

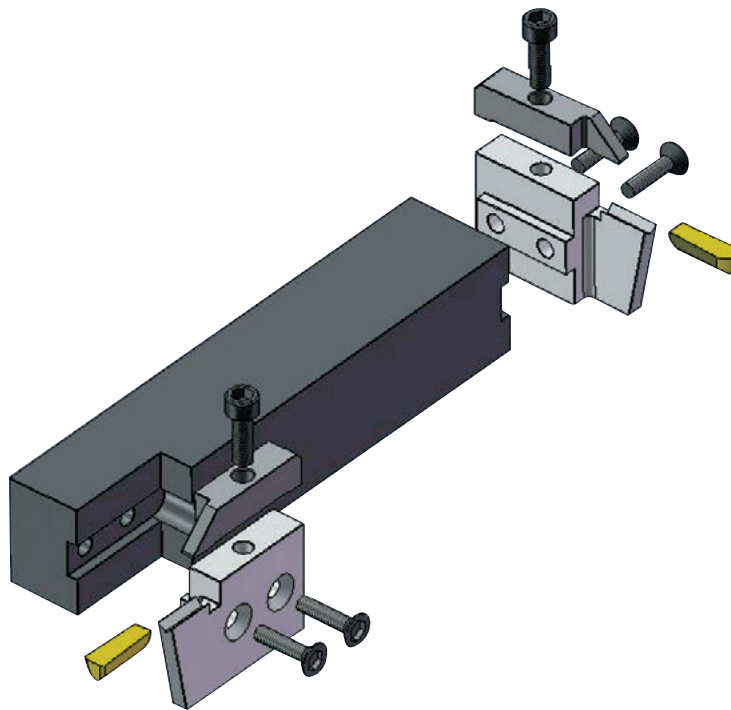
Grooving Tools

● BGV toolholder

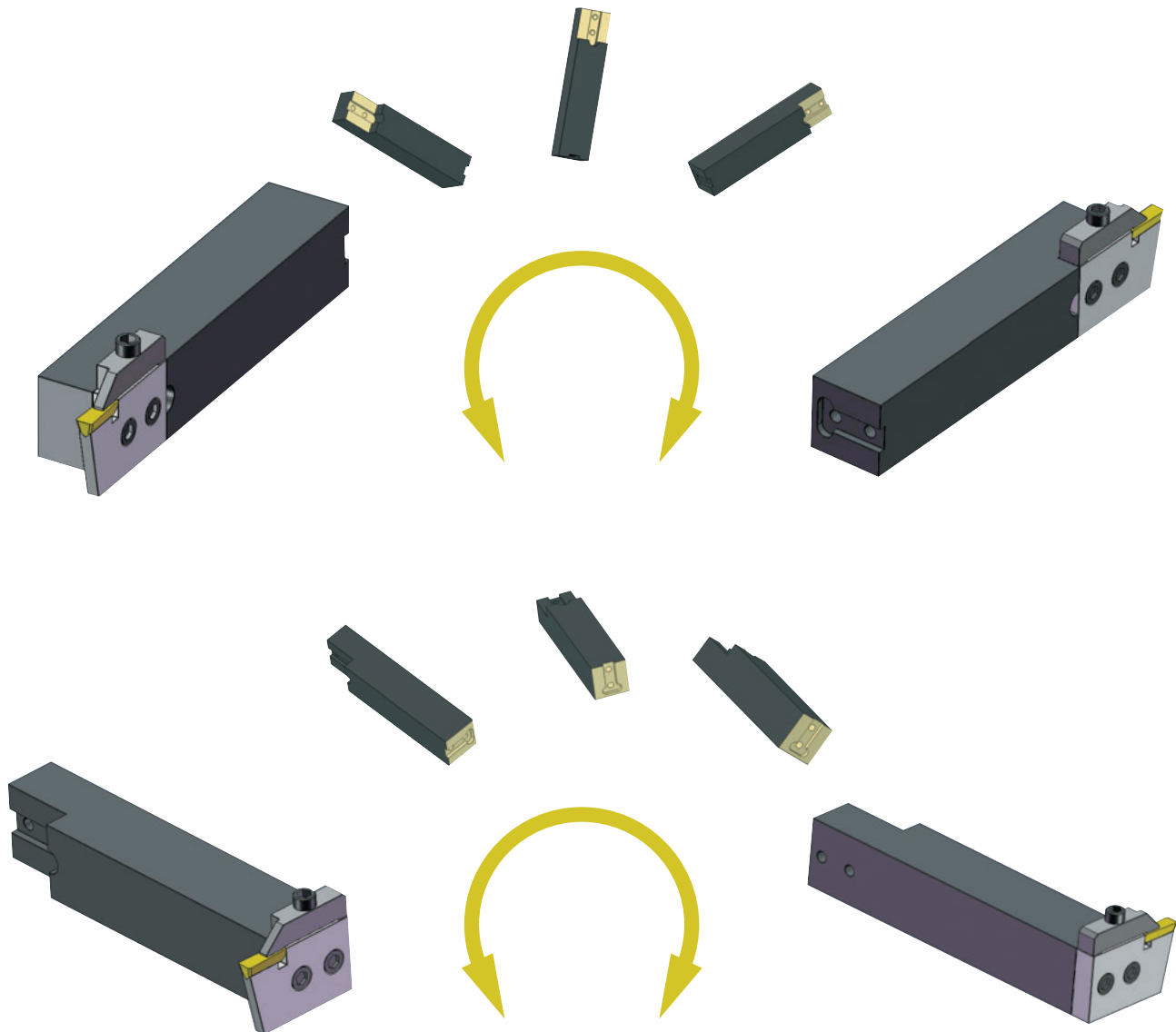
■ BGV toolholder is a flexible modular tooling system designed for ceramic grooving inserts with V-bottoms. This system provides the user with excellent index repeatability and rigid clamping.

■ This BGV tool shank offers the user flexibility and economy of a 4-way-use.

- **Designed for both Axial mounting (0°) and Radial mounting (90°).**



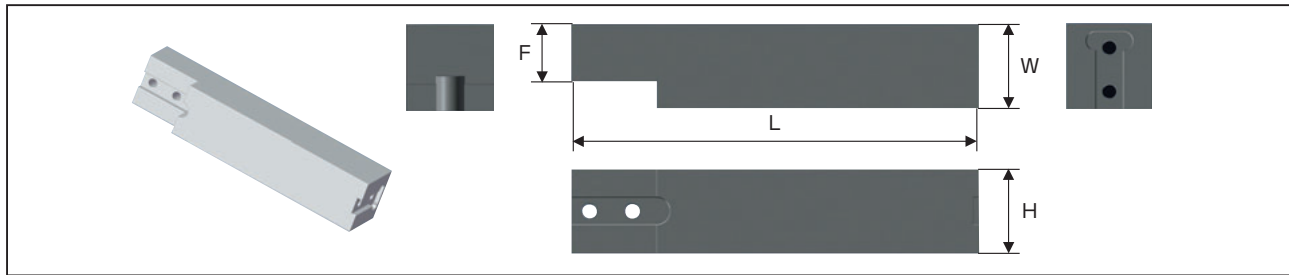
- **Designed for both a Right hand anvil and a Left hand anvil.**



Inserts are available in a width from .125" to .375". The providing a maximum depth of cut is 1.0".

BRV profiling tooling is also available. See pages 146 - 148 for details.

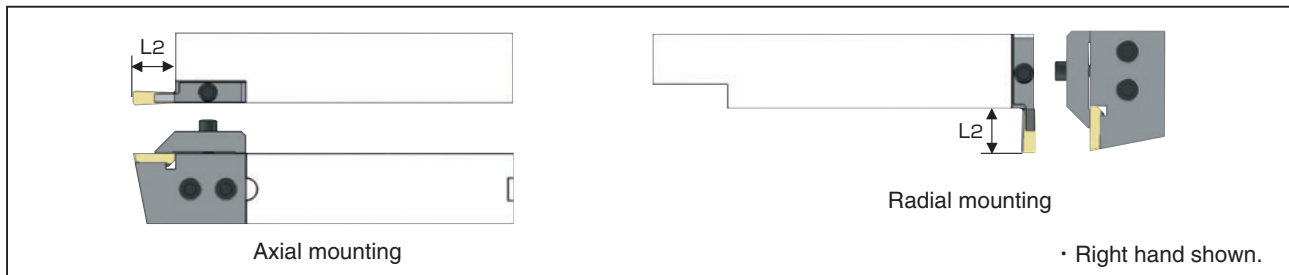
BGV



● Shank

Shank	Stock	Dimensions (inch)			Anvil Screw	Stock
		H	W	L		
BS 20	●	1.25	1.38	5.5	BAS 20	●

Note: Shank comes with anvil screws - order anvil separately



● Anvil

Right hand

	Dimensions	Stock	Clamp	Clamp Screw	Insert
	L2 (inch)				
BGVR 043020	.375	●	BGCR 04	BRCS 2V	VGW 4125 4156
054520	.562	●	BGCR 05		VGW 4156 4187
074520	.562	●	BGCR 07		VGW 6218 6250
086020	.750	●	BGCR 08		VGW 6250 6281
106020	.750	●	BGCR 10		VGW 8312 8344
119020	1.125	●	BGCR 11		VGW 8344 8375

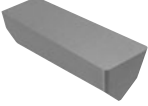
Left hand

	Dimensions	Stock	Clamp	Clamp Screw	Insert
	L2 (inch)				
BGVL 043020	.375	●	BGCL 04	BRCS 2V	VGW 4125 4156
054520	.562	●	BGCL 05		VGW 4156 4187
074520	.562	●	BGCL 07		VGW 6218 6250
086020	.750	●	BGCL 08		VGW 6250 6281
106020	.750	●	BGCL 10		VGW 8312 8344
119020	1.125	●	BGCL 11		VGW 8344 8375

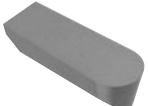
Note: Anvil comes with clamp & clamp screw

● : Stock

● Ceramic Inserts

Shape	Insert	Dimensions (inch)				Grade	
		W	R	T	L	SX5	WA1
	VGW 41251	.125	.015	.187	.500		●
	41252		.031				●
	41561	.156	.015				●
	41562		.031				●
	41871	.187	.015				●
	41872		.031				●
	62501	.250	.015	.250	.750		●
	62502		.031			●	●
	62503		.046			●	●
	62814	.281	.062			●	●
	83122	.312	.031	.337	1		●
	83124		.062			●	
	83752		.031			●	●
	83754	.375	.062			●	●

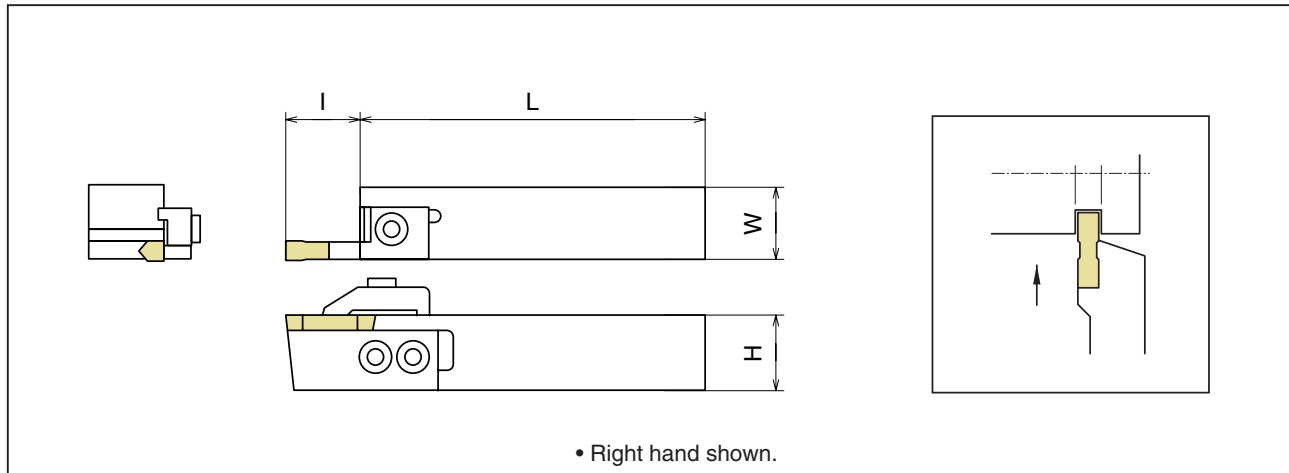
● : Stock

Shape	Insert	Dimensions (inch)				Grade	
		IC	R	T	L	SX5	WA1
	VGW 4125R	.125	.063	.187	.500		●
	4156R	.156	.078				●
	4187R	.187	.094			●	●
	6218R	.218	.109	.250	.750		●
	6250R	.250	.125			●	●
	8312R	.312	.156	.337	1	●	●
	8375R	.375	.188			●	●

For details of inserts, see pages 59 and 60.

● : Stock

DB



● Shank

Shank	Stock	Dimensions (inch)				Anvil Screw	Stock	Clamp Screw	Stock
		H inch	W inch	L inch	I inch				
DB1-1-16R	●	1.00	1.00	6.00	.750	DAS41	●	SC40F10	●
DB1-1-16L	●								
DB1-1-20R	●	1.25	1.25	7.00					
DB1-1-20L	●								

(Shanks come complete with screws - order anvil and clamp separately)

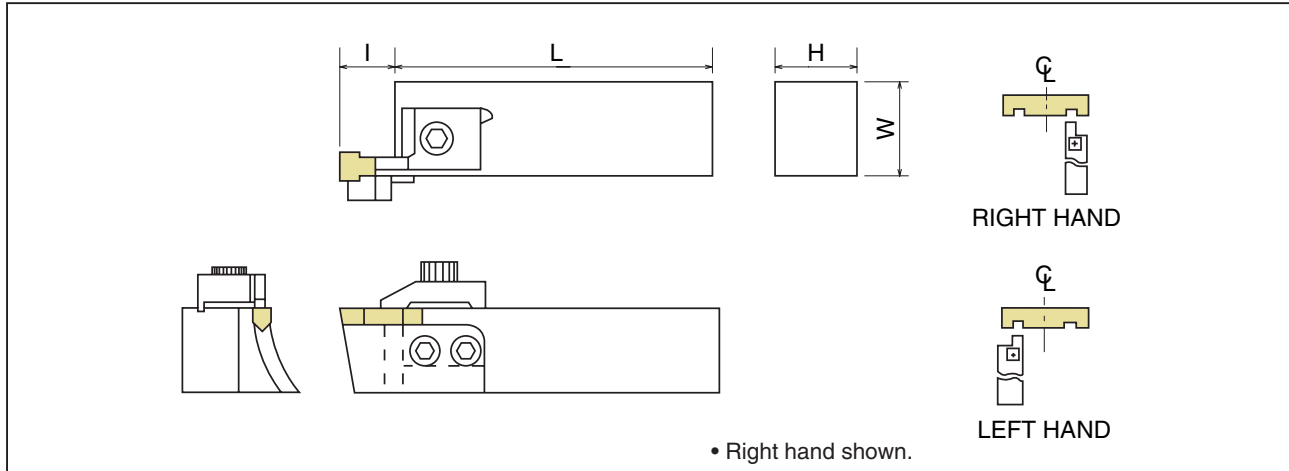
● Anvil and Clamp

Shank Size	Right Hand				Left Hand				Insert
	Anvil		Clamp		Anvil		Clamp		
1.00" SQ	R1E04	●	CR1-1-E04	●	L1E04	●	CL1-1-E04	●	VDB125
	R1E05	●	CR1-1-E06	●	L1E05	●	CL1-1-E06	●	VDB156
	R1E06	●	CR1-1-E06	●	L1E06	●	CL1-1-E06	●	VDB188, VDB218
	R1E07	●	CR1-1-E07	●	L1E07	●	CL1-1-E07	●	VDB250
	R1E09	●	CR1-1-E09	●	L1E09	●	CL1-1-E09	●	VDB312
	R1E11	●	CR1-1-E11	●	L1E11	●	CL1-1-E11	●	VDB375
1.25" SQ	R2E04	●	CR1-1-E04	●	L2E04	●	CL1-1-E04	●	VDB125
	R2E05	●	CR1-1-E06	●	L2E05	●	CL1-1-E06	●	VDB156
	R2E06	●	CR1-1-E06	●	L2E06	●	CL1-1-E06	●	VDB188, VDB218
	R2E07	●	CR1-1-E07	●	L2E07	●	CL1-1-E07	●	VDB250
	R2E09	●	CR1-1-E09	●	L2E09	●	CL1-1-E09	●	VDB312
	R2E11	●	CR1-1-E11	●	L2E11	●	CL1-1-E11	●	VDB375

● : Stock

DB

Facing, Curve In



● Shank

Shank	Stock	Dimensions (inch)				Anvil Screw	Stock	Clamp Screw	Stock
		H inch	W inch	L inch	I inch				
DB7-1-7-16R		1.00	1.00	6.00	.750	DAS41	●	SC40F10	●
DB7-1-7-20R		1.25	1.25	7.00					
DB7-1-7-16L		1.00	1.00	6.00					
DB7-1-7-20L		1.25	1.25	7.00					

(Shanks come complete with screws - order anvil and clamp separately)

● Anvil

	O.D. range				Insert
	3" - 4 - 1/2"	4 - 1/2" - 7"	7" - 14"	14" and over	
Right hand	DBA-4305	DBA-4405	DBA-4505	DBA-4605	VDB156 / VDB188
	DBA-4307	DBA-4407	DBA-4507	DBA-4607	VDB250
	DBA-4309	DBA-4309	DBA-4509	DBA-4509	VDB312
	DBA-4311	DBA-4311	DBA-4511	DBA-4511	VDB375
Left hand	DBA-8305	DBA-8405	DBA-8505	DBA-8605	VDB156 / VDB188
	DBA-8307	DBA-8407	DBA-8507	DBA-8607	VDB250
	DBA-8309	DBA-8309	DBA-8509	DBA-8509	VDB312
	DBA-8311	DBA-8311	DBA-8511	DBA-8511	VDB375

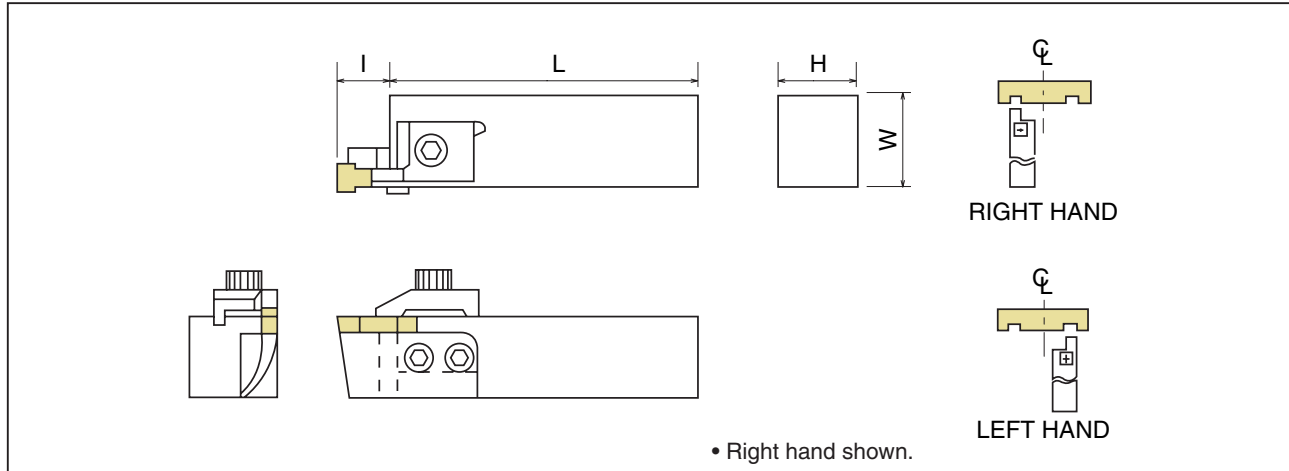
● Clamp

	Insert Number			
	VDB156 / VDB188	VDB250	VDB312	VDB375
Right hand	CR1-1-E06A	CR1-1-E07A	CR1-1-E09A	CR1-1-E11A
Left hand	CL1-1-E06A	CL1-1-E07A	CL1-1-E09A	CL1-1-E11A

● : Stock

DB

Facing, Curve Out



● Shank

Shank	Stock	Dimensions (inch)				Anvil Screw	Stock	Clamp Screw	Stock
		H inch	W inch	L inch	I inch				
DB7-1-7-16R		1.00	1.00	6.00	.750	DAS41	●	SC40F10	●
DB7-1-7-20R		1.25	1.25	7.00					
DB7-1-7-16L		1.00	1.00	6.00					
DB7-1-7-20L		1.25	1.25	7.00					

(Shanks come complete with screws - order anvil and clamp separately)

● Anvil

	O.D. range				Insert
	3" - 4 - 1/2"	4 - 1/2" - 7"	7" - 14"	14" and over	
Right hand	DBA-3305	DBA-3405	DBA-3505	DBA-3605	VDB156 / VDB188
	DBA-3307	DBA-3407	DBA-3507	DBA-3607	VDB250
	DBA-3309	DBA-3309	DBA-3509	DBA-3509	VDB312
	DBA-3311	DBA-3311	DBA-3511	DBA-3511	VDB375
Left hand	DBA-7305	DBA-7405	DBA-7505	DBA-7605	VDB156 / VDB188
	DBA-7307	DBA-7407	DBA-7507	DBA-7607	VDB250
	DBA-7309	DBA-7309	DBA-7509	DBA-7509	VDB312
	DBA-7311	DBA-7311	DBA-7511	DBA-7511	VDB375

● Clamp

	Insert Number			
	VDB156 / VDB188	VDB250	VDB312	VDB375
Right hand	CR1-1-E06A	CR1-1-E07A	CR1-1-E09A	CR1-1-E11A
Left hand	CL1-1-E06A	CL1-1-E07A	CL1-1-E09A	CL1-1-E11A

● : Stock

● VDB

	Insert	Dimensions (inch)			Ceramic				Cermet	
		W	R	T	SX5	SX9	HC2	WA1	T3N	
	VDB 125 A015	.125	.015	.250			●		●	
	156 A015	.156	.015				●			●
	188 A015	.188	.015				●			●
	218 A015	.218	.015				●			●
	250 B015	.250	.015	.337			●		●	
	B031		.031		●	●				
	B062	.062			●					
	281 B015	.281	.015				●			
	312 B015	.312	.015				●			
	B031		.031		●	●				
	B062		.062		●	●				
	344 B015	.344	.015				●			
	375 B015	.375	.015				●			
	B031		.031		●	●				
	B046		.046		●					
B062	.062		●	●						
					●	●		●		

● : Stock

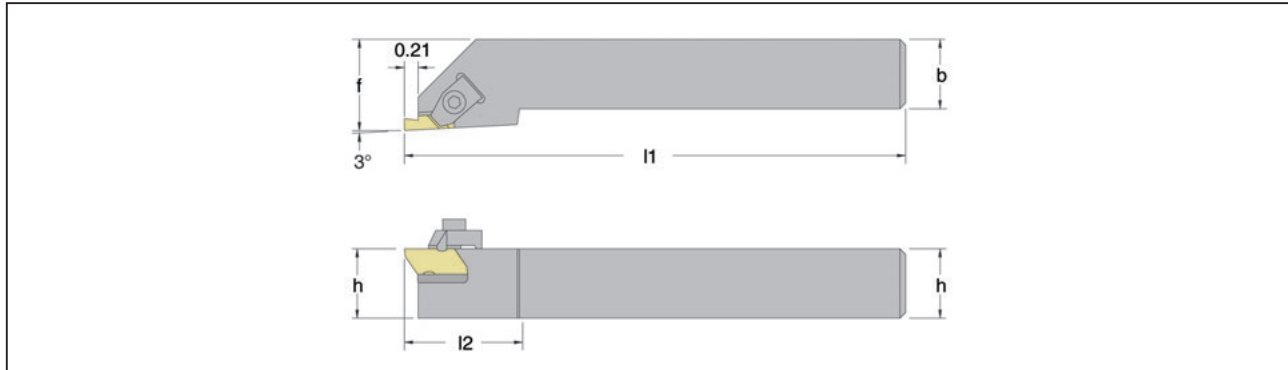
● VDB-R

	Insert	Dimensions (inch)			Ceramic			Cermet	
		W	R	T	SX5	HC2	WA1	T3N	
	VDB 125 RA	.125	.063	.250		●		●	
	156 RA	.156	.078				●		●
	188 RA	.188	.094				●		●
	218 RA	.218	.109				●		●
	250 RB	.250	.125	.337	●	●	●	●	
	281 RB	.281	.141			●			
	312 RB	.312	.156			●			
	344 RB	.344	.172			●			
	375 RB	.375	.188			●			
							●		

For details of inserts, see pages 57 and 90.

● : Stock

NS



Toolholder Number	Insert to fit	Max. Doc	b	h	l1	l2	f	Clamp	Clamp Screw	Stock
NSR16-3D	GKN3_R, RKN3_R, GKP3_R	0.210	1.00	1.00	6.00	1.25	1.25	CM-72	S-412	●
NSL16-3D	GKN3_L, RKN3_L, GKP3_L	0.210	1.00	1.00	6.00	1.25	1.25	CM-73	S-412	●

● CERAMIC INSERTS

Shape	Insert	Dimensions						Ceramic		
		W	R	D	A	B	T	SX2	HC2	ZC4
	GKN 3062 ^{R/L}	.062	.008	.094	.344	.405	.195		●	●
	3094 ^{R/L}	.094	.008	.150					●	●
	3125 ^{R/L}	.125	.012	.150				●	●	●
	3156 ^{R/L}	.156	.012	.150					●	
	3189 ^{R/L}	.189	.012	.150				●	●	
	RKN 3078 ^{R/L}	.078	.039	.150	.344	.405	.195			●
	3094 ^{R/L}	.094	.047	.150						●
	3125 ^{R/L}	.125	.063	.150						●
	3156 ^{R/L}	.156	.078	.150						●
	3189 ^{R/L}	.189	.095	.150						●

For details of inserts, see pages 42 and 44.

● : Stock

● CERMET, MICROGRAIN CARBIDE INSERTS

Shape	Insert	Dimensions						Cermet	Coated Carbide
		W	R	D	A	B	T	C7X	QM3
	GKP 3031 ^{R/L}	.031	.004	.050	.344	.405	.195	●	●
	3047 ^{R/L}	.047	.008	.075				●	
	3062 ^{R/L}	.062	.008	.094				●	●
	3088 ^{R/L}	.088	.008	.094				●	
	3094 ^{R/L}	.094	.008	.150				●	●
	3125 ^{R/L}	.125	.008	.150				●	●
	3156 ^{R/L}	.156	.008	.150				●	●
	3189 ^{R/L}	.189	.012	.150				●	●

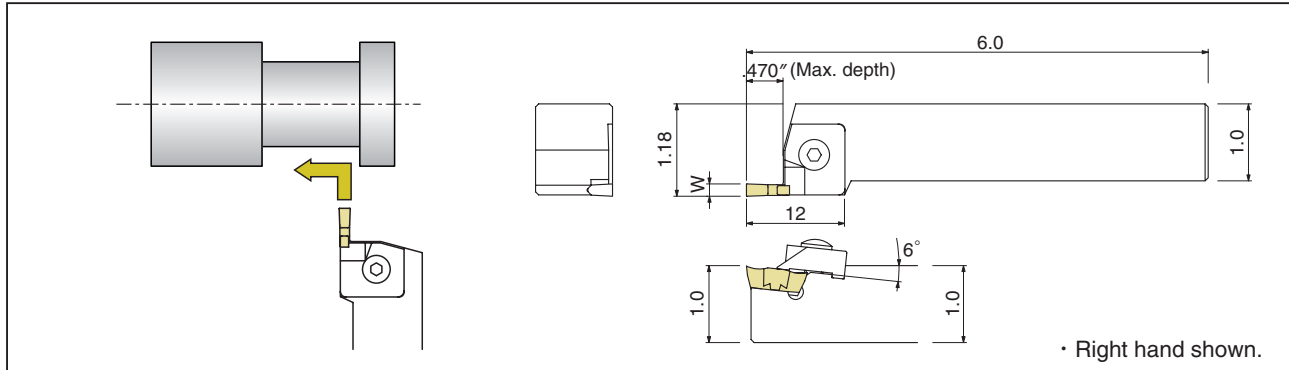
For details of inserts, see pages 76 and 102


● : Stock

* insert with special width and R in both GKN and GKP are available on requests.





VGT

Clamp-on type (Inch type)




Grooving condition		Insert	Item-No.	stock	
Width (inch)	Max Depth (inch)			R	L
.115 ~ .153	.470	 VGE	VGT^{R/L} 16 - 3	●	●
.154 ~ .220			16 - 4	●	●
.221 ~ .292			16 - 6	●	●
.293 ~ .378			16 - 8	●	●

● Parts

Toolholder	Clamp	Clamping screw	Spring	Wrench
VGT^{R/L} 16 - 3	 CV^{R/L} 3N CV^{R/L} 4N CV^{R/L} 6 CV^{R/L} 8	 AOB-6N	 ASG-6	 LW-4
16 - 4				
16 - 6				
16 - 8				

● Inserts

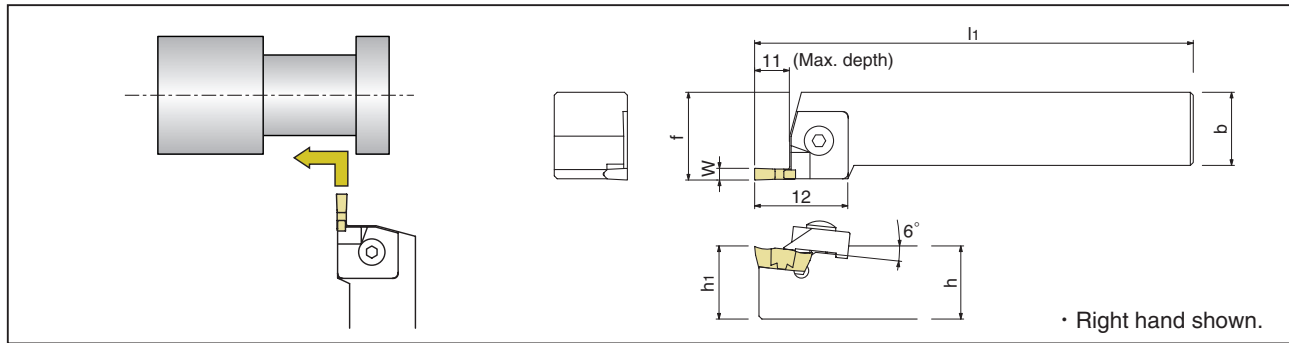
Shape	Insert	Dimensions			Cermet
		W	R	T	XN4
	VGE 125N015	.125	.015	.205	●
	156N015	.156	.015	.335	●
	188N015	.188	.015	.335	●
	250N015	.250	.015	.335	●
	312N015	.312	.015	.335	●
	375N015	.375	.015	.335	●

For details of inserts, see page 90.


● : Stock

GTV

Clamp-on type (Metric type)







• Right hand shown.

Grooving condition		Dimensions (mm)							Insert	Item-No.	stock	
Width (mm)	Max Depth (mm)	w	h	b	l1	h1	f	l2			R	L
3.00 ~ 3.50	11.0	3.0	16	16	100	16	20	25	 GEV	GTV ^{R/L} 16 - 3N	★	
3.00 ~ 3.50		3.0	20	20	125	20	25	32		20 - 3N	★	★
3.00 ~ 3.90		3.0	25	25	150	25	30	32		25 - 3N	★	★
4.00 ~ 5.90		4.0	16	16	100	18	20	25		16 - 4N	★	★
4.00 ~ 5.90		4.0								20 - 4N	★	★
6.00 ~ 7.90		6.0	20	20	125	20	25	32		20 - 6	★	
8.00 ~ 9.00		8.0								20 - 8	★	
4.00 ~ 5.90		4.0								25 - 4N	●	★
6.00 ~ 7.90		6.0	25	25	150	25	30	32		25 - 6	●	●
8.00 ~ 9.00		8.0								25 - 8	★	
4.00 ~ 5.90		4.0								32A - 4N	★	★
6.00 ~ 7.90		6.0	32	25	170	32	30	32		32A - 6	★	★
8.00 ~ 9.00		8.0								32A - 8	★	★

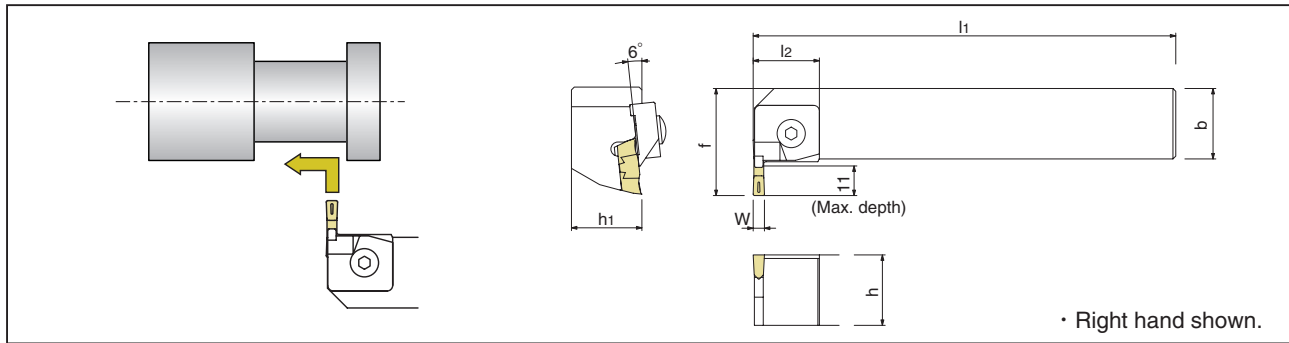
● : Stock ★ : 2 weeks delivery


● Parts

Toolholder	Clamp	Clamping screw	Spring	Wrench
GTV ^{R/L} 16 - 3N	 CV^{R/L} 3N <hr/> CV^{R/L} 4N <hr/> CV^{R/L} 6 <hr/> CV^{R/L} 8 <hr/> CV^{R/L} 4N <hr/> CV^{R/L} 6 <hr/> CV^{R/L} 8 <hr/> CV^{R/L} 4N <hr/> CV^{R/L} 6 <hr/> CV^{R/L} 8	 AOB-6C	 ASG-6	 LW-4
20 - 3N				
25 - 3N				
16 - 4N				
20 - 4N				
20 - 6				
20 - 8				
25 - 4N				
25 - 6				
25 - 8				
32A4N				
32A6				
32A8				

GKV





Clamp-on type



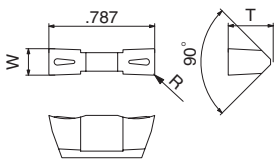

Grooving condition		Dimensions (mm)							Insert	Item-No.	stock				
Width (mm)	Max Depth (mm)	w	h	b	l1	h1	f	l2			R	L			
4.00 ~ 5.90	11.0	4.0	20	20	125	20	23.5	33	 GEV	GKV ^{R/L} 20 - 4N	★				
6.00 ~ 7.90		6.0													
8.00 ~ 9.00		8.0													
4.00 ~ 5.90		4.0	25	25	150	25	23.5	38					25 - 4N	★	
6.00 ~ 7.90		6.0													
8.00 ~ 9.00		7.0													

★ : 2 weeks delivery

● Parts

Toolholder	Clamp	Clamping screw	Spring	Wrench
GKV ^{R/L} 20 - 4N	 CV ^{R/L} 4N			
20 - 6	CV ^{R/L} 6			
20 - 8	CV ^{R/L} 8			
25 - 4N	CV ^{R/L} 4N	AOB-6C	ASG-6	LW-4
25 - 6	CV ^{R/L} 6			
25 - 8	CV ^{R/L} 8			

Grooving Tools

		Dimensions (inch)			Cermet	Coated Carbide
		W	R	T	XN4	QM3
Shape	Insert					
	GEV 300N	.118	.008	.205	★	★
	300N04	.118	.015	.205		★
	350N	.138	.008	.335	★	
	350N04	.138	.015	.335		★
	400N	.157	.008	.335	★	★
	400N04	.157	.015	.335	★	★
	450N04	.177	.015	.335		★
	500N	.197	.008	.335	★	★
	500N04	.197	.015	.335		★
	550N	.217	.008	.335	★	
	550N04	.217	.015	.335		★
	600N	.236	.008	.335	★	★
	600N04	.236	.015	.335		★
	650N	.256	.008	.335	★	
	650N04	.256	.015	.335		★
	700N04	.278	.015	.335	★	★
	750N	.295	.008	.335	★	
	750N04	.295	.015	.335		★
800N	.315	.008	.335	★		
800N04	.315	.015	.335		★	

For details of inserts, see pages 75 and 102.

★ : 2 weeks delivery