



CATALOG

GTS-Precision Tools
PCBN Tool Product Manual



T C C G W 12
Table 0 Table 1 Table 2 Table 3 Table 4 Table 5

CBN Insert model

1-Insert Shape

Mark	Blade Shape	
C	Lozenge	
D		
V		
S	Square	
T	Positive Triangle	
R	Rotundity	
W	Iso-Angle Hexagon	

2-Back Corner

Mark	The Back Corner
B	
C	
N	
P	
O	Other

The band indicates that there are also cases where 10 degrees are used

0-Overall

Mark	Overall
T	One-on-one
	Welded
Z	Composite

4-Hole Type

Mark	Hole Type	
N	No holes	
A	Cylinder holes	
B	One-sided inclination cylinder hole	
W		
T		
C	Double-sided inclination cylinder hole	
Q		
X	Special	

02 04 W D 00 1
Table 6 Table 7 Table 8 Table 9 Table 10 Table 11

3-Tip Height Allows Tolerances

Mark	High Tip Allows Tolerances	The Inner Cut Circle Allows Tolerances	The Thickness Allows Tolerances
A	±0.005	±0.025	±0.025
F	±0.005	±0.013	±0.025
C	±0.013	±0.025	±0.025
H	±0.013	±0.013	±0.025
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
M	±0.08~±0.2	±0.05~±0.15	±0.13

6-Thickness

Mark	Thickness
01	1.59
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76
05	5.56
06	6.35
07	7.94
09	9.52

5-Cut Round

Shape	Mark	Long Cutting Edge	Inscribed Circle	Shape	Mark	Long Cutting Edge	Inscribed Circle	Shape	Mark	Long Cutting Edge	Inscribed Circle			
	C	05	5.64	5.56		S	05	5.56	5.56		R	08	8	8
		06	6.4	6.35			06	6.35	6.35			10	10	10
		08	8	7.94			08	7.94	7.94			12	12	12
		09	9.7	9.525			09	9.525	9.525			12	12.7	12.7
		12	12.9	12.7			12	12.7	12.7			15	15.875	15.875
		16	16.1	15.875			15	15.875	15.875			16	16	16
		19	19.3	19.05			19	19.05	19.05			19	19.05	19.05
	D	07	7.7	6.35		T	06	6.9	3.97		W	04	4.3	6.35
		09	9.7	7.94			08	8.2	4.76			05	5.4	7.94
		11	11.6	9.525			09	9.6	5.56			06	6.5	9.525
		15	15.5	12.7			11	11	6.35			08	8.7	12.7
	V	08	8.3	4.76							10	10.9	15.875	
		09	9.7	5.56										
		11	11.1	6.35										
		16	16.6	9.525										

7-Tip Arc

Mark	Knife Tip Arc
00	0
01	0.1
02	0.2
04	0.4
08	0.8
10	1
12	1.2
16	1.6
24	2.4
M O	Round (metric)

8-Inverted Width

Mark	Size (mm)
U	0.1
V	0.15
W	0.2
X	0.25
Y	0.3
Z	0.35

9-Invert Angle

Mark	Angle
B	5°
P	10°
D	15°
E	20°
F	25°
G	30°

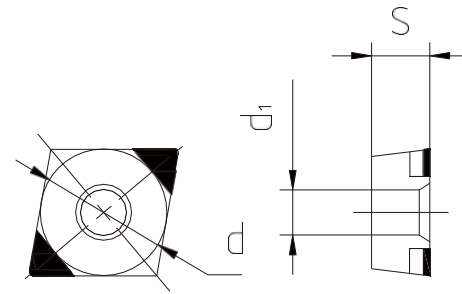
10-Passivation

Mark	Size
05	0.005
10	0.01
15	0.015
20	0.02
25	0.025

11-Number of Heads

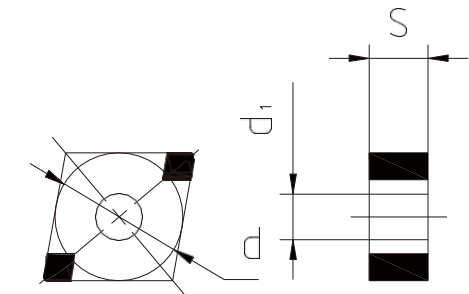
Mark	Number of Heads
1	1
2	2
3	3
4	4
6	6
8	8

CBN Tip Double Edge



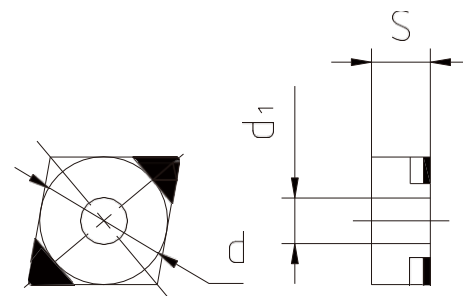
Model	Size			Material			
	d	S	d ₁	GT96S	GT90	GT70	GT50
CCGW060202VE10-2	6.35	2.38	2.8	●	●	●	●
CCGW060202WE10-2				●	●	●	●
CCGW060204VE10-2	6.35	2.38	2.8	●	●	●	●
CCGW060204WE10-2				●	●	●	●
CCGW09T302VE10-2	9.525	3.97	4.4	●	●	●	●
CCGW09T302WE10-2				●	●	●	●
CCGW09T304VE10-2	9.525	3.97	4.4	●	●	●	●
CCGW09T304WE10-2				●	●	●	●
CCGW09T308VE10-2	9.525	3.97	4.4	●	●	●	●
CCGW09T308WE10-2				●	●	●	●

CBN Tip and Four Edge



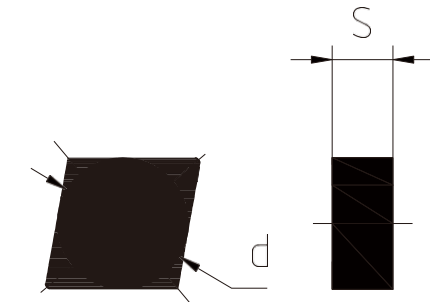
Model	Size			Material			
	d	S	d ₁	GT96S	GT90	GT70	GT50
CNGA 120404 VD10-4	12.7	4.76	5.16	●	●	●	●
CNGA 120404 VE10-4				●	●	●	●
CNGA 120408 VD10-4	12.7	4.76	5.16	●	●	●	●
CNGA 120408 VE10-4				●	●	●	●
CNGA 120412 VD10-4	12.7	4.76	5.16	●	●	●	●
CNGA 120412 VE10-4				●	●	●	●

CBN Tip Double Edge



Model	Size			Material			
	d	S	d ₁	GT96S	GT90	GT70	GT50
CNGA120404VD10-2	12.7	4.76	5.16	●	●	●	●
CNGA120404VE10-2				●	●	●	●
CNGA120408VD10-2	12.7	4.76	5.16	●	●	●	●
CNGA120408VE10-2				●	●	●	●
CNGA120412VD10-2	12.7	4.76	5.16	●	●	●	●
CNGA120412VE10-2				●	●	●	●

CBN Solid Insert



Model	Size		Material			
	d	S	GT96S	GT90	GT70	GT50
TCNGN090304VE10-4	9.525	3.18	●	●	●	●
TCNGN090304WE10-4			●	●	●	●
TCNGN090304XE10-4			●	●	●	●
TCNGN090308VE10-4	9.525	3.18	●	●	●	●
TCNGN090308WE10-4			●	●	●	●
TCNGN090308XE10-4			●	●	●	●
TCNGN090312VE10-4	9.525	3.18	●	●	●	●
TCNGN090312WE10-4			●	●	●	●
TCNGN090312XE10-4			●	●	●	●
TCNGN120408VE10-4	12.7	4.76	●	●	●	●
TCNGN120408WE10-4			●	●	●	●
TCNGN120408XE10-4			●	●	●	●
TCNGN120412VE10-4	12.7	4.76	●	●	●	●
TCNGN120412WE10-4			●	●	●	●
TCNGN120412XE10-4			●	●	●	●