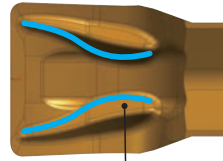
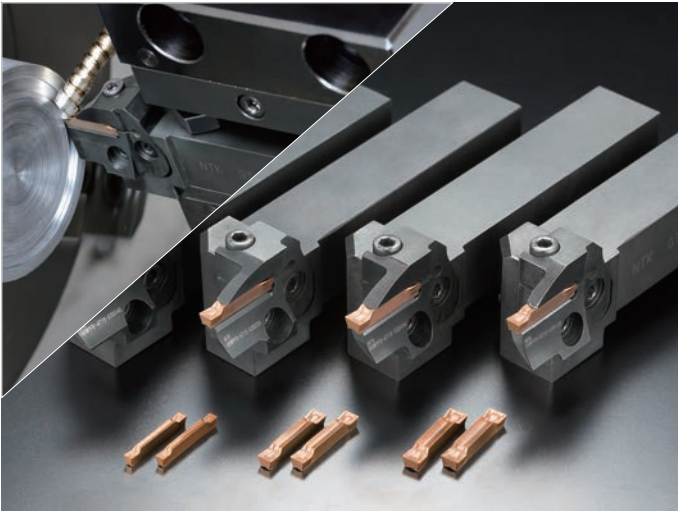
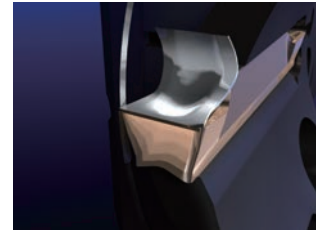


SCRUM DUO BLADE - Carbide Face Grooving Tool



Unique S-shape design

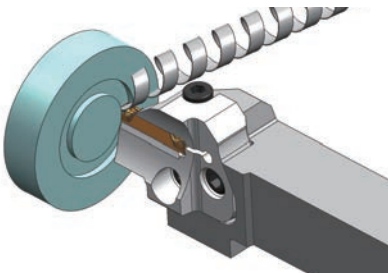


Features





- **New GT Chipbreaker designed for face-grooving**
- **The best rigidity in a Modular system**
- **Excellent chip-control and great finish**

Excellent Chip Control

• Grooving

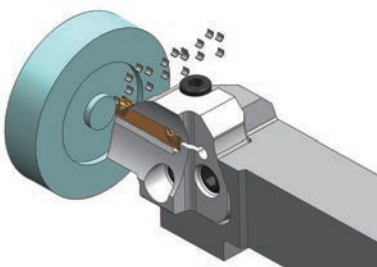


- **Excellent chip control and superior surface finish**
- **Good chip control without a peck cycle**

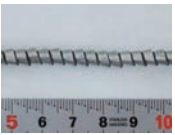

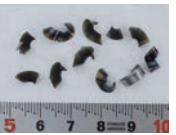


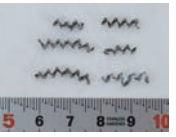

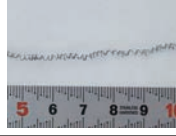

	NTK:GT chipbreaker	Competitor
Chip		 Tangled chips during deep grooving
Surface finish		 Scratches inside bottom

Material : SCM415, $V_c=150\text{m/min}$, $f=0.1\text{mm/rev}$, $\Phi 50$ diameter, 1.0mm depth, No step feed, WET
 Insert : GWPFM500N04-GT DM4 Holder : GBWPFM-5T15-050120

• Side-turning



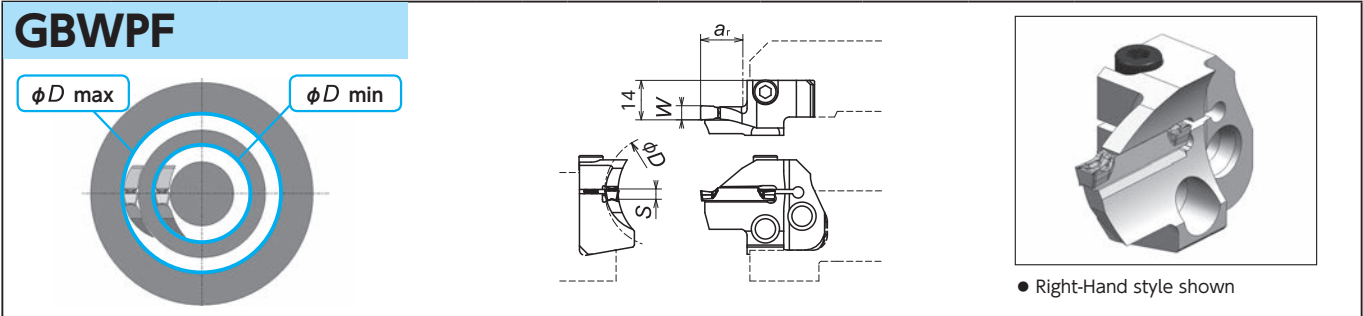
- **Excellent chip control for side-turning process**
- **Shiny surface finish**

		feed (mm/rev)		
		0.05	0.1	0.2
Depth of cut (mm)	3.0			
	1.0			
	0.2			

Material : SCM415, $V_c=150\text{m/min}$, WET
 Insert : GWPFM500N04-GT DM4 Holder : GBWPFM-5T15-050120

SCRUM DUO BLADE Series

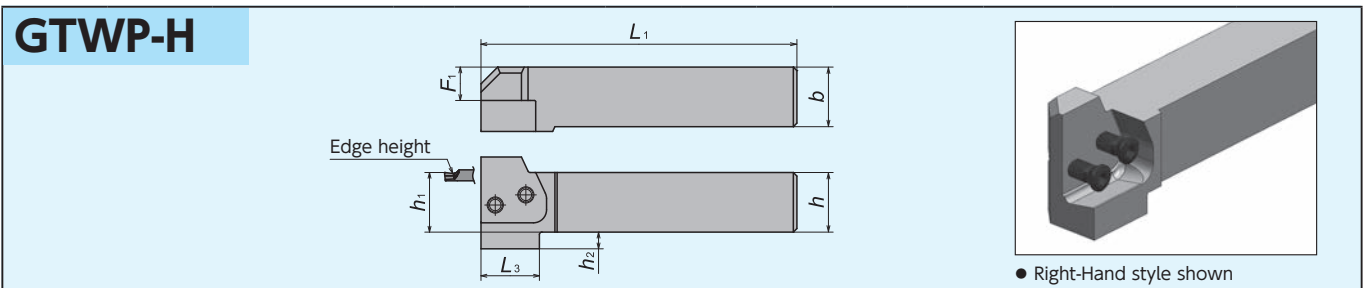
Blade



Code No.		Blade Number	Stock		Groove Width W (mm)	Face grooving OD		Max. Grooving depth ar	Seat Size S	Gage insert	Clamp Bolt
R	L		R	L		φD min	φD max				
5963335	5963491	GBWPF 1/2 -3T13-029035	●	●	3	29	35	13	C	GWPFM300	CS0515
5963343	5963509	-3T13-035045	●	●		35	45				
5963350	5963517	-3T15-045060	●	●		45	60				
5963368	5963525	-3T15-060100	●	●		60	100				
5963376	5963533	-3T15-100250	●	●	4	100	250	15	C	GWPFM400	CS0515
5963392	5963558	-4T15-030040	●	●		30	40				
5963426	5963566	-4T15-040060	●	●		40	60				
5963434	5963574	-4T15-060120	●	●		60	120				
5963442	5963582	-4T15-120300	●	●	5	120	300	15	C	GWPFM500	CS0515
5963707	5963715	-5T15-030050	●	●		30	50				
5963459	5963608	-5T15-050120	●	●		50	120				
5963467	5963616	-5T15-120999	●	●		120	∞				
5963475	5963632	-6T15-035080	●	●	6	35	80	15	C	GWPFM600	CS0515
5963483	5963640	-6T15-080999	●	●		80	∞				

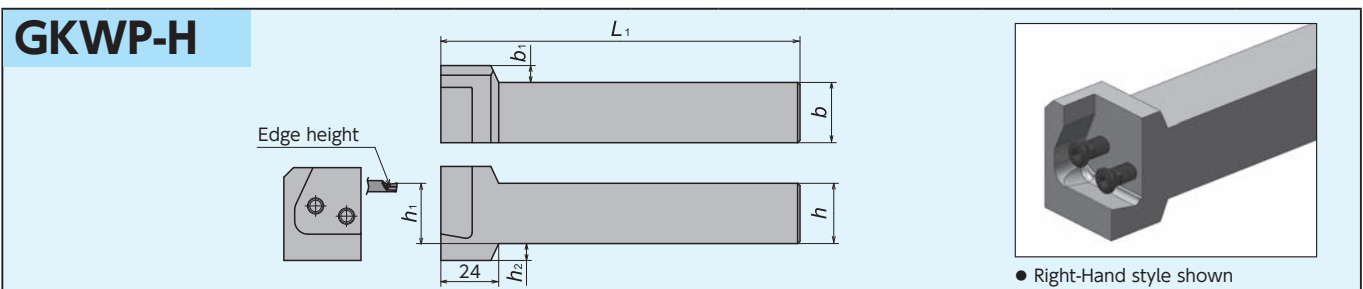
※Do not tighten clamp screw without installing insert as it may damage the insert pocket.

Toolholders Body (0° Straight style)



Code No.		Holder Number	Stock		Dimensions (mm)							Gage insert	Spare Parts	
R	L		R	L	h	b	h ₁	L ₁	F ₁	h ₂	L ₃		Clamp Screw	Wrench
5923784	5923792	GTWP 1/2 2020-H	●	●	20	20	20	107.5	9	8	28.5	GBWPF 1/2	FSI28-6.0 * 18	LW-4
5923800	5923818	1/2 2525-H	●	●	25	25	25	132.5	14	7	24.5			
5963657	5963673	1/2 3232-H	●	●	32	32	32	152.5	21	-	-			

Toolholders Body (90° L- style)



Code No.		Holder Number	Stock		Dimensions (mm)							Gage insert	Spare Parts	
R	L		R	L	h	b	h ₁	L ₁	b ₁	h ₂	Clamp Screw		Wrench	
5923826	5923834	GKWP 1/2 2020-H	●	●	20	20	20	124	12	12	GBWPF 1/2	FSI28-6.0 * 18	LW-4	
5923842	5923859	1/2 2525-H	●	●	25	25	25	149	7	7				
5963681	5963699	1/2 3232-H	●	●	32	32	32	169	-	-				

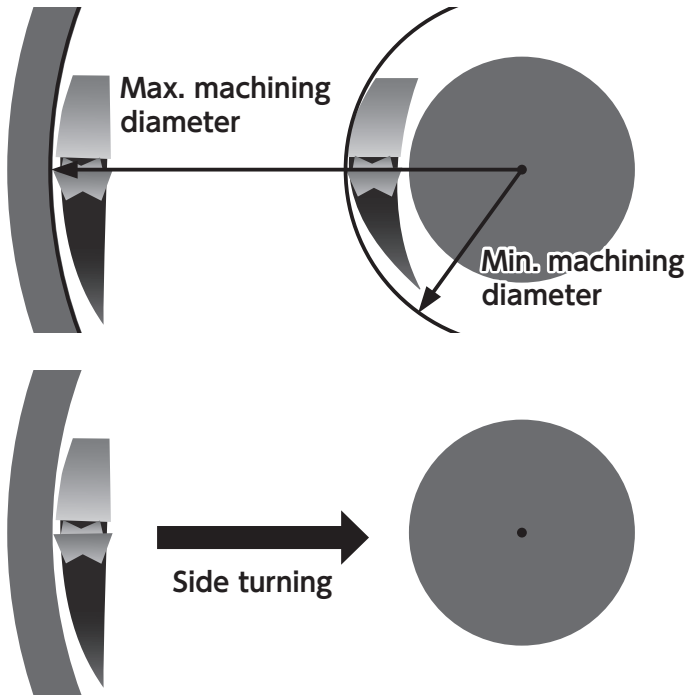
New Products
 Tool Materials / Selection Guide
 Micrograin Carbide, BIDEIMCS, PCD, CBN and Ceramics
 PVD Coated Carbide
 Insert Item List
 General Turning Toolholders
 Unique Swiss Tooling
 Grooving / Side Turning
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 Shaper
 ID Tooling
 Application Introduction
 Endmills
 Rotating Tools
 Information
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Grooving / Side Turning

SCRUM DUO BLADE Series - Inserts

Shape	Item Number	Dimensions (mm)				Seat Size S	PVD Coated Carbide	
		W	r_ϵ (mm)	M (mm)	L (mm)		DM4	Stock
	GWPFM300N02-GT	3.0	0.2	2.2	24.5	C	5963251	●
	GWPFM300N04-GT		0.4				5963269	●
	GWPFM400N04-GT	4.0	0.4	3.2			5963277	●
	GWPFM400N08-GT		0.8				5963285	●
	GWPFM500N04-GT	5.0	0.4	3.7			5963293	●
	GWPFM500N08-GT		0.8				5963301	●
	GWPFM600N04-GT	6.0	0.4	4.7			5963319	●
	GWPFM600N08-GT		0.8				5963327	●

Guidelines



- Choose a blade so that your first target grooving max. OD is between the max. OD and min. OD of the blade.

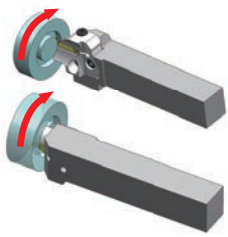
- To make the groove wide, side turn from outside to inside (direction to the center of the work piece)

■ Combination of toolholder and blade for Face Grooving

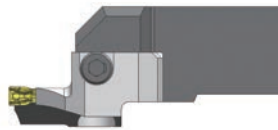
GTWP-H

Straight style toolholder

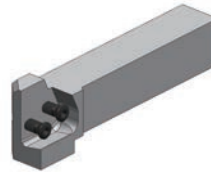
Right-hand system



Clockwise rotation (M4 command)



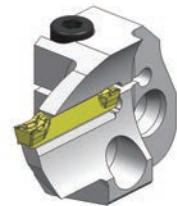
Toolholder



GTWP R-H



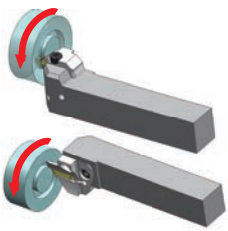
Blade



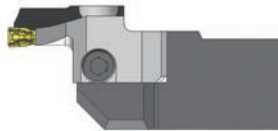
GBWPF R

* Right-hand toolholder takes Right-hand blade.

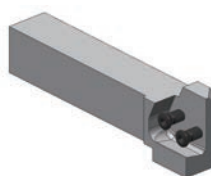
Left-hand system



Counter clockwise rotation (M3 command)



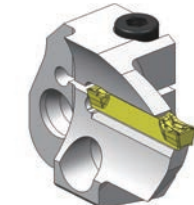
Toolholder



GTWP L-H



Blade



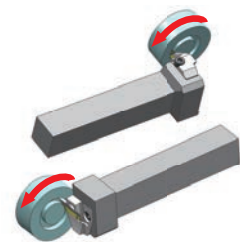
GBWPF L

* Left-hand toolholder takes Left-hand blade.

GKWP-H

L-style toolholder

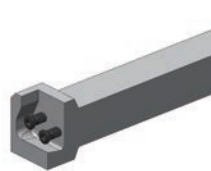
Right-hand system



Counter clockwise rotation (M3 command)



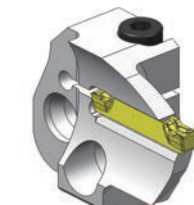
Toolholder



GKWP R-H



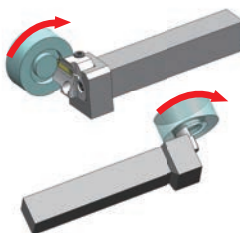
Blade



GBWPF L

* Right-hand toolholder takes Left-hand blade.

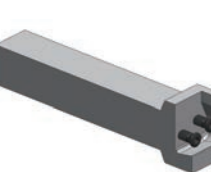
Left-hand system



Clockwise rotation (M4 command)



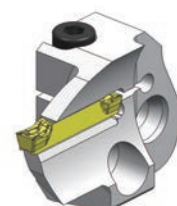
Toolholder



GKWP L-H



Blade

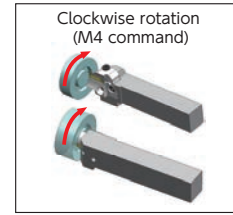
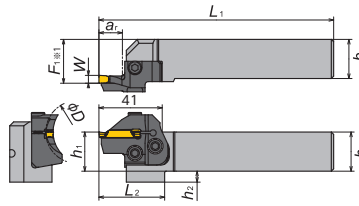
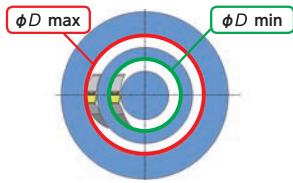


GBWPF R

* Left-hand toolholder takes Right-hand blade.

Grooving / Side Turning

Combination (0° Straight style holder and GBWPFR Blade)

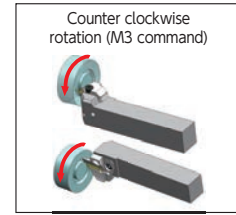
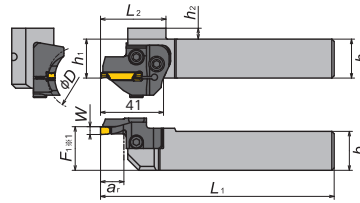
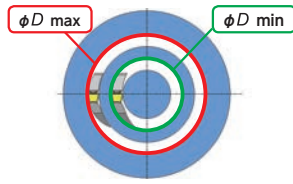


●Right-Hand style shown

Right-hand toolholder takes Right-hand blade.

Hand	Groove Width W (mm)	Face grooving OD		Max.grooving depth a. (mm)	Holder Number	Blade Number	Dimensions (mm)							Gage insert	
		φD min (mm)	φD max (mm)				h	b	L ₁	h ₁	F ₁	L ₂	h ₂		
R	3	29	35	13	GTWPR2020-H	GBWPFR-3T13-029035	20	20	125	20	23	42.5	8	GWPFM300	
		35	45			-3T13-035045									
		45	60			-3T15-045060									
		60	100			-3T15-060100									
		100	250			-3T15-100250									
	4	30	40	15		-4T15-030040									
		40	60			-4T15-040060									
		60	120			-4T15-060120									
	5	120	300	-4T15-120300											
		30	50	15		-5T15-030050									
		50	120		-5T15-050120										
	120	∞	-5T15-120999												
	6	35	80	15	-6T15-035080										
		80	∞		-6T15-080999										
	R	3	29	35	13	GTWPR2525-H	-3T13-029035	25	25	150	25	28	38.5	7	GWPFM300
			35	45			-3T13-035045								
			45	60			-3T15-045060								
			60	100			-3T15-060100								
			100	250			-3T15-100250								
		4	30	40	15		-4T15-030040								
			40	60			-4T15-040060								
			60	120			-4T15-060120								
		5	120	300	-4T15-120300										
			30	50	15		-5T15-030050								
50	120		-5T15-050120												
120	∞	-5T15-120999													
6	35	80	15	-6T15-035080											
	80	∞		-6T15-080999											
R	3	29	35	13	GTWPR3232-H	-3T13-029035	32	32	170	32	35	-	-	GWPFM300	
		35	45			-3T13-035045									
		45	60			-3T15-045060									
		60	100			-3T15-060100									
		100	250			-3T15-100250									
	4	30	40	15		-4T15-030040									
		40	60			-4T15-040060									
		60	120			-4T15-060120									
	5	120	300	-4T15-120300											
		30	50	15		-5T15-030050									
50		120	-5T15-050120												
120	∞	-5T15-120999													
6	35	80	15	-6T15-035080											
	80	∞		-6T15-080999											

Combination (0° Straight style holder and GBWPFL Blade)



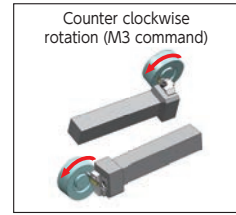
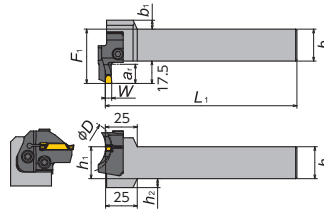
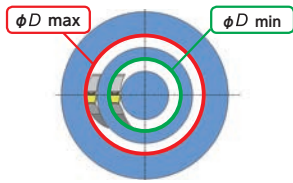
●Left-Hand style shown

Left-hand toolholder takes Left-hand blade.

Hand	Groove Width W (mm)	Face grooving OD		Max.grooving depth ar (mm)	Holder Number	Blade Number	Dimensions (mm)							Gage insert											
		ϕD min (mm)	ϕD max (mm)				h	b	L1	h1	F1	L2	h2												
L	3	29	35	13	GTWPL2020-H	GBWPFL-3T13-029035	20	20	125	20	23	42.5	8	GWPFM300											
		35	45			-3T13-035045																			
		45	60			-3T15-045060																			
		60	100			-3T15-060100																			
		100	250			-3T15-100250																			
	4	30	40	15		-4T15-030040																			
		40	60			-4T15-040060																			
		60	120			-4T15-060120																			
	5	30	50	15		-5T15-030050																			
		50	120			-5T15-050120																			
		120	∞			-5T15-120999																			
	6	35	80	15		-6T15-035080																			
		80	∞			-6T15-080999																			
	L	3	29	35		13									GTWPL2525-H	-3T13-029035	25	25	150	25	28	38.5	7	GWPFM300	
			35	45												-3T13-035045									
			45	60	-3T15-045060																				
			60	100	-3T15-060100																				
			100	250	-3T15-100250																				
		4	30	40	15	-4T15-030040																			
			40	60		-4T15-040060																			
			60	120		-4T15-060120																			
		5	30	50	15	-5T15-030050																			
			50	120		-5T15-050120																			
			120	∞		-5T15-120999																			
		6	35	80	15	-6T15-035080																			
			80	∞		-6T15-080999																			
		L	3	29	35	13	GTWPL3232-H	-3T13-029035	32	32	170	32	35	-		-									GWPFM300
				35	45			-3T13-035045																	
	45			60	-3T15-045060																				
	60			100	-3T15-060100																				
	100			250	-3T15-100250																				
	4		30	40	15	-4T15-030040																			
			40	60		-4T15-040060																			
			60	120		-4T15-060120																			
	5		30	50	15	-5T15-030050																			
			50	120		-5T15-050120																			
120			∞	-5T15-120999																					
6	35		80	15	-6T15-035080																				
	80		∞		-6T15-080999																				

Grooving / Side Turning

Combination (90° L style holder and GBWPFL Blade)

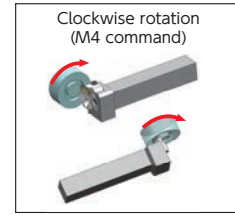
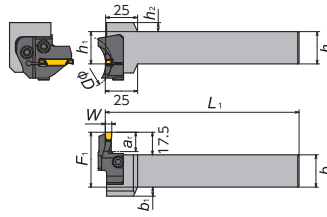
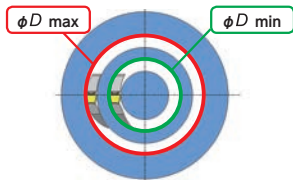


● Right-Hand style shown

Right-hand toolholder takes Left-hand blade.

Hand	Groove Width W (mm)	Face grooving OD		Max.grooving depth a (mm)	Holder Number	Blade Number	Dimensions (mm)							Gage insert	
		φD min (mm)	φD max (mm)				h	b	L ₁	h ₁	F ₁	L ₂	h ₂		
R	3	29	35	13	GKWPR2020-H	GBWPFL-3T13-029035	20	20	125	20	37.5	12	8	GWPFM300	
		35	45			-3T13-035045									
		45	60			-3T15-045060									
		60	100			-3T15-060100									
		100	250			-3T15-100250									
	4	30	40	15		-4T15-030040									
		40	60			-4T15-040060									
		60	120			-4T15-060120									
	5	120	300	-4T15-120300											
		30	50	15		-5T15-030050									
		50	120		-5T15-050120										
	120	∞	-5T15-120999												
	6	35	80	15	-6T15-035080										
		80	∞		-6T15-080999										
	R	3	29	35	13	GKWPR2525-H	-3T13-029035	25	25	150	25	42.5	7	7	GWPFM300
			35	45			-3T13-035045								
			45	60			-3T15-045060								
			60	100			-3T15-060100								
			100	250			-3T15-100250								
		4	30	40	15		-4T15-030040								
			40	60			-4T15-040060								
			60	120			-4T15-060120								
		5	120	300	-4T15-120300										
			30	50	15		-5T15-030050								
50			120	-5T15-050120											
120		∞	-5T15-120999												
6		35	80	15	-6T15-035080										
		80	∞		-6T15-080999										
R		3	29	35	13	GKWPR3232-H	-3T13-029035	32	32	170	32	49.5	-	-	GWPFM300
	35		45	-3T13-035045											
	45		60	-3T15-045060											
	60		100	-3T15-060100											
	100		250	-3T15-100250											
	4	30	40	15	-4T15-030040										
		40	60		-4T15-040060										
		60	120		-4T15-060120										
	5	120	300	-4T15-120300											
		30	50	15	-5T15-030050										
		50	120		-5T15-050120										
	120	∞	-5T15-120999												
	6	35	80	15	-6T15-035080										
		80	∞		-6T15-080999										

Combination (90° L style holder and GBWPFR Blade)



●Left-Hand style shown

Left-hand toolholder takes Right-hand blade.

Hand	Groove Width W (mm)	Face grooving OD		Max.grooving depth a (mm)	Holder Number	Blade Number	Dimensions (mm)							Gage insert											
		φD min (mm)	φD max (mm)				h	b	L ₁	h ₁	F ₁	L ₂	h ₂												
L	3	29	35	13	GKWPL2020-H	GBWPFR-3T13-029035	20	20	125	20	37.5	12	8	GWPFM300											
		35	45			-3T13-035045																			
		45	60			-3T15-045060																			
		60	100			-3T15-060100																			
		100	250			-3T15-100250																			
	4	30	40	15		-4T15-030040																			
		40	60			-4T15-040060																			
		60	120			-4T15-060120																			
	5	30	50	15		-5T15-030050																			
		50	120			-5T15-050120																			
		120	∞			-5T15-120999																			
	6	35	80	15		-6T15-035080																			
		80	∞			-6T15-080999																			
	L	3	29	35		13									GKWPL2525-H	-3T13-029035	25	25	150	25	42.5	7	7	GWPFM300	
			35	45												-3T13-035045									
			45	60	-3T15-045060																				
			60	100	-3T15-060100																				
			100	250	-3T15-100250																				
		4	30	40	15	-4T15-030040																			
			40	60		-4T15-040060																			
			60	120		-4T15-060120																			
		5	30	50	15	-5T15-030050																			
			50	120		-5T15-050120																			
			120	∞		-5T15-120999																			
		6	35	80	15	-6T15-035080																			
			80	∞		-6T15-080999																			
		L	3	29	35	13	GKWPL3232-H	-3T13-029035	32	32	170	32	49.5	-		-									GWPFM300
				35	45			-3T13-035045																	
	45			60	-3T15-045060																				
	60			100	-3T15-060100																				
	100			250	-3T15-100250																				
	4		30	40	15	-4T15-030040																			
			40	60		-4T15-040060																			
			60	120		-4T15-060120																			
	5		30	50	15	-5T15-030050																			
			50	120		-5T15-050120																			
120			∞	-5T15-120999																					
6	35		80	15	-6T15-035080																				
	80		∞		-6T15-080999																				

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