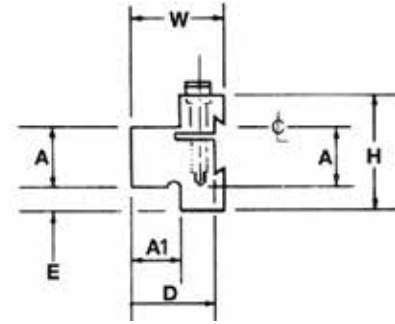


## Blade Holders

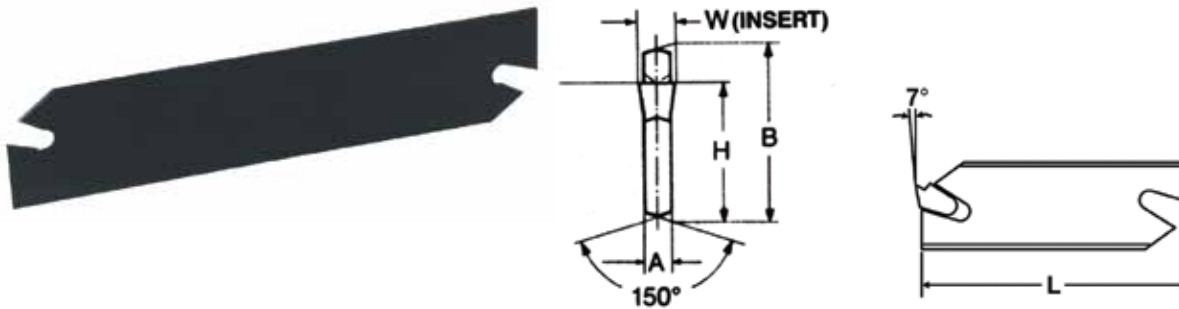


Interchangeable with most popular brands



A (Inch)	A1 (Inch)	D (Inch)	E (Inch)	H (Inch)	W (Inch)	Overall Length (Inch)	Reference Blade	Reference Blade Height Inch (mm)	Code
5/8	5/8	31/32	11/64	1-3/16	1-1/16	3	577049	0.787 (20)	577001
5/8	5/8	1-1/32	7/16	1-1/2	1-3/16	3	577051, 577053, 577055, 577057, 577059	1.020 (26)	577003
3/4	3/4	1-1/8	21/64	1-17/32	1-5/16	3-3/8	577051, 577053, 577055, 577057, 577059	1.020 (26)	577005
3/4	3/4	1-1/8	1/2	1-7/8	1-3/8	4	577061, 577063, 577066, 577067, 577069	1.260 (32)	577011
1	1	1-13/32	5/16	1-7/8	1-5/8	4-3/8	577061, 577063, 577066, 577067, 577069	1.260 (32)	577007
1-1/4	1-1/4	1-11/16	1/8	1-7/8	1-5/8	4-11/16	577061, 577063, 577066, 577067, 577069	1.260 (32)	577009

## Blades



A (Inch)	L (Inch)	H (Inch)	B Inch (mm)	Max Ø (Inch)	Insert Width Reference (Inch)	Model	Code
1/16	3-3/8	39/64	0.787 (20)	1-1/2	0.087 + 0.094	GIH19-2	577049
1/16	4-5/16	53/64	1.020 (26)	2	0.087 + 0.094	GIH26-2	577051
3/32	4-5/16	53/64	1.020 (26)	3	0.120	GIH26-3	577053
1/8	4-5/16	53/64	1.020 (26)	3	0.160	GIH26-4	577055
5/32	4-5/16	53/64	1.020 (26)	4	0.187 + 0.200	GIH26-5	577057
13/64	4-5/16	53/64	1.020 (26)	4	0.250	GIH26-6	577059
3/32	5-7/8	63/64	1.260 (32)	4	0.120	GIH32-3	577061
1/8	5-7/8	63/64	1.260 (32)	4	0.160	GIH32-4	577063
5/32	5-7/8	63/64	1.260 (32)	5	0.187 + 0.200	GIH32-5	577065
13/64	5-7/8	63/64	1.260 (32)	5	0.250	GIH32-6	577067
5/16	5-7/8	63/64	1.260 (32)	5-1/2	0.375	GIH32-9	577069

## Inserts

Neutral

**CARBIDE GRADES:**

**C2** - Uncoated for non-ferrous materials

**C6** - Uncoated for steel

**TiN** - TiN coated for steel



Neutral shown



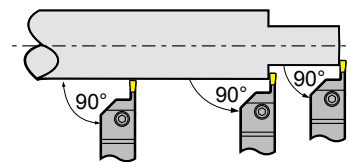
NEUTRAL

Insert Width (Inch)	C2	C6	TiN
	Code	Code	Code
0.087	577071	577073	577075
0.094	577077	577079	577081
0.120	577083	577085	577087
0.160	577089	577091	577093
0.187	577095	577097	577099
0.200	577101	577103	577105
0.250	577107	577109	577111
0.375	577113	577115	577117

## Parting Information Guide

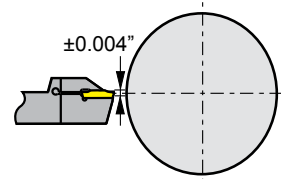
### 90° Mounting

It is very important that the insert is mounted at 90° to the center line of the workpiece in order to obtain perpendicular surfaces and reduce the risk of vibration.



### Correct Center Height Setting

Height tolerance between cutting edge of an insert and the center of the workpiece should be kept to  $\pm 0.004$ ", especially for the parting of rods and grooving of materials with small diameters. It also provides longer tool life and reduces cutting resistance and burrs.



### Parting

1. To minimize risk of vibration and deflection, always choose a toolholder with the smallest possible overhang.
2. When parting to center, reduce the feed rate by up to 75%, 0.08"-0.12" (2 mm-3 mm) prior to the part dropping off.

### External Grooving, Turning & Profiling

#### MACHINING BETWEEN WALLS

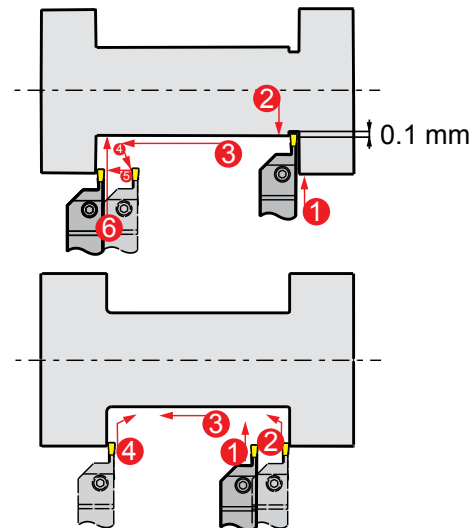
To achieve the best results, the following sequence is recommended:

1. Plunge to required depth of cut (ap max 0.75 x insert width)
2. Pull back 0.004" radially
3. Turn longitudinally to opposite shoulder position
4. Retract at the end of the cut diagonally 0.020"
5. Feed axially to finish position
6. Plunge again to required depth of cut and retract radially 0.004"

Continue sequence for subsequent roughing passes. Axial turn in both directions to use both corners of the insert and to maximize tool life.

#### MACHINING INTO A RADIUS OR CHAMFER

To reduce vibration follow the machining sequence 1 to 4 above.



### Internal Grooving & Turning

#### CUTTING AS SHOWN

The swarf will always flow in the same direction as the feed. It is therefore recommended to feed out towards the opening of the hole.

