

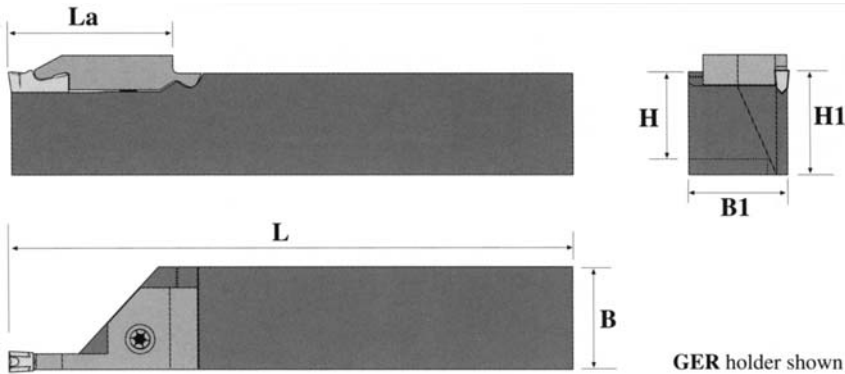
Premier

Manufacturers of Precision Ground Cutting Tools



Grooving / Boring / Turning
GrooveTurn
e - Catalogue

Type GER/L Toolholder



NOTE: Integral-shank toolholders are always supplied complete with clamp, screw and key

Inserts
Type 150
Page: BG4

GER holder shown

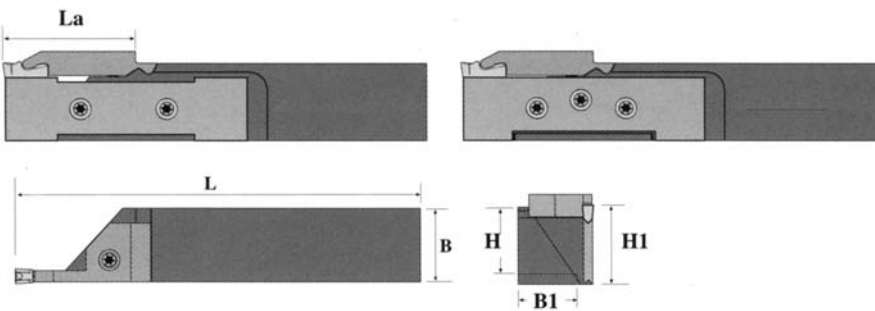
Integral shank toolholder

Part number	Insert Type	H/H1	B/B1	L	La	Clamp
GER/L 1212M3	150	12/16	12/16	150	36	CER/L 16-3
GER/L 1616M3	150	16	16	150	36	CER/L 16-3
GER/L 1620M3	150	16/20	16/20	150	36	CER/L 20-3
GER/L 2020M3	150	20	20	150	36	CER/L 20-3
GER/L 2025K3	150	20/25	25	125	36	CER/L 20-3
GER/L 2525K3	150	25	25	150	36	CER/L 20-3
GER/L 2525K4	150	25	25	150	43	CER/L 20-4

See blades and clamps for groove dimensions

GER.. .B25-F holder shown

GER.. .B20 holder shown



BEX20-.. is double sided
BEX25-.. is four sided

NOTE: Toolholders are supplied with screws for support blade and key only.

Clamps, support blades and screws for clamps must be ordered separately.

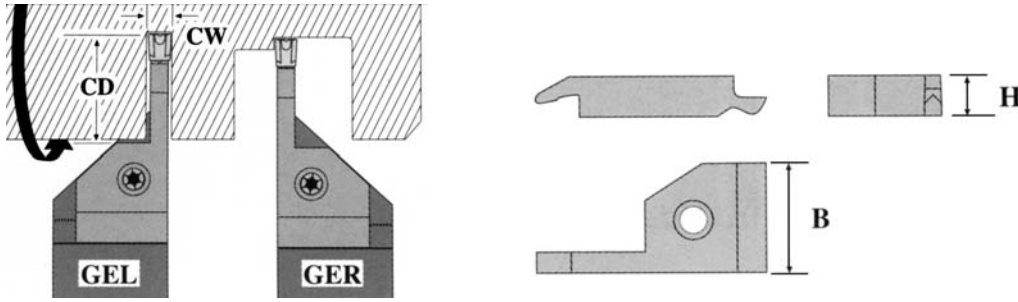
Toolholder for double or four sided support blade

Part number	Insert Type	H/H1	B/B1	L	LH	La	Support blade
GER/L 2025K B20	150	20/25	25/20	120/125	110	36/41	BEX 20-..
GER/L 2525M B20	150	25	25	145/150	135	36/41	BEX 20-..
GER/L 2532R B25F	150	25/32	32/25	202/210/219	160	45/50/59	BEX 25-..
GER/L 3232R B25F	150	32	32	202/210/219	160	45/50/59	BEX 25-..

See blades and clamps for groove dimensions

For current stock availability, refer to our latest price list

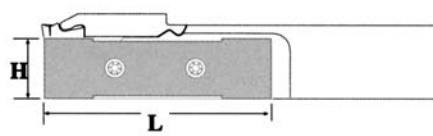
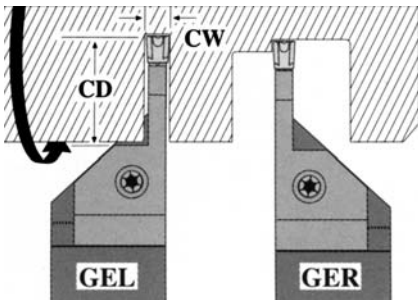
Type GER/L Blades & Clamps



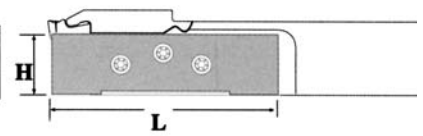
Clamps

Part number	Insert Type	CW	CD	H	B	La*	SPARE PARTS	
							Clamp Screw	Clamp screw key
CER/L 16-3	150	3	20	8	16	36	T15-M6-RL	CQ-T15
CER/L 20-3	150	3	20	8	20	36	T15-M6-RL	CQ-T15
CER/L 25-3-25	150	3	25	8	24	43	T25-M8-RL	CQ-T25
CER/L 25-3-32	150	3	32	8	24	50	T25-M8-RL	CQ-T25
CER/L 20-4	150	4-5	25	8	20	43	T15-M6-RL	CQ-T15
CER/L 25-4-32	150	4	32	8	24	50	T25-M8-RL	CQ-T25
CER/L 25-4-40	150	4	40	8	24	59	T25-M8-RL	CQ-T25
CER/L 25-5-40	150	5	40	8	24	59	T25-M8-RL	CQ-T25

State R or L version



BEX25 shown in **GER-B25F** toolholder
(4 sided blade)



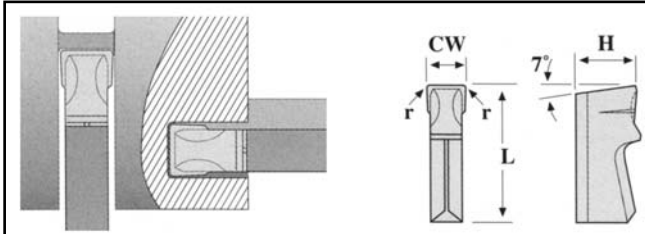
BEX20 shown in **GER-B20** toolholder
(2 sided blade)

Blades

Part number	Blade type	Insert type	CW	CD	L	H	La*	Clamp	SPARE PARTS		
									Support Blade screw	Support Blade screw key	No. of screws per holder
BEX 20-3	2 sided	150	3	20	70,8	20	36	CER/L 20-3	T15-M5	CQ-T15	3
BEX 25-3-25	4 sided	150	3	25	104	27	50	CER/L 25-3-25	T25-M6	CQ-T25	2
BEX 25-3-32	4 sided	150	3	32	104	27	50	CER/L 25-3-32	T25-M6	CQ-T25	2
BEX 20-4	2 sided	150	4-5	25	80,8	20	43	CER/L 20-4	T15-M5	CQ-T15	3
BEX 25-4-32	4 sided	150	4	32	104	27	50	CER/L 25-4-32	T25-M6	CQ-T25	2
BEX 25-4-40	4 sided	150	4	40	120	27	59	CER/L 25-4-40	T25-M6	CQ-T25	2
BEX 25-5-40	4 sided	150	5	40	120	27	59	CER/L 25-5-40	T25-M6	CQ-T25	2

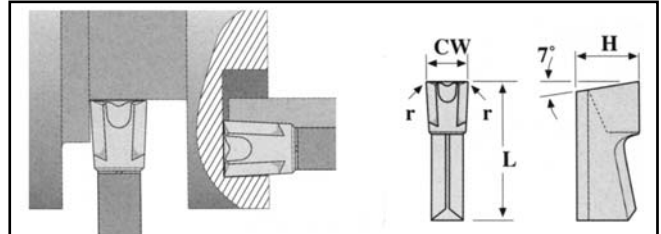
*see page BG2

Type 150 Inserts



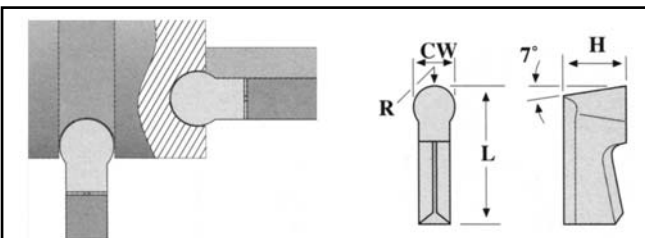
150 Standard insert with chip control

CW +0,1	Part number	H	L	r	Available grades					
					P30C	K10C	P10	P30	K10	
3,0	150.3	6,0	14	0,3	●	●		●	●	
4,0	150.4	6,0	14	0,3	●	●		●	●	
5,0	150.5	6,0	14	0,3	●	●		●	●	



150 GT Grooving and Side Turning insert

CW +0,1	Part number	H	L	r	Available grades					
					P30C	K10C	P30	K10		
3,0	150.3.GT	6,0	14	0,3	●					
4,0	150.4.GT	6,0	14	0,3	●					
5,0	150.5.GT	6,0	14	0,3	●					



150 RD Radius Insert

CW -0,1	Part number	H	L	R	Available grades					
					P30C	K10C	P30	K10		
2,7	150.3.RD	6,0	14	1,35	●	●				
3,7	150.4.RD	6,0	14	1,85	●	●				
4,6	150.5.RD	6,0	14	2,3	●	●				

Grades, Speeds & Feeds

MATERIAL	RECOMMENDED CARBIDE GRADE	FEED MM/REV			
		0,05	0,1	0,2	0,4
CUTTING SPEED M/MIN					
Low carbon steel	P30C		180	130	110
Carbon steel	P30C	200	190	160	85
Alloyed steel	P30C	165	150	110	
Stainless steel	P30C	155	140	100	
Cast steel	P30C	115	95	80	60
Heat resistant Iron-based alloys	K10C	125	80	80	50
Hard steel (Manganese steel)	K10		30	25	
Malleable Iron	K10C	160	150	130	85
Cast Iron	K10C	155	135	120	85
Aluminium alloys	K10	350	300	300	200
Heat resistant Nickel-based alloys	K10	35	25	15	
Heat resistant Cobalt-based alloys	K10	35	25	15	
Non-Ferous materials	K10	300	200	150	100

RECOMMENDATIONS FOR SIDE TURNING

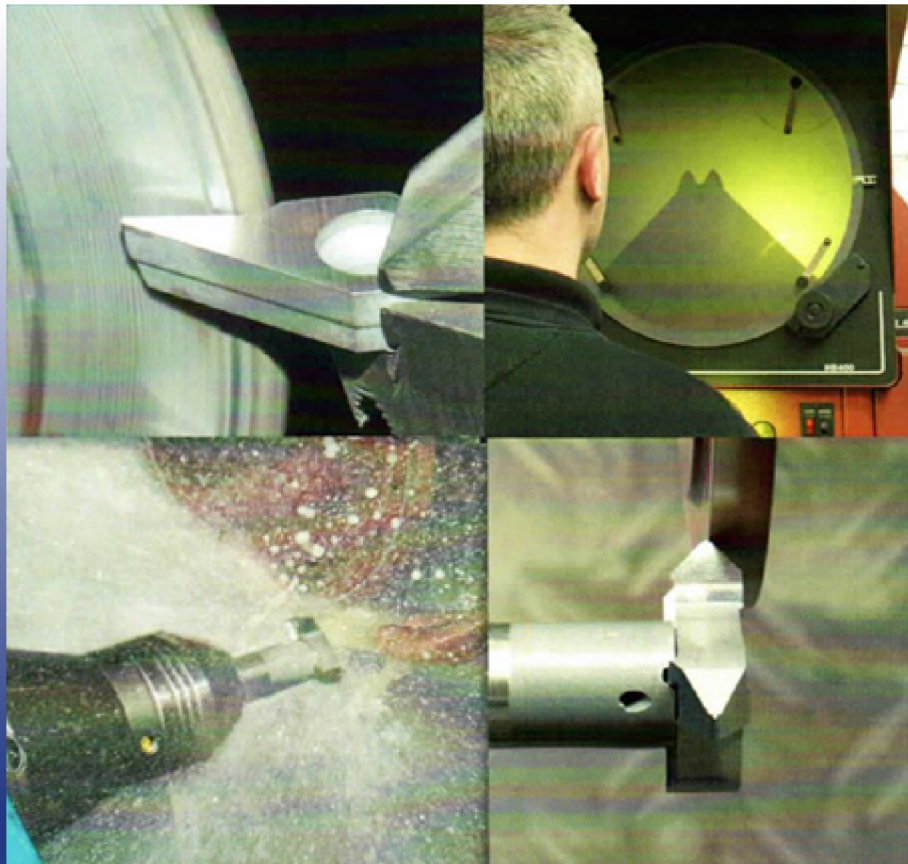
- Cutting speed same as cutting speed for grooving.
- Feed from 0,1 mm. to 0,25 mm.
- Cutting depth: min. 0,25 mm.
max. 0,8 x cutting width of insert.

NOTE

The above data are for guidance only. Actual performance depends on various factors, such as mounting stability, workpiece shape and specific material characteristics.



Manufacturers of Precision Ground Cutting Tools



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