

NEW

2026.10

B259E

PSC HOLDERS

FOR MULTI-TASKING MACHINES AND CNC LATHES
PROVIDES HIGH RIGIDITY AND PRECISION MACHINING



 **MITSUBISHI MATERIALS**

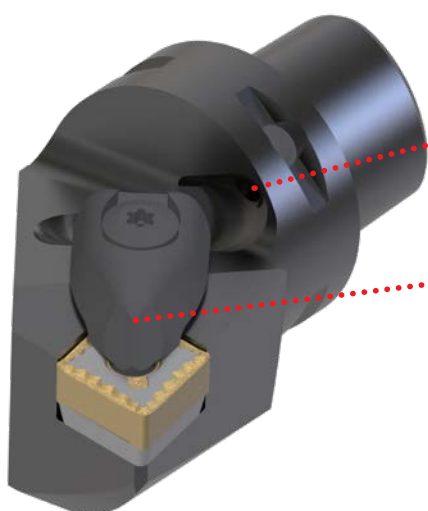
FEATURES

ISO AND GROOVING TOOL HOLDERS

The dual-face contact polygon taper shank (PSC) provides high clamping rigidity through a combination of a rigid, high precision face and taper contact.

Enables excellent repeatability during tool changes, for easy and reliable tool replacement.

ISO SERIES



EQUIPPED WITH COOLANT NOZZLES OR COOLANT HOLES *

(Recommended Max. Coolant Pressure: 4MPa)

COMPATIBLE WITH A WIDE RANGE OF ISO INSERTS

To support high-efficiency machining on multi-tasking machines, 12 types have been standardized using ISO inserts: negative C, D, T, V, W and positive C, D, T, V.

GY SERIES



EQUIPPED WITH A COOLANT NOZZLE *

(Recommended Max. Coolant Pressure: 4MPa)

OVER 100 TYPES OF MODULAR BLADES

From a range of over 100 modular type blades, users can select the correct blade for external turning, face grooving and undercutting, with up to three different grooving depths.

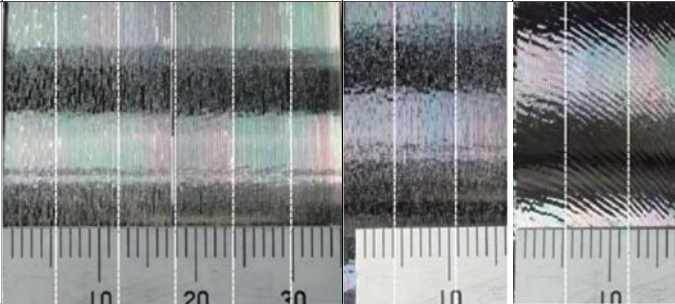
By choosing the optimal blade width and grooving depth, machining problems such as chatter and vibration can be effectively prevented.

* For details of the coolant system, please refer to the specification tables.

COMPARISON OF FINISHED SURFACES DURING CROSS-FEED MACHINING OF DIN C45 CARBON STEEL

The GY series uses modular blades with a short overhang which exhibit excellent rigidity, especially during cross-feed machining.

Workpiece material	DIN C45 Ø150 mm
CW (mm)	3
Vc (m/min)	180
Cutting mode	Cross-feed Machining External Coolant 1 Mpa

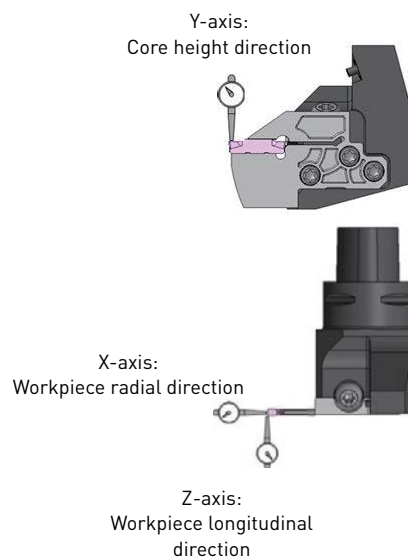
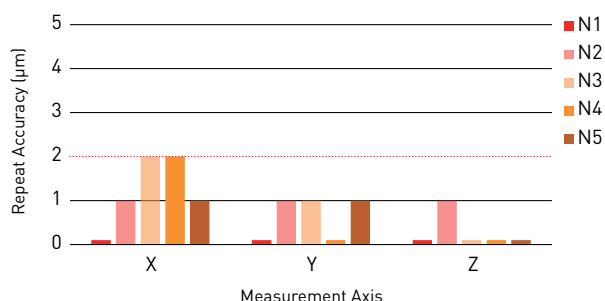
	GY PSC									Conventional
CDX (mm)	6						12			20
ap (mm)	1.0			1.5			1.0			1.0
f (mm/rev)	0.30	0.25	0.20	0.30	0.25	0.20	0.30	0.25	0.20	0.30 0.25 0.20
Machined Surface										
Finished Surface Evaluation	✓	✓	✓	✓	✓	✓	✓	✓	✓	✗ ✗ ✗
Machining Sound	✓	✓	✓	✓	✓	✓	✓	✓	✓	✗ ✗ ✗

✗: Displays chatter and vibration

REPEAT POSITIONAL ACCURACY WITH PSC INSTALLATION

Accuracy of $\pm 2 \mu\text{m}$ or less for all 3 axes is achieved when replacing tools.

REPEATABLE POSITIONAL ACCURACY



IDENTIFICATION

ISO SERIES

Mounting size	Insert geometry	Insert clearance	WF dimension	Inscribed circle	Thickness	Cutting edge length								
						CC	CN	DC	DN	TC	TN	VB	VN	WN
						CC	CN	DC	DN	TC	TN	VB	VN	WN
C3 PSC30	C RHOMBIC 80°	B 5° POSITIVE	00 0 mm	6.35	2.38			07		11				
C4 PSC40	D RHOMBIC 55°	C 7° POSITIVE	11 11 mm	9.525	4.76				11		16	16	16	06
C5 PSC50	T TRIANGULAR	N NEGATIVE	13 13 mm	9.525	3.97	09		11						
C6 PSC63	V RHOMBIC 35°		18 18 mm	9.525	3.18			09						
	W TRIGON 80°		22 22 mm	12.7	4.76			12		1504				08
			27 27 mm	12.7	6.35				15					
			35 35 mm	15.875	6.35			16						
			45 45 mm											

C5	—	D	D	J	N	R	35	—	060	1504	C/CA
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Clamp structure	Cutting angle	Hand	Functional length (LF)				With coolant hole
D Double clamp	F 91°	R Right hand	040 40 mm	070 70 mm			
S Screw-on	J 93°	L Left hand	045 45 mm	075 75 mm			
	L 95°	N Neutral	050 50 mm	080 80 mm			
	M 95°		055 55 mm	090 90 mm			
	N 62.5°		060 60 mm	105 105 mm			
	Q 107.5°		062 62 mm	115 115 mm			
	U 93°		065 65 mm				

GY SERIES

Mounting size	Holder type	Hand	Angle (degree)	Hand of modular blade
C4 PSC40	H Modular type holder	R Right hand	00 0°	R Right hand
C5 PSC50		L Left hand	50 50°	L Left hand
C6 PSC63			90 90°	

C4	—	GY	H	E	R	M	00	—	M25	R
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Series description	Coolant	Overall length	Modular blade size
	E External	M Medium	M25

GY SERIES LIG DIMENSION TOLERANCE CONVERSION TABLE

The setting dimensions LF and LH shown on the next pages will change depending on the installed insert. The standard published dimensions assume GM chipbreakers for a cutting edge angle of 00°, 90°, and BM chipbreakers for 50°.

Cutting Width CW	*1 Dimensions LIG	*2 Dimensional tolerance (mm) versus standard dimension (LIG) of each chipbreakers							
		GU	GS/GM	MS/MM	R/L-GM	Flat top	MF	BM	GL
2.00	20.70	0	0	0	0.10	0	0.35	0.20	0.35
2.24	*3 (20.7)	—	—	—	—	—	0.35	—	—
2.39	20.70	0	0	—	—	0	0.35	—	—
2.50	20.70	0	0	0	0.125	0	0.35	0.20	0.35
2.74	*3 (20.7)	—	—	—	—	—	0.35	—	—
3.00	20.70	0	0	0	0.15	0	0.35	0.20	0.35
3.18	20.70	0	0	—	—	0	0.35	0.20	—
3.24	*3 (20.7)	—	—	—	—	—	0.35	—	—
4.00	25.65	0	0	0	0.20	0	0.30	0.15	—
4.24	*3 (25.65)	—	—	—	—	—	0.30	—	—
4.75	25.65	0	0	—	—	0	0.30	0.15	—
5.00	25.65	0	0	0	0.30	0	0.30	0.15	—
5.24	*3 (25.65)	—	—	—	—	—	0.30	—	—
6.00	25.65	0	0	0	—	0	0.30	0.25	—
6.31	*3 (25.65)	—	—	—	—	—	0.30	—	—
6.35	25.65	0	0	—	—	—	0.30	0.25	—

*1 This value is used at the described holder dimension.

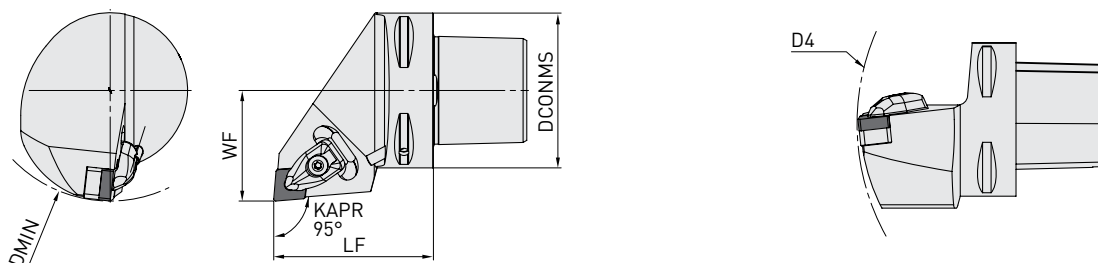
*2 — when there is no applicable chipbreakers.

*3 The standard dimensions shown here use an approximate insert width.

PSC_DCLN_A

EXTERNAL TURNING, FACING DOUBLE CLAMP TYPE

CN  Inserts



Right-hand tool holder shown.

Order number	Stock		Insert number	DCONMS	LF	WF	DMIN	D4	WT (kg)
	R	L							
C3-DCLNR-22045-12-C	★		CNC-A CNC-G CNC-M	1204	32	45	22.0	60	0.2
C3-DCLNL-22045-12-C		★		1204	32	45	22.0	60	0.2
C4-DCLNR-27050-09-C	★			0904	40	50	27.0	60	0.4
C4-DCLNL-27050-09-C		★		0904	40	50	27.0	60	0.4
C4-DCLNR-27050-12-C	★			1204	40	50	27.0	110	0.4
C4-DCLNL-27050-12-C		★		1204	40	50	27.0	110	0.4
C5-DCLNR-35060-12-C	★			1204	50	60	35.0	110	0.7
C5-DCLNL-35060-12-C		★		1204	50	60	35.0	110	0.7
C6-DCLNR-45065-12-C	★			1204	63	65	45.0	110	1.3
C6-DCLNL-45065-12-C		★		1204	63	65	45.0	110	1.2
C6-DCLNR-45065-16-C *	★			1606	63	65	45.0	125	1.3
C6-DCLNL-45065-16-C *		★		1606	63	65	45.0	125	1.3

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* Cannot be fitted to the Yamazaki Mazak INTEGREX i, j, e series.

SPARE PARTS

Holder type							
	Shim	Shim screw	Clamp set ^{*1}	Clamp torque (N·m)	Nozzle	Wrench (Insert) ^{*2}	Wrench (Shim) ^{*2}
C3-DCLNR/L-22045-12	A110003	A130015	A120012	3.9	—	TKY15F	TIP15W
C4-DCLNR/L-27050-09	A110004	A130017	A120011	1.7	NZ44200-X	Torx Size 9 ^{*3}	Torx Plus Size 9 ^{*3}
C4-DCLNR/L-27050-12	A110001	A130015	A120012	3.9	NZ44200-X	TKY15F	TIP15W
C5-DCLNR/L-35060-12	A110001	A130015	A120012	3.9	NZ44200-X	TKY15F	TIP15W
C6-DCLNR/L-45065-12	A110001	A130015	A120012	3.9	NZ44200-X	TKY15F	TIP15W
C6-DCLNR/L-45065-16	A110002	A130018	A120013	6.4	NZ44200-X	TKY20F	TIP20F-X

^{*1} Clamp set: Sold as a set of clamp bridge, spring, and clamp screw.

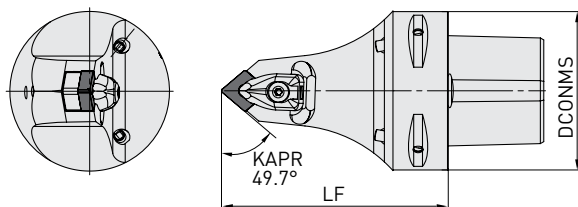
^{*2} Sold separately

^{*3} Not supplied. Please use a commercially available wrench.

PSC_DCMN_A

EXTERNAL TURNING, FACING DOUBLE CLAMP TYPE

CN  Inserts



Order number	Stock	Insert number	DCONMS	LF	WT (kg)
	N				
C5-DCMNN-00105-12-C	★	CN  A	1204	50	1.1
C6-DCMNN-00090-12-C	★	CN  G	1204	63	1.3
C6-DCMNN-00115-12-C	★	CN  M	1204	63	1.7

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SPARE PARTS

Holder type								
	Shim	Shim screw	Clamp set ^{*1}	Clamp torque (N·m)	Nozzle	Wrench (Insert) ^{*2}	Wrench (Shim) ^{*2}	Nozzle exchange key ^{*2}
C5-DCMNN-00105-12	A110001	A130015	A120012	3.9	NZ29048100S	TKY15F	TIP15W	NZKH050SL
C6-DCMNN-00  -12	A110001	A130015	A120012	3.9	NZ35050120S-X	TKY15F	TIP15W	NZKH050SX-X

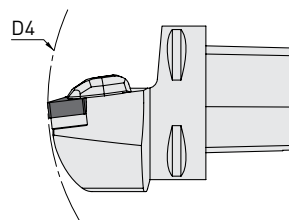
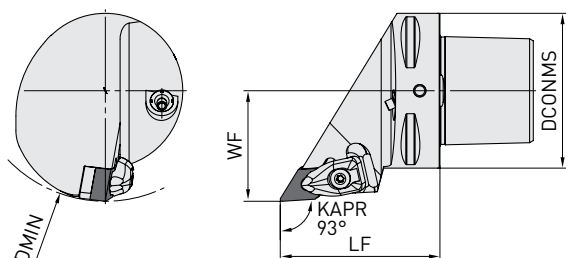
^{*1} Clamp set: Sold as a set of clamp bridge, spring, and clamp screw.

^{*2} Sold separately

PSC_DDJN_A

EXTERNAL TURNING, FACING DOUBLE CLAMP TYPE

DN  Inserts



Right-hand tool holder shown.

Order number	Stock		Insert number *1	DCONMS	LF	WF	DMIN	D4	WT (kg)
	R	L							
C3-DDJNR-22045-11-C	★		1104	32	45	22.0	80	121	0.2
C3-DDJNL-22045-11-C		★	1104	32	45	22.0	80	121	0.2
C4-DDJNR-27050-11-C	★		1104	40	50	27.0	80	140	0.3
C4-DDJNL-27050-11-C		★	1104	40	50	27.0	80	140	0.4
C4-DDJNR-27055-1504C	★		1504 (1506)	40	55	27.0	110	145	0.4
C4-DDJNL-27055-1504C		★	1504 (1506)	40	55	27.0	110	145	0.4
C4-DDJNR-27055-15-C	★		1506 (1504)	40	55	27.0	110	145	0.4
C4-DDJNL-27055-15-C		★	1506 (1504)	40	55	27.0	110	145	0.4
C5-DDJNR-35060-1504C	★		1504 (1506)	50	60	35.0	110	165	0.7
C5-DDJNL-35060-1504C		★	1504 (1506)	50	60	35.0	110	165	0.6
C5-DDJNR-35060-15-C	★		1506 (1504)	50	60	35.0	110	165	0.7
C5-DDJNL-35060-15-C		★	1506 (1504)	50	60	35.0	110	165	0.7
C6-DDJNR-45065-1504C	★		1504 (1506)	63	65	45.0	110	190	1.2
C6-DDJNL-45065-1504C		★	1504 (1506)	63	65	45.0	110	190	1.1
C6-DDJNR-45065-15-C *2	★		1506 (1504)	63	65	45.0	110	190	1.1
C6-DDJNL-45065-15-C *2		★	1506 (1504)	63	65	45.0	110	190	1.1

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*1 Changing to the shim compatible with the symbols in parentheses allows the use of inserts with different thicknesses.

*2 Cannot be fitted to the Yamazaki Mazak INTEGREX i, j, e series.

SPARE PARTS

Holder type								
	Shim	Shim screw	Clamp set *1	Clamp torque (N-m)	Nozzle	Wrench (Insert) *2	Wrench (Shim) *2	Nozzle exchange key *2
C3-DDJNR/L-22045-11	A110006	A130017	A120011	1.7	—	Torx Size 9 *3	Torx Plus Size 9 *3	—
C4-DDJNR/L-27050-11	A110006	A130017	A120011	1.7	NZ22042080S	Torx Size 9 *3	Torx Plus Size 9 *3	NZKH050S
C4-DDJNR/L-27055-1504	A110033 (A110005)	A130015	A120012	3.9	NZ22042080S	TKY15F	TIP15W	NZKH050S
C4-DDJNR/L-27055-15	A110005 (A110033)	A130015	A120012	3.9	NZ22042080S	TKY15F	TIP15W	NZKH050S
C5-DDJNR/L-35060-1504	A110033 (A110005)	A130015	A120012	3.9	NZ44200-X	TKY15F	TIP15W	—
C5-DDJNR/L-35060-15	A110005 (A110033)	A130015	A120012	3.9	NZ44200-X	TKY15F	TIP15W	—
C6-DDJNR/L-45065-1504	A110033 (A110005)	A130015	A120012	3.9	NZ29048100S	TKY15F	TIP15W	NZKH050SL
C6-DDJNR/L-45065-15	A110005 (A110033)	A130015	A120012	3.9	NZ29048100S	TKY15F	TIP15W	NZKH050SL

*1 Clamp set: Sold as a set of clamp bridge, spring, and clamp screw.

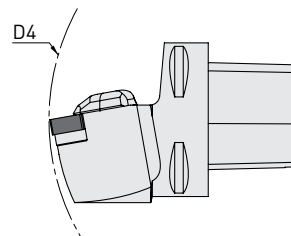
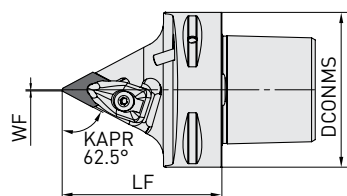
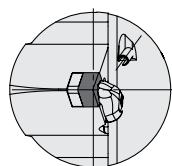
*2 Sold separately

*3 Not supplied. Please use a commercially available wrench.

PSC_DDNN_A

EXTERNAL TURNING, FACING DOUBLE CLAMP TYPE

DN  Inserts



Order number	Stock	Insert number *	DCONMS	LF	WF	DMIN	D4	
	N							
C5-DDNNN-00060-1504C	★	DNC DNC DNC DNC	1504 (1506)	50	60	0.5	165	0.6
C5-DDNNN-00060-15-C	★		1506 (1504)	50	60	0.5	165	0.6
C6-DDNNN-00065-1504C	★		1504 (1506)	63	65	0.5	190	0.9
C6-DDNNN-00065-15-C	★		1506 (1504)	63	65	0.5	190	0.9
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* Changing to the shim compatible with the symbols in parentheses allows the use of inserts with different thicknesses.

SPARE PARTS

Holder type								
	Shim	Shim screw	Clamp set ^{*1}	Clamp torque (N·m)	Nozzle	Wrench (Insert) ^{*2}	Wrench (Shim) ^{*2}	Nozzle exchange key ^{*2}
C5-DDNNN-00060-1504	A110033 (A110005)	A130015	A120012	3.9	NZ44200-X	TKY15F	TIP15W	—
C6-DDNNN-00065-1504	A110033 (A110005)	A130015	A120012	3.9	NZ29048100S	TKY15F	TIP15W	NZKH050SL
C6-DDNNN-00065-15	A110005 (A110033)	A130015	A120012	3.9	NZ29048100S	TKY15F	TIP15W	NZKH050SL

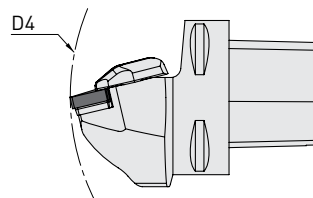
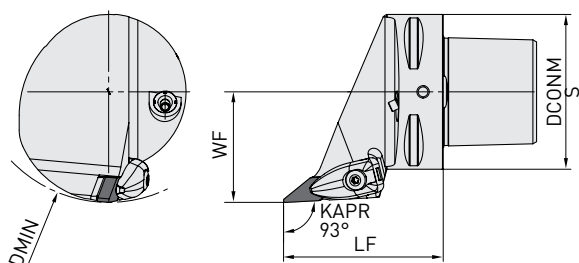
*¹ Clamp set: Sold as a set of clamp bridge, spring, and clamp screw.

*² Sold separately

PSC_DVJN_A

EXTERNAL TURNING, FACING DOUBLE CLAMP TYPE

VN  Inserts



Right-hand tool holder shown.

Order number	Stock		Insert number	DCONMS	LF	WF	DMIN	D4	WT (kg)
	R	L							
C4-DVJNR-27062-16-Ca	★		VN  VN  VN 	1604	40	62	27.0	110	0.4
C4-DVJNL-27062-16-Ca		★		1604	40	62	27.0	110	0.4
C5-DVJNR-35065-16-Ca	★			1604	50	65	35.0	110	0.6
C5-DVJNL-35065-16-Ca		★		1604	50	65	35.0	110	0.7
C6-DVJNR-45065-16-Ca *	★			1604	63	65	45.0	110	1.0
C6-DVJNL-45065-16-Ca *		★		1604	63	65	45.0	110	1.0

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* Cannot be fitted to the Yamazaki Mazak INTEGREX i, j, e series.

SPARE PARTS

Holder type								
	Shim	Shim screw	Clamp set * ¹	Clamp torque (N·m)	Nozzle	Wrench (Insert) * ²	Wrench (Shim) * ²	Nozzle exchange key * ²
C4-DVJNR/L-27062-16	A110007	A130019	A120014	3.0	NZ22042080S	TKY15F	TIP15W	NZKH050S
C5-DVJNR/L-35065-16	A110007	A130019	A120014	3.0	NZ29048100S	TKY15F	TIP15W	NZKH050SL
C6-DVJNR/L-45065-16	A110007	A130019	A120014	3.0	NZ29048100S	TKY15F	TIP15W	NZKH050SL

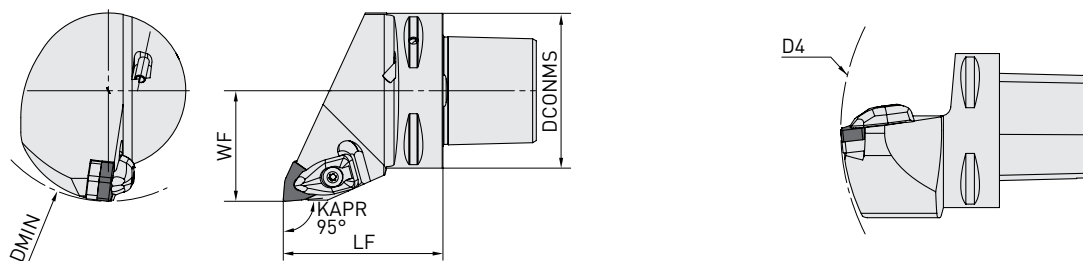
*¹ Clamp set: Sold as a set of clamp bridge, spring, and clamp screw.

*² Sold separately

PSC_DWLN_A

EXTERNAL TURNING, FACING DOUBLE CLAMP TYPE

WN $\odot$ Inserts



Right-hand tool holder shown.

Order number	Stock		Insert number	DCONMS	LF	WF	DMIN	D4	WT (kg)
	R	L							
C4-DWLN-R-27050-06-C	★		WN $\odot$ A WNMG	0604	40	50	27.0	60	0.4
C4-DWLN-L-27050-06-C		★		0604	40	50	27.0	60	0.4
C4-DWLN-R-27050-08-C	★			0804	40	50	27.0	110	0.4
C4-DWLN-L-27050-08-C		★		0804	40	50	27.0	110	0.4
C5-DWLN-R-35060-08-C	★			0804	50	60	35.0	110	0.7
C5-DWLN-L-35060-08-C		★		0804	50	60	35.0	110	0.7
C6-DWLN-R-45065-08-C *	★			0804	63	65	45.0	110	1.2
C6-DWLN-L-45065-08-C *		★		0804	63	65	45.0	110	1.3

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* Cannot be fitted to the Yamazaki Mazak INTEGREX i, j, e series.

SPARE PARTS

Holder type								
	Shim	Shim screw	Clamp set*	Clamp torque (N·m)	Nozzle	Wrench (Insert) ^{*2}	Wrench (Shim) ^{*2}	Nozzle exchange key ^{*2}
C4-DWLN-R/L-27050-06	A110009	A130017	A120011	1.7	NZ22042080S	Torx Size 9 ^{*3}	Torx Plus Size ^{*3}	NZKH050S
C4-DWLN-R/L-27050-08	A110010	A130015	A120012	3.9	NZ22042080S	TKY15F	TIP15W	NZKH050S
C5-DWLN-R/L-35060-08	A110010	A130015	A120012	3.9	NZ44200-X	TKY15F	TIP15W	—
C6-DWLN-R/L-45065-08	A110010	A130015	A120012	3.9	NZ44200-X	TKY15F	TIP15W	—

*1 Clamp set: Sold as a set of clamp bridge, spring, and clamp screw.

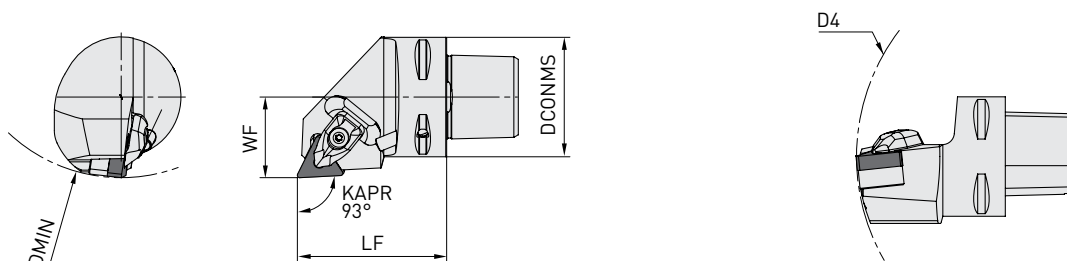
*2 Sold separately

*3 Not supplied. Please use a commercially available wrench.

PSC_DTJN_A

EXTERNAL TURNING, FACING DOUBLE CLAMP TYPE

TN  Inserts



Right-hand tool holder shown.

Order number	Stock		Insert number	DCONMS	LF	WF	DMIN	D4	WT (kg)	
	R	L								
C4-DTJNR-27050-16-C	★		TNOA TNOG TNOM	1604	40	50	27.0	110	140	0.4
C4-DTJNL-27050-16-C		★		1604	40	50	27.0	110	140	0.4
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SPARE PARTS

Holder type							
	Shim	Shim screw	Clamp set ^{*1}	Clamp torque (N·m)	Nozzle	Wrench (Insert) ^{*2}	Wrench (Shim) ^{*2}
C4-DTJNR/L	A110008	A130017	A120011	1.7	NZ44200-X	Torx Size 9 ^{*3}	Torx Plus Size 9 ^{*3}

^{*1} Clamp set: Sold as a set of clamp bridge, spring, and clamp screw.

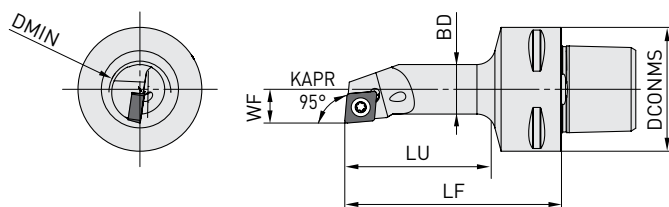
^{*2} Sold separately

^{*3} Not supplied. Please use a commercially available wrench.

PSC_SCLC_A

BORING SCREW-ON TYPE

CC $\odot$ Inserts



Right-hand tool holder shown.

Order number	Stock		Insert number	DCONMS	LF	LU	BD	WF	DMIN	WT (kg)
	R	L								
C3-SCLCR-11065-09-C	★		CC $\odot$ B CC $\odot$ H CC $\odot$ T CC $\odot$ W	09T3	32	65	48	16	10.9	0.2
C3-SCLCL-11065-09-C		★		09T3	32	65	48	16	10.9	0.2
C4-SCLCR-11070-09-C	★			09T3	40	70	47	16	10.9	0.3
C4-SCLCL-11070-09-C		★		09T3	40	70	47	16	10.9	0.3

1/1

SPARE PARTS

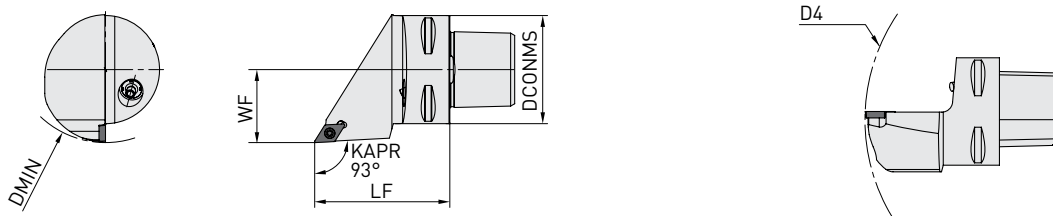
Holder type			Wrench (Insert) *
	Clamp screw	Clamp torque(N·m)	
CC $\odot$ -SCLCR/L	A130019	3.0	TIP15W

* Sold separately

PSC_SDJC_A

EXTERNAL TURNING SCREW-ON TYPE

DC  Inserts



Right-hand tool holder shown.

Order number	Stock	Insert number	DCONMS	LF	WF	DMIN	D4	WT (kg)
	R							
C3-SDJCR-22040-07-C	★	DCOT	0702	32	40	22.0	70	0.2
C4-SDJCR-27050-07-C	★	DCOW	0702	40	50	27.0	70	0.3

1/1

SPARE PARTS

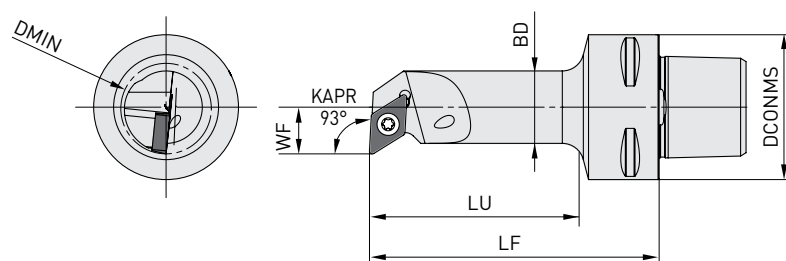
Holder type				
	Clamp screw	Clamp torque (N·m)	Nozzle	Wrench (Insert) *
CO-SDJCR	A130016	0.9	NZ22042080S	TIP07F
				Nozzle exchange key *

* Sold separately

PSC_SDUC_A

BORING SCREW-ON TYPE

DC Inserts



Right-hand tool holder shown.

Order number	Stock		Insert number	DCONMS	LF	LU	BD	WF	DMIN	WT (kg)
	R	L								
C3-SDUCR-13075-11-C	★		DCOT DCOW	11T3	32	75	58	20	12.9	0.2
C3-SDUCL-13075-11-C		★		11T3	32	75	58	20	12.9	0.2
C4-SDUCR-13080-11-C	★			11T3	40	80	57	20	12.9	0.4
C4-SDUCL-13080-11-C		★		11T3	40	80	57	20	12.9	0.4

1/1

SPARE PARTS

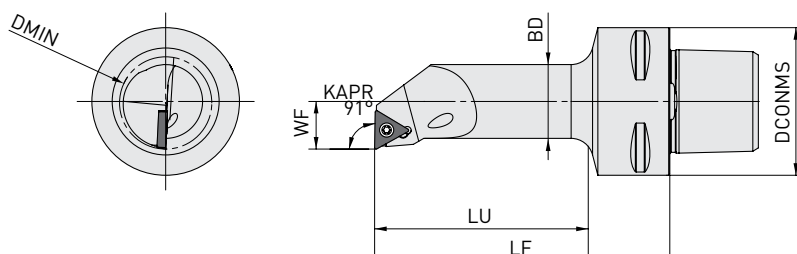
Holder type			Wrench (Insert) *
	Clamp screw	Clamp torque (N·m)	
CO-SDUCR/L	A130019	3.0	TIP15W

* Sold separately

PSC_STFC_A

BORING SCREW-ON TYPE

TC $\odot$ Inserts



Right-hand tool holder shown.

Order number	Stock		Insert number	DCONMS	LF	LU	BD	WF	DMIN	WT (kg)	
	R	L									
C4-STFCR-13080-11-C	★		TCOT	1102	40	80	57	20	12.9	25	0.4
C4-STFCL-13080-11-C		★	TCOW	1102	40	80	57	20	12.9	25	0.4
1/1											

1/1

SPARE PARTS

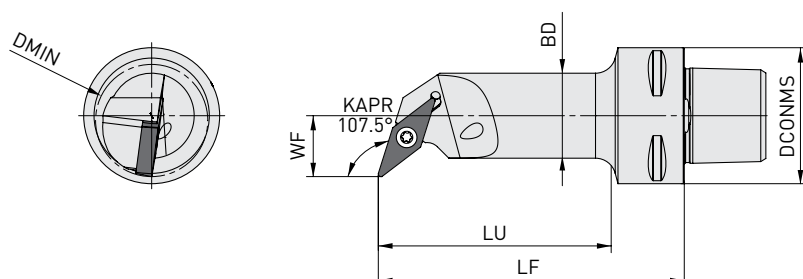
Holder type		
	Clamp screw	Wrench (Insert) *
C4-STFCR/L	A130016	TIP07F

* Sold separately

PSC_SVQB_A

BORING SCREW-ON TYPE

VB $\odot$ Inserts



Right-hand tool holder shown.

Order number	Stock		Insert number	DCONMS	LF	LU	BD	WF	DMIN	WT (kg)	
	R	L									
C4-SVQBR-18090-16-C	★		VB ^o T	1604	40	90	68	25	17.9	33	0.4
C4-SVQBL-18090-16-C		★	VBGW	1604	40	90	68	25	17.9	33	0.4
1/1											

1/1

SPARE PARTS

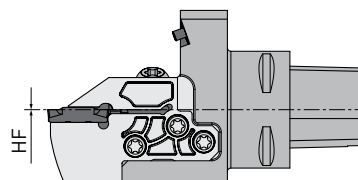
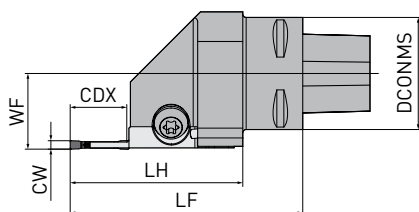
Holder type		
	Clamp screw	Wrench (Insert) *
C4-SVQBR/L	A130020	TIP15W

* Sold separately

PSC_GY00_A

GY PSC HOLDERS (EXTERNAL / FACE GROOVING)

00° type holder



Right-hand tool holder shown.

Order number	Stock		Coolant	Mounting size	DCONMS	CW	WT (kg)
	R	L					
C4-GYHER/LM00-M25R/L	●	●	External	PSC40	40	2.0 – 6.35	0.7
C5-GYHER/LM00-M25R/L	●	●	External	PSC50	50	2.0 – 6.35	1.2
C6-GYHER/LM00-M25R/L*	●	●	External	PSC63	63	2.0 – 6.35	1.8
							1/1

* Cannot be fitted to the Yamazaki Mazak INTEGREX i, j, e series.

1. Please order the modular blade and modular holder separately.

2. Please set the right-hand modular blade in the right-hand holder and the left-hand modular blade in the left-hand holder.

SPARE PARTS

											
Clamp screw			Blade Screw			Plug		Nozzle		Wrench 1	Wrench 2
Order number	Pcs.	Clamp torque (N·m)	Order number	Pcs.	Clamp torque (N·m)	Order number	Pcs.	Order number	Pcs.	Order number	Order number
GY06013M	1	6.0	TS55	5	5.0	HSD05004S	1	NZ22042080S	1	TKY25D	TKY30R

1. Nozzle exchange key: NZKH050S (Sold separately)

SET DIMENSIONS WITH MODULAR BLADES

Holder type	Modular blade type	Standard CW	CDX	WF	HF	LF	LH
C4-GYHER/LM00-M25R/L	GYM25R/LO-D06	2.0	6	27.0	0	69	47.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-D12	2.0	12	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-D20	2.0	20	27.0	0	83	61.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-E06	2.5	6	27.0	0	69	47.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-E12	2.5	12	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-E20	2.5	20	27.0	0	83	61.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-F06	3.0	6	27.0	0	69	47.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-F12	3.0	12	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-F20	3.0	20	27.0	0	83	61.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-G08	4.0	8	27.0	0	71	49.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-G14	4.0	14	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-G25	4.0	25	27.0	0	88	66.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-H08	5.0	8	27.0	0	71	49.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-H14	5.0	14	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-H25	5.0	25	27.0	0	88	66.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-J08	6.0	8	27.0	0	71	49.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-J14	6.0	14	27.0	0	77	55.6
C4-GYHER/LM00-M25R/L	GYM25R/LO-J25	6.0	25	27.0	0	88	66.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-D06	2.0	6	35.0	0	69	47.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-D12	2.0	12	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-D20	2.0	20	35.0	0	83	61.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-E06	2.5	6	35.0	0	69	47.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-E12	2.5	12	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-E20	2.5	20	35.0	0	83	61.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-F06	3.0	6	35.0	0	69	47.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-F12	3.0	12	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-F20	3.0	20	35.0	0	83	61.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-G08	4.0	8	35.0	0	71	49.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-G14	4.0	14	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-G25	4.0	25	35.0	0	88	66.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-H08	5.0	8	35.0	0	71	49.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-H14	5.0	14	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-H25	5.0	25	35.0	0	88	66.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-J08	6.0	8	35.0	0	71	49.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-J14	6.0	14	35.0	0	77	55.6
C5-GYHER/LM00-M25R/L	GYM25R/LO-J25	6.0	25	35.0	0	88	66.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-D06	2.0	6	45.0	0	71	47.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-D12	2.0	12	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-D20	2.0	20	45.0	0	85	61.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-E06	2.5	6	45.0	0	71	47.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-E12	2.5	12	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-E20	2.5	20	45.0	0	85	61.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-F06	3.0	6	45.0	0	71	47.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-F12	3.0	12	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-F20	3.0	20	45.0	0	85	61.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-G08	4.0	8	45.0	0	73	49.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-G14	4.0	14	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-G25	4.0	25	45.0	0	90	66.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-H08	5.0	8	45.0	0	73	49.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-H14	5.0	14	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-H25	5.0	25	45.0	0	90	66.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-J08	6.0	8	45.0	0	73	49.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-J14	6.0	14	45.0	0	79	55.6
C6-GYHER/LM00-M25R/L	GYM25R/LO-J25	6.0	25	45.0	0	90	66.6

1. Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter.

Example) GYM25RD-D12-040

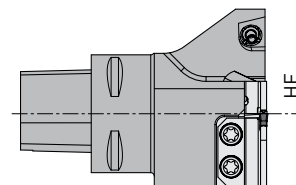
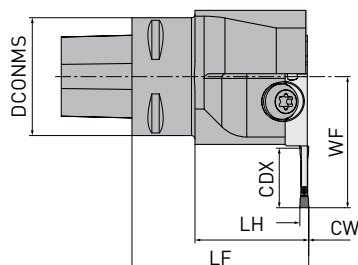
The "O" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining. To select modular blades, refer to the Modular Blade List (starting from p. 24).

2. The indicated dimensions are values for standard inserts (GM chipbreaker). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from B140. Links to PDF data are provided at the end of the document using QR codes.

PSC_GY90_A

GY PSC HOLDERS (EXTERNAL / FACE GROOVING)

90° type holder



Left-hand tool holder shown.

Order number	Stock		Coolant	Mounting size	DCONMS	CW	WT (kg)
	R	L					
C4-GYHER/LM90-M25R/L	●	●	External	PSC40	40	2.0 – 6.35	0.8
C5-GYHER/LM90-M25R/L	●	●	External	PSC50	50	2.0 – 6.35	1.1
C6-GYHER/LM90-M25R/L	●	●	External	PSC63	63	2.0 – 6.35	1.9
							1/1

1. Please order the modular blade and modular holder separately.
2. Please set the left-hand modular blade in the right-hand holder and the right-hand modular blade in the left-hand holder.

SPARE PARTS

												
Clamp screw			Blade Screw			Plug		Nozzle		Wrench 1		Wrench 2
Order number	Pcs.	Clamp torque (N·m)	Order number	Pcs.	Clamp torque (N·m)	Order number	Pcs.	Order number	Pcs.	Order number	Order number	
GY06013M	1	6.0	TS55	5	5.0	HSD05004S	1	NZ22042080S	1	TKY25D	TKY30R	

1. Nozzle exchange key: NZKH050S (Sold separately)

PSC_GY90_A SET DIMENSIONS WITH MODULAR BLADES

Holder type	Modular blade type	Standard CW	CDX	WF	HF	LF	LH
C4-GYHER/LM90-M25L/R	GYM25L/RO-D06	2.0	6	30.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-D12	2.0	12	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-D20	2.0	20	44.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-E06	2.5	6	30.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-E12	2.5	12	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-E20	2.5	20	44.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-F06	3.0	6	30.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-F12	3.0	12	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-F20	3.0	20	44.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-G08	4.0	8	32.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-G14	4.0	14	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-G25	4.0	25	49.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-H08	5.0	8	32.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-H14	5.0	14	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-H25	5.0	25	49.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-J08	6.0	8	32.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-J14	6.0	14	38.5	0	60	38.6
C4-GYHER/LM90-M25L/R	GYM25L/RO-J25	6.0	25	49.5	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-D06	2.0	6	33.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-D12	2.0	12	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-D20	2.0	20	47.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-E06	2.5	6	33.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-E12	2.5	12	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-E20	2.5	20	47.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-F06	3.0	6	33.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-F12	3.0	12	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-F20	3.0	20	47.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-G08	4.0	8	35.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-G14	4.0	14	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-G25	4.0	25	52.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-H08	5.0	8	35.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-H14	5.0	14	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-H25	5.0	25	52.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-J08	6.0	8	35.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-J14	6.0	14	41.0	0	60	38.6
C5-GYHER/LM90-M25L/R	GYM25L/RO-J25	6.0	25	52.0	0	60	38.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-D06	2.0	6	40.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-D12	2.0	12	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-D20	2.0	20	54.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-E06	2.5	6	40.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-E12	2.5	12	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-E20	2.5	20	54.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-F06	3.0	6	40.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-F12	3.0	12	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-F20	3.0	20	54.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-G08	4.0	8	42.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-G14	4.0	14	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-G25	4.0	25	59.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-H08	5.0	8	42.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-H14	5.0	14	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-H25	5.0	25	59.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-J08	6.0	8	42.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-J14	6.0	14	48.0	0	70	46.6
C6-GYHER/LM90-M25L/R	GYM25L/RO-J25	6.0	25	59.0	0	70	46.6

1. Modular blade type: Blades for face machining indicate a code for the minimum face grooving diameter.

Example) GYM25RD-D12-040

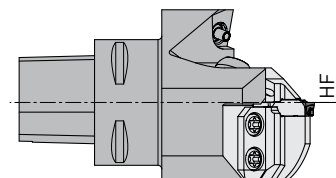
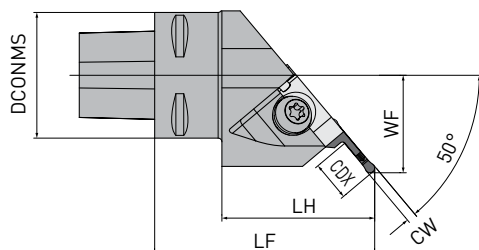
The "o" symbol is a position to insert the letter "A" for external diameter machining or "D" for face machining. To select modular blades, refer to the Modular Blade List (starting from p. 24).

2. The indicated dimensions are values for standard inserts (GM chipbreaker). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from B140. Links to PDF data are provided at the end of the document using QR codes.

PSC_GY50_A

GY PSC HOLDERS (FOR RECESSING)

For 50° recessing holder



Left-hand tool holder shown.

Order number	Stock		Coolant	Mounting size	DCONMS	CW	WT (kg)
	R	L					
C4-GYHER/LM50-M25R/L	●	●	External	PSC40	40	2.0 – 6.35	0.6
C5-GYHER/LM50-M25R/L	●	★	External	PSC50	50	2.0 – 6.35	0.9
C6-GYHER/LM50-M25R/L	●	●	External	PSC63	63	2.0 – 6.35	1.3

1/1

1. Please order the modular blade and modular holder separately.
2. Please set the left-hand modular blade in the right-hand holder and the right-hand modular blade in the left-hand holder.

SPARE PARTS

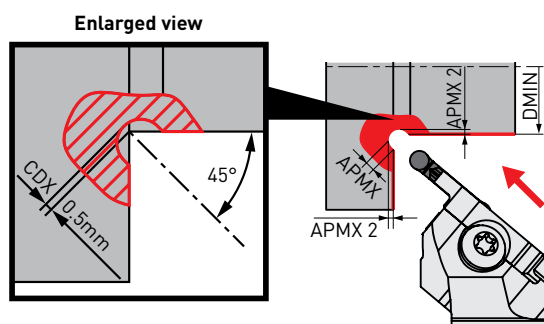
 Clamp screw			 Blade Screw			 Plug		 Nozzle		 Wrench 1		 Wrench 2	
Order number	Pcs.	Clamp torque (N·m)	Order number	Pcs.	Clamp torque (N·m)	Order number	Pcs.	Order number	Pcs.	Order number	Pcs.	Order number	Pcs.
GY06013M	1	6.0	TS54	5	5.0	HSD05004S	1	NZ22042080S	1	TKY25D	1	TKY30R	1

1. Nozzle exchange key: NZKH050S (Sold separately)

PSC_GY50_A SET DIMENSIONS WITH MODULAR BLADES

Holder type	Modular blade type	Standard CW	CDX	DMIN	APMX	APMX2	WF	HF	LF	LH
C4-GYHER/LM50-M25L/R	GYM25L/RC-D005	2.0	0.5	30	1.50	0.646	30.6	0	70.2	48.8
C4-GYHER/LM50-M25L/R	GYM25L/RC-E005	2.5	0.5	30	1.75	0.720	30.8	0	70.1	48.7
C4-GYHER/LM50-M25L/R	GYM25L/RC-F005	3.0	0.5	30	2.00	0.793	31.0	0	70.0	48.6
C4-GYHER/LM50-M25L/R	GYM25L/RC-G005	4.0	0.5	20	2.50	0.939	31.4	0	69.8	48.4
C4-GYHER/LM50-M25L/R	GYM25L/RC-H005	5.0	0.5	20	2.88	1.049	31.8	0	69.6	48.2
C4-GYHER/LM50-M25L/R	GYM25L/RC-J005	6.0	0.5	20	3.50	1.232	32.4	0	69.4	48.0
C5-GYHER/LM50-M25L/R	GYM25L/RC-D005	2.0	0.5	30	1.50	0.646	32.6	0	70.2	48.8
C5-GYHER/LM50-M25L/R	GYM25L/RC-E005	2.5	0.5	30	1.75	0.720	32.8	0	70.1	48.7
C5-GYHER/LM50-M25L/R	GYM25L/RC-F005	3.0	0.5	30	2.00	0.793	33.0	0	70.0	48.6
C5-GYHER/LM50-M25L/R	GYM25L/RC-G005	4.0	0.5	20	2.50	0.939	33.4	0	69.8	48.4
C5-GYHER/LM50-M25L/R	GYM25L/RC-H005	5.0	0.5	20	2.88	1.049	33.8	0	69.6	48.2
C5-GYHER/LM50-M25L/R	GYM25L/RC-J005	6.0	0.5	20	3.50	1.232	34.4	0	69.4	48.0
C6-GYHER/LM50-M25L/R	GYM25L/RC-D005	2.0	0.5	30	1.50	0.646	39.6	0	70.2	46.8
C6-GYHER/LM50-M25L/R	GYM25L/RC-E005	2.5	0.5	30	1.75	0.720	39.8	0	70.1	46.7
C6-GYHER/LM50-M25L/R	GYM25L/RC-F005	3.0	0.5	30	2.00	0.793	40.0	0	70.0	46.6
C6-GYHER/LM50-M25L/R	GYM25L/RC-G005	4.0	0.5	20	2.50	0.939	40.4	0	69.8	46.4
C6-GYHER/LM50-M25L/R	GYM25L/RC-H005	5.0	0.5	20	2.88	1.049	40.8	0	69.6	46.2
C6-GYHER/LM50-M25L/R	GYM25L/RC-J005	6.0	0.5	20	3.50	1.232	41.4	0	69.4	46.0

1. To select modular blades, refer to the Modular Blade List (starting from p. 24).
2. The indicated dimensions are values for standard inserts (BM chipbreaker). If other inserts are mounted, LF and LH may differ. Select the inserts and recommended conditions from B140. Links to PDF data are provided at the end of the document using QR codes.
3. DMIN = Min. Cutting Diameter



IDENTIFICATION

MODULAR BLADE

EXTERNAL/FOR RECESSING

GY

M25

R

A

—

F

12

Series Description	Modular Blade Size	Hand	Modular blade type	Shim Size *1	Max. Groove Depth CDX *2
	M25	R Right	A Standard Type	D 2.00mm	005 0.5mm
		L Left	C For recessing	2.24mm	06 6mm
			D Face Grooving	E 2.39mm	⋮ ⋮
				2.50mm	25 25mm
				2.74mm	
				F 3.00mm	
				3.18mm	
				3.24mm	
				G 4.00mm	
				4.24mm	
				H 4.75mm	
				5.00mm	
				5.24mm	
				J 6.00mm	
				6.31mm	
				6.35mm	

*1 Select a shim size with the same symbol as that of the insert.
*2 The maximum groove depth is a value when used for external grooving and changes according to the insert used.

FACE GROOVING

GY

M25

R

D

—

F

12

—

050

Min. Groove Diameter

035	35mm
040	40mm
⋮	⋮
250	250mm

MODULAR BLADES SELECTION CHART

Holder type	Holder Angle	Hand (R/L)	Seat size	Modular blade Order number	Hand (R/L)
EXTERNAL					
C-GYHERM00-M25R	00°	R	D	GYM25RA-D06	R
			D	GYM25RA-D12	R
			D	GYM25RA-D20	R
			E	GYM25RA-E06	R
			E	GYM25RA-E12	R
			E	GYM25RA-E20	R
			F	GYM25RA-F06	R
			F	GYM25RA-F12	R
			F	GYM25RA-F20	R
			G	GYM25RA-G08	R
			G	GYM25RA-G14	R
			G	GYM25RA-G25	R
			H	GYM25RA-H08	R
			H	GYM25RA-H14	R
			H	GYM25RA-H25	R
			J	GYM25RA-J08	R
			J	GYM25RA-J14	R
			J	GYM25RA-J25	R
C-GYHELM00-M25L	00°	L	D	GYM25LA-D06	L
			D	GYM25LA-D12	L
			D	GYM25LA-D20	L
			E	GYM25LA-E06	L
			E	GYM25LA-E12	L
			E	GYM25LA-E20	L
			F	GYM25LA-F06	L
			F	GYM25LA-F12	L
			F	GYM25LA-F20	L
			G	GYM25LA-G08	L
			G	GYM25LA-G14	L
			G	GYM25LA-G25	L
			H	GYM25LA-H08	L
			H	GYM25LA-H14	L
			H	GYM25LA-H25	L
			J	GYM25LA-J08	L
			J	GYM25LA-J14	L
			J	GYM25LA-J25	L
FACE GROOVING					
C-GYHERM00-M25R	00°	R	D	GYM25RD-D12-040	R
			D	GYM25RD-D12-050	R
			D	GYM25RD-D12-060	R
			D	GYM25RD-D12-075	R
			D	GYM25RD-D12-100	R
			D	GYM25RD-D12-135	R
			D	GYM25RD-D12-180	R
			E	GYM25RD-E12-040	R
			E	GYM25RD-E12-050	R
			E	GYM25RD-E12-060	R
			E	GYM25RD-E12-075	R
			E	GYM25RD-E12-100	R
			E	GYM25RD-E12-135	R
			E	GYM25RD-E12-180	R
			F	GYM25RD-F12-035	R
			F	GYM25RD-F12-040	R
			F	GYM25RD-F12-050	R
			F	GYM25RD-F12-060	R
			F	GYM25RD-F12-075	R
			F	GYM25RD-F12-100	R
			F	GYM25RD-F12-135	R
			F	GYM25RD-F12-180	R
			F	GYM25RD-F12-225	R
			F	GYM25RD-F20-060	R
			F	GYM25RD-F20-075	R
			F	GYM25RD-F20-100	R
			F	GYM25RD-F20-135	R
			F	GYM25RD-F20-180	R
			F	GYM25RD-F20-225	R
			G	GYM25RD-G14-040	R
			G	GYM25RD-G14-050	R
			G	GYM25RD-G14-060	R
			G	GYM25RD-G14-085	R
			G	GYM25RD-G14-125	R
			G	GYM25RD-G14-180	R
			G	GYM25RD-G14-250	R
G	GYM25RD-G25-060	R			
G	GYM25RD-G25-085	R			
G	GYM25RD-G25-125	R			
G	GYM25RD-G25-180	R			
G	GYM25RD-G25-250	R			
H	GYM25RD-H14-050	R			
H	GYM25RD-H14-060	R			
H	GYM25RD-H14-085	R			
H	GYM25RD-H14-125	R			
H	GYM25RD-H14-180	R			
H	GYM25RD-H14-250	R			
H	GYM25RD-H25-060	R			
H	GYM25RD-H25-085	R			
H	GYM25RD-H25-125	R			
H	GYM25RD-H25-180	R			
H	GYM25RD-H25-250	R			
J	GYM25RD-J14-050	R			
J	GYM25RD-J14-070	R			
J	GYM25RD-J14-110	R			
J	GYM25RD-J14-170	R			
J	GYM25RD-J14-250	R			
J	GYM25RD-J25-070	R			
J	GYM25RD-J25-110	R			
J	GYM25RD-J25-170	R			
J	GYM25RD-J25-250	R			
C-GYHELM00-M25L	00°	L	D	GYM25LD-D12-040	L
			D	GYM25LD-D12-050	L
			D	GYM25LD-D12-060	L
			D	GYM25LD-D12-075	L
			D	GYM25LD-D12-100	L
			D	GYM25LD-D12-135	L
			D	GYM25LD-D12-180	L
			E	GYM25LD-E12-040	L
			E	GYM25LD-E12-050	L
			E	GYM25LD-E12-060	L
			E	GYM25LD-E12-075	L
			E	GYM25LD-E12-100	L
			E	GYM25LD-E12-135	L
			E	GYM25LD-E12-180	L
			F	GYM25LD-F12-035	L
			F	GYM25LD-F12-040	L
			F	GYM25LD-F12-050	L
			F	GYM25LD-F12-060	L
			F	GYM25LD-F12-075	L
			F	GYM25LD-F12-100	L
			F	GYM25LD-F12-135	L
			F	GYM25LD-F12-180	L
			F	GYM25LD-F12-225	L
			F	GYM25LD-F20-060	L
			F	GYM25LD-F20-075	L
			F	GYM25LD-F20-100	L
			F	GYM25LD-F20-135	L
			F	GYM25LD-F20-180	L
			F	GYM25LD-F20-225	L
			G	GYM25LD-G14-040	L
			G	GYM25LD-G14-050	L
			G	GYM25LD-G14-060	L
			G	GYM25LD-G14-085	L
			G	GYM25LD-G14-125	L
			G	GYM25LD-G14-180	L
			G	GYM25LD-G14-250	L
G	GYM25LD-G25-060	L			
G	GYM25LD-G25-085	L			
G	GYM25LD-G25-125	L			
G	GYM25LD-G25-180	L			
G	GYM25LD-G25-250	L			
H	GYM25LD-H14-050	L			
H	GYM25LD-H14-060	L			
H	GYM25LD-H14-085	L			
H	GYM25LD-H14-125	L			
H	GYM25LD-H14-180	L			
H	GYM25LD-H14-250	L			
H	GYM25LD-H25-060	L			
H	GYM25LD-H25-085	L			
H	GYM25LD-H25-125	L			
H	GYM25LD-H25-180	L			
H	GYM25LD-H25-250	L			
J	GYM25LD-J14-050	L			
J	GYM25LD-J14-070	L			
J	GYM25LD-J14-110	L			
J	GYM25LD-J14-170	L			
J	GYM25LD-J14-250	L			
J	GYM25LD-J25-070	L			
J	GYM25LD-J25-110	L			
J	GYM25LD-J25-170	L			
J	GYM25LD-J25-250	L			

Holder type	Holder Angle	Hand (R/L)	Seat size	Modular blade Order number	Hand (R/L)			
FACE GROOVING								
C-  GYHERM00-M25R	00°	R	G	GYM25RD-G14-085	R			
			G	GYM25RD-G14-125	R			
			G	GYM25RD-G14-180	R			
			G	GYM25RD-G14-250	R			
			G	GYM25RD-G25-060	R			
			G	GYM25RD-G25-085	R			
			G	GYM25RD-G25-125	R			
			G	GYM25RD-G25-180	R			
			G	GYM25RD-G25-250	R			
			H	GYM25RD-H14-050	R			
			H	GYM25RD-H14-060	R			
			H	GYM25RD-H14-085	R			
			H	GYM25RD-H14-125	R			
			H	GYM25RD-H14-180	R			
			H	GYM25RD-H14-250	R			
			H	GYM25RD-H25-060	R			
			H	GYM25RD-H25-085	R			
			H	GYM25RD-H25-125	R			
			H	GYM25RD-H25-180	R			
			H	GYM25RD-H25-250	R			
			J	GYM25RD-J14-050	R			
			J	GYM25RD-J14-070	R			
			J	GYM25RD-J14-110	R			
			J	GYM25RD-J14-170	R			
			J	GYM25RD-J14-250	R			
			J	GYM25RD-J25-070	R			
			J	GYM25RD-J25-110	R			
			J	GYM25RD-J25-170	R			
			J	GYM25RD-J25-250	R			
			C-  GYHELM00-M25L	00°	L	D	GYM25LD-D12-040	L
						D	GYM25LD-D12-050	L
						D	GYM25LD-D12-060	L
D	GYM25LD-D12-075	L						
D	GYM25LD-D12-100	L						
D	GYM25LD-D12-135	L						
D	GYM25LD-D12-180	L						
E	GYM25LD-E12-040	L						
E	GYM25LD-E12-050	L						
E	GYM25LD-E12-060	L						
E	GYM25LD-E12-075	L						
E	GYM25LD-E12-100	L						
E	GYM25LD-E12-135	L						
E	GYM25LD-E12-180	L						
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F	GYM25LD-F12-040	L						
F	GYM25LD-F12-050	L						
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F	GYM25LD-F12-075	L						
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F	GYM25LD-F12-135	L						
F	GYM25LD-F12-180	L						
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F	GYM25LD-F20-075	L						
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F	GYM25LD-F20-180	L						
F	GYM25LD-F20-225	L						
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G	GYM25LD-G14-060	L						
G	GYM25LD-G14-085	L						
G	GYM25LD-G14-125	L						
G	GYM25LD-G14-180	L						
G	GYM25LD-G14-250	L						
G	GYM25LD-G25-060	L						
G	GYM25LD-G25-085	L						
G	GYM25LD-G25-125	L						

MODULAR BLADES SELECTION CHART

Holder type	Holder Angle	Hand (R/L)	Seat size	Modular blade Order number	Hand (R/L)
FACE GROOVING					
C-◯-GYHELM00-M25L	00°	L	G	GYM25LD-G25-180	L
			G	GYM25LD-G25-250	L
			H	GYM25LD-H14-050	L
			H	GYM25LD-H14-060	L
			H	GYM25LD-H14-085	L
			H	GYM25LD-H14-125	L
			H	GYM25LD-H14-180	L
			H	GYM25LD-H14-250	L
			H	GYM25LD-H25-060	L
			H	GYM25LD-H25-085	L
			H	GYM25LD-H25-125	L
			H	GYM25LD-H25-180	L
			H	GYM25LD-H25-250	L
			J	GYM25LD-J14-050	L
			J	GYM25LD-J14-070	L
			J	GYM25LD-J14-110	L
			J	GYM25LD-J14-170	L
			J	GYM25LD-J14-250	L
			J	GYM25LD-J25-070	L
			J	GYM25LD-J25-110	L
			J	GYM25LD-J25-170	L
			J	GYM25LD-J25-250	L
EXTERNAL					
C-◯-GYHERM90-M25L	90°	R	D	GYM25LA-D06	L
			D	GYM25LA-D12	L
			D	GYM25LA-D20	L
			E	GYM25LA-E06	L
			E	GYM25LA-E12	L
			E	GYM25LA-E20	L
			F	GYM25LA-F06	L
			F	GYM25LA-F12	L
			F	GYM25LA-F20	L
			G	GYM25LA-G08	L
			G	GYM25LA-G14	L
			G	GYM25LA-G25	L
			H	GYM25LA-H08	L
			H	GYM25LA-H14	L
			H	GYM25LA-H25	L
			J	GYM25LA-J08	L
			J	GYM25LA-J14	L
			J	GYM25LA-J25	L
C-◯-GYHELM90-M25R	90°	L	D	GYM25RA-D06	R
			D	GYM25RA-D12	R
			D	GYM25RA-D20	R
			E	GYM25RA-E06	R
			E	GYM25RA-E12	R
			E	GYM25RA-E20	R
			F	GYM25RA-F06	R
			F	GYM25RA-F12	R
			F	GYM25RA-F20	R
			G	GYM25RA-G08	R
			G	GYM25RA-G14	R
			G	GYM25RA-G25	R
			H	GYM25RA-H08	R
			H	GYM25RA-H14	R
			H	GYM25RA-H25	R
			J	GYM25RA-J08	R
			J	GYM25RA-J14	R
			J	GYM25RA-J25	R

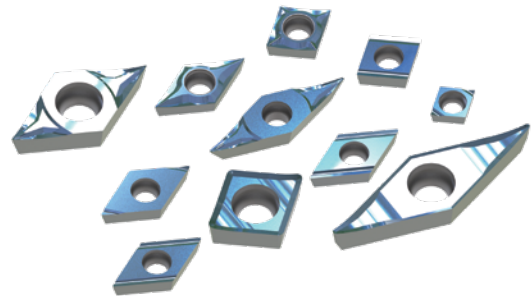
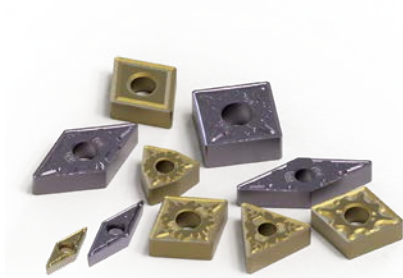
Holder type	Holder Angle	Hand (R/L)	Seat size	Modular blade Order number	Hand (R/L)
FACE GROOVING					
C-◯-GYHERM90-M25L	90°	R	D	GYM25LD-D12-040	L
			D	GYM25LD-D12-050	L
			D	GYM25LD-D12-060	L
			D	GYM25LD-D12-075	L
			D	GYM25LD-D12-100	L
			D	GYM25LD-D12-135	L
			D	GYM25LD-D12-180	L
			E	GYM25LD-E12-040	L
			E	GYM25LD-E12-050	L
			E	GYM25LD-E12-060	L
			E	GYM25LD-E12-075	L
			E	GYM25LD-E12-100	L
			E	GYM25LD-E12-135	L
			E	GYM25LD-E12-180	L
			F	GYM25LD-F12-035	L
			F	GYM25LD-F12-040	L
C-◯-GYHERM90-M25L	90°	R	F	GYM25LD-F12-050	L
			F	GYM25LD-F12-060	L
			F	GYM25LD-F12-075	L
			F	GYM25LD-F12-100	L
			F	GYM25LD-F12-135	L
			F	GYM25LD-F12-180	L
			F	GYM25LD-F12-225	L
			F	GYM25LD-F20-060	L
			F	GYM25LD-F20-075	L
			F	GYM25LD-F20-100	L
			F	GYM25LD-F20-135	L
			F	GYM25LD-F20-180	L
			F	GYM25LD-F20-225	L
			G	GYM25LD-G14-040	L
			G	GYM25LD-G14-050	L
			G	GYM25LD-G14-060	L
			G	GYM25LD-G14-085	L
			G	GYM25LD-G14-125	L
			G	GYM25LD-G14-180	L
			G	GYM25LD-G14-250	L
			G	GYM25LD-G25-060	L
			G	GYM25LD-G25-085	L
			G	GYM25LD-G25-125	L
			G	GYM25LD-G25-180	L
			G	GYM25LD-G25-250	L
C-◯-GYHELM90-M25R	90°	L	H	GYM25LD-H14-050	L
			H	GYM25LD-H14-060	L
			H	GYM25LD-H14-085	L
			H	GYM25LD-H14-125	L
			H	GYM25LD-H14-180	L
			H	GYM25LD-H14-250	L
			H	GYM25LD-H25-060	L
			H	GYM25LD-H25-085	L
			H	GYM25LD-H25-125	L
			H	GYM25LD-H25-180	L
			H	GYM25LD-H25-250	L
			J	GYM25LD-J14-050	L
			J	GYM25LD-J14-070	L
			J	GYM25LD-J14-110	L
			J	GYM25LD-J14-170	L
			J	GYM25LD-J14-250	L
			J	GYM25LD-J25-070	L
			J	GYM25LD-J25-110	L
			J	GYM25LD-J25-170	L
			J	GYM25LD-J25-250	L

MODULAR BLADES SELECTION CHART

Holder type	Holder Angle	Hand (R/L)	Seat size	Modular blade Order number	Hand (R/L)
FACE GROOVING					
CO-GYHELM90-M25R	90°	L	D	GYM25RD-D12-040	R
			D	GYM25RD-D12-050	R
			D	GYM25RD-D12-060	R
			D	GYM25RD-D12-075	R
			D	GYM25RD-D12-100	R
			D	GYM25RD-D12-135	R
			D	GYM25RD-D12-180	R
			E	GYM25RD-E12-040	R
			E	GYM25RD-E12-050	R
			E	GYM25RD-E12-060	R
			E	GYM25RD-E12-075	R
			E	GYM25RD-E12-100	R
			E	GYM25RD-E12-135	R
			E	GYM25RD-E12-180	R
			F	GYM25RD-F12-035	R
			F	GYM25RD-F12-040	R
			F	GYM25RD-F12-050	R
			F	GYM25RD-F12-060	R
			F	GYM25RD-F12-075	R
			F	GYM25RD-F12-100	R
			F	GYM25RD-F12-135	R
			F	GYM25RD-F12-180	R
			F	GYM25RD-F12-225	R
			F	GYM25RD-F20-060	R
			F	GYM25RD-F20-075	R
			F	GYM25RD-F20-100	R
			F	GYM25RD-F20-135	R
			F	GYM25RD-F20-180	R
			F	GYM25RD-F20-225	R
			G	GYM25RD-G14-040	R
			G	GYM25RD-G14-050	R
			G	GYM25RD-G14-060	R
			G	GYM25RD-G14-085	R
			G	GYM25RD-G14-125	R
			G	GYM25RD-G14-180	R
			G	GYM25RD-G14-250	R
			G	GYM25RD-G25-060	R
			G	GYM25RD-G25-085	R
			G	GYM25RD-G25-125	R
			G	GYM25RD-G25-180	R
			G	GYM25RD-G25-250	R
CO-GYHELM90-M25R	90°	L	H	GYM25RD-H14-050	R
			H	GYM25RD-H14-060	R
			H	GYM25RD-H14-085	R
			H	GYM25RD-H14-125	R
			H	GYM25RD-H14-180	R
			H	GYM25RD-H14-250	R
			H	GYM25RD-H25-060	R
			H	GYM25RD-H25-085	R
			H	GYM25RD-H25-125	R
			H	GYM25RD-H25-180	R
			H	GYM25RD-H25-250	R
			J	GYM25RD-J14-050	R
			J	GYM25RD-J14-070	R
			J	GYM25RD-J14-110	R
			J	GYM25RD-J14-170	R
			J	GYM25RD-J14-250	R
			J	GYM25RD-J25-070	R
			J	GYM25RD-J25-110	R
			J	GYM25RD-J25-170	R
			J	GYM25RD-J25-250	R

Holder type	Holder Angle	Hand (R/L)	Seat size	Modular blade Order number	Hand (R/L)
FOR RECESSING					
CO-GYHERM50-M25L	50°	R	D	GYM25LC-D005	L
			E	GYM25LC-E005	L
			F	GYM25LC-F005	L
			G	GYM25LC-G005	L
			H	GYM25LC-H005	L
CO-GYHELM50-M25R	50°	L	J	GYM25LC-J005	L
			D	GYM25RC-D005	R
			E	GYM25RC-E005	R
			F	GYM25RC-F005	R
			G	GYM25RC-G005	R
			H	GYM25RC-H005	R
			J	GYM25RC-J005	R

PLEASE USE THE WEBSITE FOR INSERT SELECTION AND RECOMMENDED CUTTING CONDITIONS



ISO TURNING TOOLS

INSERT SELECTION WEB CATALOGUE



ISO Inserts



CBN Inserts

RECOMMENDED CUTTING CONDITIONS PRODUCT BROCHURE



ISO Inserts



CBN Inserts

GROOVING TURNING TOOLS

INSERT SELECTION WEB CATALOGUE



Grooving Inserts

RECOMMENDED CUTTING CONDITIONS PRODUCT BROCHURE



Grooving / Cutting-Off

SYMBOLS



Recommended cutting conditions

NEW

Completely new products or expansions released in the current Spring or Autumn product launch and are not included in the latest version of the General Catalogue.

NEW

Products or expansions that have already been introduced in one of the previous Spring or Autumn product launches but are not included in the latest General Catalogue.

APPLICATION



Face milling



Chamfer milling



Shoulder milling with R



Face milling close to a wall



Shoulder milling



Side milling



Slot milling



Ramping



Pocket milling



Slot milling with R



Copy milling



T-Slot milling

MACHINING TYPE



Roughing



Medium cutting



Light cutting



Pre-finishing



Finishing



Fine-finishing

TOOL MATERIAL



Ultra micro grain carbide
Ultra micro grain carbide substrate material.



Cubic boron nitride
Mitsubishi Materials' original CBN material.



Ceramic
For high speed efficient machining of super alloys due to the excellent high temperature strength property.



High hardness powder metallurgy HSS
High hardness powder metallurgy HSS substrate material.



High grade high alloy HSS
High grade high alloy HSS substrate material.



Cobalt high speed steel
Cobalt high speed steel substrate material.



High speed steel
High speed steel substrate material.

SYMBOLS

COATING



SMART MIRACLE coating

New smooth and dense coating technology for high efficiency milling of difficult to cut materials.



CRN coating

Newly developed CrN coating for Copper Electrodes machining.



Violet coating

Increased tool life of 2-3 times more than TiN coated products.



DP coating

New generation coating suitable for a wide range of materials.



MIRACLE coating

The original Miracle (Al,Ti)N coating. Also suitable for dry cutting.



[Al, Ti]N coating

[Al,Ti]N highly versatile application range.



[Al,Ti,Cr]N multi-layer coating

For carbon, alloy and hardened steels.



IMPACT MIRACLE coating

Single phase nano crystal coating technology has higher film hardness and heat resistance.



MIRACLE coating

The original MIRACLE (Al,Ti)N coating. Also suitable for dry cutting.



VFR coating

The [AlCrSi]N/[AlTiSi]N PVD multilayer coating is ideal for machining of extremely hard materials up to 70 HRC.



DLC coating

Hardness similar to CVD diamond coating achieved with high adhesion strength.



Diamond coating

Suitable for CFRP and CFRP-aluminium materials.



Diamond coating

Suitable for graphite machining.



Diamond coating

The original CVD diamond coating.



CVD Diamond coating

Unique multi-layer micro-grain diamond crystal control technology drastically improves wear resistance and smoothness.

CUTTING EDGE PROPERTIES



Sharp corner edge

Indicates the end mill has a sharp corner edge.



Gash land

Indicates the end mill cutting edge has a protective chamfer.



Rake angle



Helix angle

Indicates the helix angle of the end mill.



Point angle

Indicates the drill point angle.



Roughing flute geometry



Variable helix



Rounded gash



Corner angle

WEB THINNING



X type point geometry

X web thinning used at the drill point.



XR type point geometry

XR web thinning used at the drill point.



S type point geometry

Easy cutting geometry.



N type point geometry

Effective when the point web is thick.



Chipbreaker

SYMBOLS

TOLERANCES



Tolerance of taper angle
Indicates the tolerance of the taper angle.



R tolerance
Indicates the radial tolerance of a ball nose end mill.



R tolerance
Indicates the radial tolerance of the corner radius.



R tolerance
Indicates the radial tolerance of a cutter with a corner radius.



Outside diameter tolerance
Indicates the diameter tolerance of the end mill.



Peak tolerance
Indicates the tolerance for the end diameter.



Shank diameter tolerance



Shank diameter tolerance



Drill tolerance / diameter

COOLANT HOLES



External coolant



Internal coolant



Internal coolant



Centered, internal coolant hole



Radial, internal coolant holes



Internal coolant holes



Internal coolant holes

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