H.C.S.	TK-00579
411059	411449	1.250	1.250	5.500	1.281	5/16-18 x 1 F.H.C.S.	TK-00579
411015	411016	1.500	1.500	7.500	1.531	5/16-18 x 1 F.H.C.S.	TK-00579

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

# Round Shank Holder

For Support Blades

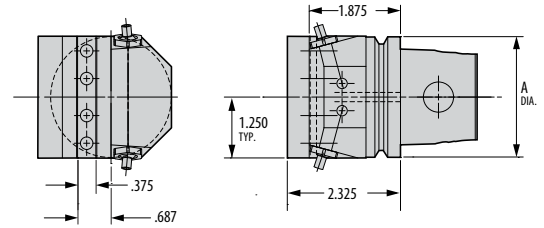



Part Number		Dimensions (inches)				Standard Components	*Tune-Up Kit
Right	Left	A	B	C	F	Mounting Screw	Includes all Standard Components
519600	519601	1.500	6.000	8.250	1.031	5/16-18 X 1 F.H.C.S.	TK-00579
519602	519603	2.000	6.000	8.250	1.281	5/16-18 X 1 F.H.C.S.	TK-00579
519604	519605	2.500	6.000	8.250	1.531	5/16-18 X 1 F.H.C.S.	TK-00579

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

# KM Shank

## Face Mount



Part Number	Dimensions (inches)	Standard Components	*Tune-Up Kit
Face Mount †	A	 Mounting Screw	Includes all Standard Components
SBH-KM50-F	1.969	5/16-18 X 1 F.H.C.S.	TK-00579
SBH-KM63-F	2.480	5/16-18 X 1 F.H.C.S.	TK-00579

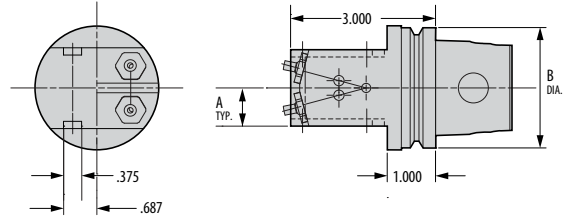
High-pressure coolant – 1,500 PSI Max (100 bar)


\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

† These tools based on KM63UT shank.

# KM Shank

## Side Mount



Part Number	Dimensions (inches)		Standard Components	*Tune-Up Kit
Face Mount †	A	B	 Mounting Screw	Includes all Standard Components
SBH-KM50-S	0.687	1.969	5/16-18 X 1 F.H.C.S.	TK-00579
SBH-KM63-S	0.790	2.480	5/16-18 X 1 F.H.C.S.	TK-00579

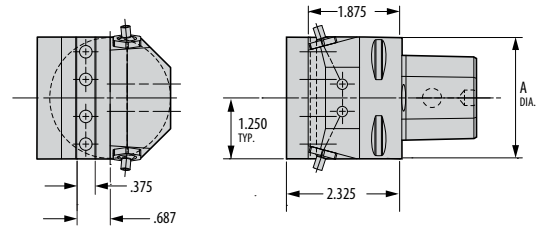
High-pressure coolant – 1,500 PSI Max (100 bar)


\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

† These tools based on KM63UT shank.

# ISO 26623 Shank

## Face Mount



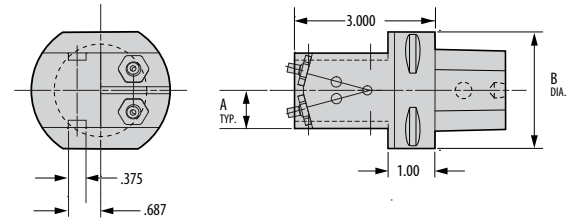
Part Number	Dimensions (inches)	Standard Components	*Tune-Up Kit
Face Mount	A	 Mounting Screw	Includes all Standard Components
SBH-C5-F	1.969	5/16-18 X 1 F.H.C.S.	TK-00579
SBH-C6-F	2.480	5/16-18 X 1 F.H.C.S.	TK-00579


High-pressure coolant – 1,500 PSI Max (100 bar)

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

# ISO 26623 Shank

## Side Mount



Part Number	Dimensions (inches)		Standard Components	*Tune-Up Kit
Face Mount	A	B	 Mounting Screw	Includes all Standard Components
SBH-C5-S	0.687	1.969	5/16-18 X 1 F.H.C.S.	TK-00579
SBH-C6-S	0.790	2.480	5/16-18 X 1 F.H.C.S.	TK-00579

High-pressure coolant – 1,500 PSI Max (100 bar)

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.