

Eco KORLOY Grooving Tool

EKGT



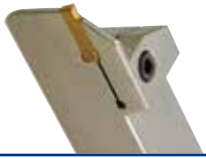
Multi-functional Machining with Strong Clamping System

- ▣ **Optimized Economical Grooving Tool**
- ▣ **Strong Clamping System**
Strong clamping system ensures stable and accurate machining
- ▣ **Wide Selection of Chip Breakers**
Wide selection of chip breakers ensures excellent chip control in various applications



Improved Stability and Performance by Strong Clamping

Economical Multi-functional Grooving Tool for High Precision Machining



EKGT



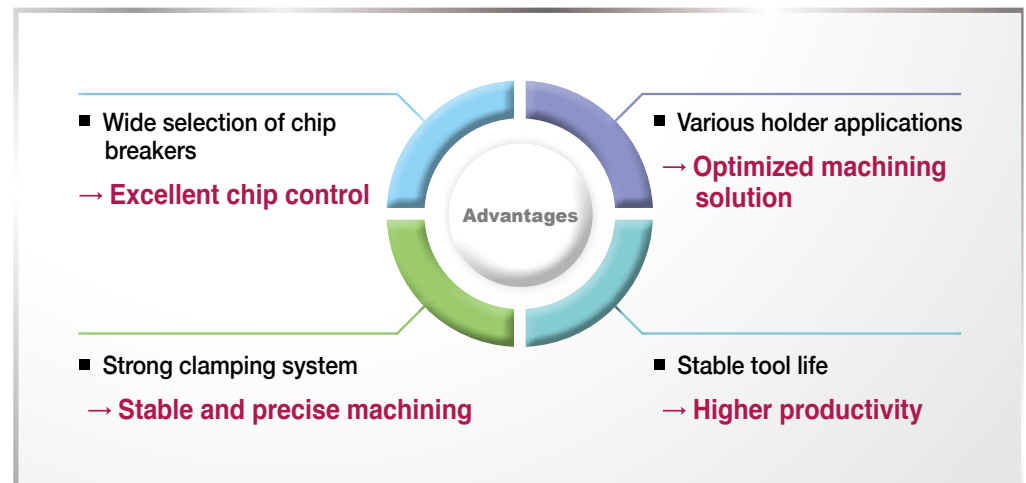
Insert

Cutting and grooving speeds are getting faster to improve productivity while higher machining quality is required to optimize the process. It was difficult to meet these requirements as the thin and long shape of grooving inserts caused vibration and reduced chip evacuation during operation, which resulted in early wear or breakage of tools.

The **EKGT** has an excellent 'V' type clamping system and a serrated shape on the clamping area so that it effectively minimizes vibrations. This results in improved stability and performance for highly efficient machining.

EKGT holders provide a total tooling solution with a wide selection for external / internal diameter machining, parting off, copying, auto lathes and relief machining.

KGT chip breakers are ready for a variety of workpieces and a wide application area with its characteristics of excellent chip evacuation for quality surface finish and high precision.



⇒ Code System

[Insert]

KG	M	N	300	(S)	-	04	-	T
KG SYSTEM (KORLOY Grooving)	Tolerance M class G class	Hand N: Neutral R: Right L: Left I: Internal	Width of cutting edge 2.0~8.0 mm	1 Corner		Nose radius 0.2 mm 0.3 mm 0.4 mm 0.8 mm		Chip breaker L/R/T/C/ LP/RP/B/A

[Holder]

EG	E	H	R/L	2525	-	3	-	T20
EG SYSTEM (Eco KORLOY Grooving)	Working style E: External process I: Internal process	Holder style H: Horizontal V: Vertical U: Undercut	Hand R: Right L: Left	Shank standard Height 25mm Width 25mm (For Internal machining: Minimum diameter for machining)		Cutting width 2.0~8.0 mm		Maximum depth 8~36 mm

➔ Recommended Insert

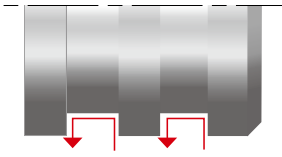
Designation	Geometry	Picture	Application							
			For external machining			For Internal machining		Copying	For relief	Special machining
			Parting	Grooving	Turning	Grooving	Turning	Copying	Relief	Special
KGMN	L Light Grooving		○	◎						
	R Rough Grooving		○	◎						
	T Turning-Multi Grooving		○	◎	◎					
KGMI	T Internal Grooving					◎	◎			
KRMN	C Copying							◎	◎	
KGMR/L	LP Light Parting		◎							
	RP Rough Parting		◎							
KGGN	B Blank			○						◎
	A Aluminum Grooving		○	◎	○					
KRGN	A Aluminum Profiling							◎	◎	

◎ First choice, ○ Second choice

➔ Grades for Recommended Application Range

Workpiece	Grade	Order of recommended grade	Recommended cutting speed (m/min)						
			50	100	150	200	800		
P Steel	PC5300	1		70	120				
	NC3225	2			130	220			
	NC5330	3			120	200			
	Alloy steel	PC5300	1		60	105			
		NC3225	2			130	200		
		NC5330	3			90	180		
M Stainless steel	PC5300	1		70	120				
	PC9030	2		70	115				
	NC5330	3		75	125				
K Cast iron	PC5300	1		55	90				
	NC5330	2			95	160			
N Non-ferrous metal	H01	1				200	790		
S HRSA	PC5300	1	20	35					

Performance Evaluation



Turning+Grooving repetition

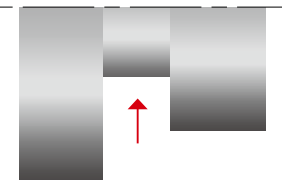
Multi-function machining

- Workpiece C45
- Cutting conditions vc (m/min) = 170, fz (mm/t) = 0.15, ap (mm) = 2, W (mm) = 3, wet
- Tool KGMN300-04-T (PC5300)

EKGT 210ea/edge
Competitor 160ea/edge



➔ Optimized geometry for turning+grooving - High efficiency.



Shoulder Grooving

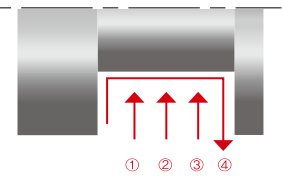
Grooving

- Workpiece X5CrNi18-9
- Cutting conditions vc (m/min) = 120, fz (mm/t) = 0.12, ap (mm) = 5, W (mm) = 4, wet
- Tool KGMN400-03-R (PC5300)

EKGT 200ea/edge
Competitor 150ea/edge



➔ Tough geometry for interrupted and deep grooving.



Grooving (Roughing)
&Turning (Finishing)

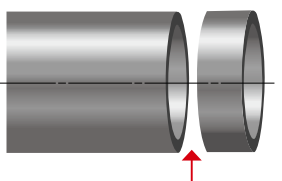
Shaft machining

- Workpiece 42CrM04
- Cutting conditions vc (m/min) = 150, fz (mm/t) = 0.15, ap (mm) = 5, W (mm) = 3x3, wet
- Tool KGMN300-04-T (PC5300)

EKGT 104ea/edge
Competitor 80ea/edge



➔ Excellent chip control for higher efficiency.



Pipe Parting-off

Parting off

- Workpiece X5CrNi18-9
- Cutting conditions vc (m/min) = 140, fz (mm/t) = 0.15, ap (mm) = 2, W (mm) = 3, wet
- Tool KGMR300-6D-LP (PC5300)


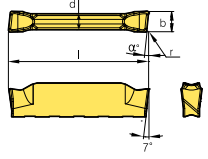

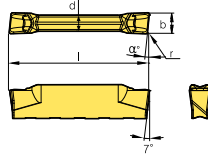

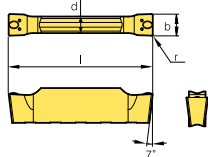

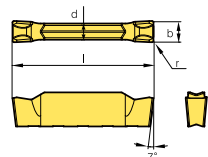

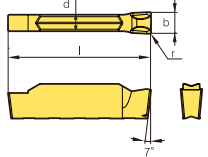

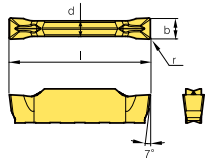

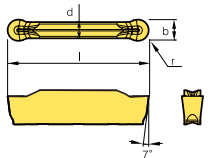
EKGT 800ea/edge
Competitor 550ea/edge



➔ Exclusive parting-off chip breaker for longer tool life.
Sharp geometry for less burr.

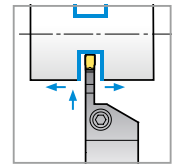
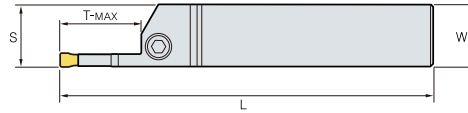
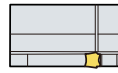
Application	Picture	Designation	Coated					Dimensions (mm)					Figure	
			NC3215	NC3225	NC5330	PC5300	PC9030	b	r	l	d	α°		
Grooving		KGMN	200-02-L	●	●	●	●	●	2.0	0.2	20	1.7	-	
			300-02-L	●	●	●	●	●	3.0	0.2	20	2.3	-	
			400-02-L	●	●	●	●	●	4.0	0.2	20	3.3	-	
			500-03-L	●	●	●	●	●	5.0	0.3	25	4.1	-	
			600-03-L	●	●	●	●	●	6.0	0.3	25	5.1	-	
Grooving · Parting off		KGMN	150-015-R	●	●	●	●	●	1.5	0.15	16	1.2	-	
			200-02-R	●	●	●	●	●	2.0	0.2	20	1.7	-	
			300-02-R	●	●	●	●	●	3.0	0.2	20	2.3	-	
			400-03-R	●	●	●	●	●	4.0	0.3	20	3.3	-	
			500-03-R	●	●	●	●	●	5.0	0.3	25	4.1	-	
			600-03-R	●	●	●	●	●	6.0	0.3	25	5.1	-	
			800-04-R	●	●	●	●	●	8.0	0.4	30	6.1	-	
Grooving · Turning		KGMN	150-015-T	●	●	●	●	●	1.5	0.15	16	1.2	-	
			200-02-T	●	●	●	●	●	2.0	0.2	20	1.7	-	
			250-02-T	●	●	●	●	●	2.5	0.2	20	2.0	-	
			300-02-T	●	●	●	●	●	3.0	0.2	20	2.3	-	
			300-04-T	●	●	●	●	●	3.0	0.4	20	2.3	-	
			400-04-T	●	●	●	●	●	4.0	0.4	20	3.3	-	
			400-08-T	●	●	●	●	●	4.0	0.8	20	3.3	-	
			500-04-T	●	●	●	●	●	5.0	0.4	25	4.1	-	
			500-08-T	●	●	●	●	●	5.0	0.8	25	4.1	-	
			600-04-T	●	●	●	●	●	6.0	0.4	25	5.1	-	
			600-08-T	●	●	●	●	●	6.0	0.8	25	5.1	-	
Profiling		KRMN	200-C	●	●	●	●	●	2.0	1.0	20	1.7	-	
			300-C	●	●	●	●	●	3.0	1.5	20	2.2	-	
			400-C	●	●	●	●	●	4.0	2.0	20	3.2	-	
			500-C	●	●	●	●	●	5.0	2.5	25	4.0	-	
			600-C	●	●	●	●	●	6.0	3.0	25	5.0	-	
			800-C	●	●	●	●	●	8.0	4.0	30	6.0	-	
Grooving · Internal		KGMI	200-02-T	●	●	●	●	●	2.0	0.2	20	1.7	-	
			300-04-T	●	●	●	●	●	3.0	0.4	20	2.3	-	
			400-04-T	●	●	●	●	●	4.0	0.4	20	3.3	-	
Parting off (Right handed)		KGMR	200-6D-LP	●	●	●	●	●	2.0	0.2	20	1.7	6	
			200-8D-LP	●	●	●	●	●	2.0	0.2	20	1.7	8	
			200-15D-LP	●	●	●	●	●	2.0	0.2	20	1.7	15	
			300-6D-LP	●	●	●	●	●	3.0	0.2	20	2.3	6	
			300-15D-LP	●	●	●	●	●	3.0	0.2	20	2.3	15	
			400-4D-LP	●	●	●	●	●	4.0	0.3	20	3.3	4	
			400-15D-LP	●	●	●	●	●	4.0	0.3	20	3.3	15	
			500-4D-LP	●	●	●	●	●	5.0	0.3	25	4.1	4	
Parting off (Right handed)		KGMR	200-6D-RP	●	●	●	●	●	2.0	0.2	20	1.7	6	
			200-8D-RP	●	●	●	●	●	2.0	0.2	20	1.7	8	
			200-15D-RP	●	●	●	●	●	2.0	0.2	20	1.7	15	
			300-6D-RP	●	●	●	●	●	3.0	0.2	20	2.3	6	
			300-15D-RP	●	●	●	●	●	3.0	0.2	20	2.3	15	
			400-4D-RP	●	●	●	●	●	4.0	0.3	20	3.3	4	
			400-15D-RP	●	●	●	●	●	4.0	0.3	20	3.3	15	
			500-4D-RP	●	●	●	●	●	5.0	0.3	25	4.1	4	

●: Stock item

Application	Picture	Designation		Coated		Uncoated		Dimensions (mm)					Figure		
				NC3215	NC5330	PC5300	PC9030	H01	H05	b	r	l		d	α°
Parting off (Left handed)		KGML	200-6D-LP						2.0	0.2	20	1.7	6		
			200-15D-LP						2.0	0.2	20	1.7	15		
			300-6D-LP						3.0	0.2	20	2.3	6		
			300-15D-LP						3.0	0.2	20	2.3	15		
			400-4D-LP						4.0	0.2	20	3.3	4		
			400-15D-LP						4.0	0.2	20	3.3	15		
Parting off (Left handed)		KGML	200-6D-RP						2.0	0.2	20	1.7	6		
			200-15D-RP						2.0	0.2	20	1.7	15		
			300-6D-RP						3.0	0.2	20	2.3	6		
			300-15D-RP						3.0	0.2	20	2.3	15		
			400-4D-RP						4.0	0.2	20	3.3	4		
			400-15D-RP						4.0	0.2	20	3.3	15		
Grooving (Ground insert)		KGGN	265-015-B						2.65	0.15	20	2.3	-		
			300-020-B						3.0	0.20	20	2.3	-		
			300-040-B						3.0	0.40	20	2.3	-		
			315-015-B						3.15	0.15	20	2.3	-		
			400-040-B						4.0	0.40	20	3.3	-		
			400-080-B						4.0	0.80	20	3.3	-		
			415-015-B						4.15	0.15	20	3.3	-		
			478-055-B						4.78	0.55	20	3.3	-		
			500-080-B						5.0	0.80	25	4.1	-		
			515-015-B						5.15	0.15	25	4.1	-		
			600-080-B						6.0	0.80	25	5.1	-		
			600-120-B						6.0	1.20	25	5.1	-		
			800-080-B						8.0	0.80	30	6.1	-		
			800-120-B						8.0	1.20	30	6.1	-		
Grooving · Parting off (Ground insert)		KGGN	200-02-R						2.0	0.2	20	1.7	-		
			300-02-R						3.0	0.2	20	2.3	-		
			400-03-R						4.0	0.3	20	3.3	-		
			500-03-R						5.0	0.3	25	4.1	-		
			600-03-R						6.0	0.3	25	5.1	-		
			800-04-R						8.0	0.4	30	6.1	-		
Grooving · Parting off (Single insert)		KGGN	200S-02-R	●					2.0	0.2	19.9	1.7	-		
			300S-02-R	●					3.0	0.2	19.9	2.3	-		
			400S-03-R	●					4.0	0.3	19.9	3.3	-		
			500S-03-R	●					5.0	0.3	24.9	4.1	-		
			600S-03-R	●					6.0	0.3	24.9	5.1	-		
			800S-04-R	●					8.0	0.4	24.9	6.1	-		
Aluminum Grooving		KGGN	200-02-A				●		2.0	0.2	20	1.7	-		
			300-02-A					●		3.0	0.2	20	2.3		-
			400-04-A					●		4.0	0.4	20	3.3		-
			500-04-A					●		5.0	0.4	25	4.1		-
			600-04-A					●		6.0	0.4	25	5.1		-
Aluminum Profiling		KRGN	300-A				●		3.0	1.5	20	2.3	-		
			400-A					●		4.0	2.0	20	3.3		-
			500-A					●		5.0	2.5	25	4.1		-
			600-A					●		6.0	3.0	25	5.1		-
			800-A					●		8.0	4.0	30	6.1		-

●: Stock item

• For grooving, turning, parting off, and relief machining



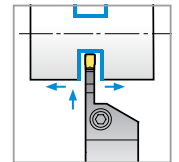
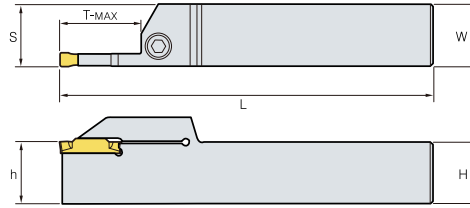
R type insert

KGGN KGMN
KGMR/L KRMN KRGN

(mm)

Designation		H=(h)	W	L	S	T-MAX	Insert	Screw	Wrench
EGEHR/L	1616-1.5-T14	16	16	100	16.20	14	KGMN150-□-□	EKS0512	EKW40L
	2020-1.5-T14	20	20	125	20.20	14			
	2525-1.5-T14	25	25	150	25.20	14			
	1616-2-T14	16	16	100	16.25	14	KGMN200-□-□ KGMR/L200-□-□ KRMN200-C KGGN200-□-□	EKS0512	EKW40L
	2020-2-T14	20	20	125	20.25	14			
	2525-2-T14	25	25	150	25.25	14			
	1616-2.5-T16	16	16	100	16.30	16			
	2020-2.5-T16	20	20	125	20.30	16	KRMN250-C KGGN250-□-□ KGMN250-□-□	EKS0616	EKW50L
	2525-2.5-T16	25	25	150	25.30	16			
	1616-3-T18	16	16	100	16.35	18			
	2020-3-T10	20	20	125	20.40	10	KGMN300-□-□ KGMR/L300-□-□ KRMN300-C KGGN300-□-□ KRGN300-□	EKS0616	EKW50L
	2020-3-T13	20	20	125	20.40	13			
	2020-3-T20	20	20	125	20.40	20			
	2525-3-T10	25	25	150	25.40	10			
	2525-3-T13	25	25	150	25.40	13			
	2525-3-T20	25	25	150	25.40	20			
	2525-3-T25	25	25	150	25.40	25			
	3232-3-T10	32	32	170	32.40	10			
	3232-3-T13	32	32	170	32.40	13			
	3232-3-T20	32	32	170	32.40	20			
	2020-4-T10	20	20	125	20.40	10	KGMN400-□-□ KGMR/L400-□-□ KRMN400-C KGGN400-□-□ KRGN400-□	EKS0616	EKW50L
	2020-4-T15	20	20	125	20.40	15			
	2020-4-T20	20	20	125	20.40	20			
	2020-4-T25	20	20	125	20.40	25			
	2525-4-T10	25	25	150	25.40	10			
	2525-4-T15	25	25	150	25.40	15			
	2525-4-T20	25	25	150	25.40	20			
	2525-4-T25	25	25	150	25.40	25			
	3232-4-T10	32	32	170	32.40	10			
	3232-4-T18	32	32	170	32.40	18			

• For grooving, turning, parting off, and relief machining



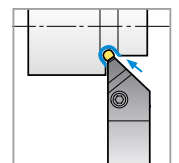
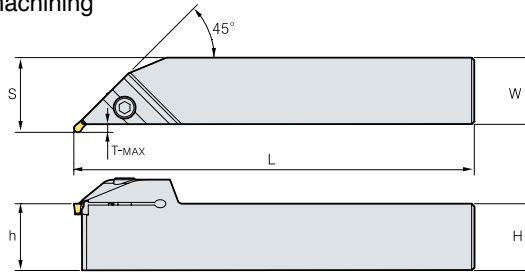
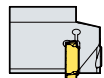
R type insert

KGGN KGMN
KGMR/L KRMN KRGN

(mm)

Designation	H=(h)	W	L	S	T-MAX	Insert	Screw	Wrench	
EGEHR/L	2020-5-T15	20	20	125	20.5	15	KGMN500-□-□ KRMN500-C KGGN500-□-□ KRGN500-□	EKS0616	EKW50L
	2020-5-T23	20	20	125	20.5	23			
	2525-5-T15	25	25	150	25.5	15			
	2525-5-T23	25	25	150	25.5	23			
	2525-5-T32	25	25	150	25.5	32			
	3232-5-T15	32	32	170	32.5	15			
	3232-5-T23	32	32	170	32.5	23			
EGEHR/L	2020-6-T15	20	20	125	20.6	15	KGMN600-□-□ KRMN600-C KGGN600-□-□ KRGN600-□	EKS0616	EKW50L
	2020-6-T23	20	20	125	20.6	23			
	2525-6-T15	25	25	150	25.6	15			
	2525-6-T23	25	25	150	25.6	23			
	2525-6-T32	25	25	150	25.6	32			
	3232-6-T15	32	32	170	32.6	15			
	3232-6-T23	32	32	170	32.6	23			
EGEHR/L	2525-8-T15	25	25	150	26.1	15	KGMN800-□-□ KRMN800-C KGGN800-□-□ KRGN800-□	EKS0616	EKW50L
	2525-8-T28	25	25	150	26.1	28			
	3232-8-T15	32	32	170	33.1	16			
	3232-8-T28	32	32	170	33.1	28			

• For relief machining



R type insert

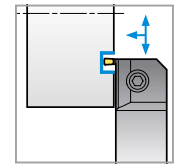
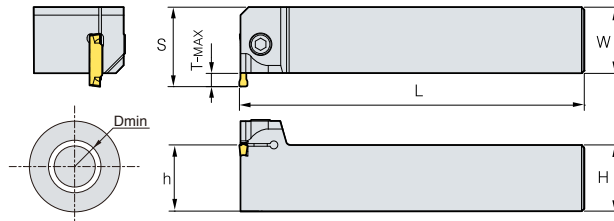
KRMN KRGN

(mm)

Designation	H=(h)	W	L	S	ØD Max	T-MAX	Insert	Screw	Wrench
EGEUR/L	2020-3	20	20	125	23	40	KRMN300-C KRGN300-□	EKS0616	EKW50L
	2525-3	25	25	150	28	40			
	3232-3	32	32	170	35	40			
EGEUR/L	2020-4	20	20	125	23	40	KRMN400-C KRGN400-□	EKS0616	EKW50L
	2525-4	25	25	150	28	40			
	3232-4	32	32	170	35	40			
EGEUR/L	2020-5	20	20	125	24	50	KRMN500-C KRGN500-□	EKS0616	EKW50L
	2525-5	25	25	150	29	50			
	3232-5	32	32	170	36	50			
EGEUR/L	2020-6	20	20	125	24	50	KRMN600-C KRGN600-□	EKS0616	EKW50L
	2525-6	25	25	150	29	50			
	3232-6	32	32	170	36	50			
EGEUR/L	2525-8	25	25	150	30	65	KRMN800-C KRGN800-□	EKS0616	EKW50L
	3232-8	32	32	170	37	65			



KGMM KRMN
KGGN KRGN

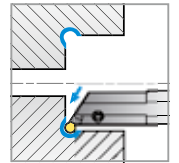
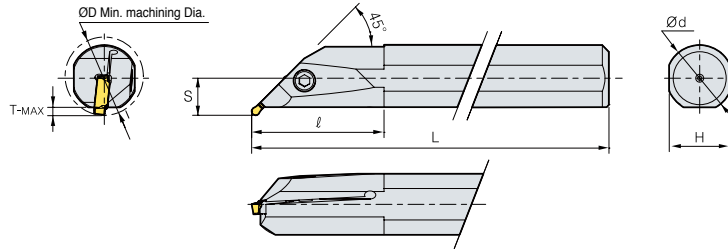


R type insert

(mm)

Designation	H=(h)	W	L	S	ØD Min	T-MAX	Insert	Screw	Wrench	
EGEVR/L	2020-1.5	20	20	125	23	85	3	KGMM150-□-□	EKS0512	EKW40L
	2525-1.5	25	25	150	28	85	3			
	3232-1.5	32	32	170	35	85	3			
	2020-2	20	20	125	23.5	65	3.5	KGMM200-□-□ KRMN200-C KGGN200-□-□	EKS0512	EKW40L
	2525-2	25	25	150	28.5	65	3.5			
	3232-2	32	32	170	35.5	65	3.5			
	2020-2.5	20	20	125	24	65	4	KGMM250-□-□	EKS0512	EKW40L
	2525-2.5	25	25	150	29	65	4			
	3232-2.5	32	32	170	36	65	4			
	2020-3	20	20	125	25.5	75	5	KGMM300-□-□ KRMN300-C KGGN300-□-□ KRGN300-□	EKS0616	EKW50L
	2525-3	25	25	150	30.5	75	5			
	3232-3	32	32	170	37.5	75	5			
	2020-4	20	20	125	25.5	70	5	KGMM400-□-□ KRMN400-C KGGN400-□-□ KRGN400-□	EKS0616	EKW50L
	2525-4	25	25	150	30.5	70	5			
	3232-4	32	32	170	37.5	70	5			
	2020-5	20	20	125	27	75	7	KGMM500-□-□ KRMN500-C KGGN500-□-□ KRGN500-□	EKS0616	EKW50L
	2525-5	25	25	150	32	75	7			
	3232-5	32	32	170	39	75	7			
	2020-6	20	20	125	27	70	7	KGMM600-□-□ KRMN600-C KGGN600-□-□ KRGN600-□	EKS0616	EKW50L
	2525-6	25	25	150	32	70	7			
3232-6	32	32	170	39	70	7				
2525-8	25	25	150	34	50	9	KGMM800-□-□ KRMN800-C KGGN800-□-□ KRGN800-□	EKS0616	EKW50L	
3232-8	32	32	170	41	50	9				

• For relief machining



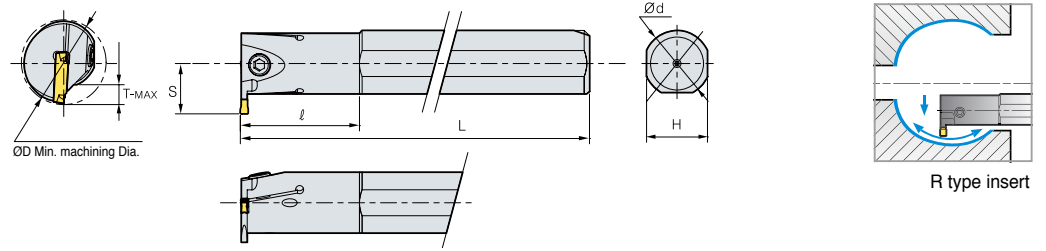
R type insert

KRMN KRGN

(mm)

Designation		ØD	Ød	L	Q	T-MAX	H	S	Insert	Screw	Wrench
EGIURL	3520-3	35	20	150	45	3.5	18	13.0	KRMN300-C KRGN300-□	EKS0616	EKW50L
	4025-3	40	25	200	45	3.5	23	15.5			
	5032-3	50	32	250	65	3.5	30	19.0			
	3520-4	35	20	150	45	3.5	18	13.0	KRMN400-C KRGN400-□	EKS0616	EKW50L
	4025-4	40	25	200	45	3.5	23	15.5			
	5032-4	50	32	250	65	3.5	30	19.0			
	4025-5	40	25	200	45	3.5	23	15.5	KRMN500-C KRGN500-□	EKS0616	EKW50L
	5032-5	50	32	250	65	3.5	30	19.0			
	4025-6	40	25	200	45	3.5	23	19.0	KRMN600-C KRGN600-□	EKS0616	EKW50L
	5032-6	50	32	250	65	3.5	30	19.0			
	4025-8	40	25	200	45	6.5	23	15.5	KRMN800-C KRGN800-□	EKS0616	EKW50L
	5032-8	50	32	250	65	6.5	30	19.0			

• For grooving, turning, profiling machining



KGMI KGMN

(mm)

Designation	ØD	Ød	L	ℓ	T-MAX	H	S	Insert	Screw	Wrench	
EGIVR/L	2520-1.5	25	20	150	45	3.5	18	13.1	KGMN150-□-□	EKS0512	EKW40L
	2925-1.5	29	25	200	45	3.5	23	16.2			
	2516-2	25	16	125	35	6.5	15	14.0	KGMI200-□-□	EKS0512	EKW40L
	2520-2	25	20	150	45	4.5	18	14.0			
	2925-2	29	25	200	45	4.5	23	17.2			
	3225-2	32	25	200	45	7	23	19.4			
	2520-2.5	25	20	150	45	4.5	18	15.1	KGMN250-□-□	EKS0512	EKW40L
	2925-2.5	29	25	200	45	4.5	23	17.2			
	2520-3	25	20	150	45	5	18	15.6	KGMI300-□-□	EKS0616	EKW50L
	3225-3	32	25	200	45	6	23	19.4			
	3732-3	37	32	250	65	6	30	21.5			
	4032-3	40	32	250	55	7.5	30	22.5			
	2520-4	25	20	150	45	6	18	15.6	KGMI400-□-□	EKS0616	EKW50L
	3225-4	32	25	200	45	6	23	19.4			
	3732-4	37	32	250	65	6	30	21.5			
	4032-4	40	32	250	55	7.5	30	22.5			
	3225-5	32	25	200	45	8	23	19.9	KGMI500-□-□	EKS0616	EKW50L
	3732-5	37	32	250	65	8	30	22.5			
	3225-6	32	25	200	45	8	23	19.9	KGMN600-□-□	EKS0616	EKW50L
	3732-6	37	32	250	65	8	30	22.5			
3732-8	37	32	250	65	10	30	23.5	KGMN800-□-□	EKS0616	EKW50L	
4540-8	45	40	300	70	10	37	27.2				

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