



SUMITOMO

CARBIDE - CBN - DIAMOND

*The Global Leader in
CBN Technology*



CBN Grooving System

“Samples in a Snap” Program



BNC30G



BN2000

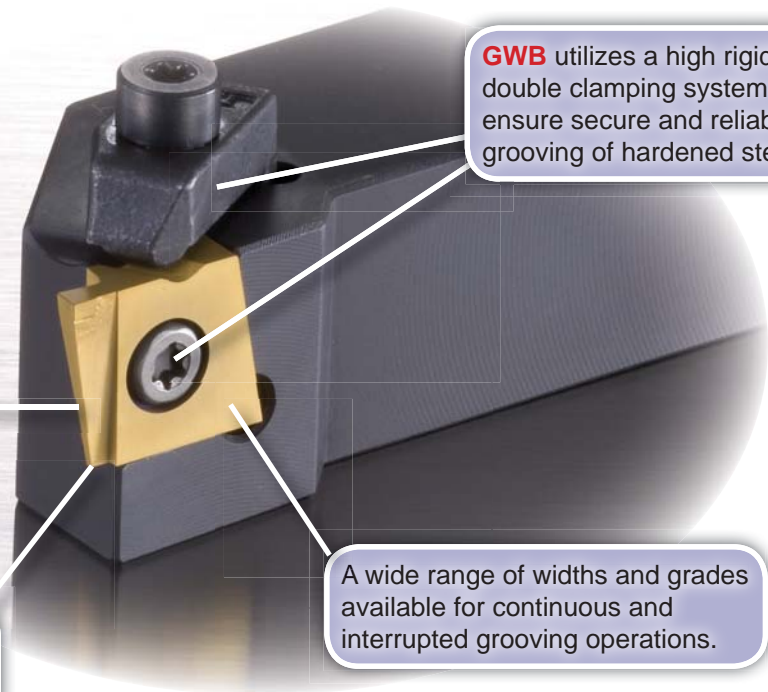
**Order today and have
your Sumitomo Grooving System
delivered in 4 WEEKS**



CBN Grooving System

The latest **Sumitomo Grooving System** combined with superior **SumiBoron** technology

GWB Grooving Holder & CGA CBN Inserts
BN2000 • BNC30G



GWB utilizes a high rigidity double clamping system to ensure secure and reliable grooving of hardened steel.

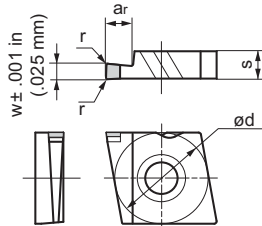
80° tangentially mounted **CGA** inserts contributes to significantly improved rigidity.


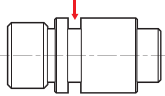

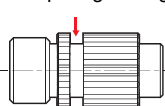
Coated **SumiBoron** grade **BNC30G** enhances the tool life of the **CGA** insert.

A wide range of widths and grades available for continuous and interrupted grooving operations.

Additional benefits:

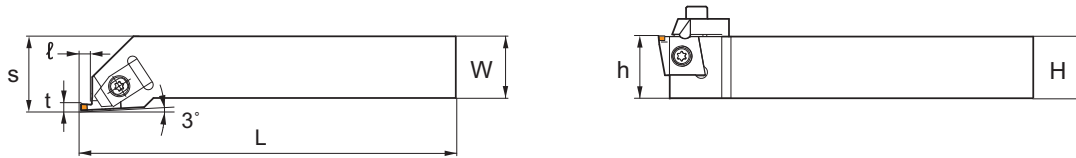
- GWB holder's solid design eliminates the need for additional anvils
- Reliable hardware and holder for low maintenance



Grade	Application	Features	Hv (GPa)	TRS (GPa)
BN2000 	Continuous grooving 	General purpose grade with good wear resistance	31-34	1.0-1.1
BNC30G 	Interrupted grooving 	Tough CBN substrate and special coating with high wear and peeling resistance	33-35	1.1-1.2

CGA CBN INSERTS

Right		Dimensions (in)					Left		
CGA	CBN	W ±.001 in ±.025 (mm)	ar in (mm)	r in (mm)	ød in (mm)	s in (mm)	CGA	CBN	
	BN2000							BNC30G	BN2000
CGAR 4062	•	.062 (1.575)	.1378 (3.5)	.0078 (.2)	.625 (15.875)	.1875 (4.76)	CGAL 4062	•	
CGAR 4094	•	.094 (2.388)	.1575 (4.0)				CGAL 4094	•	
CGAR 4125	•	.125 (3.175)	.1969 (5.0)				CGAL 4125	•	
CGAR 6189	•	.189 (4.801)	.1969 (5.0)				CGAL 6189	•	
CGAR 1504150	•	.0591 (1.5)	.1378 (3.5)				.1875 (4.76)	CGAL 1504150	•
CGAR 1504200	•	.0787 (2.0)						CGAL 1504200	•
CGAR 1504250	•	.0984 (2.5)	.1575 (4.0)				.1875 (4.76)	CGAL 1504250	•
CGAR 1504300	•	.1181 (3.0)						CGAL 1504300	•
CGAR 1504350	•	.1378 (3.5)	.1969 (5.0)				.1875 (4.76)	CGAL 1504350	•
CGAR 1504400	•	.1575 (4.0)						CGAL 1504400	•
CGAR 1504450	•	.1772 (4.5)	.1969 (5.0)	.25 (6.35)	CGAL 1504450	•			
CGAR 1506500	•	.1969 (5.0)			CGAL 1506500	•			
CGAR 1506550	•	.2165 (5.5)	.1969 (5.0)	.25 (6.35)	CGAL 1506550	•			
CGAR 1506600	•	.2362 (6.0)			CGAL 1506600	•			



■ **GWB SERIES HOLDERS**

Sumitomo Cat. No.	Stk.	H in (mm)	W in (mm)	h in (mm)	s in (mm)	t in (mm)	l in (mm)	L in (mm)	Applicable Insert
GWBR 165D4	●	1.0 (25.4)	1.0 (25.4)	1.0 (25.4)	1.181 (30.0)	$.059 < t \leq .079$ (1.5 < t ≤ 2.0)	.138 (3.5)	6.0 (152.4)	CGA R/L 1504□□ CGA R/L 4□□□
GWBL 165D4						$.079 < t \leq .118$ (2.0 < t ≤ 3.0)	.177 (4.5)	6.039 (153.4)	
						$.118 < t \leq .177$ (3.0 < t ≤ 4.5)	.197 (5.0)		
GWBR 165D6	●	1.0 (25.4)	1.0 (25.4)	1.0 (25.4)	1.181 (30.0)	$.177 < t \leq .236$ (4.5 < t ≤ 6.0)		6.039 (153.4)	CGA R/L 1506□□ CGA R/L 6□□□
GWBL 165D6									
GWBR 2525-45	★	.984 (25.0)	.984 (25.0)	.984 (25.0)	1.181 (30.0)	$.059 < t \leq .079$ (1.5 < t ≤ 2.0)	.138 (3.5)	6.0 (152.4)	CGA R/L 1504□□ CGA R/L 4□□□
GWBL 2525-45						$.079 < t \leq .118$ (2.0 < t ≤ 3.0)	.177 (4.5)	6.039 (153.4)	
						$.118 < t \leq .177$ (3.0 < t ≤ 4.5)	.197 (5.0)		
GWBR 2525-60	★	.984 (25.0)	.984 (25.0)	.984 (25.0)	1.181 (30.0)	$.177 < t \leq .236$ (4.5 < t ≤ 6.0)		6.039 (153.4)	CGA R/L 1506□□ CGA R/L 6□□□
GWBL 2525-60									

■ **RECOMMENDED CUTTING CONDITIONS**

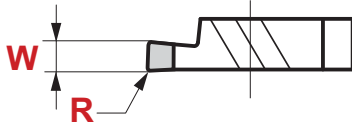
For hardened steel:	
Cutting Speed	260 - 400 sfm (80 - 120 m/min)
Feed Rate	.0016 - .0032 ipr (.04 - .08 mm/rev)
Coolant	Continuous cut: dry or wet Interrupted cut: dry
NOTE: To avoid thermal cracking of cutting edge during interrupted cutting applications, please ensure work piece remains dry.	

■ **HARDWARE**

Clamp	Clamp Screw	Insert Screw	Spring	Wrench
TF-72 (Right hand) TF-73 (Left hand)	BX0520T	BFTX 0511N	GSP06	TRX20

“Samples in a Snap” Program

Get the most innovative CBN grooving technology in your hands when you need it. Order today and receive your **SumiBoron GWB Grooving System** in **FOUR WEEKS**--the shortest lead time for CBN grooving in the industry.



		Features & Dimensions	
Step 1	Left or Right Handed (Circle one)	Left	Right
Step 2	Groove Width (W) 1.5mm - 3.5mm (.059" - .138")		
Step 3	Width Tolerance (Circle one)	+/- 0.025mm (+/- 0.001")	+/- 0.013mm (+/- 0.0005")
Step 4	Radius (R) 0.2mm - 0.4mm (.008" - .016")		
Step 5	Grade (Circle one)	BN2000 (General Purpose)	BNC30G (Interrupted)

1 _____
Distributor Name

2 _____
Contact Name

3 _____
Email Address

4 _____
Enduser Name

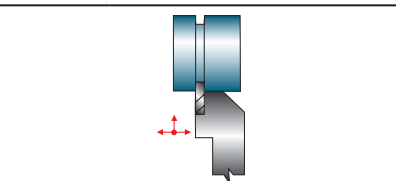
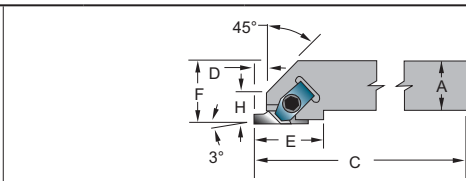
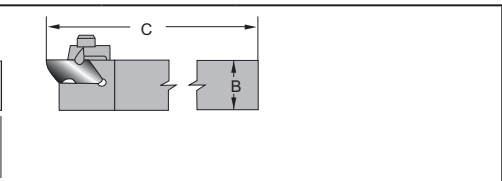
Fax Request for Quote to:
847-635-9335

Step 6 X _____
Customer Approval

_____ Date

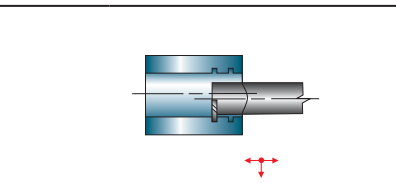
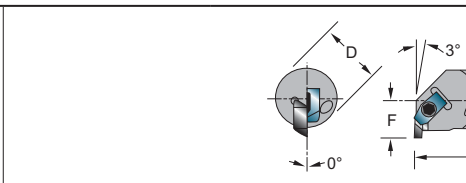
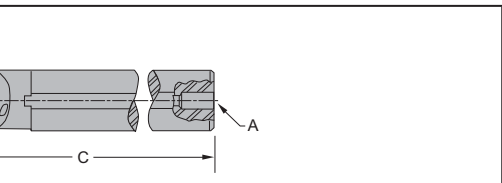
Also from Sumitomo: more CBN Grooving for your existing system*

SUMINOTCH TOOL HOLDERS

Sumitomo Cat. #		Gage Insert		A	B	C	D	E	F	H	R.H. Clamp	L.H. Clamp	Clamp Screw
Right Hand	Left Hand	R.H.	L.H.										
SSR-82V	SSL-82V	SG-2R	SG-2L	.500	.500	3.500	.140	1.25	.750	.50	TF-74	TF-75	S-310
SSR-102B	SSL-102B	SG-2R	SG-2L	.625	.625	4.500	.140	1.25	1.000	.50	TF-74	TF-75	S-310
SSR-122B	SSL-122B	SG-2R	SG-2L	.750	.750	4.500	.140	1.25	1.000	.50	TF-74	TF-75	S-310
SSR-162C	SSL-162C	SG-2R	SG-2L	1.000	1.000	5.000	.140	1.25	1.250	.50	TF-74	TF-75	S-310
SSR-123A	SSL-123A	SG-3R	SG-3L	.750	.750	4.000	.210	1.25	1.000	.50	TF72	TF-73	S-412
SSR-123B	SSL-123B	SG-3R	SG-3L	.750	.750	4.500	.210	1.25	1.000	.50	TF72	TF-73	S-412
SSR-163C	SSL-163C	SG-3R	SG-3L	1.000	1.000	5.000	.210	1.25	1.250	.50	TF72	TF-73	S-412
SSR-163D	SSL-163D	SG-3R	SG-3L	1.000	1.000	6.000	.210	1.25	1.250	.50	TF72	TF-73	S-412
SSR-853D	SSL-853D	SG-3R	SG-3L	1.000	1.000	6.000	.210	1.25	1.500	.50	TF72	TF-73	S-412
SSR-203D	SSL-203D	SG-3R	SG-3L	1.250	1.250	6.000	.210	1.25	1.500	.50	TF72	TF-73	S-412

SUMINOTCH BORING BARS

Sumitomo Cat. #		Gage Insert		D	C	F	Min. Bore	A	R.H. Clamp	L.H. Clamp	Clamp Screw
Right Hand	Left Hand	R.H.	L.H.								
A08-SER2	A08-SEL2	SG-2R	SG-2L	.500	8.000	.437	.730	1/4-18 NPT	TF-74	TF-75	S-310
A10-SER2	A10-SEL2	SG-2R	SG-2L	.625	10.000	.500	1.000	1/4-18 NPT	TF-74	TF-75	S-310
A12-SER2	A12-SEL2	SG-2R	SG-2L	.750	10.000	.562	1.125	1/4-18 NPT	TF-74	TF-75	S-310
A16-SER2	A16-SEL2	SG-2R	SG-2L	1.000	12.000	.688	1.375	1/4-18 NPT	TF-74	TF-75	S-310
A16-SER3	A16-SEL3	SG-3R	SG-3L	1.000	12.000	.688	1.375	1/4-18 NPT	TF72	TF-73	S-412
A20-SER3	A20-SEL3	SG-3R	SG-3L	1.250	14.000	.875	1.750	1/4-18 NPT	TF72	TF-73	S-412
A24-SER3	A24-SEL3	SG-3R	SG-3L	1.500	14.000	1.000	2.000	1/4-18 NPT	TF72	TF-73	S-412

SUMINOTCH GROOVING INSERTS

Right		Dimensions (in)							Left	
SG	CBN	W ±.001	R	E ±.001	T	A	B	Gage Dia.	SG	CBN
	BN2000									BN350
SG-3047R	•	.047	.005/.010	.075					SG-3047L	•
SG-3062R	•	.062	.005/.010	.094					SG-3062L	•
SG-3094R	•	.094	.005/.010	.150	.195	.344	.4050	.3750	SG-3094L	•
SG-3125R	•	.125	.005/.010	.150					SG-3125L	•
SG-3189R	•	.189	.020/.025	.150					SG-3189L	•

*SumiNotch is not included in the "Samples in a Snap" program

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