

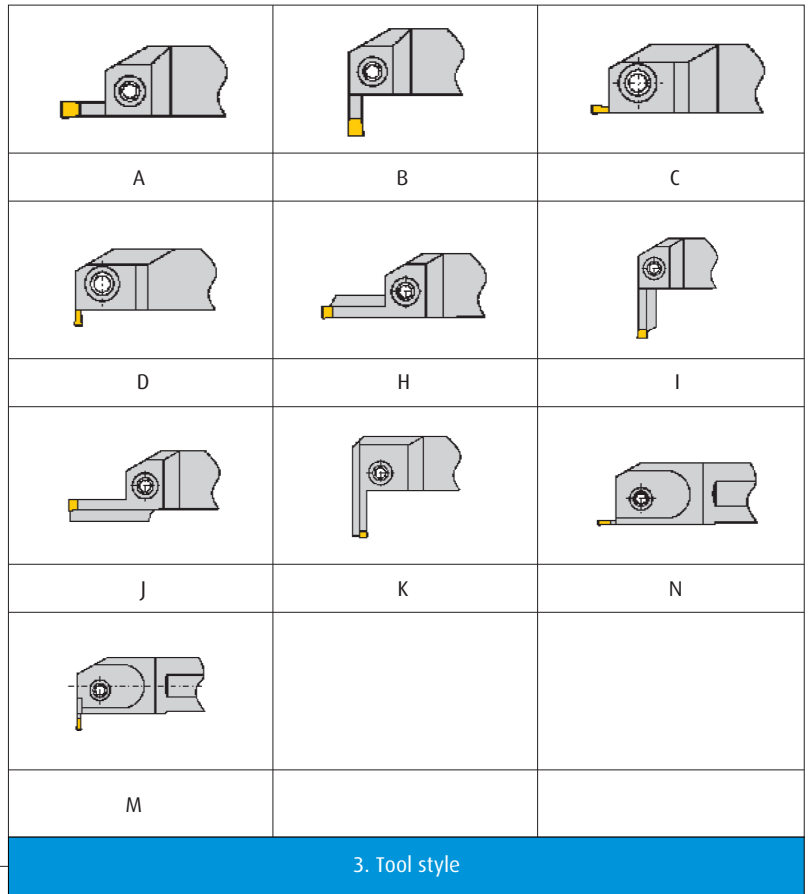
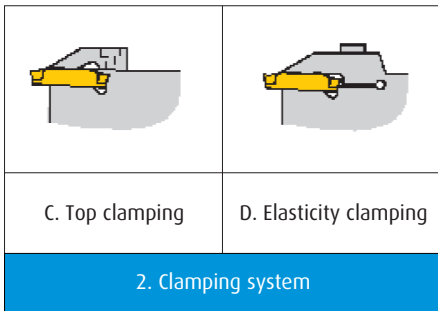
**GROOVING**

# CONTENT

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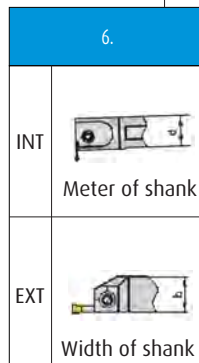
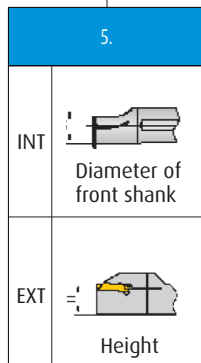
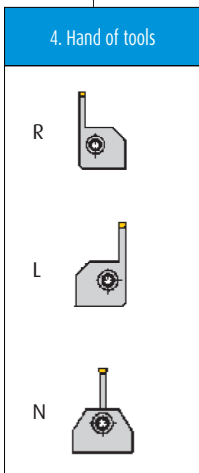
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Grooving Tools Code Key



1. Grooving tools

W	D	J	R	25	25	M	400	034	-	25
1	2	3	4	5	6	7	8	9	10	11



7. Tool length

Code	Length
E	70
F	80
H	100
K	125
M	150
P	170
Q	180
R	200
S	250
T	300

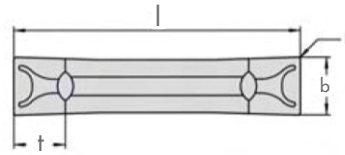
11. Max. depth of grooving

9. Min. diameter of the first pass  
Only for face grooving

8. Width of inserts

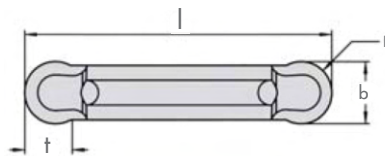


## Grooving Insert



WGFT Grooving Insert, Turning Insert

Diagram	Order No.	Size (mm)				
		b	r	l	d	t
	WGFT200	2.0	0.2	16.0	1.50	3.5
	WGFT250	2.5	0.2	18.5	2.0	3.85
	WGFT300	3.0	0.4	21.0	2.35	4.8
	WGFT400	4.0	0.4	21.0	3.3	4.8
	WGFT500	5.0	0.8	26.0	4.1	5.8
	WGFT600	6.0	0.8	26.0	5.0	5.8



WGRT Grooving Insert, Profile Turning Insert

Diagram	Order No.	Size (mm)				
		b	r	l	d	t
	WGRT200	2.0	1.0	16.0	1.50	3.5
	WGRT300	3.0	1.5	21.0	2.35	4.8
	WGRT400	4.0	2.0	21.0	3.3	4.8
	WGRT500	5.0	2.5	26.0	4.1	5.8

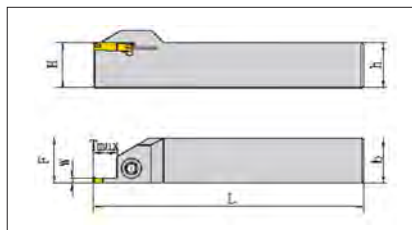
## Cutting Parameters

Material	Grade	Cutting speed (m/min)	Feed rate (mm/rev)
Carbon Steel	STL100	100~150	0.05~015
Alloy Steel	STL100	60~110	0.05~015
Cast iron	SSC100	110~130	0.05~015
Stainless Steel	SSC100	70~130	0.05~015
Aluminum Material	ALU100	150~200	0.10~0.20

## External Grooving Tools

WDAL/R

The illustration shows  
Right toolholder



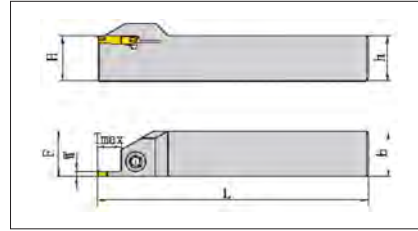
Order No.		Size (mm)							Insert	Screw	Wrench		
Left	Right	W	Tmax	h	b	H	F	L					
WDAL1616H200-08	WDAR1616H200-08	2	8	16	16	16	16.3	100	WGFT200	M5X16	S4		
WDAL2020K200-08	WDAR2020K200-08			20	20	20	20.3	125					
WDAL2525M200-08	WDAR2525M200-08			25	25	25	25.3	150					
WDAL1616H200-22	WDAR1616H200-22		22	16	16	16	16.3	100		M5X16	S4		
WDAL2020K200-22	WDAR2020K200-22			20	20	20	20.3	125					
WDAL2525M200-22	WDAR2525M200-22			25	25	25	25.3	150					
WDAL1616H250-10	WDAR1616H250-10	2.5	10	16	16	16	16.3	100	WGFT250	M5X16	S4		
WDAL2020K250-10	WDAR2020K250-10			20	20	20	20.3	125					
WDAL2525M250-10	WDAR2525M250-10			25	25	25	25.3	150					
WDAL1616H250-22	WDAR1616H250-22		22	16	16	16	16.3	100		M5X16	S4		
WDAL2020K250-22	WDAR2020K250-22			20	20	20	20.3	125					
WDAL2525M250-22	WDAR2525M250-22			25	25	25	25.3	150					
WDAL3225P250-22	WDAR3225P250-22			32	25	32	25.3	170			S5		
WDAL1616H300-10	WDAR1616H300-10	3	10	16	16	16	16.3	100	WGFT300	M5X16	S4		
WDAL2020K300-10	WDAR2020K300-10			20	20	20	20.3	125					
WDAL2525M300-10	WDAR2525M300-10			25	25	25	25.3	150					
WDAL3225P300-10	WDAR3225P300-10				32	25	32	25.3		170			S5
WDAL1616H300-22	WDAR1616H300-22		22	16	16	16	16.3	100		M5X16	S4		
WDAL2020K300-22	WDAR2020K300-22			20	20	20	20.3	125					
WDAL2525M300-22	WDAR2525 M300-22	25		25	25	25.3	150						
WDAL3225P300-22	WDAR3225P300-22			32	25	32	25.3	170			S5		
WDAL3232P300-22	WDAR3232P300-22			32	32	32	32.3	170			S6		
WDAL1616H400-13	WDAR1616H400-13	4	13	16	16	16	16.6	100	WGFT400	M5X16	S4		
WDAL2020K400-13	WDAR2020K400-13			20	20	20	20.6	125					
WDAL2525M400-13	WDAR2525M400-13			25	25	25	25.6	150					
WDAL3225P400-13	WDAR3225P400-13				32	25	32	25.6		170	M6X20	S5	
WDAL3232P400-13	WDAR3232P400-13				32	32	32	32.6		170			
WDAL4040R400-13	WDAR4040R400-13				40	40	40	40.6		200			
WDAL1616H400-25	WDAR1616H400-25	25	16	16	16	16.6	100	M5X16	S4				
WDAL2020K400-25	WDAR2020K400-25		20	20	20	20.6	125						



## External Grooving Tools

WDAL/R

The illustration shows  
Right toolholder

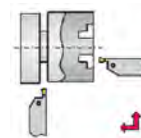
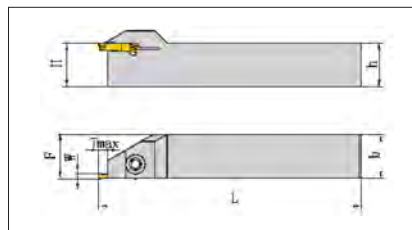


Order No.		Size (mm)							Insert	Screw	Wrench
Left	Right	W	Tmax	h	b	H	F	L			
WDAL2525M400-25	WDAR2525M400-25	4	25	25	25	25	25.6	150	WGFT400	M6X20	S5
WDAL3225P400-25	WDAR3225P400-25		25	32	25	32	25.6	170			
WDAL3232P400-25	WDAR3232P400-25		25	32	32	32	32.6	170			
WDAL4040R400-25	WDAR4040R400-25		25	40	40	40	40.6	200		M8X30	S6
WDAL2020K500-13	WDAR2020K500-13	5	13	20	20	20	20.6	125	WGFT500	M5X16	S4
WDAL2525M500-13	WDAR2525M500-13		13	25	25	25	25.6	150		M6X20	S5
WDAL3225P500-13	WDAR3225P500-13		13	32	25	32	25.6	170			
WDAL3232P500-13	WDAR3232P500-13		13	32	32	32	32.6	170		M8X30	S6
WDAL4040R500-13	WDAR4040R500-13		13	40	40	40	40.6	200		M5X16	S4
WDAL2020K500-25	WDAR2020K500-25		25	20	20	20	20.6	125			
WDAL2525M500-25	WDAR2525M500-25		25	25	25	25	25.6	150		M6X20	S5
WDAL3225P500-25	WDAR3225P500-25		25	32	25	32	25.6	170			
WDAL3232P500-25	WDAR3232P500-25		25	32	32	32	32.6	170		M8X30	S6
WDAL4040R500-25	WDAR4040R500-25		25	40	40	40	40.6	200			
WDAL2525M600-16	WDAR2525M600-16	6	16	25	25	25	25.6	150	WGFT600	M6X20	S5
WDAL3225P600-16	WDAR3225P600-16		16	32	25	32	25.6	170			
WDAL3232P600-16	WDAR3232P600-16		16	32	32	32	32.6	170		M8X30	S6
WDAL4040R600-16	WDAR4040R600-16		16	40	40	40	40.6	200			
WDAL2525M600-25	WDAR2525M600-25		25	25	25	25	25.6	150		M6X20	S5
WDAL3225P600-25	WDAR3225P600-25		25	32	25	32	25.6	170			
WDAL3232P600-25	WDAR3232P600-25		25	32	32	32	32.6	170		M8X30	S6
WDAL4040R600-25	WDAR4040R600-25		25	40	40	40	40.6	200			

## Shallow Grooving Tools

WDCL/R

The illustration shows  
Right toolholder



Order No.		Size (mm)								Insert	Screw	Wrench
Left	Right	W	Tmax	h	b	H	F	L	e			
WDCL1616H300-04	WDCR1616H300-04	2,25,3	4	16	16	16	16.3	100	30	WGFT200 WGFT250 WGFT300	M5X16	S4
WDCL2020K300-04	WDCR2020K300-04			20	20	20	20.3	125	30			
WDCL2525M300-04	WDCR2525M300-04			25	25	25	25.3	150	30			
WDCL3225P300-04	WDCR3225P300-04			32	25	32	25.3	170	30			
WDCL2525M600-06	WDCR2525M600-06	4,5,6	6	25	25	25	25.6	150	30	WGFT400 WGFT500 WGFT600	M6X20	S5
WDCL3225P600-06	WDCR3225P600-06			32	25	32	25.6	170	30			
WDCL3232P600-06	WDCR3232P600-06			32	32	32	32.6	170	30			
WDCL4040R600-06	WDCR4040R600-06			40	40	40	40.6	200	30			

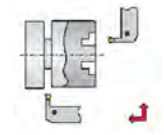
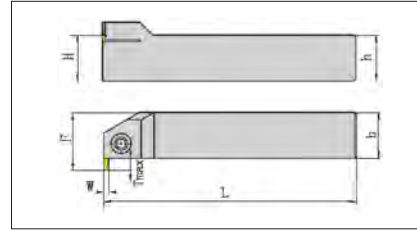
Order No. of toolholders and inserts for shallow face grooving		Diameter of the first pass(mm)		Max cutting depth (mm)	Diameter of the first pass
		Min	Max		
WDC*****300-04	WGFT200	65	∞	4	
	WGFT250	65	∞		
	WGFT300	60	∞		
WDC*****600-06	WGFT400	40	∞	6	
	WGFT500	40	∞		
	WGFT600	40	∞		



## Shallow Grooving Tools

WDDL/R

The illustration shows  
Right toolholder



Order No.		Size (mm)								Insert	Screw	Wrench
Left	Right	W	T <sub>max</sub>	h	b	H	F	L	e			
WDDL1616H300-04	WDDR1616H300-04	2,2,5,3	4	16	16	16	21	100	30	WGFT200 WGFT250 WGFT300	M5X16	S4
WDDL2020K300-04	WDDR2020K300-04			20	20	20	21	125	30			
WDDL2525M300-04	WDDR2525M300-04			25	25	25	26	150	30			
WDDL3225P300-04	WDDR3225P300-04	4,5,6	6	32	25	32	26	170	30	WGFT400 WGFT500 WGFT600	M6X20	S5
WDDL2525M600-06	WDDR2525M600-06			25	25	25	32	150	30			
WDDL3225P600-06	WDDR3225P600-06			32	25	32	26	170	30			
WDDL3232P600-06	WDDR3232P600-06			32	32	32	33	170	30			
WDDL4040R600-06	WDDR4040R600-06			40	40	40	41	200	30		M8X30	S6

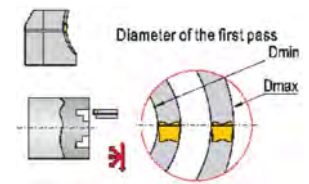
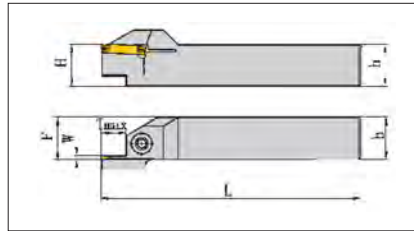
Order No. of toolholders and inserts for shallow face grooving		Diameter of the first pass(mm)		Max cutting depth (mm)	Diameter of the first pass
		Min	Max		
WDD*****300-04	WGFT200	65	∞	4	
	WGFT250	65	∞		
	WGFT300	60	∞		
WDD*****600-06	WGFT400	40	∞	6	
	WGFT500	40	∞		
	WGFT600	40	∞		



Face Grooving Tools

WDJL/R

The illustration shows  
Right toolholder



Order No.		Size (mm)									Insert	Screw	Wrench				
Left	Right	W	Tmax	Dmin-max	h	b	H	F	L								
WDJL2020K300054-19	WDJR2020K300054-19	3	19	54-75	20	20	20		125	WGFT300	M5X18	S4					
WDJL2020K300067-22	WDJR2020K300067-22		22	67-100													
WDJL2020K300090-22	WDJR2020K300090-22		22	90-160													
WDJL2020K300130-22	WDJR2020K300130-22			130-300	25	25	25	20.3	150		M6X20	S5					
WDJL2525M300034-12	WDJR2525M300034-12		12	34-44													
WDJL2525M300038-12	WDJR2525M300038-12		12	38-48													
WDJL2525M300042-19	WDJR2525M300042-19		19	42-60													
WDJL2525M300054-19	WDJR2525M300054-19		19	54-75													
WDJL2525M300067-22	WDJR2525M300067-22		22	67-100													
WDJL2525M300090-22	WDJR2525M300090-22		22	90-160	32	32	32	32.3	170		M8X30	S6					
WDJL2525M300130-22	WDJR2525M300130-22			130-300													
WDJL3232P300034-12	WDJR3232P300034-12		22	34-44													
WDJL3232P300038-12	WDJR3232P300038-12	22	38-48														
WDJL3232P300042-19	WDJR3232P300042-19	12	42-60														
WDJL3232P300054-19	WDJR3232P300054-19	12	54-75														
WDJL3232P300067-22	WDJR3232P300067-22	19	67-100														
WDJL3232P300090-22	WDJR3232P300090-22	19	90-160														
WDJL3232P300130-22	WDJR3232P300130-22		130-300	4	20	20	20	20.6	125	WGFT400	M5X16	S4					
WDJL2020K400040-20	WDJR2020K400040-20		40-60														
WDJL2020K400052-20	WDJR2020K400052-20		52-72														
WDJL2020K400064-25	WDJR2020K400064-25	22	64-100														
WDJL2020K400092-25	WDJR2020K400092-25	22	92-140														
WDJL2020K400132-25	WDJR2020K400132-25	20	132-230														
WDJL2020K400220-25	WDJR2020K400220-25		220-500														
WDJL2020K400300-25	WDJR2020K400300-25		300-														
WDJL2525M400040-20	WDJR2525M400040-20	20	40-60								25	25	25	25.6	150	M6X20	S5
WDJL2525M400052-20	WDJR2525M400052-20		52-72														
WDJL2525M400064-25	WDJR2525M400064-25		64-100														
WDJL2525M400092-25	WDJR2525M400092-25	25	92-140														
WDJL2525M400132-25	WDJR2525M400132-25		132-230														



Face Grooving Tools

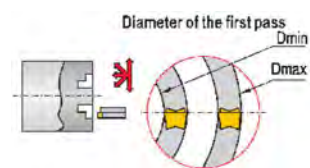
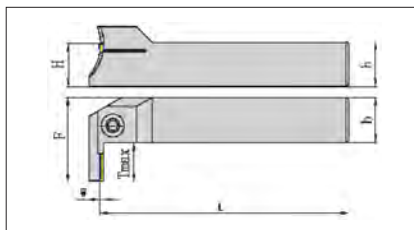
Order No.		Size (mm)								Insert	Screw	Wrench
Left	Right	W	T <sub>max</sub>	D <sub>min-max</sub>	h	b	H	F	L			
WDJL2525M400220-25	WDJR2525M400220-25	4	25	220-500	25	25	25	25.6	150	WGFT400	M6X20	S5
WDJL2525M400300-25	WDJR2525M400300-25		25	300-	25	25	25	25.6	150			
WDJL3232P400040-20	WDJR3232P400040-20		20	40-60	32	32	32	32.6	170			
WDJL3232P400052-20	WDJR3232P400052-20		20	52-72	32	32	32	32.6	170			
WDJL3232P400064-25	WDJR3232P400064-25		25	64-100	32	32	32	32.6	170			
WDJL3232P400092-25	WDJR3232P400092-25		25	92-140	32	32	32	32.6	170			
WDJL3232P400132-25	WDJR3232P400132-25		25	132-230	32	32	32	32.6	170			
WDJL3232P400220-25	WDJR3232P400220-25		25	220-500	32	32	32	32.6	170			
WDJL3232P400300-25	WDJR3232P400300-25		25	300-	32	32	32	32.6	170			
WDJL2525M500040-20	WDJR2525M500040-20	5	20	40-70	25	25	25	25.6	150	WGFT500	M8X30	S6
WDJL2525M500060-25	WDJR2525M500060-25		25	60-95	25	25	25	25.6	150			
WDJL2525M500085-25	WDJR2525M500085-25		25	85-130	25	25	25	25.6	150			
WDJL2525M500120-25	WDJR2525M500120-25		25	120-180	25	25	25	25.6	150			
WDJL2525M500175-25	WDJR2525M500175-25		25	175-500	25	25	25	25.6	150			
WDJL2525M500180-25	WDJR2525M500180-25		25	180-	25	25	25	25.6	150			
WDJL3232P500040-20	WDJR3232P500040-20		20	40-70	32	32	32	32.6	170			
WDJL3232P500060-25	WDJR3232P500060-25		25	60-95	32	32	32	32.6	170			
WDJL3232P500085-25	WDJR3232P500085-25		25	85-130	32	32	32	32.6	170			
WDJL3232P500120-25	WDJR3232P500120-25		25	120-180	32	32	32	32.6	170			
WDJL3232P500175-25	WDJR3232P500175-25		25	175-500	32	32	32	32.6	170			
WDJL3232P500180-25	WDJR3232P500180-25		25	180-	32	32	32	32.6	170			
WDJL4040R500040-20	WDJR4040R500040-20		20	40-70	40	40	40	40.6	200			
WDJL4040R500060-25	WDJR4040R500060-25		25	60-95	40	40	40	40.6	200			
WDJL4040R500085-25	WDJR4040R500085-25		25	85-130	40	40	40	40.6	200			
WDJL4040R500120-25	WDJR4040R500120-25	25	120-160	40	40	40	40.6	200				
WDJL4040R500175-25	WDJR4040R500175-25	25	175-500	40	40	40	40.6	200				
WDJL4040R500180-25	WDJR4040R500180-25	25	180-	40	40	40	40.6	200				
WDJL2525M600040-20	WDJR2525M600040-20	6	20	40-70	25	25	25	25.6	150	WGFT600	M6X20	S5
WDJL2525M600058-25	WDJR2525M600058-25		25	58-100	25	25	25	25.6	150			
WDJL2525M600088-25	WDJR2525M600088-25		25	88-180	25	25	25	25.6	150			
WDJL2525M600168-25	WDJR2525M600168-25		25	168-400	25	25	25	25.6	150			
WDJL2525M600220-25	WDJR2525M600220-25		25	220-	25	25	25	25.6	150			
WDJL3232P600040-20	WDJR3232P600040-20		20	40-70	32	32	32	32.6	170			
WDJL3232P600058-25	WDJR3232P600058-25		25	58-100	32	32	32	32.6	170			
WDJL3232P600088-25	WDJR3232P600088-25		25	88-180	32	32	32	32.6	170			
WDJL3232P600168-25	WDJR3232P600168-25		25	166-400	32	32	32	32.6	170			
WDJL3232P600220-25	WDJR3232P600220-25		25	220-	32	32	32	32.6	170			
WDJL4040R600040-20	WDJR4040R600040-20		20	40-70	40	40	40	40.6	200			
WDJL4040R600058-25	WDJR4040R600058-25		25	58-100	40	40	40	40.6	200			
WDJL4040R600088-25	WDJR4040R600088-25		25	88-180	40	40	40	40.6	200			
WDJL4040R600168-25	WDJR4040R600168-25		25	168-400	40	40	40	40.6	200			
WDJL4040R600220-25	WDJR4040R600220-25		25	220-	40	40	40	40.6	200			



### Face Grooving Tools

WDKL/R

The illustration shows  
Right toolholder



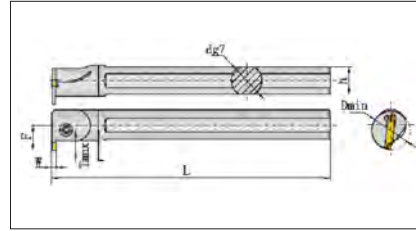
Order No.		Size (mm)									Insert	Screw	Wrench
Left	Right	W	Tmax	Dmin-max	h	b	H	F	L				
WDKL2525M400064-20	WDKR2525M400064-20	4	20	64-100	25	25	25	47	150	WGFT400	M6X20	S5	
WDKL2525M400092-20	WDKR2525M400092-20			92-140	25	25	25	27	150				
WDKL2525M400132-20	WDKR2525M400132-20			132-130	25	25	25	27	150				
WDKL2525M600058-20	WDKR2525M600058-20	6	20	58-100	25	25	25	27	151	WGFT600	M6X20	S5	
WDKL2525M600088-20	WDKR2525M600088-20			88-180	25	25	25	27	152				
WDKL2525M600168-20	WDKR2525M600168-20			168-400	25	25	25	27	153				
WDKL3232P400064-20	WDKR3232P400064-20	4	20	64-100	32	32	32	34	170	WGFT400	M8X30	S6	
WDKL3232P400092-20	WDKR3232P400092-20			92-140	32	32	32	34	170				
WDKL3232P400132-20	WDKR3232P400132-20			132-230	32	32	32	34	170				
WDKL3232P600058-20	WDKR3232P600058-20	6	20	58-100	32	32	32	34	170	WGFT600	M8X30	S6	
WDKL3232P600088-20	WDKR3232P600088-20			88-180	32	32	32	34	170				
WDKL3232P600168-20	WDKR3232P600168-20			168-400	32	32	32	34	170				
WDKL4040R400064-20	WDKR4040R400064-20	4	20	64-100	40	40	40	42	200	WGFT400	M8X30	S6	
WDKL4040R400092-20	WDKR4040R400092-20			92-140	40	40	40	42	200				
WDKL4040R400132-20	WDKR4040R400132-20			132-230	40	40	40	42	200				
WDKL4040R600058-20	WDKR4040R600058-20	6	20	58-100	40	40	40	42	200	WGFT600	M8X30	S6	
WDKL4040R600088-20	WDKR4040R600088-20			88-180	40	40	40	42	200				
WDKL4040R600168-20	WDKR4040R600168-20			168-400	40	40	40	42	200				



## Internal Grooving Inserts

WDML/R

The illustration shows  
Right toolholder



Order No.		Size (mm)							Insert	Screw	Wrench
Left	Right	W	T <sub>max</sub>	d	F	L	H	D <sub>max</sub>			
WDML0020R200-05	WDMR0020R200-05	2	5	20	15	180	18	25	WGFT200	M4X12	S3
WDML0025R200-07	WDMR0025R200-07		7	25	19.5	200	23	32		M5X16	S4
WDML0032U200-09	WDMR0032U200-09		9	32	25	250	30	40		M6X20	S5
WDML0020Q300-06	WDMR0020Q300-06	3	6	20	16	180	18	25	WGFT300	M4X12	S3
WDML0025R300-07	WDMR0025R300-07		7	25	19.5	200	23	32		M5X16	S4
WDML0032S300-09	WDMR0032S300-09		9	32	25	250	30	40		M6X20	S5
WDML0040T300-11	WDMR0040T300-11		11	40	31	300	37	50		M8X30	S6
WDML0025R400-07	WDMR0025R400-07	4	7	25	19.5	200	23	32	WGFT400	M5X16	S4
WDML0032S400-10	WDMR0032S400-10		10	32	26	250	30	40		M6X20	S5
WDML0040T400-11	WDMR0040T400-11		11	40	31	300	37	50		M8X30	S6
WDML0050U400-13	WDMR0050U400-13		13	50	38	350	46	60			
WDML0025R500-08	WDMR0025R500-08	5	8	32	20.5	200	23	32	WGFT500	M5X16	S4
WDML0032S500-11	WDMR0032S500-11		11	25	27	250	30	40		M6X20	S5
WDML0040T500-11	WDMR0040T500-11		11	40	31	300	37	50		M8X30	S6
WDML0050U500-13	WDMR0050U500-13		13	50	38	350	46	60			
WDML0032S600-11	WDMR0032S600-11	6	11	32	27	250	30	40	WGFT600	M6X20	S5
WDML0040T600-11	WDMR0040T600-11		11	40	31	300	37	50		M8X30	S6
WDML0050U600-13	WDMR0050U600-13		13	50	38	350	46	60			



Brisloy Tools India Private Limited  
711, Tower - C, Business Zone  
Nirvana Country, Sec - 50  
Gurugram - 122018  
INDIA  
Phone +91 124 494 9505  
tools@brisloy.com



<http://www.brisloy-tools.com>