



INTRODUCTION

MILLING

TURNING AND BORING

HEAVY TURNING

GROOVING, PROFILING AND CUT-OFF

API RING-GROOVE MACHINING

INDEXABLE DRILLING

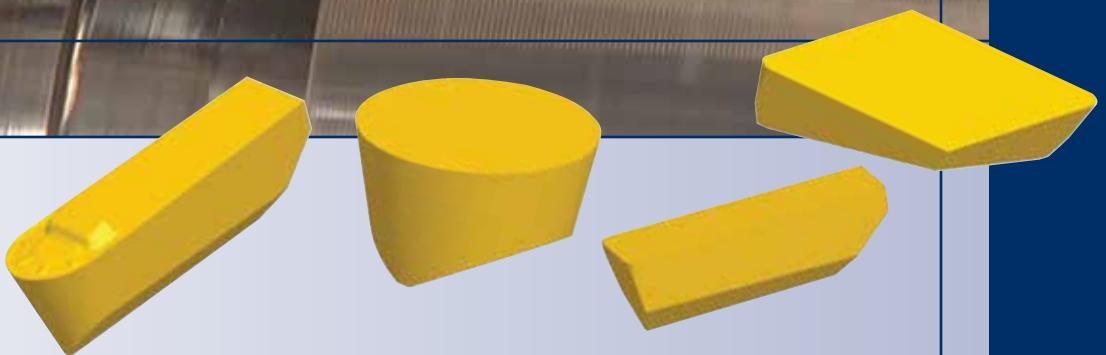
TUBE SCARFING

SPECIAL ENGINEERING

APPLICATION and TECHNICAL INFORMATION

2016 METRIC

GROOVING, PROFILING, CUT-OFF



**Grooving, Profiling and.....GP 02-03  
Cut-Off Inserts**

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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. Every application on the shop floor can use this unique tooling system that accommodates both ceramic and carbide inserts.

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

Greenleaf is the industry leader in the development and manufacture of ceramic and coated ceramic inserts including WG-600®, the only commercially available, second generation, coated ceramic-composite cutting tool using whisker reinforcement. WG-600 is one of seven prominent advanced-ceramic grades that continue to increase productivity in industry.



*Greenleaf Corporation is continually upgrading its products.  
For the most current information, please visit our web site at:*

[www.greenleafglobalsupport.com](http://www.greenleafglobalsupport.com)

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## CARBIDE

**Greenleaf offers a comprehensive line of carbide inserts in grades ranging from sub-micron C-1 through C-8 classifications. An industry pioneer in coated carbide, Greenleaf offers a variety of uncoated, MT-CVD coated and PVD-coated grades. Carbide inserts are available in ANSI standard geometries with multi-purpose chipbreakers for heavy roughing through finishing.**

### COATED – MT-CVD

**GA5025** A high-speed MT-CVD coated grade for turning, light roughing and finishing of carbon and alloy steels, as well as selected stainless steels.

**GA5026** A high-speed grade developed for turning nickel- and cobalt-based super-alloys, stainless steels, and refractory metals. The advanced MT-CVD coating over a micro-grain substrate offers high wear resistance. GA5026 has exceptional resistance to the notching and deformation common to machining high strength materials. Apply at high speeds and light feeds in turning and selected milling applications.

**GA5035** A high-performance MT-CVD coated grade for turning all types of steels, and selected stainless steels. GA5035 can be used in rough, semi-finish, and finish turning situations requiring resistance to heat deformation, thermal shock, and abrasion. GA5035 should be applied at high speeds and a range of feeds.

**GA5125** New high-performance MT-CVD coated carbide milling grade especially suited for manganese steel. GA5125 is also applicable on chrome-moly steel, tool steel and similar high alloy steels. GA5125 provides excellent resistance to abrasion, crater wear, thermal shock, deformation and edge build-up. GA5125 should be applied at high speeds with moderate feed rates.

### COATED – PVD

**G-915** Multi-layer PVD-coated grade, excellent for cut off, milling and turning high-temp alloys, stainless steel, and low carbon steels. The multi-layer PVD coating adds heat and abrasion resistance to the tough, shock-resistant substrate. G-915 should be run at moderate speeds and moderate to high feeds in milling and interrupted turning applications.

**G-920** PVD-coated grade for turning and milling high-strength materials such as high-temp alloys, titanium and stainless steel. G-920 is also an excellent grade for aluminum and refractory metals. This grade has the resistance to deformation and notching required for higher speeds than G-910.

**G-925** Multi-layer PVD-coated grade specifically designed for machining abrasive and difficult-to-machine materials. Typical applications include high-temp alloys, titanium and other refractory metals, stainless steel, and many cast irons. G-925 exhibits excellent resistance to notching and deformation. Apply at moderate to high speeds and moderate feeds.

**G-935** Multi-layer PVD-coated grade for steel milling and turning applications requiring additional resistance to mechanical and thermal shock. The multi-layered PVD coating increases the speed capability and wear resistance in tough milling and interrupted turning applications.

### UNCOATED

**G-20M** A sub-micron C-2 carbide grade suited for use in turning and milling titanium and nickel-based super-alloys. G-20M has the strength and edge wear characteristics to resist notching when turning high-strength materials.

### CERAMIC

**Greenleaf is the industry leader in the development and manufacture of ceramic and coated ceramic inserts in ANSI standard and special geometries. Some of the most prominent include:**

**WG-300®** Whisker-reinforced ceramic with excellent wear and shock resistance at high surface speeds. WG-300 is very effective at machining nickel and cobalt based super-alloys, and other hard materials at metal removal rates up to 10 times higher than carbide.

**WG-600®** Coated whisker-reinforced ceramic offering longer tool life and better performance over uncoated ceramics due to outstanding thermal properties and shock-resistance at high cutting speeds. Application areas include rough and finish turning, as well as high-performance milling of high-strength alloys, hardened steels and select stainless steels.

*U.S. Patent No. 6,447,896 B1.*

**WG-700™** New whisker-reinforced  $\text{Al}_2\text{O}_3$  ceramic substrate featuring improved toughness and a unique high-speed coating. WG-700 is ideal for machining nickel- and cobalt-based super alloys and other difficult-to-machine materials. WG-700 exhibits high metal-removal rates with exceptional tool life. *U.S. Patent No. 6,447,896 B1*

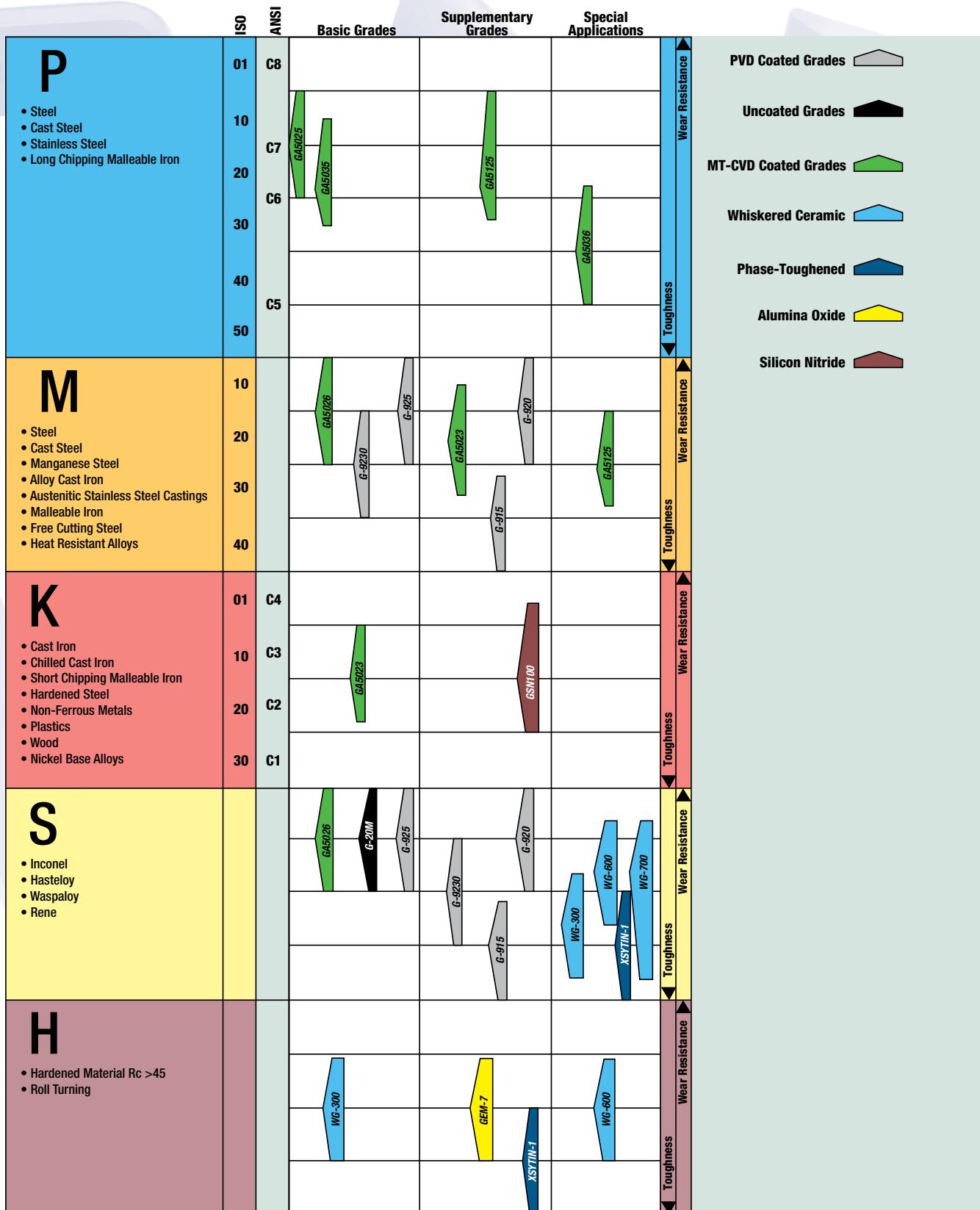
**XSYTIN™-1** New phase-toughened ceramic capable of extreme feed rates. XSYTIN™-1 excels at machining a wide variety of materials including steels, cast and ductile irons, high-temperature alloys and other challenging metals. XSYTIN™-1 is ideal for use in interrupted cuts, scale, abrasive casting materials and milling.

**GSN100™** New engineered blend of silicon nitride and proprietary toughening agents that redefines productivity in the machining of cast iron. GSN100 delivers outstanding tool life at high cutting speeds in turning, grooving and milling applications.

**GEM-7™**  $\text{Al}_2\text{O}_3 + \text{TiC}$  composite ceramic with a high degree of predictability in roll turning and hard alloy (up to 65 R/c) machining.

**GEM-19™** Cold pressed and sintered  $\text{Al}_2\text{O}_3$  ceramic for economical roughing and finishing of cast iron grades application range on severe interruption or old machinery.

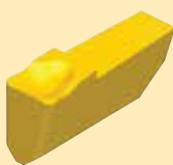
# Insert Grade Reference for Grooving, Profiling and Cut Off

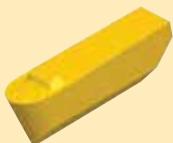
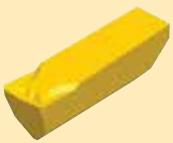
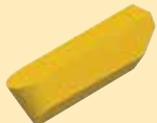




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**Greenleaf Cut-Off System**

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**Full Nose**  
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**V-Bottom Round Inserts**

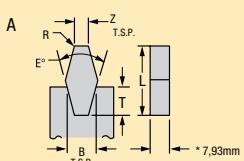
**RCGX**  
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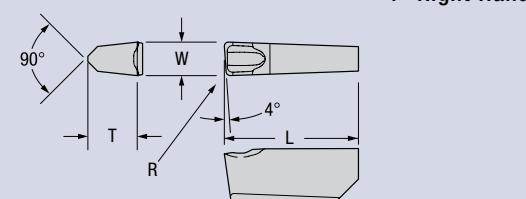
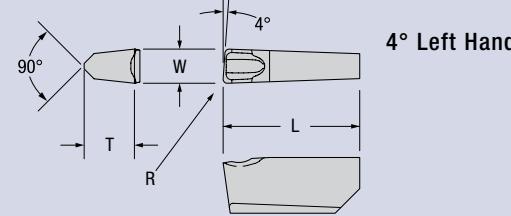
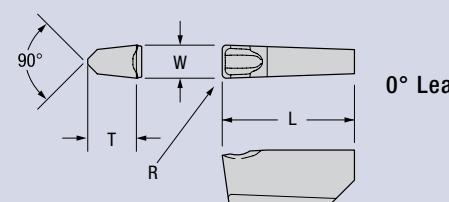
**RCGT/RPGT**  
Positive Chipform  
V-Bottom  
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**Pulley and  
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# Greenleaf Cut-Off System

Shape: Groove/Turn	Part Number ISO	G-915	Part Number ANSI	Dimensions (millimeters)			
				W	L	T	R
	COS-4094-0	●	COS-4094-0	2,39	12,70	4,75	0,25
	COS-4125-0	●	COS-4125-0	3,18	12,70	4,75	0,25
	COS-4187-0	●	COS-4187-0	4,75	12,70	4,75	0,25
	COS-4094-4L	●	COS-4094-4L	2,39	12,70	4,75	0,25
	COS-4125-4L	●	COS-4125-4L	3,18	12,70	4,75	0,25
	COS-4187-4L	●	COS-4187-4L	4,75	12,70	4,75	0,25
	COS-4094-4R	●	COS-4094-4R	2,39	12,70	4,75	0,25
	COS-4125-4R	●	COS-4125-4R	3,18	12,70	4,75	0,25
	COS-4187-4R	●	COS-4187-4R	4,75	12,70	4,75	0,25
Carbide Coatings		G-915					
		PVD Coated					



See pages GP29, GP32, GP34, GP35, GP43 and GP44 for toolholders.

## Greenleaf Sales

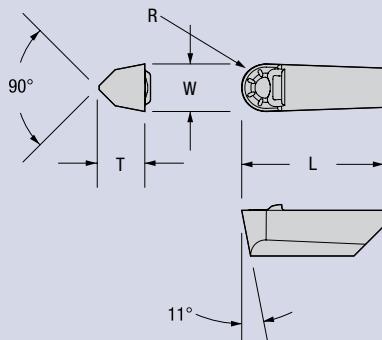
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 Stocked Standard

 Stocked or Available Upon Request

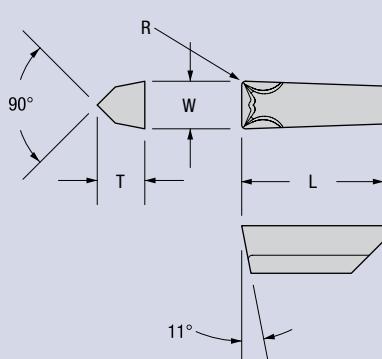
# Full Nose Grooving Inserts

Shape: Groove/Turn	Part Number	Dimensions (millimeters)					
		ANSI	W	L	T	R	
	GTS-4125	● ● ● ● ●	GTS-4125	3,18	12,70	4,75	1,59
	GTS-4187	● ● ● ● ●	GTS-4187	4,75	12,70	4,75	2,37
	GTS-6250	● ● ○ ● ●	GTS-6250	6,35	19,05	6,35	3,18
Carbide Coatings							
MT-CVD Coated		GA5026	GA5035	G-935	G-925	G-915	
PVD Coated							
Uncoated							



# Flat Nose Grooving Inserts

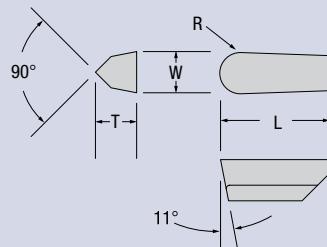
Shape: Groove/Turn	Part Number	Dimensions (millimeters)					
		ANSI	W	L	T	R	
	GTS-4125-1	● ● ● ● ●	GTS-4125-1	3,18	12,70	4,75	0,38
	GTS-4125-2	● ● ● ● ●	GTS-4125-2	3,18	12,70	4,75	0,79
	GTS-4187-1	● ● ● ● ●	GTS-4187-1	4,75	12,70	4,75	0,38
	GTS-4187-2	● ● ● ● ●	GTS-4187-2	4,75	12,70	4,75	0,79
	GTS-6250-1	● ● ● ● ●	GTS-6250-1	6,35	19,05	6,35	0,38
	GTS-6250-2	● ● ● ● ●	GTS-6250-2	6,35	19,05	6,35	0,79
Carbide Coatings							
MT-CVD Coated		GA5026	GA5035	G-935	G-915		
PVD Coated							
Uncoated							



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# WG-Style, Full Nose Grooving Inserts



Shape: Groover	Part Number	ISO							Part Number	Dimensions (millimeters)														
			WG-300	WG-600	WG-700	Whisker	XSYTIN-1	Phase Toughened	GSN100	Si <sub>3</sub> N <sub>4</sub>	GEM-19	Al <sub>2</sub> O <sub>3</sub>	W	L	T	R								
	WG-4094		● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-4094	2,39	12,70	4,75	1,19							
	WG-4125		● ● ○	● ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	WG-4125	3,18	12,70	4,75	1,59							
	WG-4156		● ● ○	● ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	WG-4156	3,96	12,70	4,75	1,98							
	WG-4187		● ● ○	● ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	WG-4187	4,75	12,70	4,75	2,37							
	WG-6218		● ● ○	● ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	WG-6218	5,54	19,05	6,35	2,77							
	WG-6250		● ● ○	● ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	WG-6250	6,35	19,05	6,35	3,18							
	WG-6281		● ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	WG-6281	7,14	19,05	6,35	3,57							
	WG-8312		○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	WG-8312	7,93	25,40	8,56	3,96							
	WG-8344		○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	WG-8344	8,74	25,40	8,56	4,37							
	WG-8375		● ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	○ ○ ○	WG-8375	9,53	25,40	8,56	4,76							
<b>Ceramic Classification</b> <table style="margin-left: auto; margin-right: auto;"> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Whisker Ceramic</td> <td>Phase Toughened</td> <td>Silicon Nitride</td> <td>Alumina TiC</td> <td>Al<sub>2</sub>O<sub>3</sub></td> </tr> </table>																				Whisker Ceramic	Phase Toughened	Silicon Nitride	Alumina TiC	Al <sub>2</sub> O <sub>3</sub>
																								
Whisker Ceramic	Phase Toughened	Silicon Nitride	Alumina TiC	Al <sub>2</sub> O <sub>3</sub>																				

Page GP 04 – grade description

\* The standard edge prep for WG groovers is "A" hone (0,012–0,025mm).

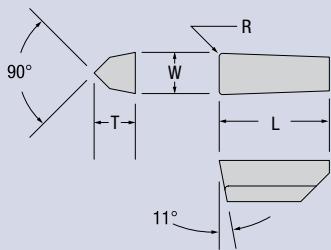
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# WG-Style, Flat Nose Grooving Inserts



Shape: Groover	Part Number							Part Number	Dimensions (millimeters)					
		WG-300	WG-600	WG-700	XSTIN-1	GSN100	Si <sub>3</sub> N <sub>4</sub>	GEM-19	Al <sub>2</sub> O <sub>3</sub>	W	L	T	R	
	WG-4094-1	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-4094-1	2,39	12,70	4,75	0,38
	WG-4094-2	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-4094-2	2,39	12,70	4,75	0,79
	WG-4125-1	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-4125-1	3,18	12,70	4,75	0,38
	WG-4125-2	● ○	● ○	● ○	○ ○	● ○	○ ○	○ ○	○ ○	WG-4125-2	3,18	12,70	4,75	0,79
	WG-4156-1	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-4156-1	3,96	12,70	4,75	0,38
	WG-4156-2	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-4156-2	3,96	12,70	4,75	0,79
	WG-4156-3	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-4156-3	3,96	12,70	4,75	1,17
	WG-4187-1	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-4187-1	4,75	12,70	4,75	0,38
	WG-4187-2	● ○	● ○	● ○	○ ○	● ○	○ ○	○ ○	○ ○	WG-4187-2	4,75	12,70	4,75	0,79
	WG-6218-1	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-6218-1	5,54	19,05	6,35	0,38
	WG-6218-2	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-6218-2	5,54	19,05	6,35	0,79
	WG-6250-1	● ●	● ●	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-6250-1	6,35	19,05	6,35	0,38
	WG-6250-2	● ●	● ●	● ○	○ ○	● ○	○ ○	○ ○	○ ○	WG-6250-2	6,35	19,05	6,35	0,79
	WG-6250-3	● ●	● ●	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-6250-3	6,35	19,05	6,35	1,17
	WG-6250-4	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-6250-4	6,35	19,05	6,35	1,57
	WG-6281-1	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-6281-1	7,14	19,05	6,35	0,38
	WG-6281-2	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-6281-2	7,14	19,05	6,35	0,79
	WG-6281-3	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-6281-3	7,14	19,05	6,35	1,17
	WG-8312-1	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-8312-1	7,92	25,40	8,56	0,38
	WG-8312-2	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-8312-2	7,92	25,40	8,56	0,79
	WG-8312-3	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-8312-3	7,92	25,40	8,56	1,17
	WG-8312-4	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-8312-4	7,92	25,40	8,56	1,57
	WG-8344-1	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-8344-1	8,74	25,40	8,56	0,38
	WG-8344-2	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-8344-2	8,74	25,40	8,56	0,79
	WG-8344-3	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-8344-3	8,74	25,40	8,56	1,17
	WG-8344-4	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-8344-4	8,74	25,40	8,56	1,57
	WG-8375-1	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-8375-1	9,53	25,40	8,56	0,38
	WG-8375-2	● ○	● ○	● ○	○ ○	● ○	○ ○	○ ○	○ ○	WG-8375-2	9,53	25,40	8,56	0,79
	WG-8375-3	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-8375-3	9,53	25,40	8,56	1,17
	WG-8375-4	● ○	● ○	● ○	○ ○	○ ○	○ ○	○ ○	○ ○	WG-8375-4	9,53	25,40	8,56	1,57

**Ceramic Classification**


Whisker Ceramic



Phase Toughened



Silicon Nitride


 Alumina TiC Al<sub>2</sub>O<sub>3</sub>

WG-300	WG-600	WG-700	XSTIN-1	GSN100	Si <sub>3</sub> N <sub>4</sub>	GEM-19	Al <sub>2</sub> O <sub>3</sub>
Whisker	Phase Toughened	Si <sub>3</sub> N <sub>4</sub>	Al <sub>2</sub> O <sub>3</sub>				

Page GP 04 – grade description

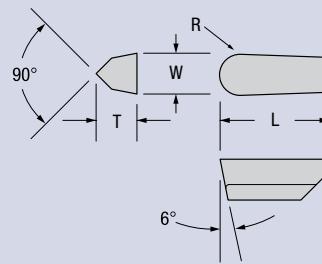
\* The standard edge prep for WG groovers is "A" hone (0,012–0,025mm).

 Stocked or Available Upon Request  

 Stocked Standard  

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# WGC Full Nose Grooving Inserts



Shape: Groover	Part Number	Whisker								Part Number	Dimensions (millimeters)				
		WG-300	WG-600	WG-700	Phase toughened	XSYTIN-1	GSN100	SiaN <sub>4</sub>	GEM-7		W	L	T	R	
	WGC-4094	○	○	○	○	○	○	○	○	WGC-4094	2,39	12,70	4,75	1,19	
	WGC-4125	○	○	○	○	○	○	○	○	WGC-4125	3,18	12,70	4,75	1,59	
	WGC-4156	○	○	○	○	○	○	○	○	WGC-4156	3,96	12,70	4,75	1,98	
	WGC-4187	○	○	○	○	○	○	○	○	WGC-4187	4,75	12,70	4,75	2,37	
	WGC-6218	○	○	○	○	○	○	○	○	WGC-6218	5,54	19,05	6,35	2,77	
	WGC-6250	○	○	○	○	○	●	○	○	WGC-6250	6,35	19,05	6,35	3,18	
	WGC-6281	○	○	○	○	○	○	○	○	WGC-6281	7,14	19,05	6,35	3,57	
	WGC-8312	○	○	○	○	○	○	○	○	WGC-8312	7,93	25,40	8,56	3,96	
	WGC-8344	○	○	○	○	○	○	○	○	WGC-8344	8,74	25,40	8,56	4,37	
	WGC-8375	○	○	○	○	○	○	○	○	WGC-8375	9,53	25,40	8,56	4,76	
Ceramic Classification															
Whisker Ceramic		■	■	■	■	■	■	■	■	Whisker	WG-300	WG-600	WG-700	XSYTIN-1	GSN100
Phase Toughened		■	■	■	■	■	■	■	■	SiaN <sub>4</sub>	○	○	○	○	○
Silicon Nitride		■	■	■	■	■	■	■	■	Al <sub>2</sub> O <sub>3</sub> -TiC	○	○	○	○	○
Alumina TiC		■	■	■	■	■	■	■	■	GEM-7	○	○	○	○	○
Al <sub>2</sub> O <sub>3</sub>		■	■	■	■	■	■	■	■	GEM-19	○	○	○	○	○

Page GP 04 – grade description

\* WGC style inserts come standard with a "T1A" edge prep (0,05–0,10mm x 20 degrees and 0,012–0,025mm hone).

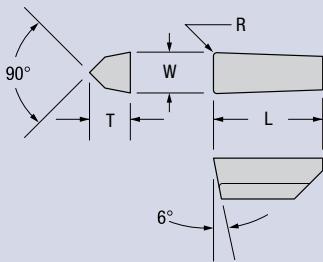
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# WGC Flat Nose Grooving Inserts



Shape: Groover	Part Number	Whisker								Part Number	Dimensions (millimeters)						
		WG-300	WG-600	WG-700	XSY/TIN-1	Phase Toughened	GSN100	Si <sub>3</sub> N <sub>4</sub>	GEM-7	Al <sub>2</sub> O <sub>3</sub> -TiC	GEM-19	Al <sub>2</sub> O <sub>3</sub>	W	L	T	R	
	WGC-4094-1	○	○	○	○	○	○	○	○	○	○	○	WGC-4094-1	2,39	12,70	4,75	0,38
	WGC-4094-2	○	○	○	○	○	○	○	○	○	○	○	WGC-4094-2	2,39	12,70	4,75	0,79
	WGC-4125-1	○	○	○	○	○	●	○	○	○	○	○	WGC-4125-1	3,18	12,70	4,75	0,38
	WGC-4125-2	○	○	○	○	○	○	○	○	○	○	○	WGC-4125-2	3,18	12,70	4,75	0,79
	WGC-4156-1	○	○	○	○	○	○	○	○	○	○	○	WGC-4156-1	3,96	12,70	4,75	0,38
	WGC-4156-2	○	○	○	○	○	○	○	○	○	○	○	WGC-4156-2	3,96	12,70	4,75	0,79
	WGC-4187-1	○	○	○	○	○	○	○	○	○	○	○	WGC-4187-1	4,75	12,70	4,75	0,38
	WGC-4187-2	○	○	○	○	○	○	○	○	○	○	○	WGC-4187-2	4,75	12,70	4,75	0,79
	WGC-6218-1	○	○	○	○	○	○	○	○	○	○	○	WGC-6218-1	5,54	19,05	6,35	0,38
	WGC-6218-2	○	○	○	○	○	○	○	○	○	○	○	WGC-6218-2	5,54	19,05	6,35	0,79
	WGC-6250-1	○	○	○	○	○	○	○	○	○	○	○	WGC-6250-1	6,35	19,05	6,35	0,38
	WGC-6250-2	○	○	○	○	○	○	○	○	○	○	○	WGC-6250-2	6,35	19,05	6,35	0,79
	WGC-6250-3	○	○	○	○	○	○	○	○	○	○	○	WGC-6250-3	6,35	19,05	6,35	1,17
	WGC-6281-1	○	○	○	○	○	○	○	○	○	○	○	WGC-6281-1	7,14	19,05	6,35	0,38
	WGC-6281-2	○	○	○	○	○	○	○	○	○	○	○	WGC-6281-2	7,14	19,05	6,35	0,79
	WGC-6281-3	○	○	○	○	○	○	○	○	○	○	○	WGC-6281-3	7,14	19,05	6,35	1,17
	WGC-8312-1	○	○	○	○	○	○	○	○	○	○	○	WGC-8312-1	7,92	25,40	8,56	0,38
	WGC-8312-2	○	○	○	○	○	○	○	○	○	○	○	WGC-8312-2	7,92	25,40	8,56	0,79
	WGC-8312-3	○	○	○	○	○	○	○	○	○	○	○	WGC-8312-3	7,92	25,40	8,56	1,17
	WGC-8312-4	○	○	○	○	○	○	○	○	○	○	○	WGC-8312-4	7,92	25,40	8,56	1,57
	WGC-8344-1	○	○	○	○	○	○	○	○	○	○	○	WGC-8344-1	8,74	25,40	8,56	0,38
	WGC-8344-2	○	○	○	○	○	○	○	○	○	○	○	WGC-8344-2	8,74	25,40	8,56	0,79
	WGC-8344-3	○	○	○	○	○	○	○	○	○	○	○	WGC-8344-3	8,74	25,40	8,56	1,17
	WGC-8344-4	○	○	○	○	○	○	○	○	○	○	○	WGC-8344-4	8,74	25,40	8,56	1,57
	WGC-8375-1	○	○	○	○	○	○	○	○	○	○	○	WGC-8375-1	9,53	25,40	8,56	0,38
	WGC-8375-2	○	○	○	○	○	○	○	○	○	○	○	WGC-8375-2	9,53	25,40	8,56	0,79
	WGC-8375-3	○	○	○	○	○	○	○	○	○	○	○	WGC-8375-3	9,53	25,40	8,56	1,17
	WGC-8375-4	○	○	○	○	○	○	○	○	○	○	○	WGC-8375-4	9,53	25,40	8,56	1,57
Ceramic Classification																	
 Whisker Ceramic  Phase Toughened  Silicon Nitride  Alumina TiC  Al <sub>2</sub> O <sub>3</sub>																	
Page GP 04 – grade description																	

\* WGC style inserts come standard with a "T1A" edge prep (0,05–0,10mm x 20° and 0,012–0,025mm hone).

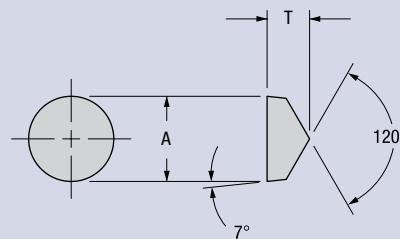
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Stocked Standard

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# Round: Positive V-Bottom Inserts (RCGX)

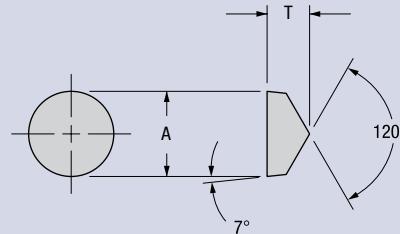
Carbide

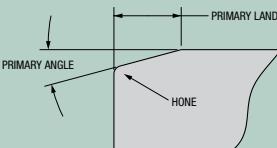
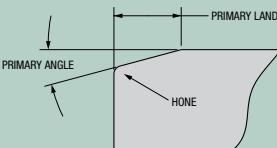
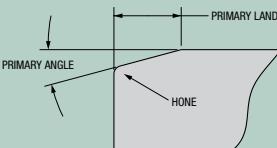


Shape: Round V-Bottom	Part Number ISO	Steel				Stainless Steel				Cast Iron		High-Temp Alloys		Part Number ANSI	Dimensions (millimeters) A      T		
		P15	P25	P25	P35	GA5025	GA5035	GA5125	GA5036	M15	GA5026	M15	K15	S			
	RCGX-060400	○	○	○	○	○	○	○	○	○	○	○	○	○	RCGN-2V	6,35      4,75	
	RCGX-060600	○	○	○	○	○	○	○	○	○	○	○	○	○	RCGX-102	6,35      6,35	
	RCGX-090700	○	○	○	○	●	●	○	○	○	○	○	●	●	RCGN-3V	9,53      7,92	
	RCGX-120700	○	○	○	○	●	●	○	○	○	○	●	●	●	RCGN-4V	12,70      7,92	
Carbide Coatings		 MT-CVD Coated	 PVD Coated	 Uncoated	P15	GA5025	GA5035	GA5125	GA5036	M15	GA5026	M15	K15	S	G-20M		
					P25	GA5026	GA5036	GA5125	GA5036	M15	GA5026	M15					
					P25	M15	GA5026	GA5125	GA5036	G-925	M15	G-920					
					P35	M15	GA5026	GA5125	GA5036	M20	GA5023	M20					
										M35	GA5023	M35					
											GA5023	GA5026					
												G-915					
													G-925				
													G-920				
													G-915				
														G-20M			

# Round: Positive V-Bottom Inserts (RCGX)

Ceramic



Shape: Round V-Bottom	Part Number ISO	Edge Prep*	Whisker				Part Number ANSI	Edge Prep*	Dimensions (millimeters) A      T				
			WG-300	WG-500	WG-700	XSYTIN-1							
	RCGX-060400	T1	●	●	●	●	○	○	○	RCGN-2V	T1	6,35	4,75
		T2A	●	○	○	○	○	●	○		T2A	6,35	4,75
	RCGX-090700	T1	●	●	●	●	●	●	○	RCGN-3V	T1	9,53	7,92
		T1A	○	○	○	○	○	○	○		T1A	9,53	7,92
	RCGX-120700	T2A	●	○	○	○	○	●	○	RCGN-4V	T2A	9,53	7,92
		T1	●	●	●	●	●	●	○		T1	12,70	7,92
		T1A	●	●	●	●	○	○	○		T1A	12,70	7,92
		T2	●	○	●	○	○	○	○		T2	12,70	7,92
		T2A	●	●	●	●	○	●	○		T2A	12,70	7,92
Ceramic Classification												Additional Edge Preps	
 Whisker Ceramic  Phase Toughened Ceramic  Silicon Nitride  Alumina TiC  Al <sub>2</sub> O <sub>3</sub>												 Primary Land  Primary Angle  Hone	

\* If edge prep is not shown, call Greenleaf technical service for assistance.

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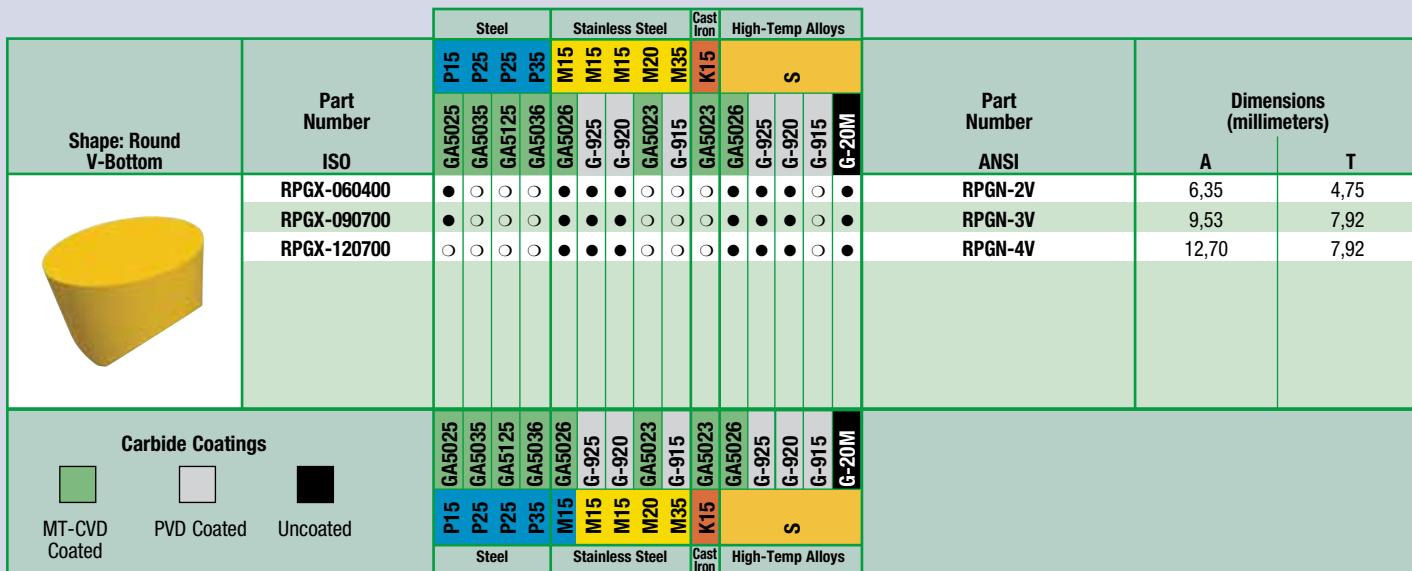
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 Stocked Standard   
  Stocked or Available Upon Request   
  Not Recommended



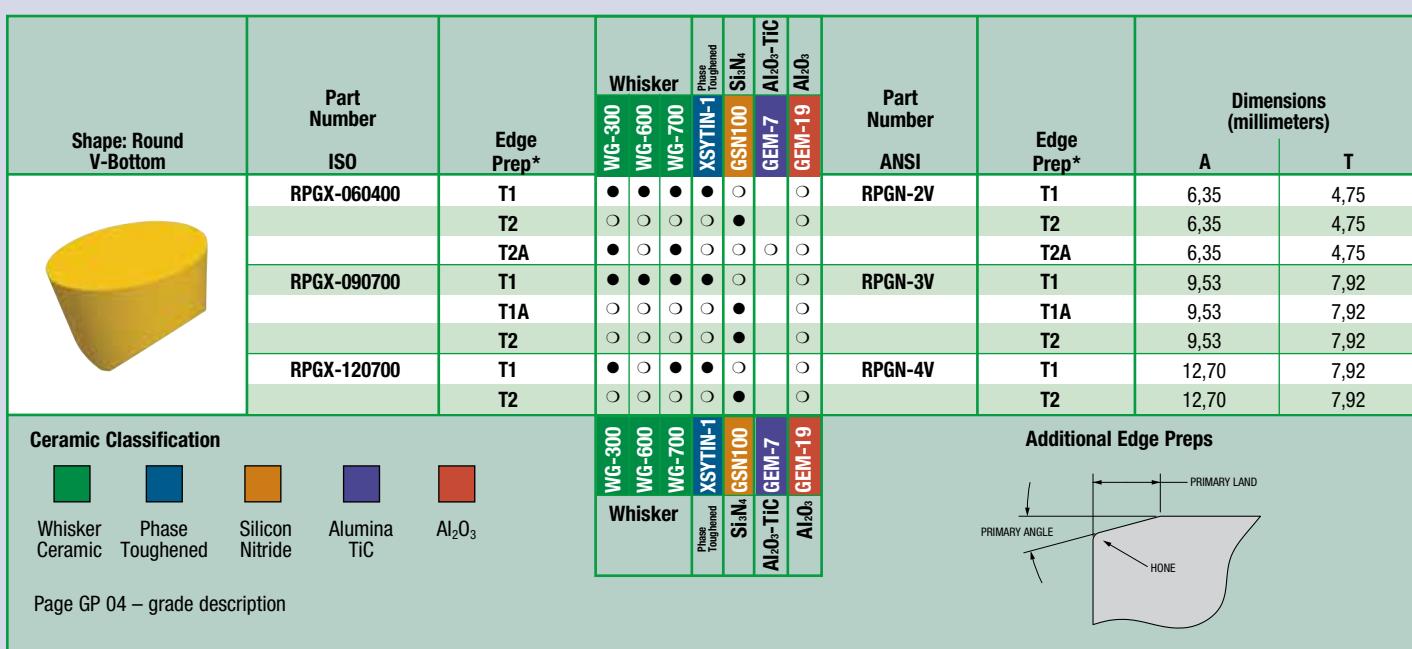
# Round: Positive V-Bottom Inserts (RPGX)

## Carbide



# Round: Positive V-Bottom Inserts (RPGX)

### Ceramic



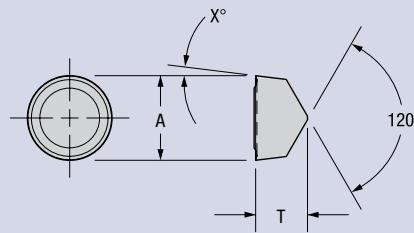
\* If edge prep is not shown, call Greenleaf technical service for assistance.

Not Recommended [ ] Stocked or Available Upon Request [ ] Stocked Standard [ ]

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# Round Inserts (RCGR-V/RPGX-V)

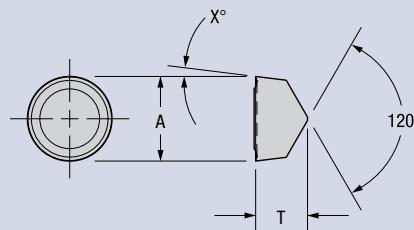
Positive Chipform V-Bottom  
Carbide



Shape: Round V-Bottom	Part Number	Steel			Stainless Steel			Cast Iron			High-Temp Alloys			Part Number	Dimensions (millimeters)
		P15	P25	P25	P35	M15	M15	M15	M20	M35	K15	S	G-20M		
	RCGR-060400V-TF				○ ○ ○						○ ○ ○	●		RCGR-2V-TF	6,35 4,75 7°
	RCGR-090700V-TF				○ ○ ○	●					○ ○ ○	○		RCGR-3V-TF	9,53 7,92 7°
	RCGR-120700V-TF				○ ○ ○						○ ○ ○	○		RCGR-4V-TF	12,70 7,92 7°
	RPGX-060400V-TF				○ ○ ○						○ ○ ○	●		RPGX-2V-TF	6,35 4,75 11°
	RPGX-090700V-TF				● ● ●						● ● ●	●		RPGX-3V-TF	9,53 7,92 11°
	RPGX-120700V-TF				● ● ●						● ● ●	○		RPGX-4V-TF	12,70 7,92 11°

# Round Inserts (RCGR-V/RPGR-V)

Positive Chipform V-Bottom  
Ceramic



Shape: Round V-Bottom	Part Number	Edge Prep *	Whisker			GEM-7			GEM-19			Part Number	Edge Prep *	Dimensions (millimeters)	
			WG-300	WG-600	WG-700	XSYTIN-1	Phase Toughened	GSN100	Si <sub>3</sub> N <sub>4</sub>	Al <sub>2</sub> O <sub>3</sub> -TiC	GEM-7	Al <sub>2</sub> O <sub>3</sub>	Al <sub>2</sub> O <sub>3</sub>		
	RCGR-060400V-GF1	A	○ ○ ○	○ ○ ○	○ ○ ○									RCGR-2V-GF1	6,35 4,75 7°
	RCGR-090700V-GF1	A	○ ○ ○	○ ○ ○	○ ○ ○									RCGR-3V-GF1	9,53 7,92 7°
	RCGR-120700V-GF1	A	● ○ ○	○ ○ ○	○ ○ ○									RCGR-4V-GF1	12,70 7,92 7°
	RPGR-060400V-GF1	A	○ ○ ○	○ ○ ○	○ ○ ○									RPGR-2V-GF1	6,35 4,75 11°
	RPGR-090700V-GF1	A	○ ○ ○	○ ○ ○	○ ○ ○									RPGR-3V-GF1	9,53 7,92 11°

### Ceramic Classification

Whisker Ceramic	Phase Toughened	Silicon Nitride	Alumina TiC	Al <sub>2</sub> O <sub>3</sub>
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Page GP 04 – grade description

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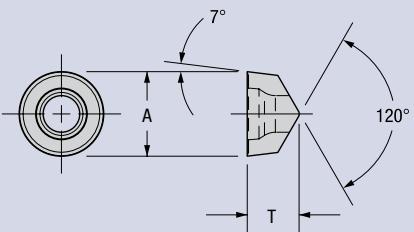
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- Stocked Standard
- Stocked or Available Upon Request
- Not Recommended



# Round Inserts (RCGT-V)

Positive Chipform V-Bottom  
Carbide



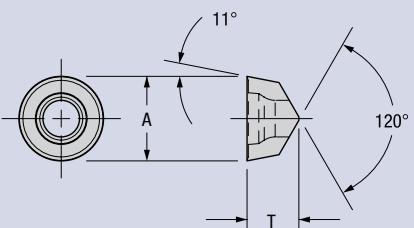
Shape: Round V-Bottom	Part Number ISO	Steel				Stainless Steel		Cast Iron		High-Temp Alloys		Part Number ANSI	Dimensions (millimeters)			
		P15	P25	P25	P35	M15	M15	M15	M20	M35	K15	G-915	G-20M	A I.C.	T	
	RCGT-060400V-TF			○	○	○				○	○	○	●	RCGT-2V-TF	6,35	4,75
	RCGT-090700V-TF			○	●	○				○	●	○	○		9,53	7,92
	RCGT-120700V-TF			○	●	○				○	●	○	●		12,70	7,92

Carbide Coatings			P15	GA5025	P25	GA5035	P25	GA5125	P35	GA5036	M15	GA5026	K15	GA5023	G-915	G-20M
MT-CVD Coated	PVD Coated	Uncoated	Steel	Stainless Steel	Cast Iron	High-Temp Alloys	Steel	Stainless Steel	Cast Iron	High-Temp Alloys	Steel	Stainless Steel	Cast Iron	High-Temp Alloys	Steel	Stainless Steel
			P15	GA5025	P25	GA5035	P25	GA5125	P35	GA5036	M15	GA5026	K15	GA5023	G-915	G-20M

# Round Inserts (RPGT-V)

Positive Chipform V-Bottom  
Carbide



Shape: Round V-Bottom	Part Number ISO	Steel				Stainless Steel		Cast Iron		High-Temp Alloys		Part Number ANSI	Dimensions (millimeters)			
		P15	P25	P25	P35	M15	M15	M15	M20	M35	K15	G-915	G-20M	A I.C.	T	
	RPGT-060400V-TF			○	●	●				○	●	●	○	RPGT-2V-TF	6,35	4,75
	RPGT-090700V-TF			●	○	○				●	○	○	●		9,53	7,92
	RPGT-120700V-TF			○	○	○				○	○	○	○		12,70	7,92

Carbide Coatings			P15	GA5025	P25	GA5035	P25	GA5125	P35	GA5036	M15	GA5026	K15	GA5023	G-915	G-20M
MT-CVD Coated	PVD Coated	Uncoated	Steel	Stainless Steel	Cast Iron	High-Temp Alloys	Steel	Stainless Steel	Cast Iron	High-Temp Alloys	Steel	Stainless Steel	Cast Iron	High-Temp Alloys	Steel	Stainless Steel
			P15	GA5025	P25	GA5035	P25	GA5125	P35	GA5036	M15	GA5026	K15	GA5023	G-915	G-20M

Not Recommended Stocked or Available Upon Request Stocked Standard

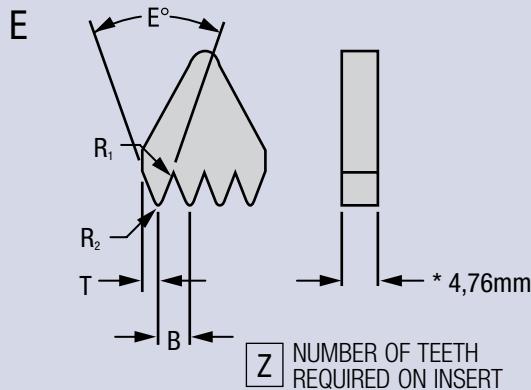
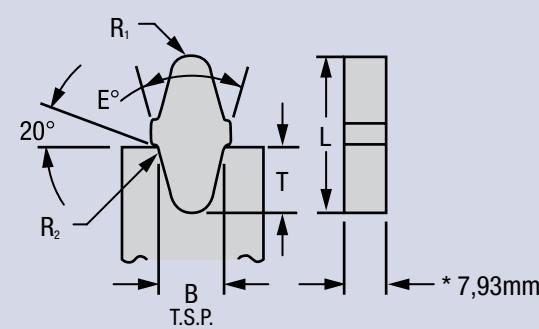
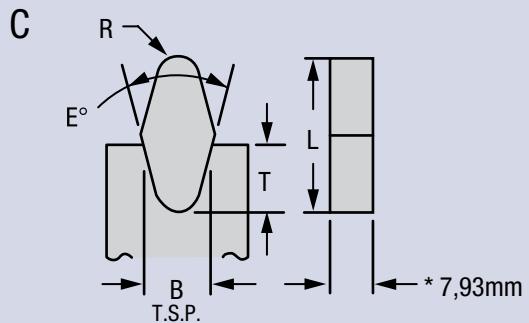
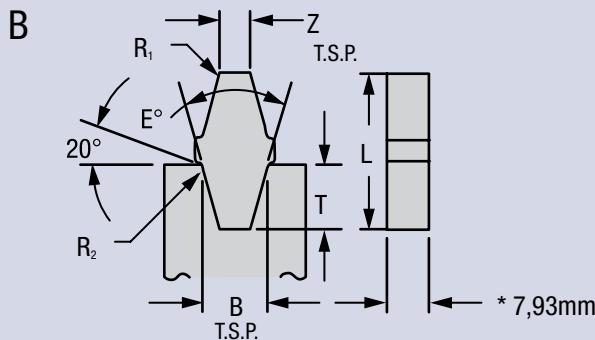
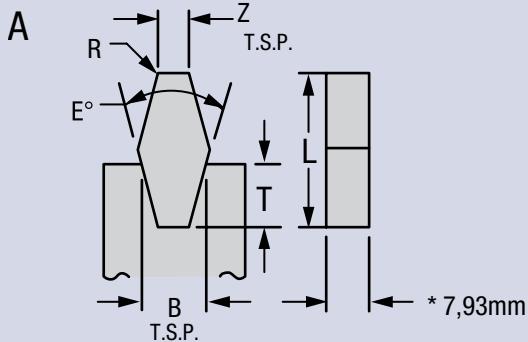
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# Pulley and Poly Grooving Inserts

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.



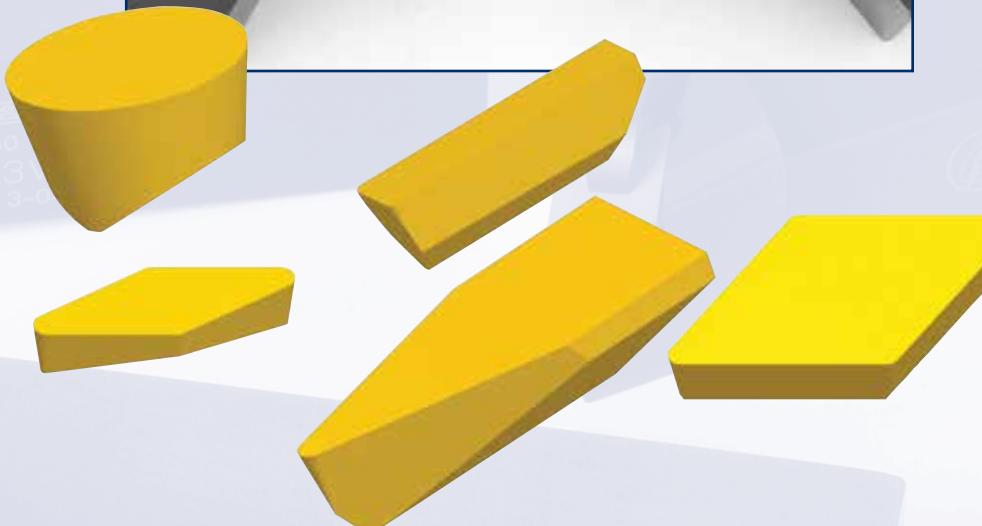
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## Grooving, Profiling and Cut-Off Toolholders and Bars

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

Utilizing 4140 alloyed steel at 42-44 RC, these qualified toolholders are offered in both milled nest and replaceable nest designs to provide further options in your tooling requirements.



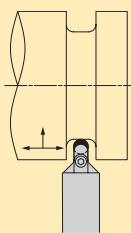
Greenleaf Corporation is continually upgrading its products.  
For the most current information, please visit our web site at:

[www.greenleafglobalsupport.com](http://www.greenleafglobalsupport.com)

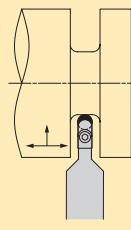
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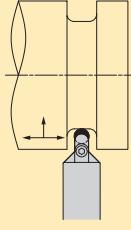


**V-Bottom Round Toolholders**


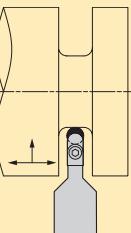
**CRDPN-VS**  
Replaceable Nest  
Shallow D.O.C.  
page: GP 22



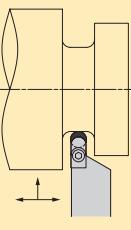
**CRDPN-V**  
Replaceable Nest  
Deep D.O.C.  
page: GP 22



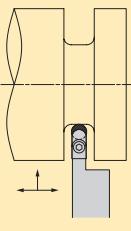
**CRDPN-VMS**  
Milled Nest  
Shallow D.O.C.  
page: GP 23



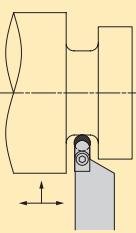
**CRDPN-VM**  
Milled Nest  
Deep D.O.C.  
page: GP 23



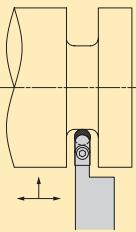
**O.D.**  
Replaceable Nest  
Shallow D.O.C.  
page: GP 24



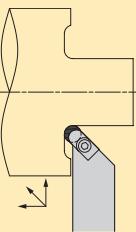
**O.D.**  
Replaceable Nest  
Deep D.O.C.  
page: GP 24

**V-Bottom Round Toolholders continued**


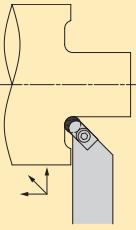
**O.D.**  
Milled Nest  
Shallow D.O.C.  
page: GP 25



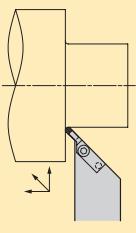
**O.D.**  
Milled Nest  
Deep D.O.C.  
page: GP 25



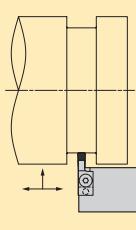
**CRGPR-V**  
**CRGPL-V**  
45°  
Replaceable Nest  
page: GP 26



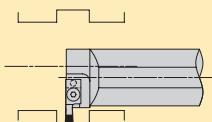
**CRGPR-VM**  
**CRGPL-VM**  
45°  
Milled Nest  
page: GP 26

**Single-Ended Groovers continued**


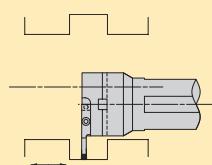
**45° G/P**  
Toolholder  
page: GP 31



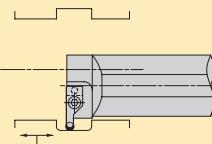
**90° G/P**  
Toolholder  
page: GP 32-33

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


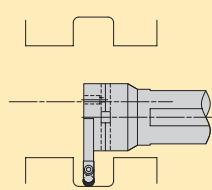
**Cut-Off**  
Grooving Bar  
page: GP 34



**Cut-Off**  
Grooving  
Support Blade  
For Single-Ended,  
V-Bottom Inserts  
page: GP 35



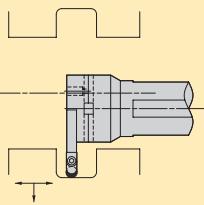
**Profiling Bar**  
Round V-Bottom Insert  
Milled Nest  
page: GP 36

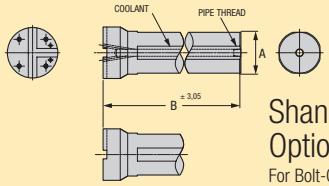


**Profiling**  
Support Blade  
Round V-Bottom Insert  
Milled Nest  
page: GP 37

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

**Profiling Support Blade**

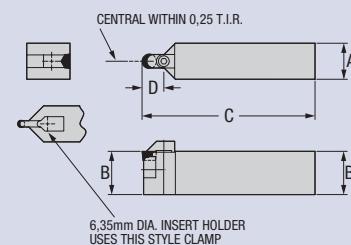
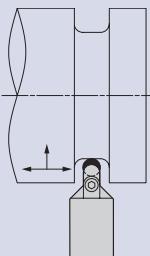
 Round V-Bottom Insert  
 Replaceable Nest  
*page: GP 37*

**Shank Options**

 For Bolt-On  
 Support Blades  
*page: GP 38*
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## CRDPN-VS Toolholder

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



Part Number	Gage Insert	Stock	D.O.C.	Dimensions (millimeters)			Standard Components				*Tune-Up Kit Includes All Standard Components
				D	A	B	C	Nest	Nest Screw	Clamp	
CRDPN-2525-06VS	**RPGX-060400	●	10	25	25	150	410631	BHCS M2.5-0.45x10mm	411910-250VRC	434416	TK-02684
CRDPN-3232-06VS		●	10	32	32	170	410631	BHCS M2.5-0.45x10mm	411910-250VRC	434416	TK-02684
CRDPN-4040-06VS		○	10	40	40	200	410631	BHCS M2.5-0.45x10mm	411910-250VRC	434416	TK-02684
CRDPN-2525-09VS	**RPGX-090700	●	15	25	25	150	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
CRDPN-3232-09VS		●	15	32	32	170	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
CRDPN-4040-09VS		○	15	40	40	200	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
CRDPN-2525-12VS	**RPGX-120700	●	20	25	25	150	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02686
CRDPN-3232-12VS		●	20	32	32	170	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02686
CRDPN-4040-12VS		○	20	40	40	200	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02686

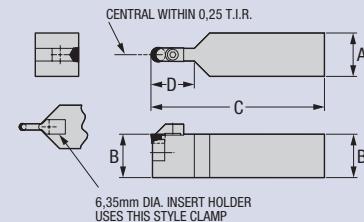
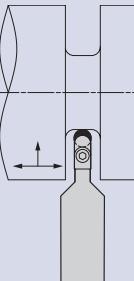
\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

See page GP 14 for ceramic and carbide inserts.

\*\* RCGX can be used in place of RPGX.

## CRDPN-V Toolholder

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



Part Number	Gage Insert	Stock	D.O.C.	Dimensions (millimeters)			Standard Components				*Tune-Up Kit Includes All Standard Components
				D	A	B	C	Nest	Nest Screw	Clamp	
CRDPN-2525-06V	**RPGX-060400	●	19	25	25	150	410631	BHCS M2.5-0.45x10mm	411910-250VRC	434416	TK-02684
CRDPN-3232-06V		●	19	32	32	170	410631	BHCS M2.5-0.45x10mm	411910-250VRC	434416	TK-02684
CRDPN-4040-06V		○	19	40	40	200	410631	BHCS M2.5-0.45x10mm	411910-250VRC	434416	TK-02684
CRDPN-2525-09V	**RPGX-090700	●	28	25	25	150	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
CRDPN-3232-09V		●	28	32	32	170	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
CRDPN-4040-09V		○	28	40	40	200	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
CRDPN-2525-12V	**RPGX-120700	●	38	25	25	150	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02686
CRDPN-3232-12V		●	38	32	32	170	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02686
CRDPN-4040-12V		○	38	40	40	200	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02686

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

See page GP 14 for ceramic and carbide inserts.

\*\* RCGX can be used in place of RPGX .

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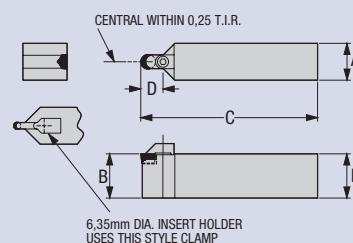
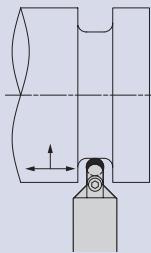
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Stocked Standard

10 Business Days or Less

# CRDPN-VMS Toolholder

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



Part Number	Gage Insert	Stock	D.O.C.	Dimensions (millimeters)			Standard Components	Clamp	Clamp Screw	*Tune-Up Kit Includes All Standard Components	Optional Component Insert Screw Key Code
				D	A	B					
CRDPN-2525-06VMS	**RPGX-060400	●	10	25	25	150	411910-250VRC		434416	TK-02717	PT-542T
CRDPN-3232-06VMS		●	10	32	32	170	411910-250VRC		434416	TK-02717	PT-542T
CRDPN-4040-06VMS		●	10	40	40	200	411910-250VRC		434416	TK-02717	PT-542T
CRDPN-2525-09VMS	**RPGX-090700	●	15	25	25	150	308063	TSHCS M5-0.8x12mm		TK-01709	PT-545T
CRDPN-3232-09VMS		●	15	32	32	170	308063	TSHCS M5-0.8x12mm		TK-01709	PT-545T
CRDPN-4040-09VMS		●	15	40	40	200	308063	TSHCS M5-0.8x12mm		TK-01709	PT-545T
CRDPN-2525-12VMS	**RPGX-120700	●	20	25	25	150	308136		434258	TK-02691	CO-5018
CRDPN-3232-12VMS		●	20	32	32	170	308136		434258	TK-02691	CO-5018
CRDPN-4040-12VMS		●	20	40	40	200	308136		434258	TK-02691	CO-5018

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

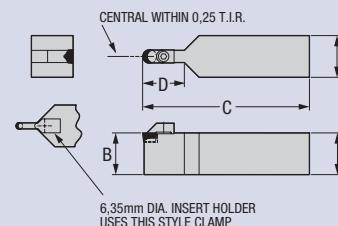
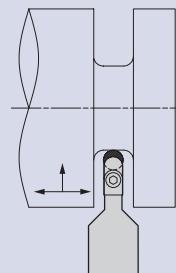
See page GP 14 for ceramic and carbide inserts.

\*\* RCGX can be used in place of RPGX.

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

# CRDPN-VM Toolholder

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



Part Number	Gage Insert	Stock	D.O.C.	Dimensions (millimeters)			Standard Components	Clamp	Clamp Screw	*Tune-Up Kit Includes All Standard Components	Optional Component Insert Screw Key Code
				D	A	B					
CRDPN-2525-06VM	**RPGX-060400	●	19	25	25	150	411910-250VRC		434416	TK-02717	PT-542T
CRDPN-3232-06VM		●	19	32	32	170	411910-250VRC		434416	TK-02717	PT-542T
CRDPN-4040-06VM		●	19	40	40	200	411910-250VRC		434416	TK-02717	PT-542T
CRDPN-2525-09VM	**RPGX-090700	●	28	25	25	150	308063	TSHCS M5-0.8x12mm		TK-02734	PT-545T
CRDPN-3232-09VM		●	28	32	32	170	308063	TSHCS M5-0.8x12mm		TK-02734	PT-545T
CRDPN-4040-09VM		●	28	40	40	200	308063	TSHCS M5-0.8x12mm		TK-02734	PT-545T
CRDPN-2525-12VM	**RPGX-120700	●	38	25	25	150	308136		434258	TK-02691	CO-5018
CRDPN-3232-12VM		●	38	32	32	170	308136		434258	TK-02691	CO-5018
CRDPN-4040-12VM		●	38	40	40	200	308136		434258	TK-02691	CO-5018

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

See page GP 14 for ceramic and carbide inserts.

\*\* RCGX can be used in place of RPGX.

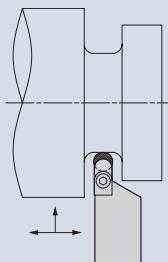
NOTE: Use carbide inserts RCGT and RPCT with optional insert screw for finishing.

10 Business Days or Less

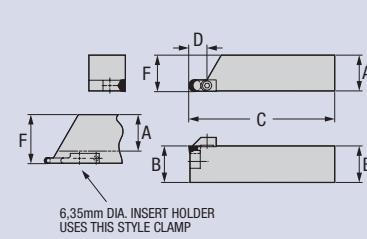
Stocked Standard

# O.D. Grooving/Profiling Toolholder

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



Right-Hand  
Toolholder Shown



6.35mm DIA. INSERT HOLDER  
USES THIS STYLE CLAMP

Part Number		Gage Insert	Stock	D.O.C.	Dimensions (millimeters)				Standard Components				*Tune-Up Kit Includes All Std. Components	
Right	Left		R	L	D	A	B	C	F	Nest	Nest Screw	Clamp	Clamp Screw	
M-415419-06VRS	-	** RPGX-060400	●		10	25	25	150	38	410631	BHCS M2.5-0.45x10mm	411905-250VRC	434259	TK-02692
-	M-415420-06VRS		●		10	25	25	150	38	410631	BHCS M2.5-0.45x10mm	411906-250VRC	434259	TK-02693
M-415421-06VRS	-		●		10	32	32	170	45	410631	BHCS M2.5-0.45x10mm	411905-250VRC	434259	TK-02692
-	M-415422-06VRS		●		10	32	32	170	45	410631	BHCS M2.5-0.45x10mm	411906-250VRC	434259	TK-02693
M-415423-06VRS	-		●		10	40	40	200	53	410631	BHCS M2.5-0.45x10mm	411905-250VRC	434259	TK-02692
-	M-415424-06VRS		●		10	40	40	200	53	410631	BHCS M2.5-0.45x10mm	411906-250VRC	434259	TK-02693
M-415427-09VRS	M-415428-09VRS	** RPGX-090700	●	●	15	25	25	150	25	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
M-415429-09VRS	M-415430-09VRS		●	●	15	32	32	170	32	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
M-415431-09VRS	M-415432-09VRS		●	●	15	40	40	200	40	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
M-415435-12VRS	M-415436-12VRS	** RPGX-120700	●	●	20	25	25	150	25	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02696
M-415437-12VRS	M-415438-12VRS		●	●	20	32	32	170	32	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02696
M-415439-12VRS	M-415440-		●	●	20	40	40	200	40	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02696

12VRS

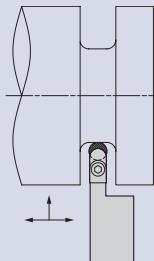
\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

See page GP 14 for ceramic and carbide inserts.

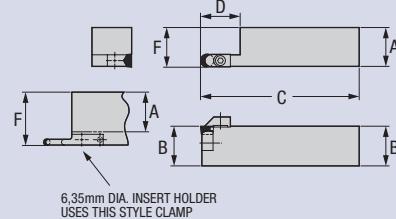
\*\* RCGX can be used in place of RPGX.

# O.D. Grooving/Profiling Toolholder

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



Right-Hand  
Toolholder Shown



6.35mm DIA. INSERT HOLDER  
USES THIS STYLE CLAMP

Part Number		Gage Insert	Stock	D.O.C.	Dimensions (millimeters)				Standard Components				*Tune-Up Kit Includes All Std. Components	
Right	Left		R	L	D	A	B	C	F	Nest	Nest Screw	Clamp	Clamp Screw	
M-411149-06VRS	-	** RPGX-060400	●		19	25	25	150	38	410631	BHCS M2.5-0.45x10mm	411905-250VRC	434259	TK-02692
-	M-411150-06VRS		●		19	25	25	150	38	410631	BHCS M2.5-0.45x10mm	411906-250VRC	434259	TK-02693
M-411151-06VRS	-		●		19	32	32	170	45	410631	BHCS M2.5-0.45x10mm	411905-250VRC	434259	TK-02692
-	M-411156-06VRS		●		19	32	32	170	45	410631	BHCS M2.5-0.45x10mm	411906-250VRC	434259	TK-02693
M-411157-06VRS	-		●		19	40	40	200	53	410631	BHCS M2.5-0.45x10mm	411905-250VRC	434259	TK-02692
-	M-411158-06VRS		●		19	40	40	200	53	410631	BHCS M2.5-0.45x10mm	411906-250VRC	434259	TK-02693
M-411157-09VRS	M-411158-09VRS	** RPGX-090700	○	○	29	25	25	150	25	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
M-411159-09VRS	M-411160-09VRS		●	●	29	32	32	170	32	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
M-411161-09VRS	M-411162-09VRS		○	○	29	40	40	200	40	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
M-411165-12VRS	M-411166-12VRS	** RPGX-120700	●	●	38	25	25	150	25	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02686
M-411167-12VRS	M-411168-12VRS		●	●	38	32	32	170	32	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02686
M-411169-12VRS	M-411170-12VRS		○	○	38	40	40	200	40	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02686

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

See page GP 14 for ceramic and carbide inserts.

\*\* RCGX can be used in place of RPGX.

## Greenleaf Sales

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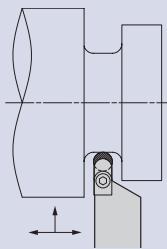
Stocked Standard



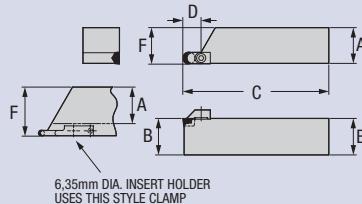
10 Business Days or Less

# O.D. Grooving/Profiling Toolholder

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



Right-Hand  
Toolholder Shown



6.35mm DIA. INSERT HOLDER  
USES THIS STYLE CLAMP

Part Number		Gage Insert	Stock	D.O.C.	Dimensions (millimeters)				Standard Components	Clamp	Clamp Screw	*Tune-Up Kit Includes All Standard Components	Optional Component	
Right	Left		R	L	D	A	B	C	F				Insert Screw	
M-421450-06VMRS	-	** RPGX-060400	●	10	25	25	150	38	411905-250VRC		434259	TK-02689	PT-542T	
-	M-421451-06VMRS		●	10	25	25	150	38	411906-250VRC		434259	TK-02690	PT-542T	
M-421452-06VMRS	-	** RPGX-060400	●	10	32	32	170	45	411905-250VRC		434259	TK-02689	PT-542T	
-	M-421453-06VMRS		●	10	32	32	170	45	411906-250VRC		434259	TK-02690	PT-542T	
M-421454-06VMRS	-	** RPGX-060400	○	10	40	40	200	53	411905-250VRC		434259	TK-02689	PT-542T	
-	M-421455-06VMRS		○	10	40	40	200	53	411906-250VRC		434259	TK-02690	PT-542T	
M-421458-09VMRS	M-421459-09VMRS	** RPGX-090700	●	●	15	25	25	150	25	308063	TSHCS M5-0.8x12mm	TK-02734	PT-545T	
M-421460-09VMRS	M-421461-09VMRS		●	●	15	32	32	170	32	308063	TSHCS M5-0.8x12mm	TK-02734	PT-545T	
M-421462-09VMRS	M-421463-09VMRS		○	○	15	40	40	200	40	308063	TSHCS M5-0.8x12mm	TK-02734	PT-545T	
M-421466-12VMRS	M-421467-12VMRS	** RPGX-120700	●	●	20	25	25	150	25	308136		434258	TK-02691	CO-5018
M-421468-12VMRS	M-421469-12VMRS		●	●	20	32	32	170	32	308136		434258	TK-02691	CO-5018
M-421470-12VMRS	M-421471-12VMRS		○	○	20	40	40	200	40	308136		434258	TK-02691	CO-5018

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

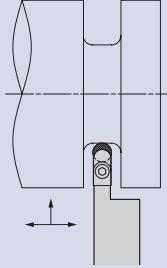
See page GP 14 for ceramic and carbide inserts.

\*\* RCGX can be used in place of RPGX.

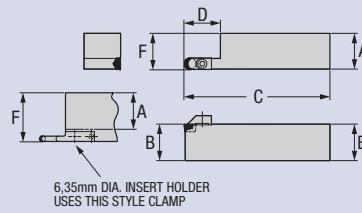
NOTE: Use carbide inserts RCGT and RPCT with optional insert screw for finishing.

# O.D. Grooving/Profiling Toolholder

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



Right-Hand  
Toolholder Shown



6.35mm DIA. INSERT HOLDER  
USES THIS STYLE CLAMP

Part Number		Gage Insert	Stock	D.O.C.	Dimensions (millimeters)				Standard Components	Clamp	Clamp Screw	*Tune-Up Kit Includes All Standard Components	Optional Component	
Right	Left		R	L	D	A	B	C	F				Insert Screw	
M-421498-06VMRS	-	** RPGX-060400	●	19	25	25	150	38	411905-250VRC		434259	TK-02689	PT-542T	
-	M-421499-06VMRS		●	19	25	25	150	38	411906-250VRC		434259	TK-02690	PT-542T	
M-421500-06VMRS	-	** RPGX-060400	●	19	32	32	170	45	411905-250VRC		434259	TK-02689	PT-542T	
-	M-421501-06VMRS		●	19	32	32	170	45	411906-250VRC		434259	TK-02690	PT-542T	
M-421502-06VMRS	-	** RPGX-060400	●	19	40	40	200	53	411905-250VRC		434259	TK-02689	PT-542T	
-	M-421503-06VMRS		●	19	40	40	200	53	411906-250VRC		434259	TK-02690	PT-542T	
M-421504-09VMRS	M-421505-09VMRS	** RPGX-090700	●	●	29	25	25	150	25	308063	TSHCS M5-0.8x12mm	TK-02734	PT-545T	
M-421506-09VMRS	M-421507-09VMRS		●	●	29	32	32	170	32	308063	TSHCS M5-0.8x12mm	TK-02734	PT-545T	
M-421508-09VMRS	M-421509-09VMRS		●	●	29	40	40	200	40	308063	TSHCS M5-0.8x12mm	TK-02734	PT-545T	
M-421510-12VMRS	M-421511-12VMRS	** RPGX-120700	●	●	38	25	25	150	25	308136		434258	TK-02691	CO-5018
M-421512-12VMRS	M-421513-12VMRS		●	●	38	32	32	170	32	308136		434258	TK-02691	CO-5018
M-421514-12VMRS	M-421515-12VMRS		●	●	38	40	40	200	40	308136		434258	TK-02691	CO-5018

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

See page GP 14 for ceramic and carbide inserts.

\*\* RCGX can be used in place of RPGX.

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

## Greenleaf Sales

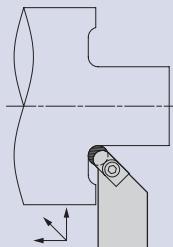
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10 Business Days or Less

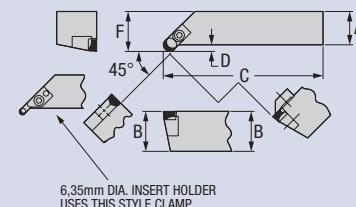
Stocked Standard

## CRGPR-V/CRGPL-V

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



Right-Hand  
Toolholder Shown



6.35mm DIA. INSERT HOLDER  
USES THIS STYLE CLAMP

Part Number		Gage	Stock	D.O.C.	Dimensions (millimeters)				Standard Components			*Tune-Up Kit Includes All Std. Components		
Right	Left	Insert	R	L	D	A	B	C	F	Nest	Nest Screw	Clamp	Clamp Screw	
CRGPR-2525-06V	-	** RPGX-060400	●	●	7	25	25	150	32	411108	BHCS M2.5-0.45x10mm	412131-250GC	434258	TK-02687
-	CRGPL-2525-06V		●	●	7	25	25	150	32	411108	BHCS M2.5-0.45x10mm	412132-250GC	434258	TK-02731
CRGPR-3232-06V	-		●	●	7	32	32	170	39	411108	BHCS M2.5-0.45x10mm	412131-250GC	434258	TK-02687
-	CRGPL-3232-06V		●	●	7	32	32	170	39	411108	BHCS M2.5-0.45x10mm	412132-250GC	434258	TK-02731
CRGPR-4040-06V	-		○	○	7	40	40	200	47	411108	BHCS M2.5-0.45x10mm	412131-250GC	434258	TK-02687
-	CRGPL-4040-06V		○	○	7	40	40	200	47	411108	BHCS M2.5-0.45x10mm	412132-250GC	434258	TK-02731
CRGPR-2525-09V	CRGPL-2525-09V	** RPGX-090700	●	●	7	25	25	150	32	414009	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02733
CRGPL-3232-09V	CRGPL-3232-09V		●	●	7	32	32	170	39	414009	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02733
CRGPL-4040-09V	CRGPL-4040-09V		○	○	7	40	40	200	47	414009	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02733
CRGPR-2525-12V	CRGPL-2525-12V	** RPGX-120700	●	●	7	25	25	150	32	414008	TBHCS M5-0.8x16mm	308136	434258	TK-02732
CRGPL-3232-12V	CRGPL-3232-12V		●	●	7	32	32	170	39	414008	TBHCS M5-0.8x16mm	308136	434258	TK-02732
CRGPL-4040-12V	CRGPL-4040-12V		○	○	7	40	40	200	47	414008	TBHCS M5-0.8x16mm	308136	434258	TK-02732

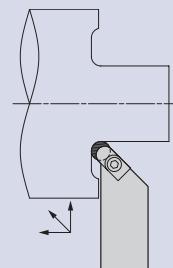
\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.

See page GP 14 for ceramic and carbide inserts.

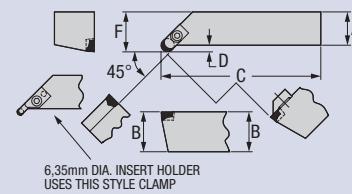
\*\* RCGX can be used in place of RPGX.

## CRGPR-VM/CRGPL-VM

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



Right-Hand  
Toolholder Shown



6.35mm DIA. INSERT HOLDER  
USES THIS STYLE CLAMP

Part Number		Gage	Stock	D.O.C.	Dimensions (millimeters)				Standard Components		*Tune-Up Kit Includes All Standard Components	Optional Component	
Right	Left	Insert	R	L	D	A	B	C	F	Clamp	Clamp Screw	Insert Screw	
CRGPR-2525-06VM	-	** RPGX-060400	●	●	7	25	25	150	32	412131-250GC	434259	TK-02745	PT-542T
-	CRGPL-2525-06VM		●	●	7	25	25	150	32	412132-250GC	434259	TK-02746	PT-542T
CRGPR-3232-06VM	-		●	●	7	32	32	170	39	412131-250GC	434259	TK-02745	PT-542T
-	CRGPL-3232-06VM		●	●	7	32	32	170	39	412132-250GC	434259	TK-02746	PT-542T
CRGPR-4040-06VM	-		○	○	7	40	40	200	47	412131-250GC	434259	TK-02745	PT-542T
-	CRGPL-4040-06VM		○	○	7	40	40	200	47	412132-250GC	434259	TK-02746	PT-542T
CRGPR-2525-09VM	CRGPL-2525-09VM	** RPGX-090700	●	●	7	25	25	150	32	308063	TSHCS M5-0.8x12mm	TK-02733	PT-545T
CRGPL-3232-09VM	CRGPL-3232-09VM		●	●	7	32	32	170	39	308063	TSHCS M5-0.8x12mm	TK-02733	PT-545T
CRGPL-4040-09VM	CRGPL-4040-09VM		○	○	7	40	40	200	47	308063	TSHCS M5-0.8x12mm	TK-02733	PT-545T
CRGPR-2525-12VM	CRGPL-2525-12VM	** RPGX-120700	●	●	7	25	25	150	32	308136	434258	TK-02691	CO-5018
CRGPL-3232-12VM	CRGPL-3232-12VM		●	●	7	32	32	170	39	308136	434258	TK-02691	CO-5018
CRGPL-4040-12VM	CRGPL-4040-12VM		○	○	7	40	40	200	47	308136	434258	TK-02691	CO-5018

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

See page GP 14 for ceramic and carbide inserts.

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

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

### Greenleaf Sales

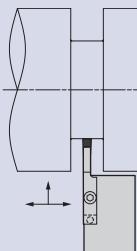
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Stocked Standard

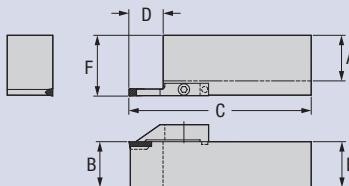
10 Business Days or Less

# Grooving/Profiling/ Cut-Off Toolholder

Deep D.O.C. Series



Right-Hand  
Toolholder Shown



Part Number		Groove Width	Stock	D.O.C.	Dimensions (millimeters)				Standard Components	Tune-Up Kit Includes Standard Clamp and *Clamp Screw	Optional Components		
Right	Left				R	L	D	A			Insert	Clamp	
M-427635-094VGS	-	2,39	●		19	25	25	150	38	WGC-4094	427651-094GC	TK-02626	429524-094GC
-	M-427636-094VGS	2,39	●	●	19	25	25	150	38	WG-4094	427652-094GC	TK-02627	COS-4094-0
M-427637-094VGS	-	2,39	●		19	32	32	170	45		427651-094GC	TK-02626	429524-094GC
-	M-427638-094VGS	2,39	●	●	19	32	32	170	45	WG-4094	427652-094GC	TK-02627	COS-4094-4L
M-427639-094VGS	-	2,39	○		19	40	40	200	53		427651-094GC	TK-02626	429524-094GC
-	M-427640-094VGS	2,39	○	○	19	40	40	200	53	WG-4094	427652-094GC	TK-02627	COS-4094-4R
M-411173-125VGS	-	3,18	●		19	25	25	150	38		411966-125GC	TK-02628	429512-125GC
-	M-411961-125VGS	3,18	●	●	19	25	25	150	38	WG-4125	411967-125GC	TK-02629	GTS-4125
M-411250-125VGS	-	3,18	●		19	32	32	170	45		411966-125GC	TK-02628	COS-4125-0
-	M-411251-125VGS	3,18	●	●	19	32	32	170	45	GTS-4125-1	411967-125GC	TK-02629	COS-4125-4L
M-411962-125VGS	-	3,18	○		19	40	40	200	53		411966-125GC	TK-02628	429512-125GC
-	M-411963-125VGS	3,18	○	○	19	40	40	200	53	GTS-4125-2	411967-125GC	TK-02629	429513-125GC
M-411964-156VGS	-	3,96	●		19	25	25	150	38		411968-156GC	TK-02630	436373-156GC
-	M-411965-156VGS	3,96	●	●	19	25	25	150	38	WG-4156	411969-156GC	TK-02631	436374-156GC
M-411256-156VGS	-	3,96	●		19	32	32	170	45		411968-156GC	TK-02630	GTS-4156
-	M-411257-156VGS	3,96	●	●	19	32	32	170	45	WG-4156	411969-156GC	TK-02631	436374-156GC
M-411258-156VGS	-	3,96	○		19	40	40	200	53		411968-156GC	TK-02630	436373-156GC
-	M-411259-156VGS	3,96	○	○	19	40	40	200	53	WG-4156	411969-156GC	TK-02631	436374-156GC
M-411970-187VGS	-	4,75	●		19	25	25	150	38		411977-187GC	TK-02632	429518-187GC
-	M-411178-187VGS	4,75	●	●	19	25	25	150	38	WG-4187	411978-187GC	TK-02633	GTS-4187
M-411262-187VGS	-	4,75	●		19	32	32	170	45		411977-187GC	TK-02632	COS-4187-0
-	M-411263-187VGS	4,75	●	●	19	32	32	170	45	GTS-4187-1	411978-187GC	TK-02633	COS-4187-4L
M-411971-187VGS	-	4,75	○		19	40	40	200	53		411977-187GC	TK-02632	429518-187GC
-	M-411972-187VGS	4,75	○	○	19	40	40	200	53	GTS-4187-2	411978-187GC	TK-02633	429519-187GC
M-411179-218VGS	-	5,54	●		29	25	25	150	38		411979-218GC	TK-02634	-
-	M-411180-218VGS	5,54	●	●	29	25	25	150	38	WG-6218	411130-218GC	TK-02635	-
M-411268-218VGS	-	5,54	●		29	32	32	170	45		411979-218GC	TK-02634	-
-	M-411269-218VGS	5,54	●	●	29	32	32	170	45	WG-6218	411130-218GC	TK-02635	-
M-411270-218VGS	-	5,54	○		29	40	40	200	53		411979-218GC	TK-02634	-
-	M-411271-218VGS	5,54	○	○	29	40	40	200	53	WG-6218	411130-218GC	TK-02635	-
M-411973-250VGS	-	6,35	●		29	25	25	150	38		411980-250GC	TK-02636	-
-	M-411974-250VGS	6,35	●	●	29	25	25	150	38	WG-6250	411981-250GC	TK-02637	-
M-411975-250VGS	-	6,35	●		29	32	32	170	45		411980-250GC	TK-02636	-
-	M-411275-250VGS	6,35	●	●	29	32	32	170	45	GTS-6250	411981-250GC	TK-02637	-
M-411276-250VGS	-	6,35	○		29	40	40	200	53		411980-250GC	TK-02636	-
-	M-411277-250VGS	6,35	○	○	29	40	40	200	53	GTS-6250	411981-250GC	TK-02637	-
M-411183-281VGS	-	7,14	●		29	25	25	150	38		411133-281GC	TK-02638	-
-	M-411184-281VGS	7,14	●	●	29	25	25	150	38	WG-6281	411134-281GC	TK-02648	-
M-411280-281VGS	-	7,14	●		29	32	32	170	45		411133-281GC	TK-02638	-
-	M-411281-281VGS	7,14	●	●	29	32	32	170	45	WG-6281	411134-281GC	TK-02648	-
M-411282-281VGS	-	7,14	○		29	40	40	200	53		411133-281GC	TK-02638	-
-	M-411283-281VGS	7,14	○	○	29	40	40	200	53	WG-6281	411134-281GC	TK-02648	-

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.

\* All toolholders include standard clamp and clamp screw 33-434259-000 (Greenleaf Metric M6-1.0 clamp screw).

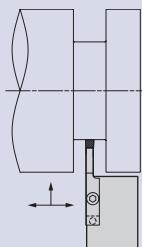
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10 Business Days or Less

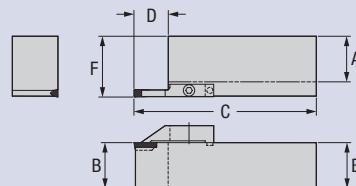
Stocked Standard

# Grooving/Profiling/ Cut-Off Toolholder

Deep D.O.C. Series (Continued)



Right-Hand  
Toolholder Shown



Part Number		Stock	D.O.C.	Dimensions (millimeters)				Standard Components		Tune-Up Kit Includes Standard Clamp and *Clamp Screw	Optional Components				
Right	Left			Groove Width	R	L	D	A	B	C	F	Insert	Clamp		
M-411982-312VGS	-	WGC-8312	WG-8312	7,92	●	●	38	25	25	150	38	411985-312GC	TK-02640	-	-
-	M-411186-312VGS			7,92	●	●	38	25	25	150	38	411136-312GC	TK-02641	-	-
M-411286-312VGS	-	WG-8312	WGC-8344	7,92	●	●	38	32	32	170	45	411985-312GC	TK-02640	-	-
-	M-411287-312VGS			7,92	●	●	38	32	32	170	45	411136-312GC	TK-02641	-	-
M-411288-312VGS	-	WG-8344	WG-8344	7,92	○	○	38	40	40	200	53	411985-312GC	TK-02640	-	-
-	M-411289-312VGS			7,92	○	○	38	40	40	200	53	411136-312GC	TK-02641	-	-
M-411187-344VGS	-	WG-8344	WG-8375	8,74	●	●	38	25	25	150	38	411137-344GC	TK-02642	-	-
-	M-411188-344VGS			8,74	●	●	38	25	25	150	38	411138-344GC	TK-02643	-	-
M-411292-344VGS	-	WG-8344	WG-8375	8,74	●	●	38	32	32	170	45	411137-344GC	TK-02642	-	-
-	M-411293-344VGS			8,74	●	●	38	32	32	170	45	411138-344GC	TK-02643	-	-
M-411294-344VGS	-	WG-8375	WG-8375	8,74	○	○	38	40	40	200	53	411137-344GC	TK-02642	-	-
-	M-411295-344VGS			8,74	○	○	38	40	40	200	53	411138-344GC	TK-02643	-	-
M-411189-375VGS	-	WG-8375	WG-8375	9,53	●	●	38	25	25	150	38	411986-375GC	TK-02649	-	-
-	M-411190-375VGS			9,53	●	●	38	25	25	150	38	411987-375GC	TK-02645	-	-
M-411983-375VGS	-	WG-8375	WG-8375	9,53	●	●	38	32	32	170	45	411986-375GC	TK-02649	-	-
-	M-411984-375VGS			9,53	●	●	38	32	32	170	45	411987-375GC	TK-02645	-	-
M-411300-375VGS	-	WG-8375	WG-8375	9,53	○	○	38	40	40	200	53	411986-375GC	TK-02649	-	-
-	M-411301-375VGS			9,53	○	○	38	40	40	200	53	411987-375GC	TK-02645	-	-

\* All toolholders include standard clamp and clamp screw 33-434259-000 (Greenleaf Metric M6-1.0 clamp screw).

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.

## Greenleaf Sales

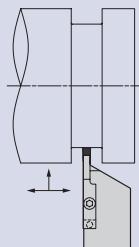
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 Stocked Standard

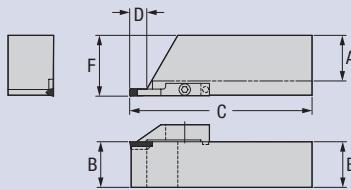
 10 Business Days or Less

# Grooving/Profiling/ Cut-Off Toolholder

Shallow D.O.C. Series



Right-Hand  
Toolholder Shown



Part Number		Groove Width	Stock	D.O.C.	Dimensions (millimeters)				Standard Components		Tune-Up Kit Includes Standard Clamp and *Clamp Screw	Optional Components		
Right	Left				R	L	D	A	B	C	F	Insert	Clamp	
M-427641-094VGS	-	2,39	○		10	25	25	150	38	WG-4094	427651-094GC	TK-02626	COS-4094-0	429524-094GC
-	M-427642-094VGS	2,39	○	○	10	25	25	150	38		427652-094GC	TK-02627		429525-094GC
M-427643-094VGS	-	2,39	○		10	32	32	170	45	WGC-4094	427651-094GC	TK-02626	COS-4094-4L	429524-094GC
-	M-427644-094VGS	2,39	○	○	10	32	32	170	45		427652-094GC	TK-02627		429525-094GC
M-427645-094VGS	-	2,39	○		10	40	40	200	53	WG-4094	427651-094GC	TK-02626	COS-4094-4R	429524-094GC
-	M-427646-094VGS	2,39	○	○	10	40	40	200	53		427652-094GC	TK-02627		429525-094GC
M-415316-125VGS	-	3,18	○		10	25	25	150	38	GTS-4125-1	411966-125GC	TK-02628	GTS-4125	429512-125GC
-	M-415317-125VGS	3,18	○	○	10	25	25	150	38		411967-125GC	TK-02629		429513-125GC
M-415318-125VGS	-	3,18	○		10	32	32	170	45	GTS-4125-2	411966-125GC	TK-02628	COS-4125-0	429512-125GC
-	M-415319-125VGS	3,18	○	○	10	32	32	170	45		411967-125GC	TK-02629		429513-125GC
M-415320-125VGS	-	3,18	○		10	40	40	200	53	WG-4125	411966-125GC	TK-02628	COS-4125-4L	429512-125GC
-	M-415321-125VGS	3,18	○	○	10	40	40	200	53		411967-125GC	TK-02629		429513-125GC
M-415324-156VGS	-	3,96	○		10	25	25	150	38	WG-4156	411968-156GC	TK-02630	GTS-4156	436373-156GC
-	M-415325-156VGS	3,96	○	○	10	25	25	150	38		411969-156GC	TK-02631		436374-156GC
M-415326-156VGS	-	3,96	○		10	32	32	170	45	WGC-4156	411968-156GC	TK-02630	GTS-4156	436373-156GC
-	M-415327-156VGS	3,96	○	○	10	32	32	170	45		411969-156GC	TK-02631		436374-156GC
M-415328-156VGS	-	3,96	○		10	40	40	200	53	WG-4156	411968-156GC	TK-02630	COS-4125-4R	436373-156GC
-	M-415329-156VGS	3,96	○	○	10	40	40	200	53		411969-156GC	TK-02631		436374-156GC
M-415332-187VGS	-	4,75	○		10	25	25	150	38	GTS-4187-1	411977-187GC	TK-02632	GTS-4187	429518-187GC
-	M-415333-187VGS	4,75	○	○	10	25	25	150	38		411978-187GC	TK-02633		429519-187GC
M-415334-187VGS	-	4,75	○		10	32	32	170	45	GTS-4187-2	411977-187GC	TK-02632	COS-4187-0	429518-187GC
-	M-415335-187VGS	4,75	○	○	10	32	32	170	45		411978-187GC	TK-02633		429519-187GC
M-415336-187VGS	-	4,75	○		10	40	40	200	53	WG-4187	411977-187GC	TK-02632	COS-4187-4L	429518-187GC
-	M-415337-187VGS	4,75	○	○	10	40	40	200	53		411978-187GC	TK-02633		429519-187GC
M-415340-218VGS	-	5,54	○		15	25	25	150	38	WG-6218	411979-218GC	TK-02634	WG-6218	-
-	M-415341-218VGS	5,54	○	○	15	25	25	150	38		411130-218GC	TK-02635		-
M-415342-218VGS	-	5,54	○		15	32	32	170	45	WGC-6218	411979-218GC	TK-02634	WGC-6218	-
-	M-415343-218VGS	5,54	○	○	15	32	32	170	45		411130-218GC	TK-02635		-
M-415344-218VGS	-	5,54	○		15	40	40	200	53	WG-6218	411979-218GC	TK-02634	WG-6218	-
-	M-415345-218VGS	5,54	○	○	15	40	40	200	53		411130-218GC	TK-02635		-
M-415348-250VGS	-	6,35	●		15	25	25	150	38	GTS-6250	411980-250GC	TK-02636	GTS-6250	-
-	M-415349-250VGS	6,35	●	●	15	25	25	150	38		411981-250GC	TK-02637		-
M-415350-250VGS	-	6,35	●		15	32	32	170	45	GTS-6250-1	411980-250GC	TK-02636	GTS-6250-1	-
-	M-415351-250VGS	6,35	●	●	15	32	32	170	45		411981-250GC	TK-02637		-
M-415352-250VGS	-	6,35	○		15	40	40	200	53	WG-6250	411980-250GC	TK-02636	WG-6250	-
-	M-415353-250VGS	6,35	○	○	15	40	40	200	53		411981-250GC	TK-02637		-
M-415356-281VGS	-	7,14	○		15	25	25	150	38	WG-6281	411133-281GC	TK-02638	WG-6281	-
-	M-415357-281VGS	7,14	○	○	15	25	25	150	38		411134-281GC	TK-02648		-
M-415358-281VGS	-	7,14	○		15	32	32	170	45	WGC-6281	411133-281GC	TK-02638	WGC-6281	-
-	M-415359-281VGS	7,14	○	○	15	32	32	170	45		411134-281GC	TK-02648		-
M-415360-281VGS	-	7,14	○		15	40	40	200	53	WG-6281	411133-281GC	TK-02638	WG-6281	-
-	M-415361-281VGS	7,14	○	○	15	40	40	200	53		411134-281GC	TK-02648		-

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

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

\* All toolholders include standard clamp and clamp screw 33-434259-000 (Greenleaf Metric M6-1.0 clamp screw).

Continued on next page.

## Greenleaf Sales

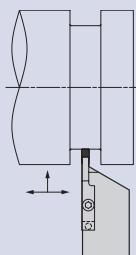
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10 Business Days or Less

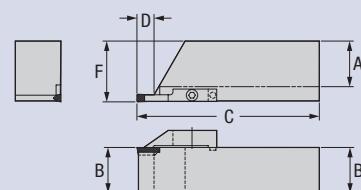
Stocked Standard

# Grooving/Profiling/Cut-Off Toolholder

Shallow D.O.C. Series (Continued)



Right-Hand  
Toolholder Shown



Part Number		Stock	D.O.C.	Dimensions (millimeters)					Standard Components		Tune-Up Kit Includes Standard Clamp and *Clamp Screw	Optional Components			
Right	Left			Groove Width	R	L	D	A	B	C	F	Insert	Clamp	Insert	Clamp
M-415364-312VGS	-	WG-8312	WGC-8312	7,92	●		20	25	25	150	38	411985-312GC	TK-02640	-	-
-	M-415365-312VGS			7,92		●	20	25	25	150	38	411136-312GC	TK-02641	-	-
M-415366-312VGS	-	WG-8344	WGC-8344	7,92	●		20	32	32	170	45	411985-312GC	TK-02640	-	-
-	M-415367-312VGS			7,92		●	20	32	32	170	45	411136-312GC	TK-02641	-	-
M-415368-312VGS	-	WG-8344	WGC-8344	7,92	○		20	40	40	200	53	411985-312GC	TK-02640	-	-
-	M-415369-312VGS			7,92		○	20	40	40	200	53	411136-312GC	TK-02641	-	-
M-415372-344VGS	-	WG-8375	WGC-8375	8,74	○		20	25	25	150	38	411137-344GC	TK-02642	-	-
-	M-415373-344VGS			8,74		○	20	25	25	150	38	411138-344GC	TK-02643	-	-
M-415374-344VGS	-	WG-8344	WGC-8344	8,74	○		20	32	32	170	45	411137-344GC	TK-02642	-	-
-	M-415375-344VGS			8,74		○	20	32	32	170	45	411138-344GC	TK-02643	-	-
M-415376-344VGS	-	WG-8344	WGC-8344	8,74	○		20	40	40	200	53	411137-344GC	TK-02642	-	-
-	M-415377-344VGS			8,74		○	20	40	40	200	53	411138-344GC	TK-02643	-	-
M-415380-375VGS	-	WG-8375	WGC-8375	9,53	○		20	25	25	150	38	411986-375GC	TK-02649	-	-
-	M-415381-375VGS			9,53		○	20	25	25	150	38	411987-375GC	TK-02645	-	-
M-415382-375VGS	-	WG-8375	WGC-8375	9,53	○		20	32	32	170	45	411986-375GC	TK-02649	-	-
-	M-415383-375VGS			9,53		○	20	32	32	170	45	411987-375GC	TK-02645	-	-
M-415384-375VGS	-	WG-8375	WGC-8375	9,53	○		20	40	40	200	53	411986-375GC	TK-02649	-	-
-	M-415385-375VGS			9,53		○	20	40	40	200	53	411987-375GC	TK-02645	-	-

\* All toolholders include standard clamp and clamp screw 33-434259-000 (Greenleaf Metric M6-1.0 clamp screw).

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

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

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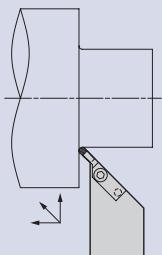
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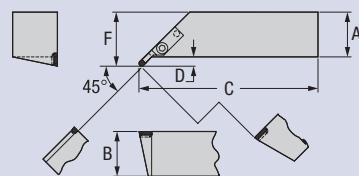
 Stocked Standard

 10 Business Days or Less

# 45° Grooving/Profiling Toolholder



Right-Hand  
Toolholder Shown



Part Number		Gage	Stock	D.O.C.	Dimensions (millimeters)				Standard Components	Tune-Up Kit Includes Standard Clamp and *Clamp Screw	Optional Components	
Right	Left	Insert	R L	D	A	B	C	F	Clamp	Insert	Clamp	
M-415293-45VGS -	M-415294-45VGS	GTS-4125-1		8	25	25	150,5	33,43	415305-GC 415306-GC	TK-02655 TK-02656	GTS-4125	429514-GC 429515-GC
		GTS-4125-2		8	25	25	150,3	33,25				
		WG-4125		8	25	25	150,0	32,92				
		WG-4125-1	O	8	25	25	150,5	33,43				
		WG-4125-2	O	8	25	25	150,3	33,25				
		WG-4156		8	25	25	150,1	33,05				
		WG-4156-1		8	25	25	150,6	33,71				
		WG-4156-2		8	25	25	150,6	33,53				
M-415295-45VGS -	M-415296-45VGS	GTS-4125-1		8	32	32	170,5	40,43	415305-GC 415306-GC	TK-02655 TK-02656	GTS-4125	429514-GC 429515-GC
		GTS-4125-2		8	32	32	170,3	40,26				
		WG-4125		8	32	32	170,0	39,93				
		WG-4125-1	O	8	32	32	170,5	40,43				
		WG-4125-2	O	8	32	32	170,3	40,26				
		WG-4156		8	32	32	170,1	40,05				
		WG-4156-1		8	32	32	170,6	40,71				
		WG-4156-2		8	32	32	170,6	40,53				
M-415297-45VGS -	M-415298-45VGS	GTS-4125-1		8	40	40	200,5	33,43	415305-GC 415306-GC	TK-02655 TK-02656	GTS-4125	429514-GC 429515-GC
		GTS-4125-2		8	40	40	200,3	33,43				
		WG-4125		8	40	40	200,0	47,93				
		WG-4125-1	O	8	40	40	200,5	48,43				
		WG-4125-2	O	8	40	40	200,3	48,26				
		WG-4156		8	40	40	200,1	48,05				
		WG-4156-1		8	40	40	200,8	33,43				
		WG-4156-2		8	40	40	200,6	33,43				
M-415299-45VGS -	M-415300-45VGS	GTS-4187-1		8	25	25	150,83	33,76	415307-GC 415308-GC	TK-02657 TK-02658	GTS-4187	429520-GC 429521-GC
		GTS-4187-2	O	8	25	25	150,66	33,59				
		WG-4187	O	8	25	25	150,00	32,92				
		WG-4187-1		8	25	25	150,83	33,76				
		WG-4187-2		8	25	25	150,66	33,58				
M-415301-45VGS -	M-415302-45VGS	GTS-4187-1		8	32	32	170,83	40,76	415307-GC 415308-GC	TK-02657 TK-02658	GTS-4187	429520-GC 429521-GC
		GTS-4187-2	O	8	32	32	170,66	40,59				
		WG-4187	O	8	32	32	170,0	39,92				
		WG-4187-1		8	32	32	170,83	40,76				
		WG-4187-2		8	32	32	170,66	40,59				
M-415303-45VGS -	M-415304-45VGS	GTS-4187-1		8	40	40	200,8	48,76	415307-GC 415308-GC	TK-02657 TK-02658	GTS-4187	429520-GC 429521-GC
		GTS-4187-2	O	8	40	40	200,7	49,73				
		WG-4187	O	8	40	40	200,0	47,92				
		WG-4187-1		8	40	40	200,8	48,76				
		WG-4187-2		8	40	40	200,7	48,58				

\* All toolholders include standard clamp and clamp screw 33-434259-000 (Greenleaf Metric M6-1.0 clamp screw).

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.

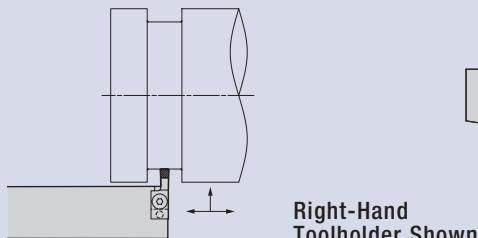
WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.

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

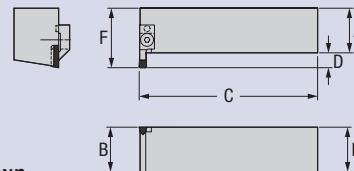
10 Business Days or Less

Stocked Standard

# 90° Grooving/Profiling Toolholder



Right-Hand  
Toolholder Shown



Part Number		Groove Width	Stock	D.O.C.	Dimensions (millimeters)				Standard Components	Tune-Up Kit Includes Standard Clamp and *Clamp Screw	Optional Components			
Right	Left				R	L	D	A			Insert	Clamp		
M-411693-125VGS	-	3,18	○		10	25	25	150	35	411765-125GC	TK-02659	429516-125GC		
-	M-411694-125VGS	3,18	○		10	25	25	150	35	411766-125GC	TK-02660	GTS-4125		
M-411695-125VGS	-	3,18	○		10	32	32	170	42	411765-125GC	TK-02659	COS-4125-0		
-	M-411696-125VGS	3,18	○		10	32	32	170	42	411766-125GC	TK-02660	COS-4125-4R		
M-411697-125VGS	-	3,18	○		10	40	40	200	50	411765-125GC	TK-02659	COS-4125-4L		
-	M-411698-125VGS	3,18	○		10	40	40	200	50	411766-125GC	TK-02660	429517-125GC		
M-411701-156VGS	-	3,96	○		10	25	25	150	35	WG-4156	411767-156GC	TK-02661	-	
-	M-411702-156VGS	3,96	○		10	25	25	150	35		411768-156GC	TK-02662	-	
M-411703-156VGS	-	3,96	○		10	32	32	170	42		411767-156GC	TK-02661	-	
-	M-411704-156VGS	3,96	○		10	32	32	170	42		411768-156GC	TK-02662	-	
M-411705-156VGS	-	3,96	○		10	40	40	200	50	WGC-4156	411767-156GC	TK-02661	-	
-	M-411706-156VGS	3,96	○		10	40	40	200	50		411768-156GC	TK-02662	-	
M-411709-187VGS	-	4,75	○		10	25	25	150	35		411769-187GC	TK-02663	429522-187GC	
-	M-411710-187VGS	4,75	○		10	25	25	150	35		411770-187GC	TK-02664	GTS-4187	
M-411711-187VGS	-	4,75	○		10	32	32	170	42	GTS-4187	411769-187GC	TK-02663	429523-187GC	
-	M-411712-187VGS	4,75	○		10	32	32	170	42		411770-187GC	TK-02664	COS-4187-0	
M-411713-187VGS	-	4,75	○		10	40	40	200	50		411769-187GC	TK-02663	429522-187GC	
-	M-411714-187VGS	4,75	○		10	40	40	200	50		411770-187GC	TK-02664	COS-4187-4R	
M-411717-218VGS	-	5,54	○		13	25	25	150	38	WG-6218	411771-218GC	TK-02665	429522-187GC	
-	M-411718-218VGS	5,54	○		13	25	25	150	38		411772-218GC	TK-02666	GTS-4187	
M-411719-218VGS	-	5,54	○		13	32	32	170	45		411771-218GC	TK-02665	429523-187GC	
-	M-411720-218VGS	5,54	○		13	32	32	170	45		411772-218GC	TK-02666	COS-4187-0	
M-411721-218VGS	-	5,54	○		13	40	40	200	53	WGC-6218	411771-218GC	TK-02665	429522-187GC	
-	M-411722-218VGS	5,54	○		13	40	40	200	53		411772-218GC	TK-02666	COS-4187-4R	
M-411725-250VGS	-	6,35	●		13	25	25	150	38		411773-250GC	TK-02667	429522-187GC	
-	M-411726-250VGS	6,35	●		13	25	25	150	38		411774-250GC	TK-02668	GTS-4187	
M-411727-250VGS	-	6,35	●		13	32	32	170	45	GTS-6250	411773-250GC	TK-02667	429523-187GC	
-	M-411728-250VGS	6,35	●		13	32	32	170	45		411774-250GC	TK-02668	COS-4187-0	
M-411729-250VGS	-	6,35	○		13	40	40	200	53		411773-250GC	TK-02667	429522-187GC	
-	M-411730-250VGS	6,35	○		13	40	40	200	53		411774-250GC	TK-02668	COS-4187-4R	
M-411733-281VGS	-	7,14	○		13	25	25	150	38	WG-6281	411775-281GC	TK-02669	429522-187GC	
-	M-411734-281VGS	7,14	○		13	25	25	150	38		411776-281GC	TK-02670	GTS-4187	
M-411735-281VGS	-	7,14	○		13	32	32	170	45		411775-281GC	TK-02669	429523-187GC	
-	M-411736-281VGS	7,14	○		13	32	32	170	45		411776-281GC	TK-02670	COS-4187-0	
M-411737-281VGS	-	7,14	○		13	40	40	200	53	WGC-6281	411775-281GC	TK-02669	429522-187GC	
-	M-411738-281VGS	7,14	○		13	40	40	200	53		411776-281GC	TK-02670	COS-4187-4R	
M-411743-312VGS	-	7,92	○		16	32	32	170	48	WG-8312	411777-312GC	TK-02671	429522-187GC	
-	M-411744-312VGS	7,92	○		16	32	32	170	48		411778-312GC	TK-02672	GTS-4187	
M-411745-312VGS	-	7,92	○		16	40	40	200	56	WGC-8312	411777-312GC	TK-02671	429523-187GC	
-	M-411746-312VGS	7,92	○		16	40	40	200	56		411778-312GC	TK-02672	COS-4187-0	

\* All toolholders include standard clamp and BHCS clamp screw 31-434416-000.

Continued on next page.

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.

## Greenleaf Sales

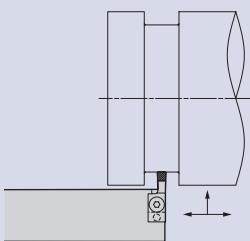
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Stocked Standard

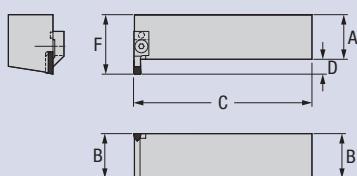
10 Business Days or Less

# 90° Grooving/Profiling Toolholder

(Continued)



Right-Hand  
Toolholder Shown



Part Number		Groove Width	Stock		D.O.C.	Dimensions (millimeters)				Standard Components		Tune-Up Kit Includes Standard Clamp and *Clamp Screw	Optional Components	
Right	Left		R	L		A	B	C	F	Insert	Clamp		Insert	Clamp
M-411751-344VGS	–	8,74	○		16	32	32	170	48	WG-8344	411779-344GC	TK-02673	–	–
–	M-411752-344VGS	8,74		○		32	32	170	48		411780-344GC	TK-02674	–	–
M-411753-344VGS	–	8,74	○		16	40	40	200	56	WGC-8344	411779-344GC	TK-02673	–	–
–	M-411754-344VGS	8,74		○		40	40	200	56		411780-344GC	TK-02674	–	–
M-411759-375VGS	–	9,53	○		16	32	32	170	48	WG-8375	411781-375GC	TK-02675	–	–
–	M-411760-375VGS	9,53		○		32	32	170	48		411782-375GC	TK-02676	–	–
M-411761-375VGS	–	9,53	○		16	40	40	200	56	WGC-8375	411781-375GC	TK-02675	–	–
–	M-411762-375VGS	9,53		○		40	40	200	56		411782-375GC	TK-02676	–	–

\* All toolholders include standard clamp and BHCS clamp screw 31-434416-000.

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.

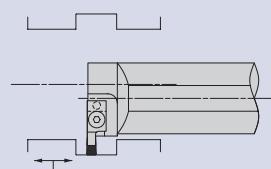
WG is Greenleaf flat-top groover with an 11° nose clearance. Pages GP 10 and GP 11.

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

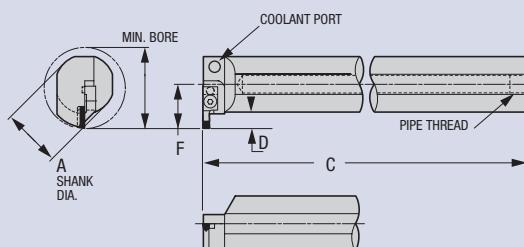
10 Business Days or Less

Stocked Standard

# Cut-Off Grooving Bar



Right-Hand Grooving Bar Shown



Part Number		Stock	D.O.C.	Min. Bore	Dimensions (millimeters)			Standard Components		Tune-Up Kit Includes Standard Clamp and *Clamp Screw	Optional Components			
Right	Left				Groove Width	R	L	D	A	C	F	Insert	Clamp	
M-512074-125VGS	-	3,18	○		10	63	50	400	35	GTS-4125-1	411765-125GC	TK-02659	GTS-4125	429516-125GC
-	M-512075-125VGS	3,18		○	10	63	50	400	35	GTS-4125-2	411766-125GC	TK-02660	COS-4125-0	429517-125GC
										WG-4125			COS-4125-4R	
										WGC-4125			COS-4125-4L	
M-512086-156VGS	-	3,96	○		10	63	50	400	35	WG-4156	411767-156GC	TK-02661	-	-
-	M-512087-156VGS	3,96		○	10	63	50	400	35	WGC-4156	411768-156GC	TK-02662	-	-
M-512098-187VGS	-	4,75	○		10	63	50	400	35	GTS-4187-1	411769-187GC	TK-02663	GTS-4187	429522-187GC
-	M-512099-187VGS	4,75		○	10	63	50	400	35	GTS-4187-2	411770-187GC	TK-02664	COS-4187-0	429523-187GC
										WG-4187			COS-4187-4R	
										WGC-4187			COS-4187-4L	
M-512106-218VGS	-	5,54	○		13	70	50	400	38	WG-6218	411771-218GC	TK-02665	-	-
-	M-512107-218VGS	5,54		○	13	70	50	400	38	WGC-6218	411772-218GC	TK-02666	-	-
M-512116-250VGS	-	6,35	●		13	70	50	400	38	GTS-6250	411773-250GC	TK-02667	-	-
-	M-512117-250VGS	6,35		●	13	70	50	400	38	GTS-6250-1	411774-250GC	TK-02668	-	-
										GTS-6250-2				
										WG-6250				
										WGC-6250				
M-512126-281VGS	-	7,14	○		13	70	50	400	38	WG-6281	411775-281GC	TK-02669	-	-
-	M-512127-281VGS	7,14		○	13	70	50	400	38	WGC-6281	411776-281GC	TK-02670	-	-
M-512132-312VGS	-	7,92	○		16	77	50	400	41	WG-8312	411777-312GC	TK-02671	-	-
-	M-512133-312VGS	7,92		○	16	77	50	400	41	WGC-8312	411778-312GC	TK-02672	-	-
M-512138-344VGS	-	8,74	○		16	77	50	400	41	WG-8344	411779-344GC	TK-02673	-	-
-	M-512139-344VGS	8,74		○	16	77	50	400	41	WGC-8344	411780-344GC	TK-02674	-	-
M-512144-375VGS	-	9,53	○		16	77	50	400	41	WG-8375	411781-375GC	TK-02675	-	-
-	M-512145-375VGS	9,53		○	16	77	50	400	41	WGC-8375	411782-375GC	TK-02676	-	-

\* All toolholders include standard clamp and BHCS clamp screw 31-434416-000.

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.

## Greenleaf Sales

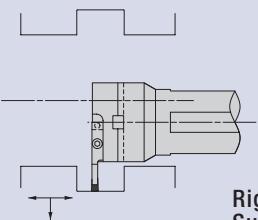
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 Stocked Standard  
 10 Business Days or Less

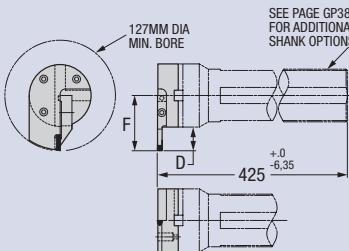
 Stocked Standard  
 10 Business Days or Less

# Cut-Off Grooving Support Blade

For Single Ended V-Bottom Inserts



Right-Hand  
Support Blade Shown



Part Number		Groove Width	Stock		D.O.C.	Dimensions (millimeters)	Standard Components		Tune-Up Kit Includes Standard Clamp and *Clamp Screw	Optional Components	
Right	Left		R	L			Insert	Clamp		Insert	Clamp
M-511309-125VGB	-	3,18	○		19	57,15	GTS-4125-1	411967-125GC	TK-02629	GTS-4125	429513-125GC
-	M-512228-125VGB	3,18		○	19	57,15	GTS-4125-2	411966-125GC	TK-02628	COS-4125-0	429512-125GC
							WG-4125			COS-4125-4R	
							WGC-4125			COS-4125-4L	
M-511311-156VGB	-	3,96	○		19	57,15	WG-4156	411969-156GC	TK-02631	-	-
-	M-511312-156VGB	3,96		○	19	57,15	WGC-4156	411968-156GC	TK-02630	-	-
M-511313-187VGB	-	4,75	○		19	57,15	GTS-4187-1	411978-187GC	TK-02633	GTS-4187	429519-187GC
-	M-511314-187VGB	4,75		○	19	57,15	GTS-4187-2	411977-187GC	TK-02632	COS-4187-0	429518-187GC
							WG-4187			COS-4187-4R	
							WGC-4187			COS-4187-4L	
M-511315-218VGB	-	5,54	○		28,6	66,68	WG-6218	411130-218GC	TK-02635	-	-
-	M-512229-218VGB	5,54		○	28,6	66,68	WGC-6218	4111979-218GC	TK-02634	-	-
M-512230-250VGB	-	6,35	○		28,6	66,68	GTS-6250	411981-250GC	TK-02637	-	-
-	M-511318-250VGB	6,35		○	28,6	66,68	GTS-6250-1	411980-250GC	TK-02636	-	-
							GTS-6250-2				
							WG-6250				
							WGC-6250				
M-511319-281VGB	-	7,14	○		28,6	66,68	WG-6281	411134-281GC	TK-02648	-	-
-	M-511320-281VGB	7,14		○	28,6	66,68	WGC-6281	411133-281GC	TK-02638	-	-
M-511321-312VGB	-	7,92	○		38,1	76,20	WG-8312	411136-312GC	TK-02641	-	-
-	M-511322-312VGB	7,92		○	38,1	76,20	WGC-8312	411985-312GC	TK-02640	-	-
M-511323-344VGB	-	8,74	○		38,1	76,20	WG-8344	411138-344GC	TK-02643	-	-
-	M-511324-344VGB	8,74		○	38,1	76,20	WGC-8344	411137-344GC	TK-02642	-	-
M-511325-375VGB	-	9,53	○		38,1	76,20	WG-8375	411987-375GC	TK-02645	-	-
-	M-511326-375VGB	9,53		○	38,1	76,20	WGC-8375	411986-375GC	TK-02649	-	-

See page GP 38 for additional shank options.

All toolholders include standard clamp and clamp screw 31-434259-000.

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.

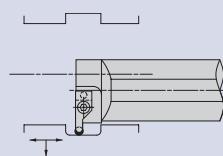
WGC is Greenleaf's flat-top groover with a 6° nose clearance. Pages GP 12 and GP 13.

10 Business Days or Less

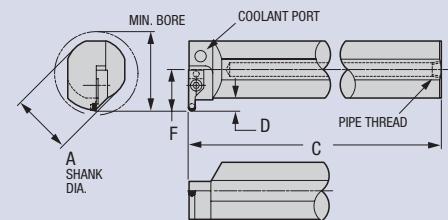
Stocked Standard

# Profiling Bar

Round V-Bottom Insert  
Milled Nest



Right-Hand Profiling Bar Shown



Part Number		Gage—Option 1	Gage—Option 2	Stock	D.O.C.	Dimensions (millimeters)			Standard Components	Clamp	Clamp Screw	*Tune-Up Kit Includes All Std. Components	Optional Component Insert Screw
Right	Left	Insert	Min. Bore	Insert	Min. Bore	R	L	D	A	C	F		
M-519700-06VMRB	—	RPGN-060400	38	RCGN-060400	90	○	○	10	25	300	22	412131-250GC	434258
—	M-519701-06VMRB	RPGN-060400	38	RCGN-060400	90	○	○	10	25	300	22	412132-250GC	434258
M-519702-06VMRB	—	RPGN-060400	45	RCGN-060400	90	○	○	10	32	300	25	412131-250GC	434258
—	M-519703-06VMRB	RPGN-060400	45	RCGN-060400	90	○	○	10	32	300	25	412132-250GC	434258
M-519704-06VMRB	—	RPGN-060400	50	RCGN-060400	90	○	○	10	40	350	28	412131-250GC	434258
—	M-519705-06VMRB	RPGN-060400	50	RCGN-060400	90	○	○	10	40	350	28	412132-250GC	434258
M-519706-06VMRB	—	RPGN-060400	64	RCGN-060400	90	○	○	10	50	400	35	412131-250GC	434258
—	M-519707-06VMRB	RPGN-060400	64	RCGN-060400	90	○	○	10	50	400	35	412132-250GC	434258
M-519708-09VMRB	M-519709-09VMRB	RPGN-090700	57	RCGN-090700	115	○	○	13	32	300	29	308063	TSHCS M5-0.8x12mm
M-519710-09VMRB	M-519711-09VMRB	RPGN-090700	64	RCGN-090700	115	●	●	13	40	350	33	308063	TSHCS M5-0.8x12mm
M-519712-09VMRB	M-519713-09VMRB	RPGN-090700	70	RCGN-090700	115	●	●	13	50	400	38	308063	TSHCS M5-0.8x12mm
M-519714-12VMRB	M-519715-12VMRB	RPGN-120700	57	RCGN-120700	115	○	○	16	32	300	32	308136	434258
M-519716-12VMRB	M-519717-12VMRB	RPGN-120700	64	RCGN-120700	115	●	●	16	40	350	35	308136	434258
M-519718-12VMRB	M-519719-12VMRB	RPGN-120700	70	RCGN-120700	115	●	●	16	50	400	41	308136	434258

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

See page GP 14 for ceramic and carbide inserts.

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

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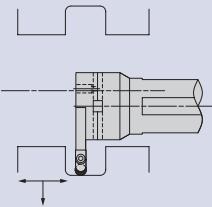
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Stocked Standard

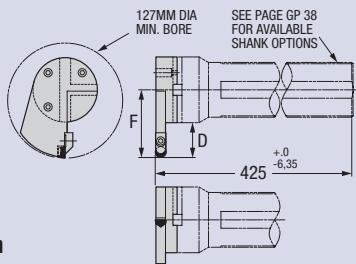
10 Business Days or Less

# Profiling Support Blade

Round V-Bottom Insert  
Milled Nest



Right-Hand Profiling Bar Shown



Part Number		Gage	Stock	D.O.C.	Dimensions (millimeters)	Standard Components		*Tune-Up Kit Includes All Standard Components	Optional Component
Right	Left	Insert	R	L	D	F	Clamp	Clamp Screw	Insert Screw
M-519740-06VMRB	-	** RPGN-060400	○		19,05	60,33	411906-250VRC	434259	TK-02690
-	M-519741-06VMRB	** RPGN-060400		○	19,05	60,33	411905-250VRC	434259	PT-542T
M-519742-09VMRB	-	** RPGN-090700	○		28,60	69,85	308063	TSHCS M5-0.8x16mm	TK-01709
-	M-519743-09VMRB	** RPGN-090700		○	28,60	69,85	308063	TSHCS M5-0.8x16mm	PT-545T
M-519744-12VMRB	-	** RPGN-120700	○		38,10	79,38	308136	434258	TK-02691
-	M-519745-12VMRB	** RPGN-120700		○	38,10	79,38	308136	434258	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.

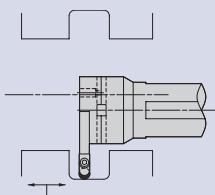
NOTE: Use carbide inserts RCGT and RPGT with optional insert screw for finishing.

See page GP 14 for ceramic and carbide inserts.

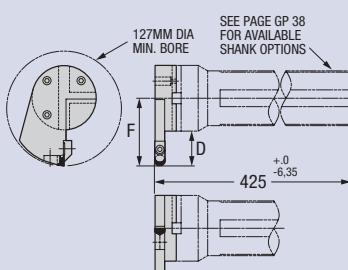
See page GP 38 for available shank options.

# Profiling Support Blade

Round V-Bottom Insert  
Replaceable Nest



Right-Hand Profiling Bar Shown



Part Number		Gage	Stock	D.O.C.	Dimensions (millimeters)	Standard Components		*Tune-Up Kit Includes All Standard Components	
Right	Left	Insert	R	L	D	Nest	Nest Screw	Clamp	Clamp Screw
M-512227-06VRB	-	** RPGN-060400	○		19,05	60,33	411108	BHCS M2.5-0.45x10mm	411906-250VRC
-	M-511287-06VRB	** RPGN-060400		○	19,05	60,33	411108	BHCS M2.5-0.45x10mm	434259
M-511288-09VRB	-	** RPGN-090700	○		38,10	69,85	414009	TBHCS M3-0.5x12mm	411905-250VRC
-	M-511289-09VRB	** RPGN-090700		○	38,10	69,85	414009	TBHCS M3-0.5x12mm	434259
M-511290-12VRB	-	** RPGN-120700	○		38,10	79,38	414008	TBHCS M5-0.8x16mm	434258
-	M-511291-12VRB	** RPGN-120700		○	38,10	79,38	414008	TBHCS M5-0.8x16mm	434258

\* 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 page GP 14 for ceramic and carbide inserts.

See page GP 38 for available shank options.

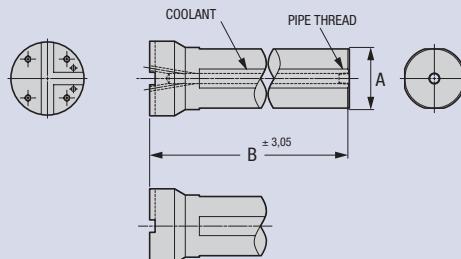
10 Business Days or Less

Stocked Standard

# Shank Options

For Bolt-On Support Blades

Part Number	Stock	Dimensions (millimeters)	
Shank No.	Stock	A	B
M-529756	○	50	400
M-529757	○	60	400
M-529758	○	72	400



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 Stocked Standard

 10 Business Days or Less

## Grooving, Profiling and Cut-Off Support Blades

The Greenleaf Advanced Tooling System for grooving, profiling and cut off is further expanded to a support blade system that couples qualified shanks and qualified support blades to increase the application range of each toolholder or bar. Each Greenleaf tool has the option to utilize 252 support blade combinations of cut-off, V-bottom round profilers, and grooving inserts to meet your cut-off, grooving, profiling and face-grooving application needs.

Quick-change shanks such as CAPTO or KM, as well as straight shank holders and bars, are all part of this tooling system. Call Greenleaf to design your unique right- or left-hand support blade.

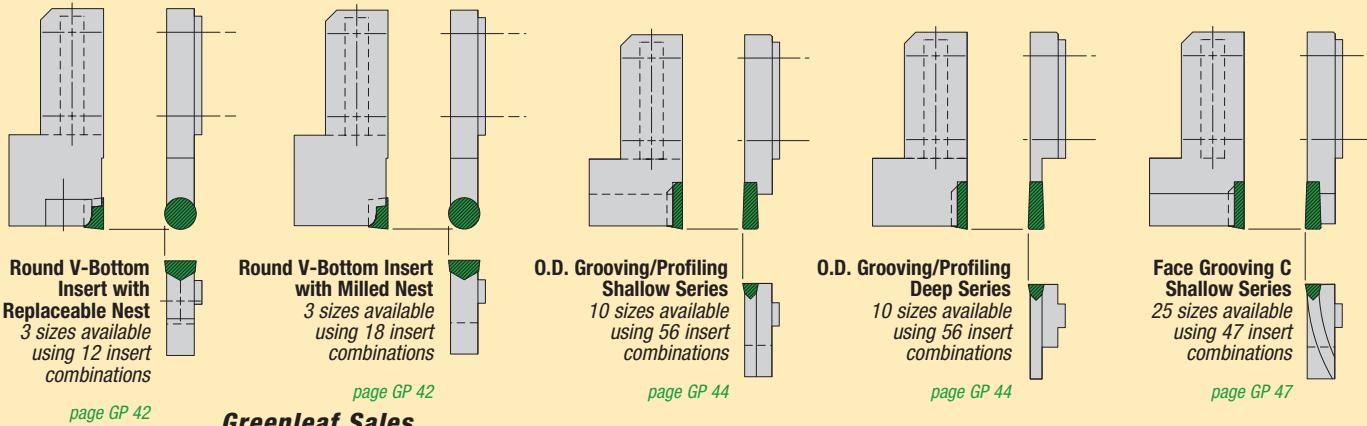
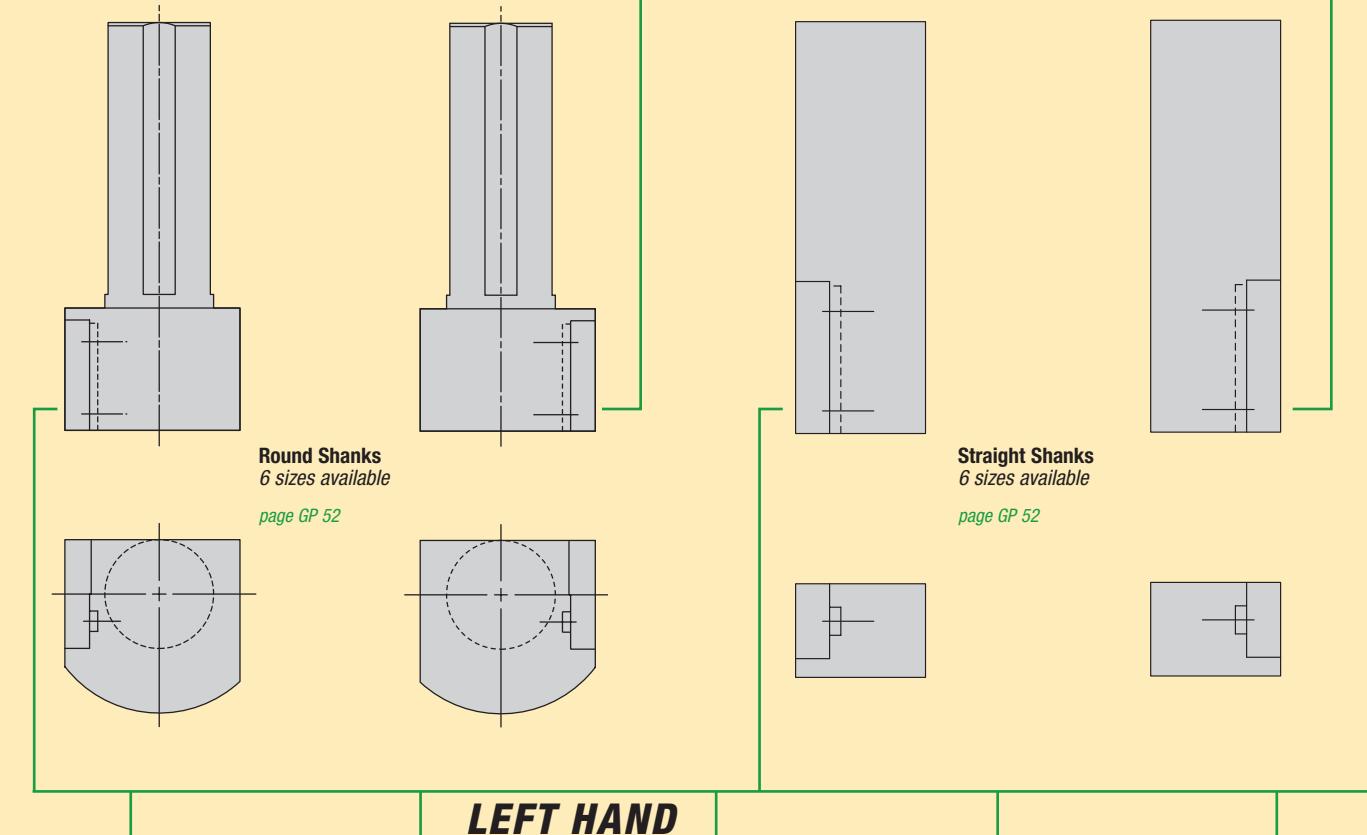
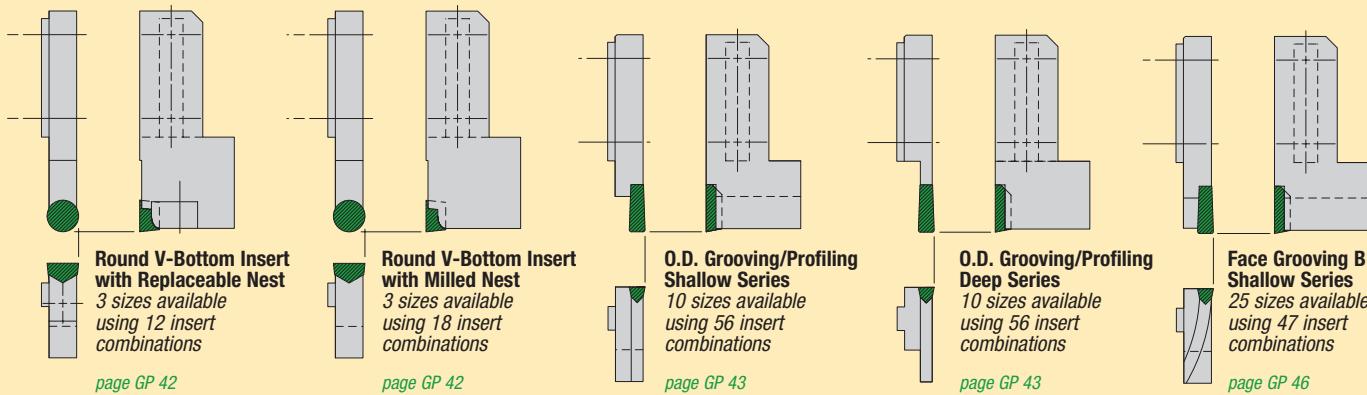


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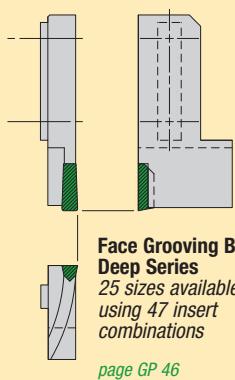
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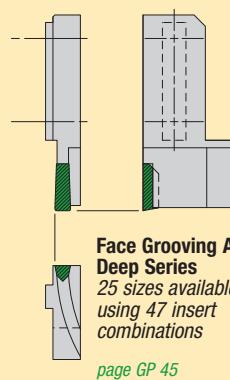
**Face Grooving B  
Deep Series**  
25 sizes available  
using 47 insert  
combinations

page GP 46



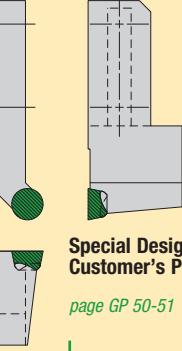
**Face Grooving A  
Shallow Series**  
25 sizes available  
using 47 insert  
combinations

page GP 45



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

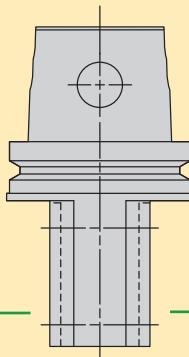
page GP 45



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

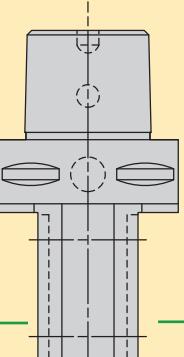
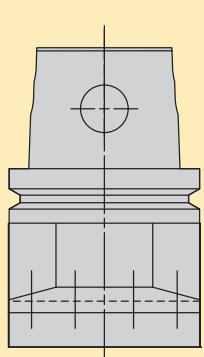
page GP 50-51

## RIGHT HAND



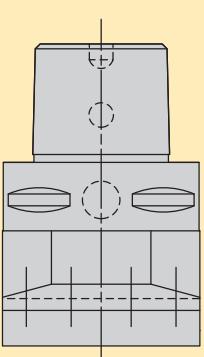
**KM Tool Shanks**  
4 sizes available

page GP 53

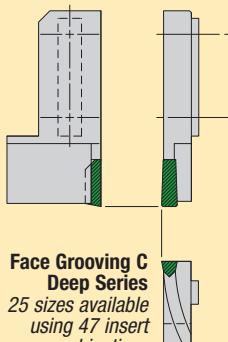


**Capto Tool Shanks**  
4 sizes available

page GP 54

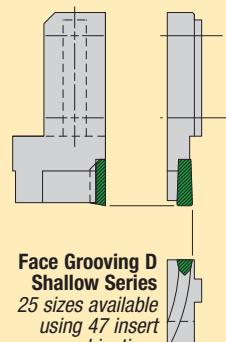


## LEFT HAND



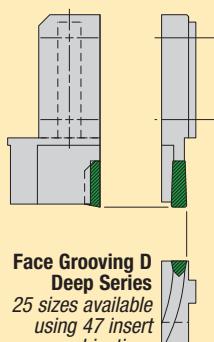
**Face Grooving C  
Deep Series**  
25 sizes available  
using 47 insert  
combinations

page GP 47



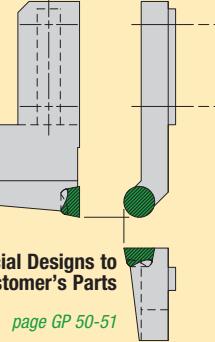
**Face Grooving D  
Shallow Series**  
25 sizes available  
using 47 insert  
combinations

page GP 48



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

page GP 48



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

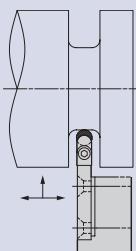
page GP 50-51

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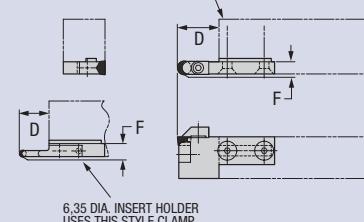
# O.D. Grooving/Profiling Support Blade

Round V-Bottom Insert  
Replaceable Nest



Right-Hand Support Blade Shown

SEE PAGES GP 53-54 FOR ADDITIONAL SHANK OPTIONS



6.35 DIA. INSERT HOLDER USES THIS STYLE CLAMP

Part Number		Gage	Stock	D.O.C.	Dimensions (millimeters)	Standard Components				*Tune-Up Kit Includes All Std. Components	
Right	Left	Insert	R	L	D	F	Nest	Nest Screw	Clamp	Clamp Screw	
M-411959-06VR	-	** RPN-060400	●		19,05	11,91	410631	BHCS M2.5-0.45x10mm	411905-250VRC	434259	TK-02692
-	M-411960-06VR	** RPN-060400		●	19,05	11,91	410631	BHCS M2.5-0.45x10mm	411906-250VRC	434259	TK-02693
M-411011-09VR	M-411012-09VR	** RPN-090700	●	●	28,60	11,91	413970	TBHCS M3-0.5x12mm	308063	TSHCS M5-0.8x12mm	TK-02685
M-411009-12VR	M-411010-12VR	** RPN-120700	●	●	38,10	11,91	414007	TBHCS M5-0.8x16mm	308136	434258	TK-02686

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

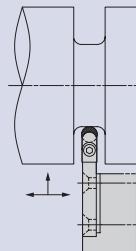
See page GP 14 for ceramic and carbide inserts.

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

See pages GP 53-54 for additional shank options.

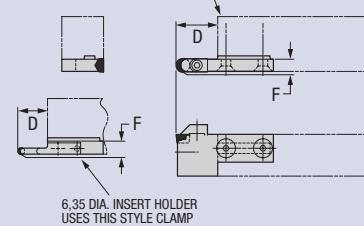
# O.D. Grooving/Profiling Support Blade

Round V-Bottom Insert  
Milled Nest



Right-Hand Support Blade Shown

SEE PAGES GP 53-54 FOR ADDITIONAL SHANK OPTIONS



6.35 DIA. INSERT HOLDER USES THIS STYLE CLAMP

Part Number		Gage	Stock	D.O.C.	Dimensions (millimeters)	Standard Components				*Tune-Up Kit Includes All Standard Components	Optional Component
Right	Left	Insert	R	L	D	F	Clamp	Clamp Screw		Insert Screw	
M-421534-06VMR	-	** RPN-060400	●		19,05	11,91	411905-250VRC	434259	TK-02689	PT-542T	
-	M-421535-06VMR	** RPN-060400		●	19,05	11,91	411906-250VRC	434259	TK-02690	PT-542T	
M-421536-09VMR	M-421537-09VMR	** RPN-090700	●	●	28,60	11,91	308063	TSHCS M5-0.8x12mm	TK-02734	PT-545T	
M-421538-12VMR	M-421539-12VMR	** RPN-120700	●	●	38,10	11,91	308136	434258	TK-02691	CO-5018	

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

See page GP 14 for ceramic and carbide inserts.

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

See pages GP 53-54 for additional shank options.

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

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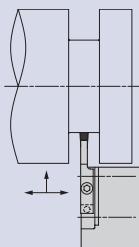
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Stocked Standard

10 Business Days or Less

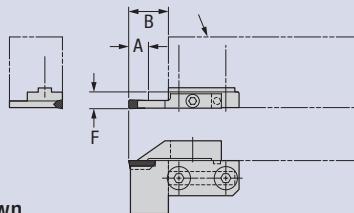
# O.D. Grooving/Profiling/Cut-Off Support Blade

Right Hand



Right-Hand Support Blade Shown

SEE PAGES GP 53-54 FOR ADDITIONAL SHANK OPTIONS



Part Number		Groove Width	Stock		Dimensions (millimeters)			Standard Components		*Tune-Up Kit Includes Standard Clamp and *Clamp Screw	Optional Components	
Shallow Series	Deep Series		Shallow	Deep	A	B	F	Insert	Clamp		Insert	Clamp
M-427647-094VG		2,39	○		9,6	—	11,91	WG-4094	427651-094GC	TK-02626	COS-4094-0	429524-094GC
	M-427648-094VG			○	—	19	11,91	WGC-4094	427651-094GC	TK-02626	COS-4094-4L	429524-094GC
M-421109-125VG		3,18	●		9,6	—	11,91	GTS-4125-1	411966-125GC	TK-02628	GTS-4125	429512-125GC
	M-411988-125VG			●	—	19	11,91	GTS-4125-2	411966-125GC	TK-02628	COS-4125-0	429512-125GC
								WG-4125		COS-4125-4R		
								WGC-4125		COS-4125-4L		
M-421110-156VG		3,96	○		9,6	—	11,91	WG-4156	411968-156GC	TK-02630	—	—
	M-411066-156VG			○	—	19	11,91	WGC-4156	411968-156GC	TK-02630		
M-421111-187VG		4,75	○		9,6	—	11,91	GTS-4187-1	411977-187GC	TK-02632	GTS-4187	429518-187GC
	M-411068-187VG			○	—	19	11,91	GTS-4187-2	411977-187GC	TK-02632	COS-4187-0	429518-187GC
								WG-4187		COS-4187-4R		
								WGC-4187		COS-4187-4L		
M-421112-218VG		5,54	○		14,2	—	11,91	WG-6218	411979-218GC	TK-02634	—	—
	M-411081-218VG			○	—	28,7	11,91	WGC-6218	411979-218GC	TK-02634		
M-421113-250VG		6,35	●		14,2	—	11,91	WG-6250	411980-250GC	TK-02636	—	—
	M-411992-250VG			●	—	28,7	11,91	WGC-6250	411980-250GC	TK-02636		
								GTS-6250				
								GTS-6250-1				
								GTS-6250-2				
M-421114-281VG		7,14	○		14,2	—	11,91	WG-6281	411133-281GC	TK-02638	—	—
	M-411085-281VG			○	—	28,7	11,91	WGC-6281	411133-281GC	TK-02638		
M-421115-312VG		7,92	●		19	—	11,91	WG-8312	411985-312GC	TK-02640	—	—
	M-411087-312VG			●	—	38,1	11,91	WGC-8312	411985-312GC	TK-02640		
M-421116-344VG		8,74	○		19	—	11,91	WG-8344	411137-344GC	TK-02642	—	—
	M-411089-344VG			○	—	38,1	11,91	WGC-8344	411137-344GC	TK-02642		
M-421117-375VG		9,53	○		19	—	11,91	WG-8375	411986-375GC	TK-02649	—	—
	M-411994-375VG			○	—	38,1	11,91	WGC-8375	411986-375GC	TK-02649		

\* 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 clamp screw 31-434259-000.

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.

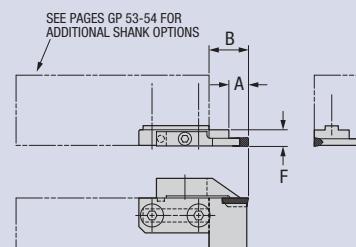
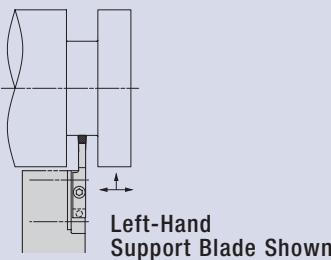
See pages GP 53-54 for additional shank options.

10 Business Days or Less

Stocked Standard

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

Left Hand



Part Number		Groove Width	Stock		Dimensions (millimeters)			Standard Components		*Tune-Up Kit Includes Standard Clamp and *Clamp Screw	Optional Components	
Shallow Series	Deep Series		Shallow	Deep	A	B	F	Insert	Clamp		Insert	Clamp
M-427649-094VG	M-427650-094VG	2,39	○	○	9,6	—	11,91	WG-4094	427652-094GC	TK-02627	COS-4094-0	429525-094GC
M-421100-125VG	M-411989-125VG	3,18	●	●	9,6	—	11,91	GTS-4125-1	411967-125GC	TK-02629	GTS-4125	429513-125GC
M-421101-156VG	M-411990-156VG	3,96	○	○	9,6	—	11,91	GTS-4125-2	411967-125GC	TK-02629	COS-4125-0	429513-125GC
M-421102-187VG	M-411991-187VG	4,75	○	○	9,6	—	11,91	WG-4125	411969-156GC	TK-02631	COS-4125-4R	429513-125GC
M-421103-218VG	M-411082-218VG	5,54	○	○	14,2	—	11,91	WG-4125	411969-156GC	TK-02631	COS-4125-4L	429513-125GC
M-421104-250VG	M-411993-250VG	6,35	●	●	14,2	—	11,91	GTS-4187-1	411978-187GC	TK-02633	GTS-4187	429519-187GC
M-421105-281VG	M-411086-281VG	7,14	○	○	14,2	—	11,91	GTS-4187-2	411978-187GC	TK-02633	COS-4187-0	429519-187GC
M-421106-312VG	M-411088-312VG	7,92	●	●	19	—	11,91	WG-6250	411981-250GC	TK-02637	COS-4187-4R	429519-187GC
M-421107-344VG	M-411090-344VG	8,74	○	○	19	—	11,91	WG-6250	411981-250GC	TK-02637	COS-4187-4L	429519-187GC
M-421108-375VG	M-411122-375VG	9,53	○	○	19	—	11,91	GTS-6250	411136-312GC	TK-02641	—	—
					—	28,7	11,91	GTS-6250	411136-312GC	TK-02641	—	—
					—	38,1	11,91	GTS-6250-1	411136-312GC	TK-02641	—	—
					—	38,1	11,91	GTS-6250-2	411136-312GC	TK-02641	—	—
					—	38,1	11,91	WG-8312	411134-281GC	TK-02648	—	—
					—	38,1	11,91	WG-8312	411134-281GC	TK-02648	—	—
					—	38,1	11,91	WG-8344	411138-344GC	TK-02643	—	—
					—	38,1	11,91	WG-8344	411138-344GC	TK-02643	—	—
					—	38,1	11,91	WG-8375	411987-375GC	TK-02645	—	—
					—	38,1	11,91	WG-8375	411987-375GC	TK-02645	—	—

\* 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 clamp screw 31-434259-000.

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 53-54 for additional shank options.

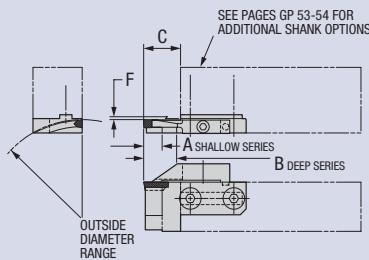
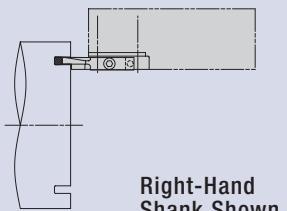
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 Stocked Standard  
 10 Business Days or Less

 Stocked Standard  
 10 Business Days or Less

# Face Grooving Support Blade A



Part Number		Gage	Stock	Outside Diameter Range	Dimensions (millimeters)				Standard Components		*Tune-Up Kit Includes All Standard Components
Shallow Series	Deep Series	Insert	Shallow Deep		A	B	C	F	Clamp	Clamp Screw	
M-421218-125S-030	M-421243-125L-030	WG-4125	○ ○	76,20 - 88,90	9,65	16	19,05	0,79	421323-125GC	434259	TK-02650
M-421219-125S-035	M-421244-125L-035	WG-4125	○ ○	88,90 - 107,95	9,65	16	19,05	0,79	421323-125GC	434259	TK-02650
M-421220-125S-0425	M-421245-125L-0425	WG-4125	○ ○	107,95 - 139,70	9,65	16	19,05	0,79	421323-125GC	434259	TK-02650
M-421221-125S-055	M-421246-125L-055	WG-4125	○ ○	139,70 - 190,50	9,65	16	19,05	0,79	421323-125GC	434259	TK-02650
M-421222-125S-075	M-421247-125L-075	WG-4125	○ ○	190,50 - 317,50	9,65	16	19,05	0,79	421323-125GC	434259	TK-02650
M-421223-125S-125	M-421248-125L-125	WG-4125	○ ○	317,50 - 1016,0	9,65	16	19,05	0,79	421323-125GC	434259	TK-02650
M-421224-187S-030	M-421249-187L-030	WG-4187	○ ○	76,20 - 88,90	9,65	16	19,05	0,79	421324-187GC	434259	TK-02651
M-421225-187S-035	M-421250-187L-035	WG-4187	○ ○	88,90 - 107,95	9,65	16	19,05	0,79	421324-187GC	434259	TK-02651
M-421226-187S-0425	M-421251-187L-0425	WG-4187	○ ○	107,95 - 139,70	9,65	16	19,05	0,79	421324-187GC	434259	TK-02651
M-421227-187S-055	M-421252-187L-055	WG-4187	○ ○	139,70 - 190,50	9,65	16	19,05	0,79	421324-187GC	434259	TK-02651
M-421228-187S-075	M-421253-187L-075	WG-4187	○ ○	190,50 - 317,50	9,65	16	19,05	0,79	421324-187GC	434259	TK-02651
M-421229-187S-125	M-421254-187L-125	WG-4187	○ ○	317,50 - 1016,0	9,65	16	19,05	0,79	421324-187GC	434259	TK-02651
M-421230-250S-030	M-421255-250L-030	WG-6250	○ ○	76,20 - 107,95	14,22	25,40	28,58	0,79	421325-250GC	434259	TK-02652
M-421231-250S-0425	M-421256-250L-0425	WG-6250	○ ○	107,95 - 152,40	14,22	25,40	28,58	0,79	421325-250GC	434259	TK-02652
M-421232-250S-060	M-421257-250L-060	WG-6250	○ ○	152,40 - 215,90	14,22	25,40	28,58	0,79	421325-250GC	434259	TK-02652
M-421233-250S-085	M-421258-250L-085	WG-6250	○ ○	215,90 - 393,70	14,22	25,40	28,58	0,79	421325-250GC	434259	TK-02652
M-421234-250S-155	M-421259-250L-155	WG-6250	○ ○	393,70 - 1016,0	14,22	25,40	28,58	0,79	421325-250GC	434259	TK-02652
M-421235-312S-030	M-421260-312L-030	WG-8312	○ ○	76,20 - 127,00	19,05	33,27	38,10	0,79	421326-312GC	434259	TK-02653
M-421236-312S-050	M-421261-312L-050	WG-8312	○ ○	127,00 - 228,60	19,05	33,27	38,10	0,79	421326-312GC	434259	TK-02653
M-421237-312S-090	M-421262-312L-090	WG-8312	○ ○	228,60 - 482,60	19,05	33,27	38,10	0,79	421326-312GC	434259	TK-02653
M-421238-312S-190	M-421263-312L-190	WG-8312	○ ○	482,60 -	19,05	33,27	38,10	0,79	421326-312GC	434259	TK-02653
M-421239-375S-030	M-421264-375L-030	WG-8375	○ ○	76,20 - 127,00	19,05	33,27	38,10	0,79	421327-375GC	434259	TK-02654
M-421240-375S-050	M-421265-375L-050	WG-8375	○ ○	127,00 - 228,60	19,05	33,27	38,10	0,79	421327-375GC	434259	TK-02654
M-421241-375S-090	M-421266-375L-090	WG-8375	○ ○	228,60 - 482,60	19,05	33,27	38,10	0,79	421327-375GC	434259	TK-02654
M-421242-375S-190	M-421267-375L-190	WG-8375	○ ○	482,60 -	19,05	33,27	38,10	0,79	421327-375GC	434259	TK-02654

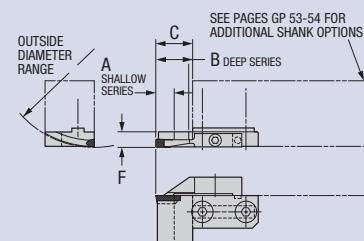
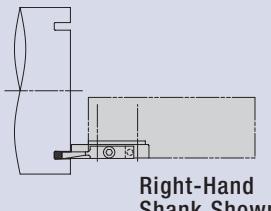
\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade. See pages GP 10 and GP 11 for ceramic and carbide inserts.

See pages GP 53-54 for additional shank options.

10 Business Days or Less

Stocked Standard

# Face Grooving Support Blade B



Part Number		Gage Insert	Stock Shallow	Stock Deep	Outside Diameter Range	Dimensions (millimeters)				Standard Components		*Tune-Up Kit Includes All Standard Components
Shallow Series	Deep Series					A	B	C	F	Clamp	Clamp Screw	
M-421118-125S-030	M-421143-125L-030	WG-4125	○	○	76,20 - 88,90	9,65	16	19,05	11,91	421318-125GC	434259	TK-02677
M-421119-125S-035	M-421144-125L-035	WG-4125	○	○	88,90 - 107,95	9,65	16	19,05	11,91	421318-125GC	434259	TK-02677
M-421120-125S-0425	M-421145-125L-0425	WG-4125	○	○	107,95 - 139,70	9,65	16	19,05	11,91	421318-125GC	434259	TK-02677
M-421121-125S-055	M-421146-125L-055	WG-4125	○	○	139,70 - 190,50	9,65	16	19,05	11,91	421318-125GC	434259	TK-02677
M-421122-125S-075	M-421147-125L-075	WG-4125	○	○	190,50 - 317,50	9,65	16	19,05	11,91	421318-125GC	434259	TK-02677
M-421123-125S-125	M-421148-125L-125	WG-4125	○	○	317,50 - 1016,0	9,65	16	19,05	11,91	421318-125GC	434259	TK-02677
M-421124-187S-030	M-421149-187L-030	WG-4187	○	○	76,20 - 88,90	9,65	16	19,05	11,91	421319-187GC	434259	TK-02678
M-421125-187S-035	M-421150-187L-035	WG-4187	○	○	88,90 - 107,95	9,65	16	19,05	11,91	421319-187GC	434259	TK-02678
M-421126-187S-0425	M-421151-187L-0425	WG-4187	○	○	107,95 - 139,70	9,65	16	19,05	11,91	421319-187GC	434259	TK-02678
M-421127-187S-055	M-421152-187L-055	WG-4187	○	○	139,70 - 190,50	9,65	16	19,05	11,91	421319-187GC	434259	TK-02678
M-421128-187S-075	M-421153-187L-075	WG-4187	○	○	190,50 - 317,50	9,65	16	19,05	11,91	421319-187GC	434259	TK-02678
M-421129-187S-125	M-421154-187L-125	WG-4187	○	○	317,50 - 1016,0	9,65	16	19,05	11,91	421319-187GC	434259	TK-02678
M-421130-250S-030	M-421155-250L-030	WG-6250	○	○	76,20 - 107,95	14,22	25,40	28,58	11,91	421320-250GC	434259	TK-02679
M-421131-250S-0425	M-421156-250L-0425	WG-6250	○	○	107,95 - 152,40	14,22	25,40	28,58	11,91	421320-250GC	434259	TK-02679
M-421132-250S-060	M-421157-250L-060	WG-6250	○	○	152,40 - 215,90	14,22	25,40	28,58	11,91	421320-250GC	434259	TK-02679
M-421133-250S-085	M-421158-250L-085	WG-6250	○	○	215,90 - 393,70	14,22	25,40	28,58	11,91	421320-250GC	434259	TK-02679
M-421134-250S-155	M-421159-250L-155	WG-6250	○	○	393,70 - 1016,0	14,22	25,40	28,58	11,91	421320-250GC	434259	TK-02679
M-421135-312S-030	M-421160-312L-030	WG-8312	○	○	76,20 - 127,00	19,05	33,27	38,10	11,91	421321-312GC	434259	TK-02680
M-421136-312S-050	M-421161-312L-050	WG-8312	○	○	127,00 - 228,60	19,05	33,27	38,10	11,91	421321-312GC	434259	TK-02680
M-421137-312S-090	M-421162-312L-090	WG-8312	○	○	228,60 - 482,60	19,05	33,27	38,10	11,91	421321-312GC	434259	TK-02680
M-421138-312S-190	M-421163-312L-190	WG-8312	○	○	482,60 -	19,05	33,27	38,10	11,91	421321-312GC	434259	TK-02680
M-421139-375S-030	M-421164-375L-030	WG-8375	○	○	76,20 - 127,00	19,05	33,27	38,10	11,91	421322-375GC	434259	TK-02681
M-421140-375S-050	M-421165-375L-050	WG-8375	○	○	127,00 - 228,60	19,05	33,27	38,10	11,91	421322-375GC	434259	TK-02681
M-421141-375S-090	M-421166-375L-090	WG-8375	○	○	228,60 - 482,60	19,05	33,27	38,10	11,91	421322-375GC	434259	TK-02681
M-421142-375S-190	M-421167-375L-190	WG-8375	○	○	482,60 -	19,05	33,27	38,10	11,91	421322-375GC	434259	TK-02681

\* Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the support blade. See page GP 10 and GP 11 for ceramic and carbide inserts.

See pages GP 53-54 for additional shank options.

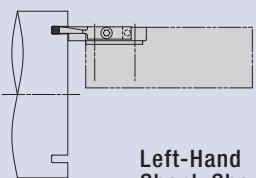
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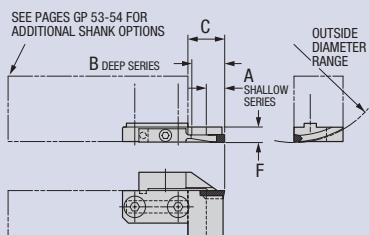
 Stocked Standard

 10 Business Days or Less

# Face Grooving Support Blade C



Left-Hand  
Shank Shown



Part Number		Gage	Stock	Outside Diameter Range	Dimensions (millimeters)				Standard Components		*Tune-Up Kit Includes All Standard Components	
Shallow Series	Deep Series	Insert	Shallow	Deep	A	B	C	F	Clamp	Clamp Screw		
M-421168-125S-030	M-421193-125L-030	WG-4125	<input type="radio"/>	<input type="radio"/>	76,20 - 88,90	9,65	16	19,05	11,91	421323-125GC	434259	TK-02650
M-421169-125S-035	M-421194-125L-035	WG-4125	<input type="radio"/>	<input type="radio"/>	88,90 - 107,95	9,65	16	19,05	11,91	421323-125GC	434259	TK-02650
M-421170-125S-0425	M-421195-125L-0425	WG-4125	<input type="radio"/>	<input type="radio"/>	107,95 - 139,70	9,65	16	19,05	11,91	421323-125GC	434259	TK-02650
M-421171-125S-055	M-421196-125L-055	WG-4125	<input type="radio"/>	<input type="radio"/>	139,70 - 190,50	9,65	16	19,05	11,91	421323-125GC	434259	TK-02650
M-421172-125S-075	M-421197-125L-075	WG-4125	<input type="radio"/>	<input type="radio"/>	190,50 - 317,50	9,65	16	19,05	11,91	421323-125GC	434259	TK-02650
M-421173-125S-125	M-421198-125L-125	WG-4125	<input type="radio"/>	<input type="radio"/>	317,50 - 1016,0	9,65	16	19,05	11,91	421323-125GC	434259	TK-02650
M-421174-187S-030	M-421199-187L-030	WG-4187	<input type="radio"/>	<input type="radio"/>	76,20 - 88,90	9,65	16	19,05	11,91	421324-187GC	434259	TK-02651
M-421175-187S-035	M-421200-187L-035	WG-4187	<input type="radio"/>	<input type="radio"/>	88,90 - 107,95	9,65	16	19,05	11,91	421324-187GC	434259	TK-02651
M-421176-187S-0425	M-421201-187L-0425	WG-4187	<input type="radio"/>	<input type="radio"/>	107,95 - 139,70	9,65	16	19,05	11,91	421324-187GC	434259	TK-02651
M-421177-187S-055	M-421202-187L-055	WG-4187	<input type="radio"/>	<input type="radio"/>	139,70 - 190,50	9,65	16	19,05	11,91	421324-187GC	434259	TK-02651
M-421178-187S-075	M-421203-187L-075	WG-4187	<input type="radio"/>	<input type="radio"/>	190,50 - 317,50	9,65	16	19,05	11,91	421324-187GC	434259	TK-02651
M-421179-187S-125	M-421204-187L-125	WG-4187	<input type="radio"/>	<input type="radio"/>	317,50 - 1016,0	9,65	16	19,05	11,91	421324-187GC	434259	TK-02651
M-421180-250S-030	M-421205-250L-030	WG-6250	<input type="radio"/>	<input type="radio"/>	76,20 - 107,95	14,22	25,40	28,58	11,91	421325-250GC	434259	TK-02652
M-421181-250S-0425	M-421206-250L-0425	WG-6250	<input type="radio"/>	<input type="radio"/>	107,95 - 152,40	14,22	25,40	28,58	11,91	421325-250GC	434259	TK-02652
M-421182-250S-060	M-421207-250L-060	WG-6250	<input type="radio"/>	<input type="radio"/>	152,40 - 215,90	14,22	25,40	28,58	11,91	421325-250GC	434259	TK-02652
M-421183-250S-085	M-421208-250L-085	WG-6250	<input type="radio"/>	<input type="radio"/>	215,90 - 393,70	14,22	25,40	28,58	11,91	421325-250GC	434259	TK-02652
M-421184-250S-155	M-421209-250L-155	WG-6250	<input type="radio"/>	<input type="radio"/>	393,70 - 1016,0	14,22	25,40	28,58	11,91	421325-250GC	434259	TK-02652
M-421185-312S-030	M-421210-312L-030	WG-8312	<input type="radio"/>	<input type="radio"/>	76,20 - 127,00	19,05	33,27	38,10	11,91	421326-312GC	434259	TK-02653
M-421186-312S-050	M-421211-312L-050	WG-8312	<input type="radio"/>	<input type="radio"/>	127,00 - 228,60	19,05	33,27	38,10	11,91	421326-312GC	434259	TK-02653
M-421187-312S-090	M-421212-312L-090	WG-8312	<input type="radio"/>	<input type="radio"/>	228,60 - 482,60	19,05	33,27	38,10	11,91	421326-312GC	434259	TK-02653
M-421188-312S-190	M-421213-312L-190	WG-8312	<input type="radio"/>	<input type="radio"/>	482,60 -	19,05	33,27	38,10	11,91	421326-312GC	434259	TK-02653
M-421189-375S-030	M-421214-375L-030	WG-8375	<input type="radio"/>	<input type="radio"/>	76,20 - 127,00	19,05	33,27	38,10	11,91	421327-375GC	434259	TK-02654
M-421190-375S-050	M-421215-375L-050	WG-8375	<input type="radio"/>	<input type="radio"/>	127,00 - 228,60	19,05	33,27	38,10	11,91	421327-375GC	434259	TK-02654
M-421191-375S-090	M-421216-375L-090	WG-8375	<input type="radio"/>	<input type="radio"/>	228,60 - 482,60	19,05	33,27	38,10	11,91	421327-375GC	434259	TK-02654
M-421192-375S-190	M-421217-375L-190	WG-8375	<input type="radio"/>	<input type="radio"/>	482,60 -	19,05	33,27	38,10	11,91	421327-375GC	434259	TK-02654

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

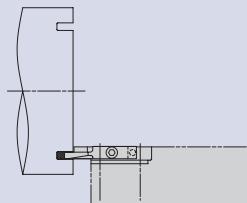
See page GP 10 and GP 11 for ceramic and carbide inserts.

See pages GP 53-54 for additional shank options.

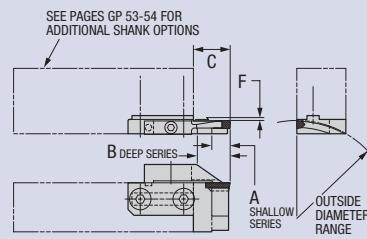
10 Business Days or Less 

Stocked Standard 

# Face Grooving Support Blade D



Left-Hand  
Shank Shown



Part Number		Gage	Stock		Outside Diameter Range	Dimensions (millimeters)				Standard Components		*Tune-Up Kit Includes All Standard Components
Shallow Series	Deep Series	Insert	Shallow	Deep		A	B	C	F	Clamp	Clamp Screw	
M-421268-125S-030	M-421293-125L-030	WG-4125	○	○	76,20 - 88,90	9,65	16	19,05	0,79	421318-125GC	434259	TK-02677
M-421269-125S-035	M-421294-125L-035	WG-4125	○	○	88,90 - 107,95	9,65	16	19,05	0,79	421318-125GC	434259	TK-02677
M-421270-125S-0425	M-421295-125L-0425	WG-4125	○	○	107,95 - 139,70	9,65	16	19,05	0,79	421318-125GC	434259	TK-02677
M-421271-125S-055	M-421296-125L-055	WG-4125	○	○	139,70 - 190,50	9,65	16	19,05	0,79	421318-125GC	434259	TK-02677
M-421272-125S-075	M-421297-125L-075	WG-4125	○	○	190,50 - 317,50	9,65	16	19,05	0,79	421318-125GC	434259	TK-02677
M-421273-125S-125	M-421298-125L-125	WG-4125	○	○	317,50 - 1016,0	9,65	16	19,05	0,79	421318-125GC	434259	TK-02677
M-421274-187S-030	M-421299-187L-030	WG-4187	○	○	76,20 - 88,90	9,65	16	19,05	0,79	421319-187GC	434259	TK-02678
M-421275-187S-035	M-421300-187L-035	WG-4187	○	○	88,90 - 107,95	9,65	16	19,05	0,79	421319-187GC	434259	TK-02678
M-421276-187S-0425	M-421301-187L-0425	WG-4187	○	○	107,95 - 139,70	9,65	16	19,05	0,79	421319-187GC	434259	TK-02678
M-421277-187S-055	M-421302-187L-055	WG-4187	○	○	139,70 - 190,50	9,65	16	19,05	0,79	421319-187GC	434259	TK-02678
M-421278-187S-075	M-421303-187L-075	WG-4187	○	○	190,50 - 317,50	9,65	16	19,05	0,79	421319-187GC	434259	TK-02678
M-421279-187S-125	M-421304-187L-125	WG-4187	○	○	317,50 - 1016,0	9,65	16	19,05	0,79	421319-187GC	434259	TK-02678
M-421280-250S-030	M-421305-250L-030	WG-6250	○	○	76,20 - 107,95	14,22	25,40	28,58	0,79	421320-250GC	434259	TK-02679
M-421281-250S-0425	M-421306-250L-0425	WG-6250	○	○	107,95 - 152,40	14,22	25,40	28,58	0,79	421320-250GC	434259	TK-02679
M-421282-250S-060	M-421307-250L-060	WG-6250	○	○	152,40 - 215,90	14,22	25,40	28,58	0,79	421320-250GC	434259	TK-02679
M-421283-250S-085	M-421308-250L-085	WG-6250	○	○	215,90 - 393,70	14,22	25,40	28,58	0,79	421320-250GC	434259	TK-02679
M-421284-250S-155	M-421309-250L-155	WG-6250	○	○	393,70 - 1016,0	14,22	25,40	28,58	0,79	421320-250GC	434259	TK-02679
M-421285-312S-030	M-421310-312L-030	WG-8312	○	○	76,20 - 127,00	19,05	33,27	38,10	0,79	421321-312GC	434259	TK-02680
M-421286-312S-050	M-421311-312L-050	WG-8312	○	○	127,00 - 228,60	19,05	33,27	38,10	0,79	421321-312GC	434259	TK-02680
M-421287-312S-090	M-421312-312L-090	WG-8312	○	○	228,60 - 482,60	19,05	33,27	38,10	0,79	421321-312GC	434259	TK-02680
M-421288-312S-190	M-421313-312L-190	WG-8312	○	○	482,60 -	19,05	33,27	38,10	0,79	421321-312GC	434259	TK-02680
M-421289-375S-030	M-421314-375L-030	WG-8375	○	○	76,20 - 127,00	19,05	33,27	38,10	0,79	421322-375GC	434259	TK-02681
M-421290-375S-050	M-421315-375L-050	WG-8375	○	○	127,00 - 228,60	19,05	33,27	38,10	0,79	421322-375GC	434259	TK-02681
M-421291-375S-090	M-421316-375L-090	WG-8375	○	○	228,60 - 482,60	19,05	33,27	38,10	0,79	421322-375GC	434259	TK-02681
M-421292-375S-190	M-421317-375L-190	WG-8375	○	○	482,60 -	19,05	33,27	38,10	0,79	421322-375GC	434259	TK-02681

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

See page GP 10 and GP 11 for ceramic and carbide inserts.

See pages GP 53-54 for additional shank options.

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 Stocked Standard

 10 Business Days or Less

## NOTES:

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## Face Grooving Tools - Ordering Instructions

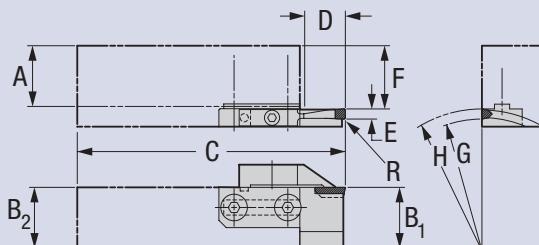
Face grooving tools must be matched to a specific radius and are, therefore, manufactured to order for your particular application.

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.

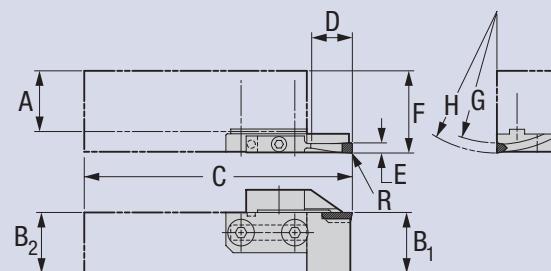
When ordering replaceable blade styles, we suggest the purchase of additional back-up blades at time of original order.

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.

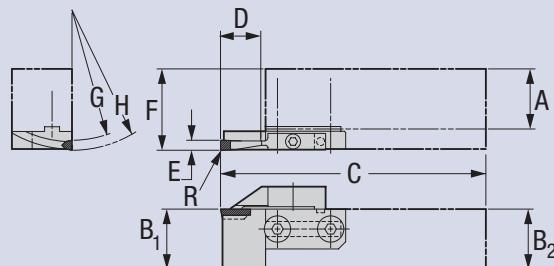
*Note: Tools will be quoted either with radius relieved blades or angular relieved blades, according to groove diameter. Radius relieved blades are illustrated.*



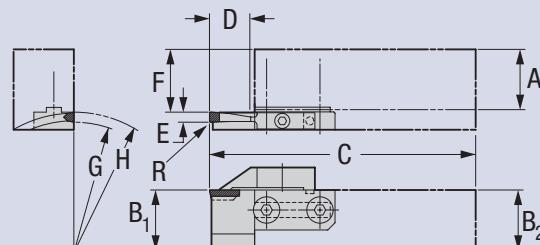
AFGVLL



AFGVLR

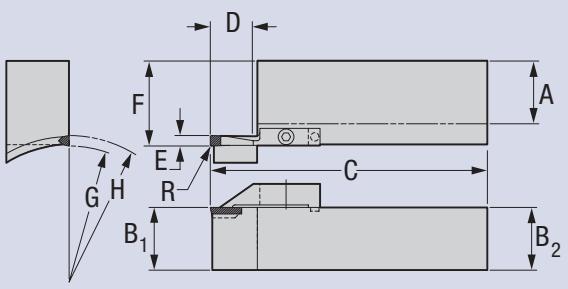
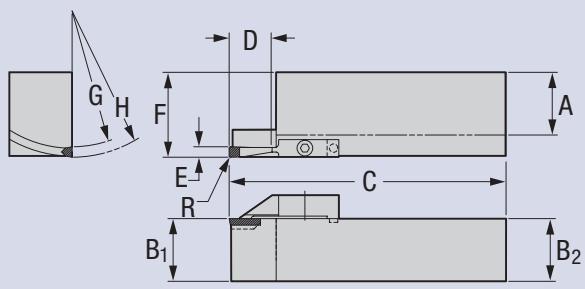
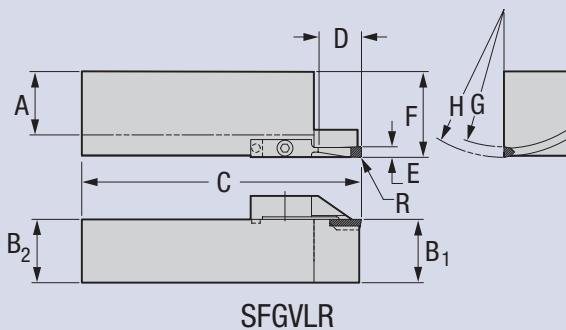
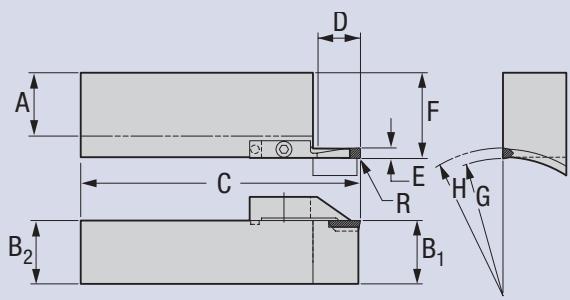


AFGVRL



AFGVRR

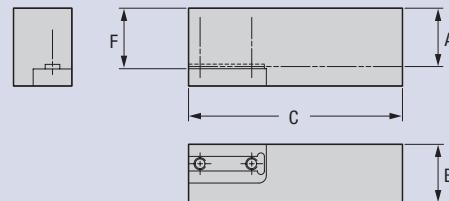
AFGV__	A	C	F
Drawing #	B <sub>1</sub>	D (depth of cut)	G (radius)
R (radius)	B <sub>2</sub>	E	H (radius)



SFGV__	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

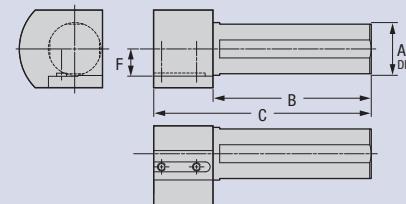


Part Number		Stock		Dimensions (millimeters)				Standard Component	*Tune-Up Kit Includes All Standard Components
Right	Left	R	L	A	B	C	F	Mounting Screw	
M-411055	M-411056	●	●	25	25	125	26	FHCS M8-1.25x25mm	TK-02682
M-411059	M-411449	●	●	32	32	150	33	FHCS M8-1.25x25mm	TK-02682
M-411015	M-411016	○	○	40	40	200	41	FHCS M8-1.25x25mm	TK-02682

\* 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		Stock		Dimensions (millimeters)				Standard Component	*Tune-Up Kit Includes All Standard Components
Right	Left	R	L	A	B	C	F	Mounting Screw	
M-529678	M-529679	○	○	32	150	200	23	FHCS M8-1.25x25mm	TK-02682
M-529680	M-529681	●	●	40	150	200	27	FHCS M8-1.25x25mm	TK-02682
M-529682	M-529683	●	●	50	150	200	32	FHCS M8-1.25x25mm	TK-02682
M-529684	M-529685	○	○	60	150	200	37	FHCS M8-1.25x25mm	TK-02682

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

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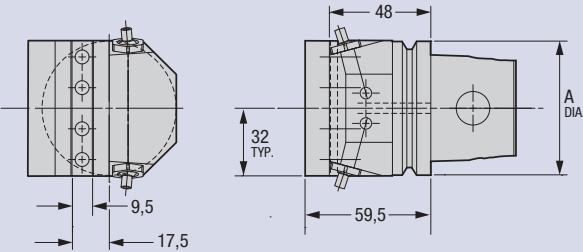
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 Stocked Standard

 10 Business Days or Less

# KM Shank

Face Mount



Part Number		Dimensions (millimeters)	Standard Component	*Tune-Up Kit Includes All Standard Components
† Face Mount	Stock	A	Mounting Screw	
M-SBH-KM50-F	○	50	FHCS M8-1.25x25mm	TK-02682
M-SBH-KM63-F	○	63	FHCS M8-1.25x25mm	TK-02682

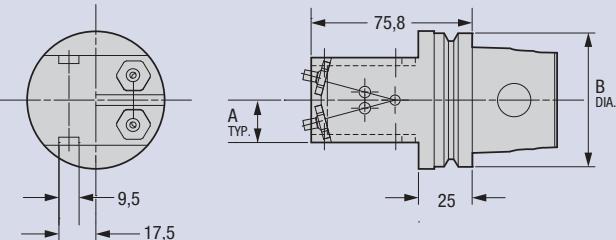
High-pressure coolant – 1,500 PSI Max (100 bar)

\* 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 (millimeters)	Standard Component	*Tune-Up Kit Includes All Standard Components
† Side Mount	Stock	A	B	Mounting Screw
M-SBH-KM50-S	○	17,5	50	FHCS M8-1.25x25mm
M-SBH-KM63-S	○	20	63	FHCS M8-1.25x25mm

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.

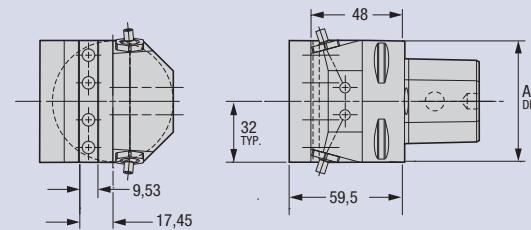
† These tools based on KM63UT shank.

10 Business Days or Less

Stocked Standard

## Capto Shank

Face Mount



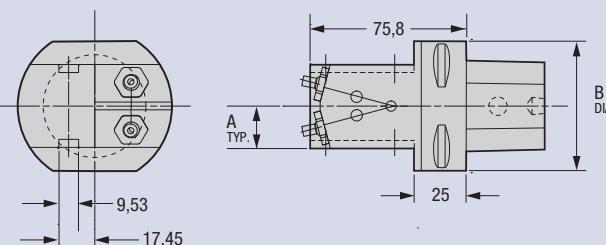
Part Number		Dimensions (millimeters)	Standard Component	*Tune-Up Kit Includes All Standard Components
Face Mount	Stock	A	Mounting Screw	
M-SBH-C5-F	○	50	FHCS M8-1.25x25mm	TK-02682
M-SBH-C6-F	○	63	FHCS M8-1.25x25mm	TK-02682

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.

## Capto Shank

Side Mount



Part Number		Dimensions (millimeters)	Standard Component	*Tune-Up Kit Includes All Standard Components
Side Mount	Stock	A	B	Mounting Screw
M-SBH-C5-S	○	17.5	50	FHCS M8-1.25x25mm
M-SBH-C6-S	○	20	63	FHCS M8-1.25x25mm

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.

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 Stocked Standard

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## NOTES:

*Greenleaf Corporation is continually upgrading its products.  
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