

DORMER PRAMET

GO DEEPER

PARTING-OFF AND GROOVING



PARTING – OFF & GROOVING – ICONS OVERVIEW

General icons

	Primary use		Finishing – very good surface quality		Suitable for stable working conditions
	Possible use		Medium machining – good surface quality		Suitable for unstable working conditions
			Roughing – unlimited surface roughness		Suitable for very unstable working conditions

Turning operations

	Copy turning (multi directional machining)		Internal grooving		Shallow radial groove
	Deep and wide axial groove (with following expansion)		Internal grooving (with following expansion)		Tube parting off
	Deep axial groove		Parting off		Wide radial groove (with following expansion)
	Deep radial groove		Shallow and wide axial groove (with following expansion)		
	Face copy turning		Shallow axial groove		

Features

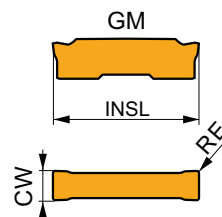
	First choice		Universal wide range option		Rounded edge
	Large overhang		Heavy working conditions		Rounded edge with facet

Other

	Clamping torque of screw [Nm]		Internal supply of coolant
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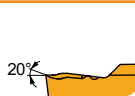
GL. D - GM

	CW	CWTOLL	CWTOLU	INSL
	[mm]	[mm]	[mm]	[mm]
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



Workpiece material suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap).

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]

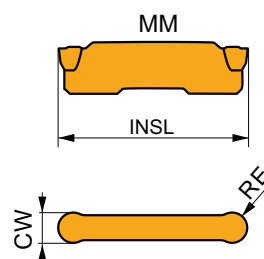


GM geometry for grooving and longitudinal turning, and continuous to interrupted cuts.

GL2-D200M02-GM	G8330	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
	T7325	0.2	220	0.10	0.8	170	0.09	0.8	—	—	—	—	—	—	70	0.08	0.6	—	—	—
GL3-D300M02-GM	G8330	0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	—	—	—	35	0.14	0.8	—	—	—
	T7325	0.2	175	0.20	1.0	135	0.18	1.0	—	—	—	—	—	—	55	0.14	0.8	—	—	—
GL3-D300M04-GM	G8330	0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	—	—	—	40	0.14	0.8	—	—	—
	T7325	0.4	185	0.20	1.0	140	0.18	1.0	—	—	—	—	—	—	60	0.14	0.8	—	—	—
GL4-D400M04-GM	G8330	0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	—	—	—	35	0.18	1.0	—	—	—
	T7325	0.4	170	0.25	1.2	130	0.23	1.2	—	—	—	—	—	—	55	0.18	1.0	—	—	—
GL4-D400M08-GM	G8330	0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	—	—	—	45	0.18	1.0	—	—	—
	T7325	0.8	200	0.25	1.2	155	0.23	1.2	—	—	—	—	—	—	65	0.18	1.0	—	—	—
GL5-D500M08-GM	G8330	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	—	—	—	40	0.21	1.0	—	—	—
	T7325	0.8	190	0.30	1.2	145	0.27	1.2	—	—	—	—	—	—	60	0.21	1.0	—	—	—
GL6-D600M08-GM	G8330	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	—	—	—	40	0.21	1.0	—	—	—
	T7325	0.8	190	0.30	1.2	145	0.27	1.2	—	—	—	—	—	—	60	0.21	1.0	—	—	—

GL. D - MM

	CW	CWTOLL	CWTOLU	INSL
	[mm]	[mm]	[mm]	[mm]
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0



Workpiece material suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap).

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]

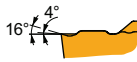


MM geometry, with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.

GL2-D200MM0-MM	G8330	1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	—	—	—	60	0.08	0.8	—	—	—
	T7325	1.0	285	0.10	1.0	220	0.09	1.0	—	—	—	—	—	—	90	0.08	0.8	—	—	—

Workpiece material suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap).

Product		RE [mm]	P			M			K			N			S			H		
			vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]



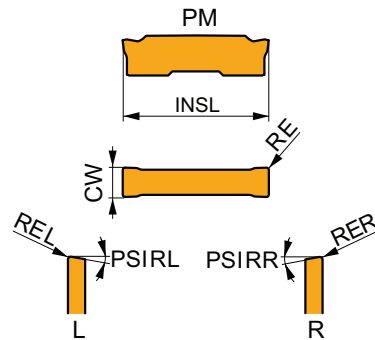
MM geometry, with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.

GL3-D300MM0-MM	G8330	1.5	■	210	0.20	1.2	■	125	0.18	1.2	■	195	0.20	1.2	—	—	—	▣	50	0.14	1.0	—	—	—
	T7325	1.5	▣	240	0.20	1.2	■	185	0.18	1.2	■	—	—	—	—	—	—	▣	75	0.14	1.0	—	—	—
GL4-D400MM0-MM	G8330	2.0	■	220	0.20	1.2	■	130	0.18	1.2	■	205	0.20	1.2	—	—	—	▣	55	0.14	1.0	—	—	—
	T7325	2.0	▣	250	0.20	1.2	■	195	0.18	1.2	■	—	—	—	—	—	—	▣	80	0.14	1.0	—	—	—
GL5-D500MM0-MM	G8330	2.5	■	205	0.25	1.2	■	120	0.23	1.2	■	190	0.25	1.2	—	—	—	▣	50	0.18	1.0	—	—	—
	T7325	2.5	▣	235	0.25	1.2	■	180	0.23	1.2	■	—	—	—	—	—	—	▣	75	0.18	1.0	—	—	—
GL6-D600MM0-MM	G8330	3.0	■	195	0.30	1.2	■	115	0.27	1.2	■	185	0.30	1.2	—	—	—	▣	45	0.21	1.0	—	—	—
	T7325	3.0	▣	220	0.30	1.2	■	170	0.27	1.2	■	—	—	—	—	—	—	▣	70	0.21	1.0	—	—	—

GL. D - PM

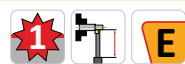
PRAMET

	CW [mm]	CWTOLL [mm]	CWTOLU [mm]	INSL [mm]
200	2.00	-0.05	0.05	25.0
250	2.55	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



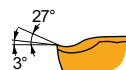
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE [mm]	P		M		K		N		S		H		PSIRR [°]	PSIRL [°]
			vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]		



PM geometry, first choice for parting-off and grooving, and continuous to slightly interrupted cuts.

GL2-D200M02-PM	G8330	0.2	■	130	0.08	■	75	0.07	■	120	0.08	—	—	■	30	0.06	—	—	—	—
	T7325	0.2	■	150	0.08	■	115	0.07	—	—	—	—	—	■	45	0.06	—	—	—	—
GL3-D250G02-PM	G8330	0.2	■	130	0.10	■	75	0.09	■	120	0.10	—	—	■	30	0.07	—	—	—	—
	T7325	0.2	■	150	0.10	■	115	0.09	—	—	—	—	—	■	45	0.07	—	—	—	—
GL4-D400M02-PM	G8330	0.2	■	130	0.12	■	75	0.11	■	120	0.12	—	—	■	30	0.10	—	—	—	—
	T7325	0.2	■	150	0.12	■	115	0.11	—	—	—	—	—	■	45	0.10	—	—	—	—
GL5-D500M03-PM	G8330	0.3	■	130	0.15	■	75	0.14	■	120	0.15	—	—	■	30	0.12	—	—	—	—
GL6-D600M03-PM	G8330	0.3	■	130	0.15	■	75	0.14	■	120	0.15	—	—	■	30	0.12	—	—	—	—

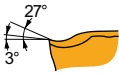


R-PM right-handed geometry, first choice for parting-off, and continuous to slightly interrupted cuts.

GL2-D200G02R06-PM	G8330	0.2	■	130	0.08	■	75	0.07	■	120	0.08	—	—	■	30	0.06	—	—	6	—
	T7325	0.2	■	150	0.08	■	115	0.07	—	—	—	—	—	■	45	0.06	—	—	6	—
GL2-D200G02R12-PM	G8330	0.2	■	130	0.08	■	75	0.07	■	120	0.08	—	—	■	30	0.06	—	—	12	—
	T7325	0.2	■	150	0.10	■	115	0.09	—	—	—	—	—	■	45	0.07	—	—	6	—
GL3-D300G02R06-PM	G8330	0.2	■	130	0.10	■	75	0.09	■	120	0.10	—	—	■	30	0.07	—	—	6	—
	T7325	0.2	■	150	0.10	■	115	0.09	—	—	—	—	—	■	45	0.07	—	—	6	—
GL3-D300G02R12-PM	G8330	0.2	■	130	0.10	■	75	0.09	■	120	0.10	—	—	■	30	0.07	—	—	12	—
	T7325	0.2	■	150	0.12	■	115	0.11	—	—	—	—	—	■	45	0.10	—	—	6	—
GL4-D400G02R06-PM	G8330	0.2	■	130	0.12	■	75	0.11	■	120	0.12	—	—	■	30	0.10	—	—	6	—
	T7325	0.2	■	150	0.12	■	115	0.11	—	—	—	—	—	■	45	0.10	—	—	6	—
GL4-D400G02R12-PM	G8330	0.2	■	130	0.12	■	75	0.11	■	120	0.12	—	—	■	30	0.10	—	—	12	—

Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE [mm]	P		M		K		N		S		H		PSIRR [°]	PSIRL [°]
			vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]		



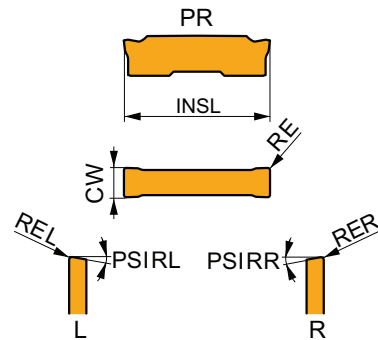
L-PM left-handed geometry, first choice for parting-off and continuous to slightly interrupted cuts.

GL2-D200G02L06-PM	G8330	0.2	130	0.08	75	0.07	120	0.08	—	—	30	0.06	—	—	—	6
	T7325	0.2	150	0.08	115	0.07	—	—	—	—	45	0.06	—	—	—	6
GL2-D200G02L12-PM	G8330	0.2	130	0.08	75	0.07	120	0.08	—	—	30	0.06	—	—	—	12
GL3-D300G02L06-PM	G8330	0.2	130	0.10	75	0.09	120	0.10	—	—	30	0.07	—	—	—	6
	T7325	0.2	150	0.10	115	0.09	—	—	—	—	45	0.07	—	—	—	6
GL3-D300G02L12-PM	G8330	0.2	130	0.10	75	0.09	120	0.10	—	—	30	0.07	—	—	—	12
GL4-D400G02L06-PM	G8330	0.2	130	0.12	75	0.11	120	0.12	—	—	30	0.10	—	—	—	6
	T7325	0.2	150	0.12	115	0.11	—	—	—	—	45	0.10	—	—	—	6
GL4-D400G02L12-PM	G8330	0.2	130	0.12	75	0.11	120	0.12	—	—	30	0.10	—	—	—	12

GL. D - PR



	CW [mm]	CWTOLL [mm]	CWTOLU [mm]	INSL [mm]
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE [mm]	P		M		K		N		S		H		PSIRR [°]	PSIRL [°]
			vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]	vc [m/min]	f [mm/rev]		



PR geometry, first choice for parting-off and grooving, and continuous to interrupted cuts.

GL2-D200M02-PR	G8330	0.2	130	0.10	75	0.09	120	0.10	—	—	—	—	—	—	—	—
	T7325	0.2	150	0.10	115	0.09	—	—	—	—	—	—	—	—	—	—
GL3-D300M02-PR	G8330	0.2	130	0.12	75	0.11	120	0.12	—	—	—	—	—	—	—	—
	T7325	0.2	150	0.12	115	0.11	—	—	—	—	—	—	—	—	—	—
GL4-D400M02-PR	G8330	0.2	130	0.15	75	0.14	120	0.15	—	—	—	—	—	—	—	—
	T7325	0.2	150	0.15	115	0.14	—	—	—	—	—	—	—	—	—	—
GL5-D500M04-PR	G8330	0.4	130	0.18	75	0.16	120	0.18	—	—	—	—	—	—	—	—
GL6-D600M04-PR	G8330	0.4	130	0.18	75	0.16	120	0.18	—	—	—	—	—	—	—	—

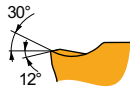


R-PR right-handed geometry, first choice for parting-off, and continuous to interrupted cuts.

GL2-D200G02R06-PR	G8330	0.2	130	0.10	75	0.09	120	0.10	—	—	—	—	—	—	6	—
GL2-D200G02R12-PR	G8330	0.2	130	0.10	75	0.09	120	0.10	—	—	—	—	—	—	12	—
GL3-D300G02R06-PR	G8330	0.2	130	0.12	75	0.11	120	0.12	—	—	—	—	—	—	6	—
GL3-D300G02R12-PR	G8330	0.2	130	0.12	75	0.11	120	0.12	—	—	—	—	—	—	12	—
GL4-D400G02R06-PR	G8330	0.2	130	0.15	75	0.14	120	0.15	—	—	—	—	—	—	6	—
GL4-D400G02R12-PR	G8330	0.2	130	0.15	75	0.14	120	0.15	—	—	—	—	—	—	12	—

Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc f		vc f		vc f		vc f		vc f		vc f			
			(mm)		(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)		



L-PR left-handed geometry, first choice for parting-off, and continuous to interrupted cuts.

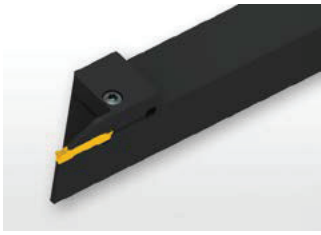
GL2-D200G02L06-PR	G8330	0.2	■	130	0.10	▣	75	0.09	■	120	0.10	—	—	—	—	6
GL2-D200G02L12-PR	G8330	0.2	■	130	0.10	▣	75	0.09	■	120	0.10	—	—	—	—	12
GL3-D300G02L06-PR	G8330	0.2	■	130	0.12	▣	75	0.11	■	120	0.12	—	—	—	—	6
GL3-D300G02L12-PR	G8330	0.2	■	130	0.12	▣	75	0.11	■	120	0.12	—	—	—	—	12
GL4-D400G02L06-PR	G8330	0.2	■	130	0.15	▣	75	0.14	■	120	0.15	—	—	—	—	6
GL4-D400G02L12-PR	G8330	0.2	■	130	0.15	▣	75	0.14	■	120	0.15	—	—	—	—	12

GLSF(RL) EXT



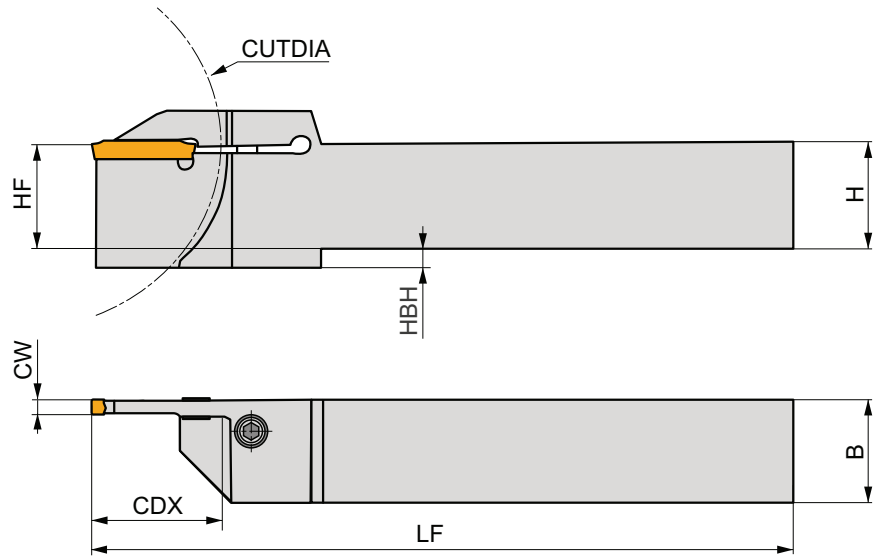
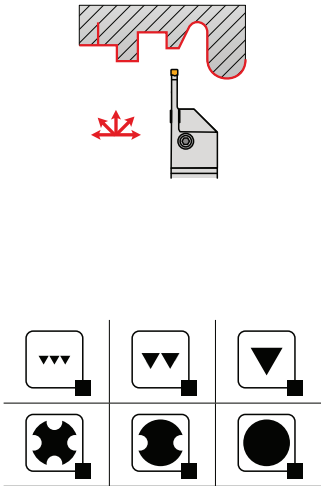
PRAMET

G



External V-Groove Top Clamp Grooving and Parting-Off tool for GL Inserts

External Right/Left hand radial tool holder for grooving with double-sided GL 2, 3, 4, 5, or 6 style inserts. Suited for radial grooving and parting-off applications, up to 32 mm maximum depth of cut. Available with shank size 20x20 or 25x25 mm. Reinforced body design for longer tool life and low vibrations.



	Product	HF	HBH	H	B	LF	CW	CDX	CUTDIA	kg		
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			
R	GL2-S2020KFR-20-80	20	—	20	20	125	2.00	20	80	0.38	GI334	GL11
	GL2-S2020KFR-24-80	20	5	20	20	125	2.00	24	80	0.36	GI334	GL11
	GL2-S2525MFR-20-80	25	—	25	25	150	2.00	20	80	0.68	GI334	GL11
	GL2-S2525MFR-24-80	25	—	25	25	150	2.00	24	80	0.64	GI334	GL11
	GL3-S2020KFR-20-80	20	—	20	20	125	3.00	20	80	0.38	GI335	GL11
	GL3-S2020KFR-24-80	20	5	20	20	125	3.00	24	80	0.36	GI335	GL11
	GL3-S2525MFR-20-80	25	—	25	25	150	3.00	20	80	0.68	GI335	GL11
	GL3-S2525MFR-24-80	25	—	25	25	150	3.00	24	80	0.65	GI335	GL11
	GL3-S2525PFR-32-80	25	5	25	25	170	3.00	32	80	0.72	GI335	GL11
	GL4-S2020KFR-20-80	20	—	20	20	125	4.00	20	80	0.38	GI336	GL11
	GL4-S2020KFR-24-80	20	5	20	20	125	4.00	24	80	0.37	GI336	GL11
	GL4-S2525MFR-20-80	25	—	25	25	150	4.00	20	80	0.68	GI336	GL11
	GL4-S2525MFR-24-80	25	—	25	25	150	4.00	24	80	0.65	GI336	GL11
	GL4-S2525PFR-32-80	25	5	25	25	170	4.00	32	80	0.78	GI336	GL11
	GL5-S2020KFR-20-80	20	—	20	20	125	5.00	20	80	0.38	GI337	GL11
	GL5-S2525MFR-20-80	25	—	25	25	150	5.00	20	80	0.68	GI337	GL11
	GL5-S2525PFR-32-100	25	5	25	25	170	5.00	32	100	0.75	GI337	GL11
	GL6-S2020KFR-20-80	20	—	20	20	125	6.00	20	80	0.39	GI338	GL11
L	GL6-S2525MFR-20-80	25	—	25	25	150	6.00	20	80	0.68	GI338	GL11
	GL6-S2525PFR-32-100	25	5	25	25	170	6.00	32	100	0.75	GI338	GL11
	GL2-S2020KFL-20-80	20	—	20	20	125	2.00	20	80	0.38	GI334	GL11
	GL2-S2020KFL-24-80	20	5	20	20	125	2.00	24	80	0.36	GI334	GL11
	GL2-S2525MFL-20-80	25	—	25	25	150	2.00	20	80	0.70	GI334	GL11
	GL2-S2525MFL-24-80	25	—	25	25	150	2.00	24	80	0.64	GI334	GL11
	GL3-S2020KFL-20-80	20	—	20	20	125	3.00	20	80	0.38	GI335	GL11
	GL3-S2020KFL-24-80	20	5	20	20	125	3.00	24	80	0.36	GI335	GL11
	GL3-S2525MFL-20-80	25	—	25	25	150	3.00	20	80	0.68	GI335	GL11

Product	HF	HBH	H	B	LF	CW	CDX	CUTDIA				
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				
L	GL3-S2525MFL-24-80	25	—	25	25	150	3.00	24	80	0.65	GI335	GL11
	GL3-S2525PFL-32-80	25	5	25	25	170	3.00	32	80	0.78	GI335	GL11
	GL4-S2020KFL-20-80	20	—	20	20	125	4.00	20	80	0.38	GI336	GL11
	GL4-S2020KFL-24-80	20	5	20	20	125	4.00	24	80	0.37	GI336	GL11
	GL4-S2525MFL-20-80	25	—	25	25	150	4.00	20	80	0.68	GI336	GL11
	GL4-S2525MFL-24-80	25	—	25	25	150	4.00	24	80	0.65	GI336	GL11
	GL4-S2525PFL-32-80	25	5	25	25	170	4.00	32	80	0.72	GI336	GL11
	GL5-S2020KFL-20-80	20	—	20	20	125	5.00	20	80	0.38	GI337	GL11
	GL5-S2525MFL-20-80	25	—	25	25	150	5.00	20	80	0.71	GI337	GL11
	GL5-S2525PFL-32-100	25	5	25	25	170	5.00	32	100	0.75	GI337	GL11
	GL6-S2020KFL-20-80	20	—	20	20	125	6.00	20	80	0.39	GI338	GL11
	GL6-S2525MFL-20-80	25	—	25	25	150	6.00	20	80	0.71	GI338	GL11
	GL6-S2525PFL-32-100	25	5	25	25	170	6.00	32	100	0.75	GI338	GL11

			
GI334		GL2..	
GI335		GL3..	
GI336		GL4..	
GI337		GL5..	
GI338		GL6..	

					
GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P

Cutting depths on machined diameter on page xxx.

GLSF(RL) EXT-G



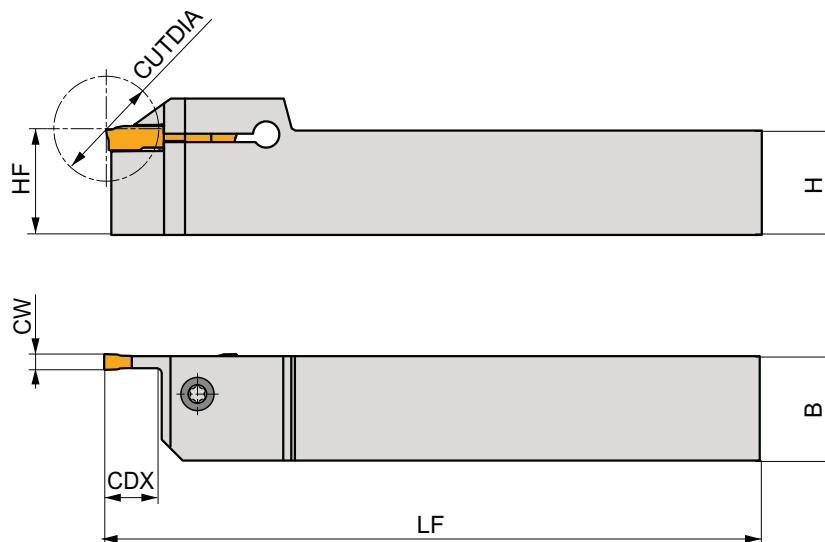
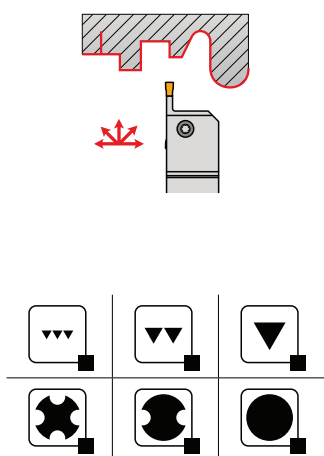
PRAMET

G



External V-Groove Top Clamp Grooving and Turning tool for GL Inserts

External Right/Left hand radial tool holder for grooving with double-sided GL 2, 3, 4, 5, or 6 style inserts. Suited for radial grooving, longitudinal turning and profiling applications, up to 12 mm maximum depth of cut. Available with shank size 20x20 or 25x25 mm. Body treated for longer tool life.



Product		HF	H	B	LF	CW	CDX	CUTDIA			
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			
R	GL2-S2020KFR-10	20	20	20	125	2.00	10	20	0.38	GI334	GL11
	GL2-S2525MFR-10	25	25	25	150	2.00	10	20	0.69	GI334	GL11
	GL3-S2020KFR-10	20	20	20	125	3.00	10	20	0.36	GI335	GL11
	GL3-S2525MFR-10	25	25	25	150	3.00	10	20	0.69	GI335	GL11
	GL4-S2020KFR-12	20	20	20	125	4.00	12	24	0.37	GI336	GL11
	GL4-S2525MFR-12	25	25	25	150	4.00	12	24	0.69	GI336	GL11
	GL5-S2020KFR-12	20	20	20	125	5.00	12	24	0.36	GI337	GL11
	GL5-S2525MFR-12	25	25	25	150	5.00	12	24	0.70	GI337	GL11
	GL6-S2020KFR-12	20	20	20	125	6.00	12	24	0.36	GI338	GL11
GL6-S2525MFR-12	25	25	25	150	6.00	12	24	0.68	GI338	GL11	
L	GL2-S2020KFL-10	20	20	20	125	2.00	10	20	0.37	GI334	GL11
	GL2-S2525MFL-10	25	25	25	150	2.00	10	20	0.70	GI334	GL11
	GL3-S2020KFL-10	20	20	20	125	3.00	10	20	0.36	GI335	GL11
	GL3-S2525MFL-10	25	25	25	150	3.00	10	20	0.70	GI335	GL11
	GL4-S2020KFL-12	20	20	20	125	4.00	12	24	0.37	GI336	GL11
	GL4-S2525MFL-12	25	25	25	150	4.00	12	24	0.69	GI336	GL11
	GL5-S2020KFL-12	20	20	20	125	5.00	12	24	0.36	GI337	GL11
	GL5-S2525MFL-12	25	25	25	150	5.00	12	24	0.69	GI337	GL11
	GL6-S2020KFL-12	20	20	20	125	6.00	12	24	0.36	GI338	GL11
GL6-S2525MFL-12	25	25	25	150	6.00	12	24	0.68	GI338	GL11	

			
GI334		GL2..	
GI335		GL3..	
GI336		GL4..	
GI337		GL5..	
GI338		GL6..	

GLSF(RL) EXT-S



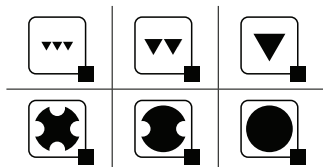
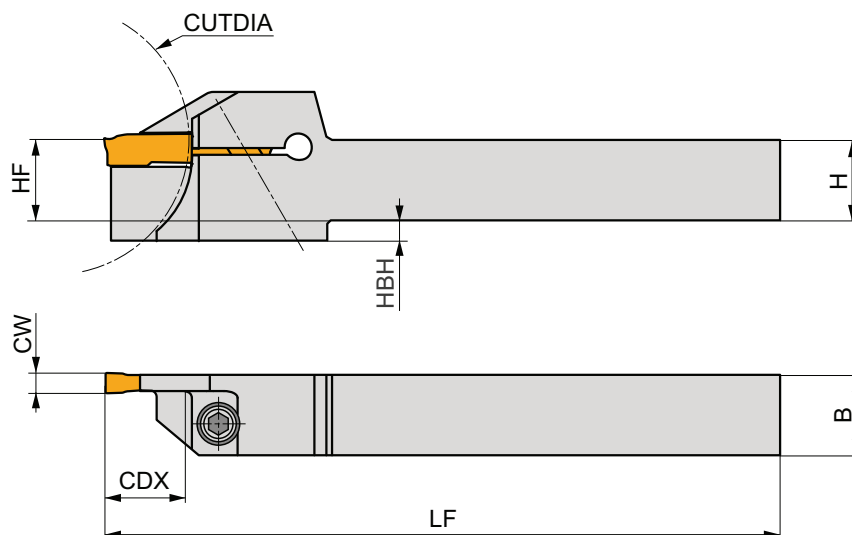
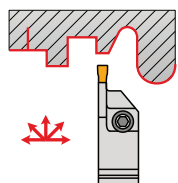
PRAMET

G



External Grooving and Parting-Off tool, GL Inserts for Sliding head machines

External Right/Left hand radial tool holder for sliding head machines GL 2, 3, 4 pocket widths. For radial grooving, profiling and parting-off applications up to 16 mm maximum depth of cut. Available with shank size 12x12 or 16x16 mm. Reinforced body design for longer tool life and low vibrations, easy access clamping.



	Product	HF	HBH	H	B	LF	CW	CDX	CUTDIA	kg		
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			
R	GL2-S1212HFR-12-40	12	3	12	12	100	2.00	12	40	0.11	GI334	GL13
	GL2-S1616KFR-16-45	16	3	16	16	125	2.00	16	45	0.23	GI334	GL12
	GL3-S1212HFR-12-40	12	3	12	12	100	3.00	12	40	0.11	GI335	GL13
	GL3-S1616KFR-16-45	16	3	16	16	125	3.00	16	45	0.23	GI335	GL12
	GL4-S1616KFR-16-45	16	4	16	16	125	4.00	16	45	0.26	GI336	GL12
L	GL2-S1212HFL-12-40	12	3	12	12	100	2.00	12	40	0.11	GI334	GL13
	GL2-S1616KFL-16-45	16	3	16	16	125	2.00	16	45	0.23	GI334	GL12
	GL3-S1212HFL-12-40	12	3	12	12	100	3.00	12	40	0.11	GI335	GL13
	GL3-S1616KFL-16-45	16	3	16	16	125	3.00	16	45	0.23	GI335	GL12
	GL4-S1616KFL-16-45	16	4	16	16	125	4.00	16	45	0.24	GI336	GL12

GI334												
GI335												
GI336												

					
GL12	HS 0516	5.0	M 5	16	HXK 4
GL13	HS 0412	5.0	M 4	12	HXK 3

Cutting depths on machined diameter on page xxx.

GLS B



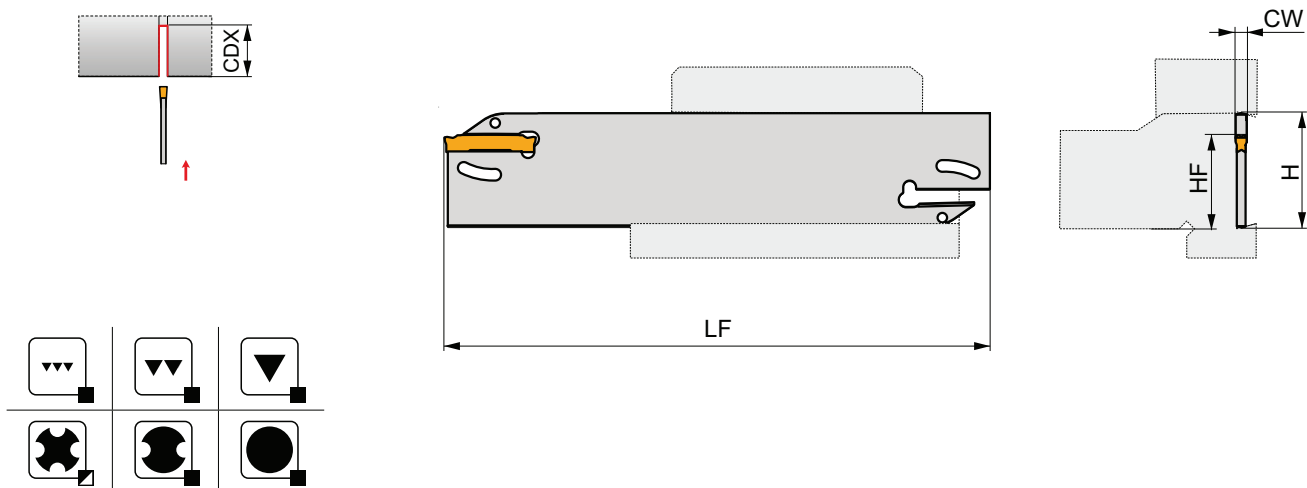
PRAMET

X



Double-Ended Parting-off Blade for GL Inserts

Blade for parting-off applications up to 60 mm maximum depth or Ø120 mm bar material. Suited for double-sided inserts GL family. Available in height of 26 and 32 mm. Can be fitted into the DU Pramet basic holders. Blade treated for longer tool life.



Product	CDX [mm]	HF [mm]	LF [mm]	CW [mm]	CDX [mm]	kg		
GL2-S26KB	21.4	26	125	2.00	35	0.13	GI334	KV2
GL2-S32MB	25	32	150	2.00	50	0.15	GI334	KV2
GL3-S26KB	21.4	26	125	3.00	35	0.15	GI335	KV2
GL3-S32MB	25	32	150	3.00	50	0.16	GI335	KV2
GL4-S32MB	25	32	150	4.00	50	0.16	GI336	KV2
GL5-S32MB	25	32	150	5.00	60	0.16	GI337	KV2
GL6-S32MB	25	32	150	6.00	60	0.16	GI338	KV2

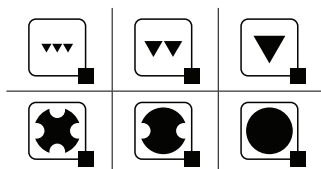
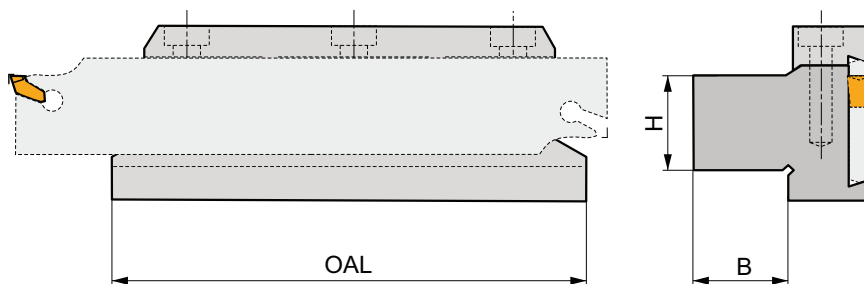
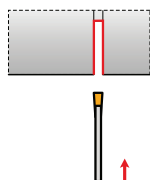
GI334	GL2..
GI335	GL3..
GI336	GL4..
GI337	GL5..
GI338	GL6..

KV2	KV 15x150
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Tool Holder Block for Parting-off Blades

Tool holder to fit GL or XLC. blades for parting-off. Available with shank size 20x20 up to 40x40 mm. Body treated for longer tool life.



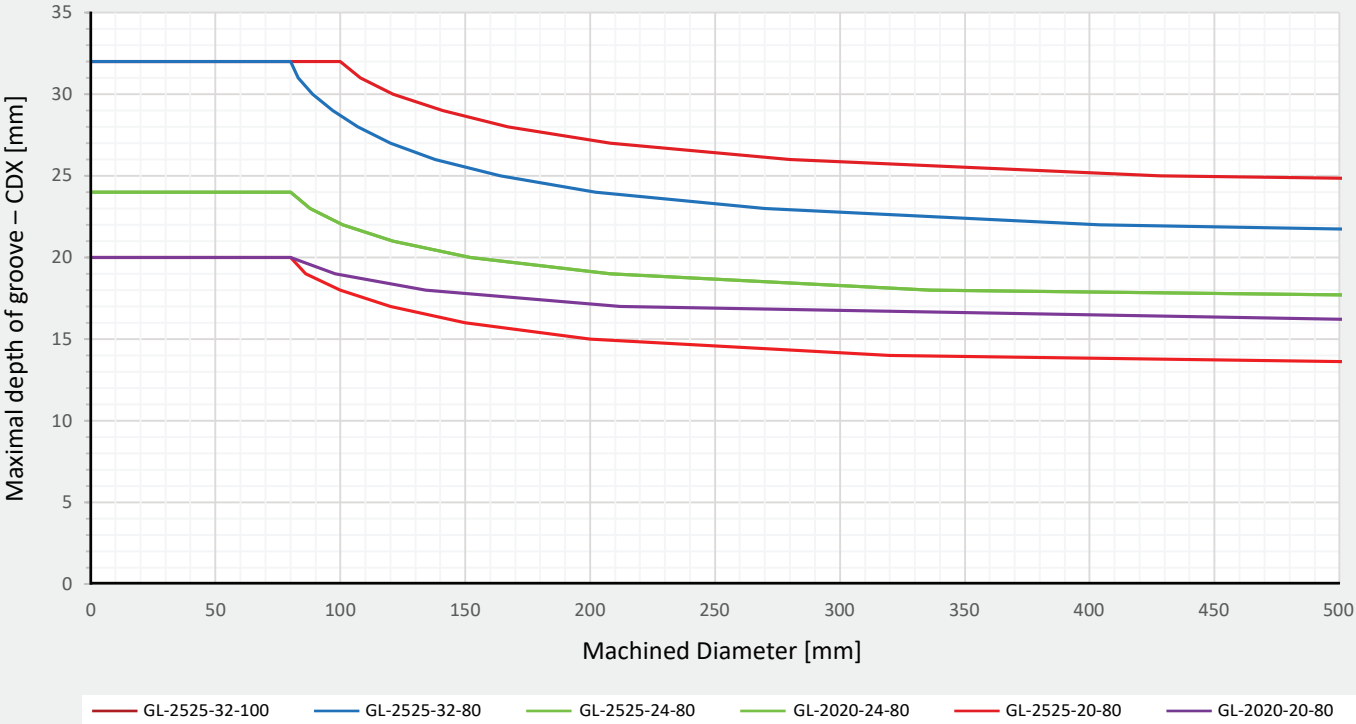
Product	H	B	LB	kg		
	[mm]	[mm]	[mm]			
26-DU 2020	20	20	90	0.70	GI007	ND2
26-D 2020	20	20	100	0.82	GI007	ND2
32-DU 2523	25	23	110	1.02	GI008	ND2
32-DU 2532	25	32	110	1.10	GI008	ND2
32-DU 3229	32	29	110	1.25	GI008	ND2
32-D 2530	25	30	115	1.30	GI008	ND2
45-DU 3229	32	29	110	1.50	GI009	ND7
45-DU 4036	40	36	110	2.05	GI009	ND7
47-D 4040	40	40	150	3.88	GI091	ND3

GI007	XLC.N 26..	GL.-S26.B
GI008	XLC.N 32..	GL.-S32.B
GI009	XLC.N 45..	-
GI091	XLC.N 47..	-

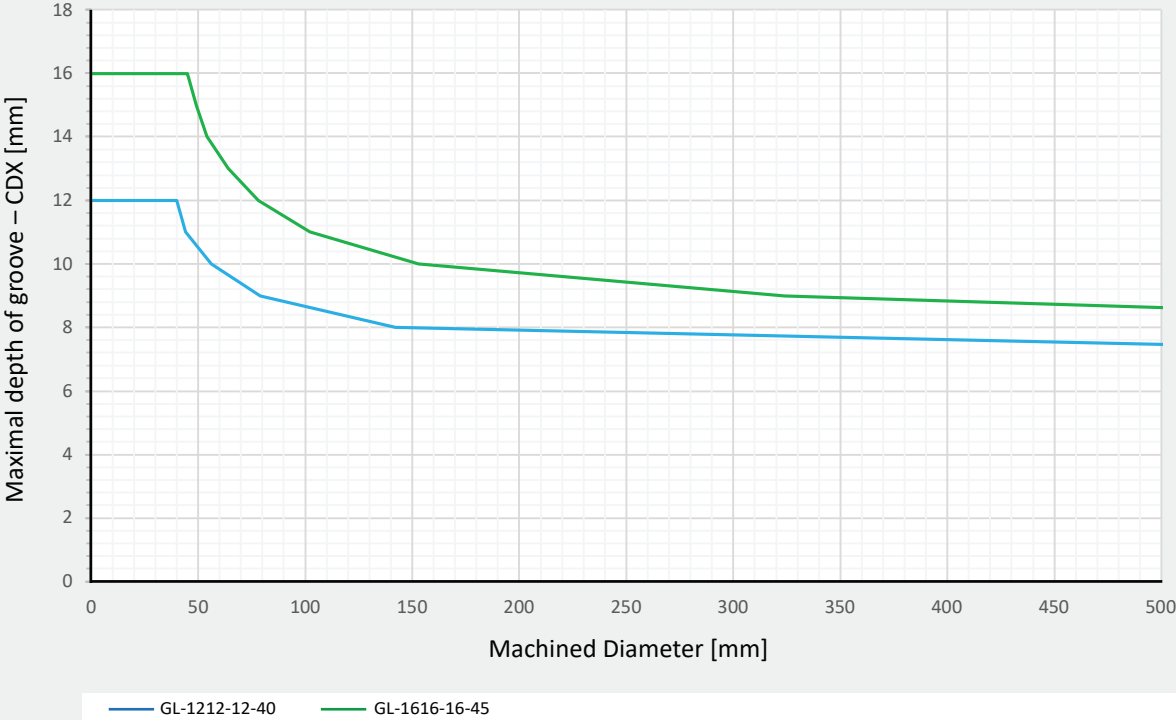
ND2	HS 0625	6.0	M 6	25	HXK 5
ND3	HS 1030	8.0	M 10	30	HXK 8
ND7	HS 0630	6.0	M 6	30	HXK 5

CUTTING DEPTHS DEPENDING ON MACHINED DIAMETER

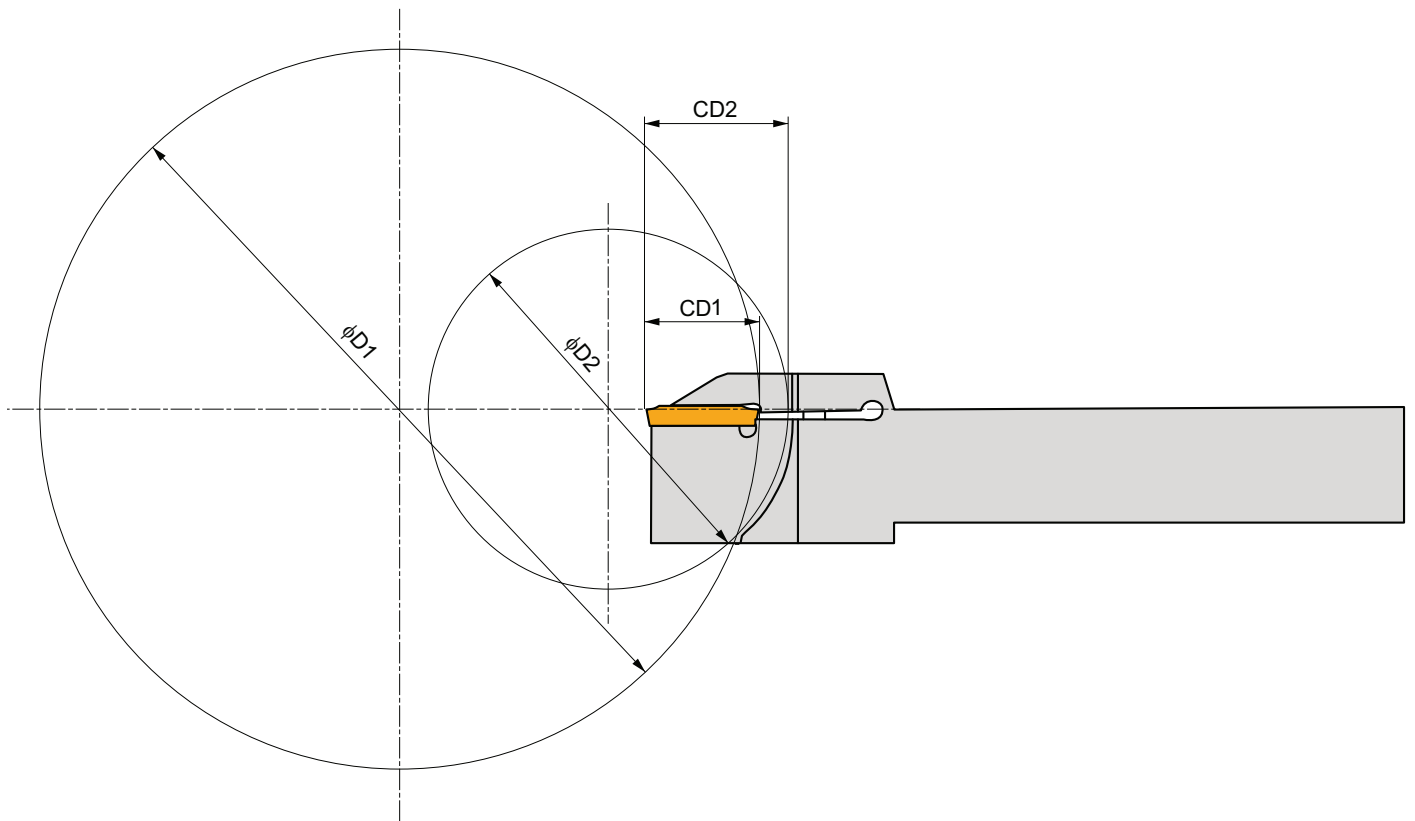
GLSF (RL) EXT



GLSF (RL) EXT-S



CUTTING DEPTHS DEPENDING ON MACHINED DIAMETER



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