

Universal tools for Grooving / Parting Off / Turning

MGT Plus

KORLOY
TECH-NEWS



- Various chip breakers with good chip control
- Improved tool life and workpiece surface roughness via Consistent edge treatment application

Universal tools for Grooving / Parting Off / Turning

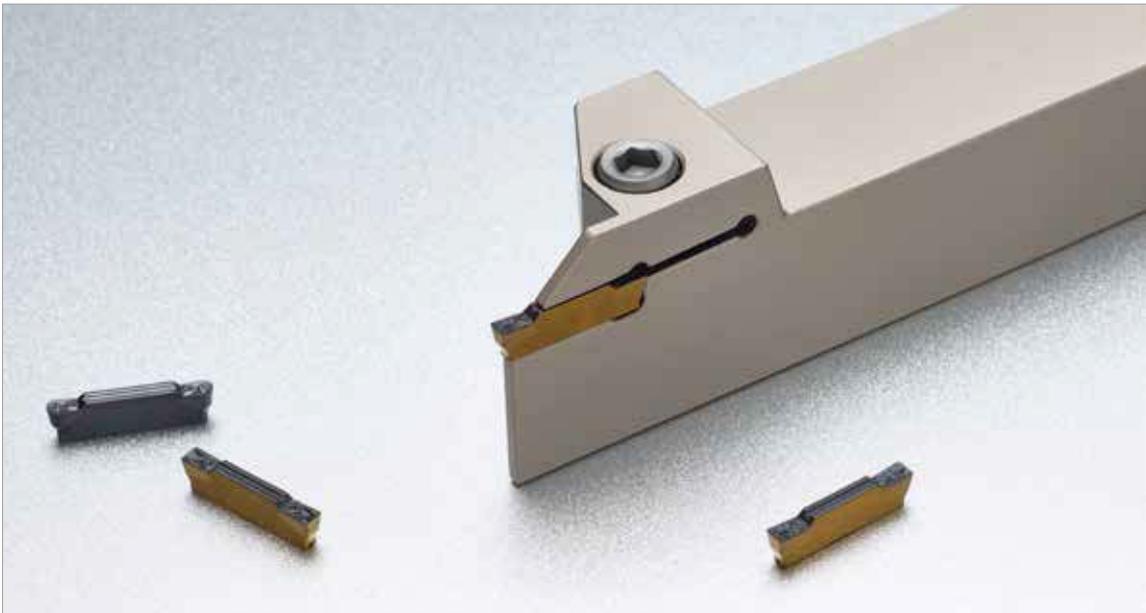
MGT Plus

The **MGT Plus** is a versatile tool for Grooving and Parting off.

The **MGT Plus insert** has excellent chipping resistance and fracture resistance with its hightoughness substrate based new grade. Tool life and workpiece surface roughness will get improved with the consistent edge treatment application. In addition, the new chipbreakers, MM, GM, RM ensure excellent chip control in various machining such as grooving, partingoff, turning, copying,

relief cutting and so on. The symbol curved in each MGT Plus insert means KORLOY's identity for its exclusive design.

The **MGT Plus holder** gives great convenience to customers with its multiple structures for various cutting (external cutting, internal cutting, parting and cutting etc.), and it is interchangeable for theMGT Plus inserts. Also, its stable clamping system provides high cutting performance and long toolife in even various cutting conditions.



High chipping resistance and fracture resistance

- Applying high toughness new grade

Additional edge treatment for its consistency

- Good surface finish of workpiece and high preciseness

Excellent chip control

- Various chip breakers for good chip control

Applicable for various MGT holders

- Providing great convenience with the various shaped MGT holders applicable

Code system

Insert

PG	M	N	300	-	04	MM
MGT Plus Grooving	Tolerance M: Pressed class	Hand N: Neutral	Width of cutting edge 200: 2 mm 300: 3 mm 400: 4 mm		Nose R 04: 0.4 mm	Chip breaker MM / GM

Insert (Round)

PR	M	N	300	-	RM
MGT Plus Grooving Round	Tolerance M: Pressed class	Hand N: Neutral	Width of cutting edge 200: 2 mm 300: 3 mm 400: 4 mm		Chip breaker RM

Shank (External)

MG	E	H	R	25	25	-	3	-	T20
MGT Grooving	Use E: External	Holder type H: Horizontal V: Vertical U: Under cut	Hand R: Right L: Left	Shank height 25: 25 mm 32: 32 mm	Shank width 25: 25 mm 32: 32 mm		Width of insert cutting edge 3: 3 mm		Max. depth of cut T20 : 20 mm

Shank (Internal)

MG	I	V	R	25	20	-	3
MGT Grooving	Use I: Internal	Holder type V: Vertical U: Under cut	Hand R: Right L: Left	Min. cutting dia. 25: 25 mm	Shank dia. 20: 20 mm 25: 25 mm		Width of insert cutting edge 3: 3 mm

Code system

Shank (Facing)

MG	F	H	R	3	25	-	44	/	70	T15
MGT Grooving	Use F: Facing	Holder type H: Horizontal V: Vertical	Hand R: Right L: Left	Width of Insert cutting edge 3: 3 mm	Shank height, Shank width 25: 25 mm 32: 32 mm		Min. cutting dia. 44: 44 mm		Max. cutting dia. 70: 70 mm	Max. depth of cut T15: 15 mm

Cartridge (Holder)

MC	H	R	25	-	25
MGT Cartridge system	Holder type H: Horizontal V: Vertical	Hand R: Right L: Left	Shank height 25: 25 mm		Shank width 25: 25 mm

Cartridge (External)

MC	E	R	3	-	T16
MGT Cartridge system	Use E: External	Hand R: Right L: Left	Width of Insert cutting edge 3: 3 mm 4: 4 mm		Max. depth of cut T16: 16 mm

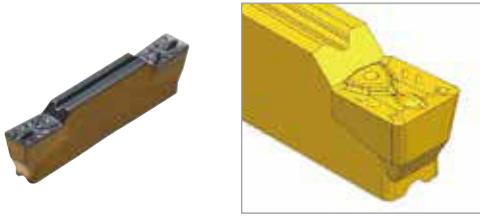
Cartridge (Facing)

MC	E	R	3	-	44	/	70	T16
MGT Cartridge system	Use E: External	Hand R: Right L: Left	Width of Insert cutting edge 3: 3 mm		Min. cutting dia. 44: 44 mm		Max. cutting dia. 70: 70 mm	Max. depth of cut T16: 16 mm

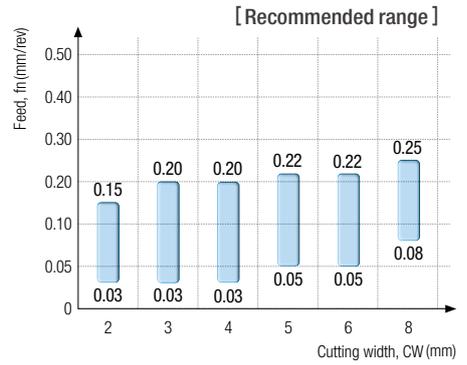
Features of Chip breaker

⊙: 1st recommendation ○: 2nd recommendation

MM - Multi Medium



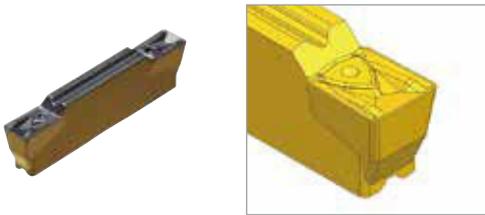
- For grooving, parting and turning
- Bumps on the rake surface
- Straight cutting edge
- Various workpieces



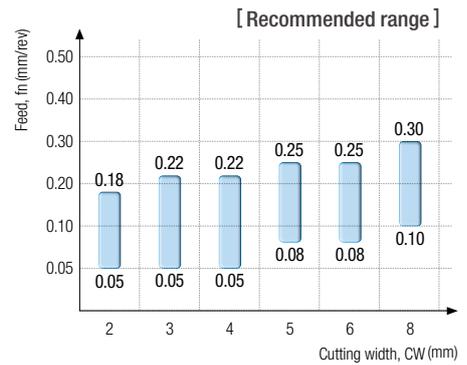
Recommended cutting											
External					Internal				Facing		Special
Grooving	Parting	Turning	Copying	Relief	Grooving	Turning	Copying	Relief	Grooving	Turning	
⊙	○	⊙			○	○			○	○	

Recommended workpiece				
P	M	K	N	S
⊙	○	○		○

GM - Groove Medium



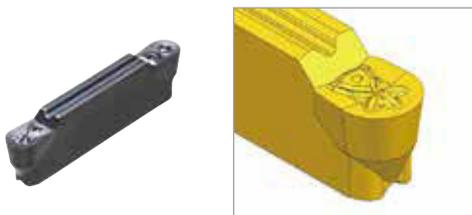
- For grooving and parting
- Straight cutting edge
- Bumps on the rake surface
- Various workpieces
- High depth of cut machining
- For Hard-to-cut material Cutting



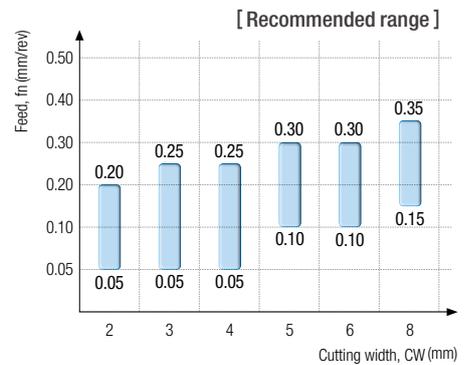
Recommended cutting											
External					Internal				Facing		Special
Grooving	Parting	Turning	Copying	Relief	Grooving	Turning	Copying	Relief	Grooving	Turning	
⊙	⊙				○				⊙		

Recommended workpiece				
P	M	K	N	S
⊙	⊙	○		○

RM - Relief Medium



- For copying and relief cutting
- Round cutting edge
- Bumps on the rake surface
- Excellent surface finish

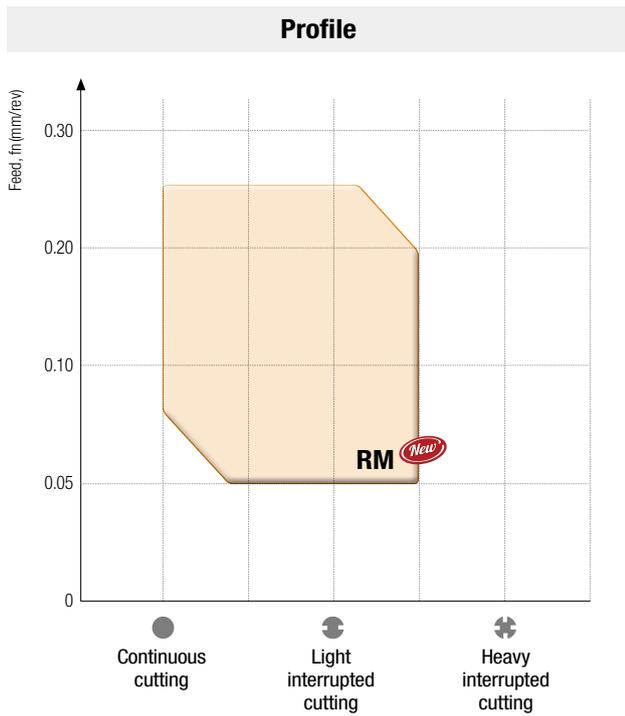
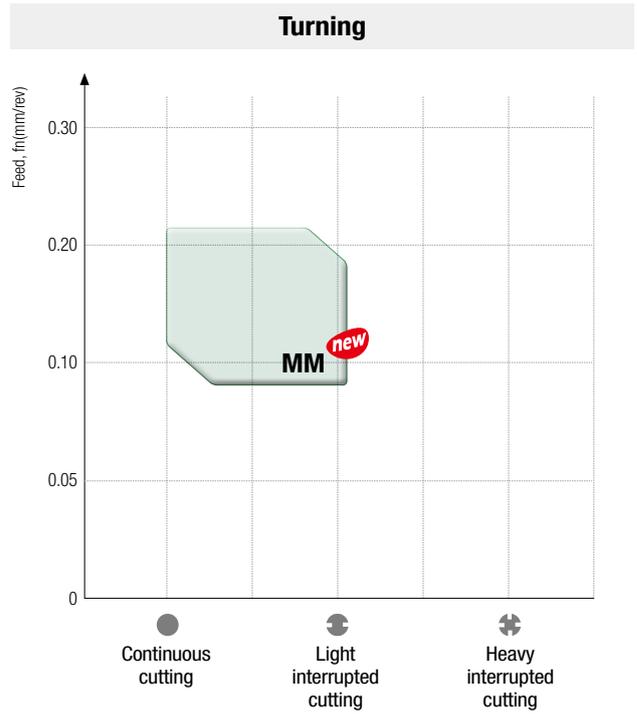
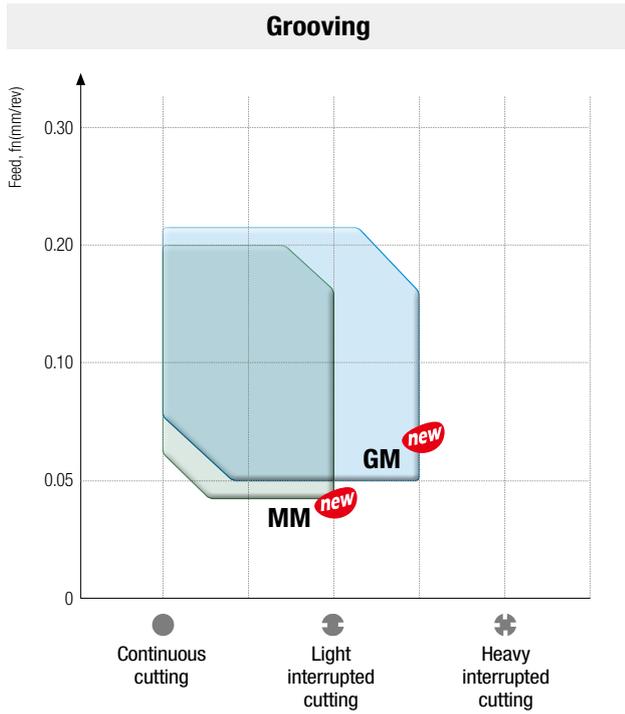


Recommended cutting											
External					Internal				Facing		Special
Grooving	Parting	Turning	Copying	Relief	Grooving	Turning	Copying	Relief	Grooving	Turning	
○			⊙	⊙			⊙	⊙			

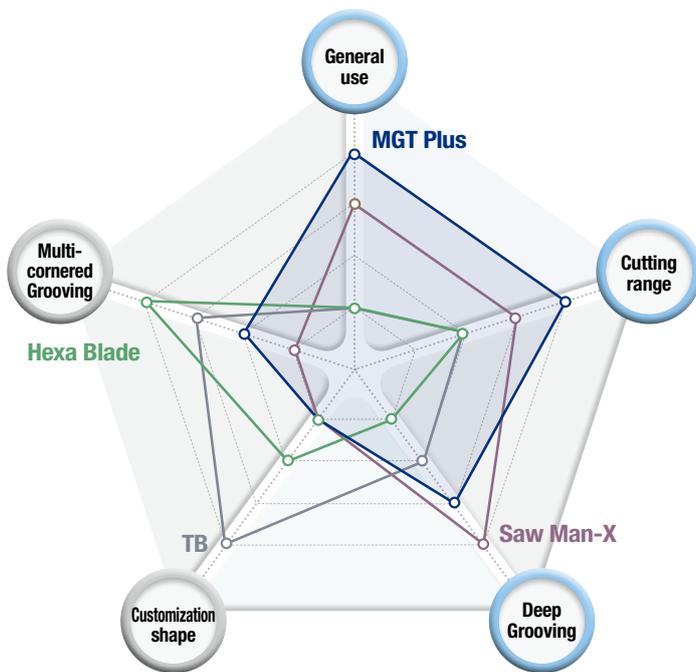
Recommended workpiece				
P	M	K	N	S
⊙	○	○		○

Cutting range

Cutting width (mm) = Based on 3



Tool selection guide



MGT Plus ^{new}

- 2-cornered insert
- Various applications
- Universal use



Saw Man-X ^{new}

- 1 cornered insert
- Optimal for interrupted and high feed Parting
- Deep Grooving



TB

- Precision typed and 3 cornered insert
- Optimal for automated machining
- Precision Grooving



Hexa Blade ^{new}

- Precision typed and 6 cornered insert
- High cost efficiency
- Precision Grooving and multi-cornered Grooving



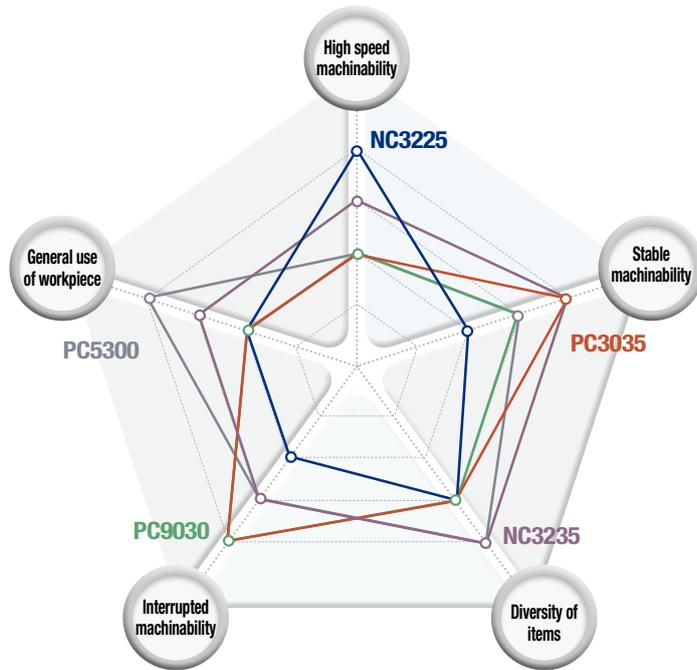
Tool	General use	Cutting range	Deep Grooving	Customization shape	Multi-cornered Grooving
MGT Plus ^{new}	★★★★★	★★★★★	★★★	★	★★
Saw Man-X ^{new}	★★★	★★★	★★★★★	★	★
TB	★	★★	★★	★★★★★	★★★
Hexa Blade ^{new}	★	★★	★	★★	★★★★★

Cutting width and cutting depth by tools

⊙: 1st recommendation ○: 2nd recommendation

Tool	Cutting width (mm)				No. of edge	Machining				Feature
	2	4	6	8		External	Internal	Facing	Parting	
	Cutting depth maximum (mm)									
MGT Plus ^{new} 	1.5	8		28	2	⊙	○	○	⊙	<ul style="list-style-type: none"> • Various application • Wide cutting range
Saw Man-X ^{new} 	2	6		60	1	○			⊙	<ul style="list-style-type: none"> • Various lead angles • Minimizing burr
TB 	1.25	6		6.5	3	⊙			○	<ul style="list-style-type: none"> • Precision type • Optimal for automated machining
Hexa Blade ^{new} 	1.78	4		5	6	⊙			○	<ul style="list-style-type: none"> • Precision type • High cost efficient cutting

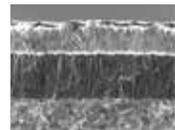
Grade selection guide



NC3225

- CVD coating, general Steel and forged Steel
- Great wear resistance and chipping resistance

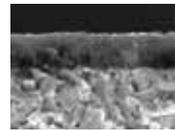
P M K N S



PC3035

- PVD coating, Steel material exclusive
- Good wear resistance and cutting stability

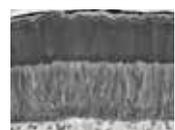
P M K N S



NC3235

- CVD coating, general Steel and Stainless steel interrupted cutting
- Good chipping resistance and fracture resistance

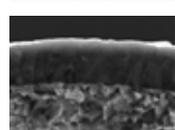
P M K N S



PC9030

- PVD coating, medium to roughing interrupted cutting for Stainless steel
- Good chipping resistance and welding resistance

P M K N S



PC5300

- PVD coating, universal grade
- Interrupted cutting and good wear resistance

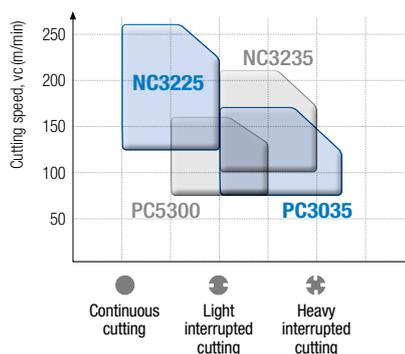
P M K N S



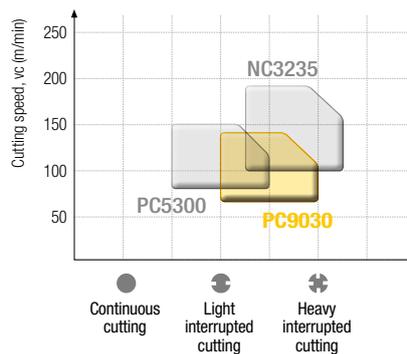
Grade	High speed machinability	Stable machinability	Diversity of items	Interrupted machinability	General use of workpiece
NC3225	★★★★	★★	★★★	★★	★★
PC3035	★★	★★★★	★★★	★★★★	★★
NC3235	★★★	★★★★	★★★★	★★★	★★★
PC9030	★★	★★★	★★★	★★★★	★★
PC5300	★★	★★★	★★★★	★★★	★★★★

Grade application range

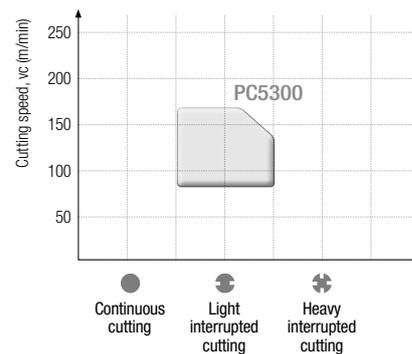
P Steel



M Stainless steel



K Cast iron



Recommended cutting conditions

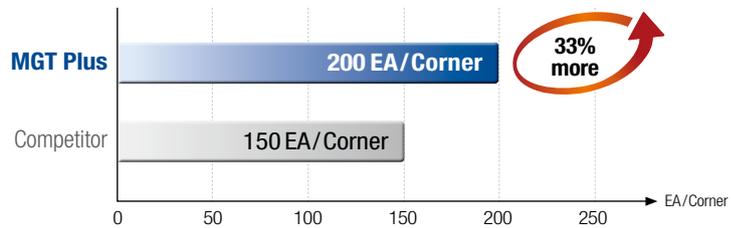
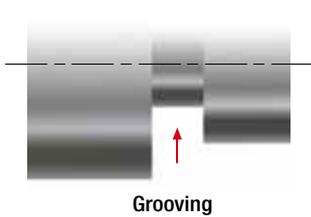
Cutting width (mm) = Based on 3

Workpiece					Grade					Chip breaker						
ISO	Workpiece material	ISO	AISI	Brinell hardness (HB)	CVD		PVD			Grooving			Turning			
					NC3225	NC3235	PC3035	PC5300	PC9030	MM	GM	RM	MM	RM		
					vc (m/min)					fn (mm/rev)			fn (mm/rev)			
P	Carbon steel	C = 0.25%	C25	1025	125	180	140	110	110	110	0.20	0.22	0.25	0.20	0.25	
						275	215	170	170	170	0.12	0.14	0.15	0.16	0.20	
						370	290	230	230	230	0.03	0.05	0.05	0.12	0.15	
		C = 0.35%	C35	1035	160	170	130	100	100	100	0.20	0.22	0.25	0.20	0.25	
						255	200	155	155	155	0.12	0.14	0.15	0.16	0.20	
						340	270	210	210	210	0.03	0.05	0.05	0.12	0.15	
		C = 0.45%	C45	1045	170	150	120	90	90	90	0.20	0.22	0.25	0.20	0.25	
						235	185	145	145	145	0.12	0.14	0.15	0.16	0.20	
						320	250	200	200	200	0.03	0.05	0.05	0.12	0.15	
	Low alloy steel ≤ 5%	Non-hardened	42CrMo4	4140	180	130	100	80	80	80	0.20	0.22	0.25	0.18	0.23	
						195	155	120	120	120	0.12	0.14	0.15	0.14	0.18	
		Hardened and tempered	-	-	4145	350	80	60	50	50	50	0.20	0.22	0.25	0.18	0.23
							115	90	75	75	75	0.12	0.14	0.15	0.14	0.18
							150	120	100	100	100	0.03	0.05	0.05	0.10	0.13
							115	90	75	75	75	0.12	0.14	0.15	0.14	0.18
High alloy steel < 5%	Annealed	-	D2	200	100	80	60	60	60	0.20	0.22	0.20	0.18	0.23		
					150	120	90	90	90	0.12	0.14	0.12	0.14	0.18		
	Hardened tool steel	X40CrMoV5-1	H13	352	80	60	50	50	50	0.20	0.22	0.20	0.18	0.23		
					120	95	75	75	75	0.12	0.14	0.12	0.14	0.18		
M	Austenite series	X5CrNi18-9	304	160 - 180	-	100	-	80	80	0.15	0.15	0.18	0.18	0.23		
					-	145	-	115	115	0.09	0.09	0.13	0.14	0.18		
					-	190	-	150	150	0.03	0.03	0.08	0.10	0.13		
		X5CrNiMo17-12-2	316	160 - 180	-	100	-	80	80	0.15	0.15	0.18	0.18	0.23		
					-	145	-	115	115	0.09	0.09	0.13	0.14	0.18		
					-	190	-	150	150	0.03	0.03	0.08	0.10	0.13		
K	Gray cast iron	Low tensile strength	150	No25B	≤ 212	-	-	-	100	-	0.25	0.25	0.25	0.18	0.23	
						-	-	-	150	-	0.17	0.17	0.15	0.14	0.18	
						-	-	-	200	-	0.09	0.09	0.05	0.10	0.13	
		High tensile strength	250 350	No35B No50B	≤ 248 ≤ 277	-	-	-	80	-	0.25	0.25	0.25	0.18	0.23	
						-	-	-	125	-	0.17	0.17	0.15	0.14	0.18	
						-	-	-	170	-	0.09	0.09	0.05	0.10	0.13	
	Ductile cast iron	Ferritic	500-7	65-45-12	170 - 241	-	-	-	70	-	0.25	0.25	0.25	0.20	0.25	
						-	-	-	105	-	0.17	0.17	0.15	0.16	0.20	
						-	-	-	140	-	0.09	0.09	0.05	0.12	0.15	
		Pearlitic	600-3	80-55-06	192 - 269	-	-	-	50	-	0.25	0.25	0.25	0.20	0.25	
						-	-	-	80	-	0.17	0.17	0.15	0.16	0.20	
						-	-	-	110	-	0.09	0.09	0.05	0.12	0.15	
Martensitic	700-2	100-70-03	229 - 302	-	-	-	50	-	0.20	0.22	0.20	0.20	0.25			
				-	-	-	80	-	0.12	0.14	0.12	0.16	0.20			
				-	-	-	110	-	0.03	0.05	0.03	0.12	0.15			
S	Inconel	-	-	200	-	-	-	20	-	0.10	0.10	0.12	0.13	0.16		
					-	-	-	35	-	0.06	0.06	0.10	0.11	0.14		
					-	-	-	50	-	0.03	0.03	0.08	0.09	0.12		
		-	-	250 350	-	-	-	20	-	0.10	0.10	0.12	0.13	0.16		
					-	-	-	35	-	0.06	0.06	0.10	0.11	0.14		
					-	-	-	50	-	0.03	0.03	0.08	0.09	0.12		
	Titanium alloy	-	-	3400	-	-	-	60	-	0.10	0.10	0.18	0.18	0.20		
					-	-	-	80	-	0.06	0.06	0.13	0.14	0.18		
					-	-	-	100	-	0.03	0.03	0.08	0.10	0.16		
		-	-	950	-	-	-	30	-	0.10	0.10	0.18	0.18	0.20		
					-	-	-	45	-	0.06	0.06	0.13	0.14	0.18		
					-	-	-	60	-	0.03	0.03	0.08	0.10	0.16		

Performance evaluation

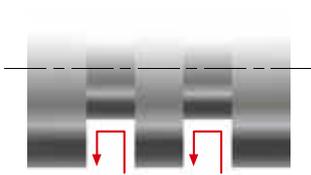
Shaft cutting

Workpiece	Stainless steel (X5CrNi18-9)	
Cutting condition	vc = 120 m/min · fn = 0,12 mm/rev · ap = 5 mm · wet	
Tool	Insert PGMN400-03-GM (PC5300)	Holder MGEHR2525-4-T15

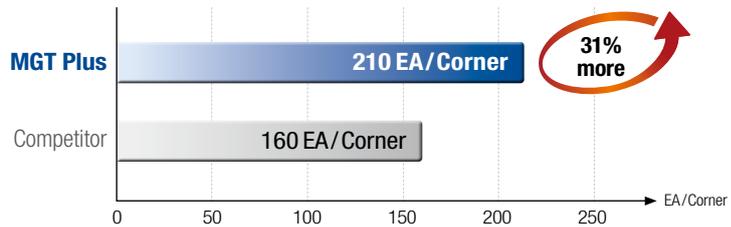


Multi-functional cutting

Workpiece	Carbon steel (C45)	
Cutting condition	vc = 170 m/min · fn = 0,15 mm/rev · ap = 2 mm · wet	
Tool	Insert PGMN300-04-MM (PC5300)	Holder MGEHR2525-3-T13



[Repetition of Turning after Grooving]



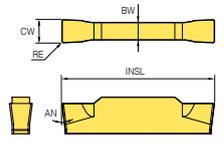
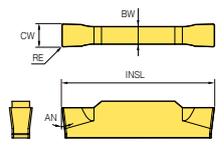
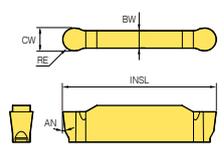
MGT Plus ↔ MGT insert interchangeable chart

MGT Plus	MGT	MGT Plus	MGT
PGMN150 - □□	MGMN150 - □□	PRMN200 - □□	MRMN200 - □□
PGMN200 - □□	MGMN200 - □□	PRMN300 - □□	MRMN300 - □□
PGMN250 - □□	MGMN250 - □□	PRMN400 - □□	MRMN400 - □□
PGMN300 - □□	MGMN300 - □□	PRMN500 - □□	MRMN500 - □□
PGMN400 - □□	MGMN400 - □□	PRMN600 - □□	MRMN600 - □□
PGMN500 - □□	MGMN500 - □□	PRMN800 - □□	MRMN800 - □□
PGMN600 - □□	MGMN600 - □□		
PGMN800 - □□	MGMN800 - □□		

※ The MGT Plus insert is compatible with MGT insert.
It is available to use MGT Plus insert clamping on the MGT holder.

Insert

※ AN = 7°

Picture	Designation	Coated					Dimension (mm)				Geometry
		NC3225	NC3235	PC3035	PC5300	PC9030	CW	RE	INSL	BW	
	PGMN 200-02-MM	●	▲	●	▲	●	2.00	0.2	16	1.6	
	300-04-MM	●	▲	●	▲	●	3.00	0.4	21	2.35	
	400-04-MM	●	▲	●	▲	●	4.00	0.4	21	3.3	
	500-08-MM	●	▲	●	▲	●	5.00	0.8	26	4.1	
	600-08-MM	●	▲	●	▲	●	6.00	0.8	26	5.0	
	800-08-MM	●	●	●	●	●	8.00	0.8	31	6.0	
	PGMN 150-015-GM	●	▲	●	▲	●	1.50	0.15	16	1.2	
	200-02-GM	●	▲	●	▲	●	2.00	0.2	16	1.6	
	250-02-GM	●	▲	●	▲	●	2.50	0.2	18.5	2.0	
	300-03-GM	●	▲	●	▲	●	3.00	0.3	21	2.35	
	400-03-GM	●	▲	●	▲	●	4.00	0.3	21	3.3	
	PRMN 200-RM	●	▲	●	▲	●	2.00	1.0	16	1.6	
	300-RM	●	▲	●	▲	●	3.00	1.5	21	2.35	
	400-RM	●	▲	●	▲	●	4.00	2.0	21	3.3	
	500-RM	●	▲	●	▲	●	5.00	2.5	26	4.1	
	600-RM	●	▲	●	▲	●	6.00	3.0	26	5.0	
	800-RM	●	▲	●	▲	●	8.00	4.0	31	6.0	

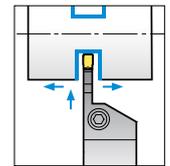
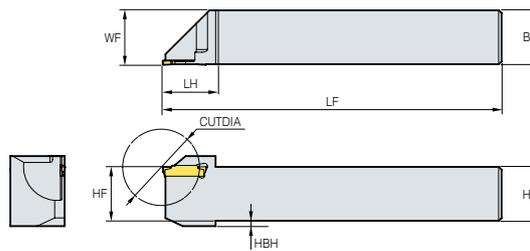
Holder

MGEHR/L-X00A Auto Tool

External automatic lathe



PGMN PRMN



- R type holder

Designation	Stock		H = HF	B	CUT DIA	WF	LH	LF	HBH	Applicable insert	Screw	Wrench
	R	L										
MGEHR/L 1010-X15A	●	○	10	10	20	10.2	18	125	2	PGMN150-□□	ETNA0412	TW15L
1212-X15A	●	○	12	12	25	12.2	19.5	125	2			
1010-X20A	●	○	10	10	20	10.25	18	125	2	PGMN200-□□ PRMN200-□		
1212-X20A	▲	○	12	12	25	12.25	19.5	125	2			
1616-X20A	○	○	16	16	32	16.25	25	125	2	PGMN250-□□		
1010-X25A	○	○	10	10	20	10.3	20	125	2			
1212-X25A	●	○	12	12	25	12.3	20	125	2			
1616-X25A	○	○	16	16	32	16.3	25	125	-			

(mm)

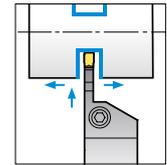
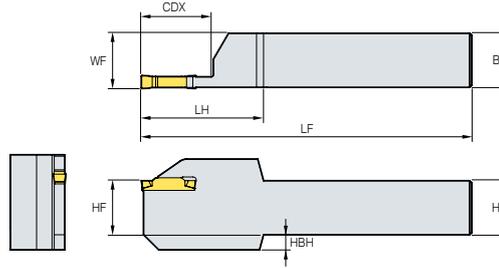
▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

MGEHR/L

External Grooving, Parting, Turning, Copying



PGMN PRMN



- R type holder

(mm)

Designation	Stock		H = HF	B	CDX	WF	LH	LF	HBH	Applicable insert	Screw	Wrench
	R	L										
MGEHR/L 1616-1,5	●	●	16	16	14	16.2	34.5	100	-	PGMN150-□-□	LTX0514	TW20L
2020-1,5	▲	●	20	20	14	20.2	34.5	125	-			
2525-1,5	▲	▲	25	25	14	25.2	34.5	150	-			
1212-2	●	○	12	12	14	12.25	32	100	-	PGMN200-□-□ PRMN200-□	MHA0512	HW40L
1616-2	●	▲	16	16	14	16.25	36.5	100	-			
2020-2	▲	▲	20	20	14	20.25	36.5	125	-			
2525-2	▲	●	25	25	14	25.25	36.5	150	-	PGMN250-□-□		
1616-2,5	●	●	16	16	16	16.3	39	100	-			
2020-2,5	●	●	20	20	20	20.3	39	125	-			
2525-2,5	●	●	25	25	16	25.3	41.5	100	-	PGMN300-□-□ PRMN300-□		
1616-3	▲	▲	16	16	18	16.35	41.5	125	-			
2020-3-T10	●	○	20	20	10	20.35	41.5	125	-			
2020-3	▲	▲	20	20	18	20.35	41.5	150	-	PGMN300-□-□ PRMN300-□		
2525-3-T10	●	●	25	25	10	25.35	41.5	150	-			
2525-3	▲	▲	25	25	18	25.35	41.5	170	-			
3232-3-T10	○	○	32	32	10	32.35	41.5	170	-	PGMN400-□-□ PRMN400-□		
3232-3	●	●	32	32	18	32.35	41.5	125	-			
2020-4-T10	●	○	20	20	10	20.4	41.5	125	-			
2020-4	▲	●	20	20	18	20.4	41.5	150	-	PGMN400-□-□ PRMN400-□		
2525-4-T10	●	●	25	25	10	25.4	41.5	150	-			
2525-4	▲	▲	25	25	18	25.4	41.5	170	-			
3232-4-T10	○	○	32	32	10	32.4	41.5	170	-	PGMN500-□-□ PRMN500-□	BHA0616	HW50L
3232-4	●	●	32	32	18	32.4	46.5	150	-			
2020-5-T15	○	○	20	20	15	20.5	46.5	150	-			
2020-5	●	●	20	20	23	20.5	46.5	170	-	PGMN500-□-□ PRMN500-□		
2525-5	▲	●	25	25	23	25.5	46.5	170	-			
2525-5-T15	○	○	25	25	15	25.5	46.5	125	-			
3232-5-T15	○	○	32	32	15	32.5	46.5	125	-	PGMN600-□-□ PRMN600-□		
3232-5	▲	●	32	32	23	32.5	46.5	150	-			
2020-6-T15	○	○	20	20	15	20.55	46.5	150	-			
2020-6	▲	●	20	20	23	20.55	46.5	170	-	PGMN600-□-□ PRMN600-□		
2525-6-T15	○	○	25	25	15	25.55	46.5	170	-			
2525-6	●	●	25	25	23	25.55	51.5	150	-			
3232-6-T15	○	○	32	32	15	32.55	51.5	150	-	PGMN800-□-□ PRMN800-□		
3232-6	▲	●	32	32	23	32.55	51.5	170	-			
2525-8-T15	●	○	25	25	15	26.1	51.5	170	-			

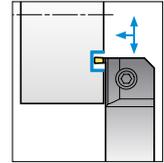
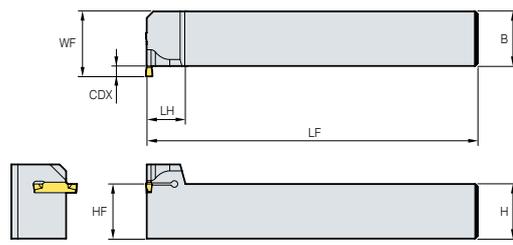
▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

MGEVR/L

External Grooving, Turning, Copying



PGMN PRMN



· R type holder

(mm)

Designation	Stock		H = HF	B	CDX	WF	LH	LF	Applicable insert	Screw 	Wrench 
	R	L									
MGEVR/L 2020-1,5	●	○	20	20	3	23.5	28	125	PGMN150-□-□	LTX0514	TW20L
	○	○	25	25	3	28.5	28	150			
	○	○	32	32	3	35.5	28	170			
2020-2	●	○	20	20	3.5	23.5	28	125	PGMN200-□-□ PRMN200-□	BHA0616	HW50L
	○	○	25	25	3.5	28.5	28	150			
	○	○	32	32	3.5	35.5	28	170			
2020-2,5	○	○	20	20	4	24.8	28	125	PGMN250-□-□		
	○	○	25	25	4	29.8	28	150			
	○	○	32	32	4	36.8	28	170			
2020-3	○	●	20	20	5	25.5	28	125	PGMN300-□-□ PRMN300-□		
	○	●	25	25	5	30.5	28	150			
	○	○	32	32	5	37.5	28	170			
2020-4	○	○	20	20	5	25.5	28	125	PGMN400-□-□ PRMN400-□		
	●	○	25	25	5	30.5	28	150			
	○	○	32	32	5	37.5	28	170			
2020-5	○	○	20	20	7	27	30	125	PGMN500-□-□ PRMN500-□		
	○	○	25	25	7	32	30.5	150			
	○	○	32	32	7	39	30	170			
2020-6	○	○	20	20	7	30.5	30.5	125	PGMN600-□-□ PRMN600-□		
	○	○	25	25	7	32	30.5	150			
	○	○	32	32	7	39	30.5	170			
2525-8	○	○	25	25	9	34	31	150	PGMN800-□-□ PRMN800-□		
	○	○	32	32	9	41	31	170			

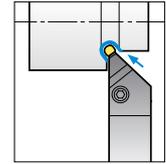
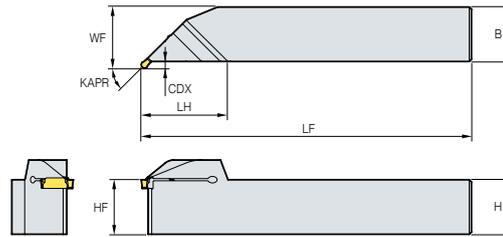
▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

MGEUR/L

External Copying, Relief



PRMN



• R type holder

(mm)

Designation	Stock		H = HF	B	CDX	KAPR (°)	WF	LH	LF	Applicable insert	Screw 	Wrench 
	R	L										
MGEUR/L 2020-3	●	○	20	20	3	45	23	39.5	125	PRMN300-□	BHA0616	HW50L
2525-3	●	○	25	25	3	45	28	39.5	150			
3232-3	○	○	32	32	3	45	35	39.5	170			
2020-4	○	○	20	20	3	45	23	39.5	125	PRMN400-□		
2525-4	●	○	25	25	3	45	28	39.5	150			
3232-4	○	○	32	32	3	45	35	39.5	170			
2020-5	○	○	20	20	4	45	24	39.5	125	PRMN500-□		
2525-5	●	●	25	25	4	45	29	41	150			
3232-5	○	○	32	32	4	45	36	40	170			
2020-6	○	○	20	20	4	45	24	40	125	PRMN600-□		
2525-6	●	○	25	25	4	45	29	40	150			
3232-6	●	●	32	32	4	45	36	40	170			
2525-8	○	○	25	25	5	45	30	45	150	PRMN800-□		
3232-8	○	○	32	32	5	45	37	45	170			

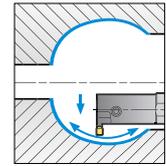
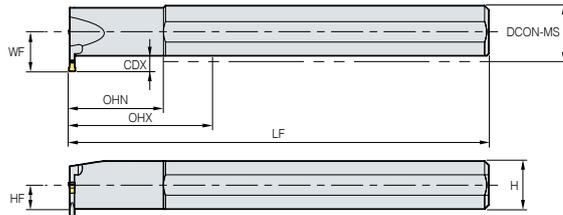
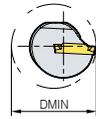
▲: Stock item Europe ●: Stock item Korea ○: Production on demand

MGIVR/L

Internal Grooving, Turning, Copying



PGMN PRMN



- R type holder

(mm)

Designation	Stock		DMIN	DCON-MS	HF	H	CDX	WF	OHN	LF	Applicable insert	Screw	Wrench
	R	L											
MGIVR/L 2016-1,5	○	○	20	16	7.5	15	3.5	11.3	35	125	PGMN150-□-□	MHB0310	HW25L
	○	○	25	20	9	18	3.5	13.1	45	150		MHA0512	HW40L
	○	○	29	25	11.5	23	3.5	16.2	45	200			
2016-2	▲	●	20	16	7.5	15	4.9	11.95	35	125	PGMN200-□-□ PRMN200-□-□	MHB0310	HW25L
	●	▲	25	20	9	18	5	14	45	150		MHA0512	HW40L
	●	●	29	25	11.5	23	4.5	16.5	45	200			
2016-2,5	▲	○	20	16	7.5	15	4.5	12.5	35	125	PGMN250-□-□	MHB0310	HW25L
	○	○	25	20	9	18	5.5	15.1	45	150		MHA0512	HW40L
	○	○	29	25	11.5	23	5	17.25	45	200			
2520-3	▲	●	25	20	9	18	5.3	15.6	45	150	PGMN300-□-□ PRMN300-□-□	MHA0512	HW40L
	●	○	25	20	9	18	7	16.5	45	150			
	▲	●	31	25	11.5	23	6.5	18.9	45	200			
3125-3-T10	●	○	31	25	11.5	23	10	18.9	45	200			
	●	●	37	32	15	30	6.5	21.5	65	250			
	●	○	37	32	15	30	12	21.5	65	250			
3732-3-T12	●	○	37	32	15	30	12	21.5	65	250			
	●	●	25	20	9	18	6.17	15.6	45	150	PGMN400-□-□ PRMN400-□-□	MHA0512	HW40L
	●	○	25	20	9	18	7	15.6	45	150			
▲	○	31	25	11.5	23	6.5	18.9	45	200				
2520-4-T7	●	○	31	25	11.5	23	10	19	45	200			
	●	○	37	32	15	30	6.5	21.5	65	250	BHA0620	HW50L	
	●	○	37	32	15	30	12	21.5	65	250	MHA0512	HW40L	
3125-4	●	○	31	25	11.5	23	8	19.4	45	200	PGMN500-□-□ PRMN500-□-□	BHA0616	HW50L
	●	○	37	32	15	30	8	21.5	65	250		BHA0620	HW50L
	●	●	31	25	11.5	23	8	19.4	45	200			
3125-6	●	○	37	32	15	30	8	21.5	65	250	PGMN600-□-□ PRMN600-□-□	BHA0616	HW50L
	●	○	37	32	15	30	8	21.5	65	250		BHA0620	HW50L
	●	●	31	25	11.5	23	8	19.4	45	200			
3732-6	●	○	37	32	15	30	10	23.4	65	250	PGMN800-□-□ PRMN800-□-□	BHA0620	HW50L
	●	○	37	32	15	30	10	23.4	65	250			
	●	○	45	40	19	38	10	27.2	70	300			

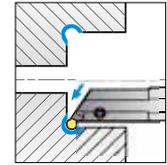
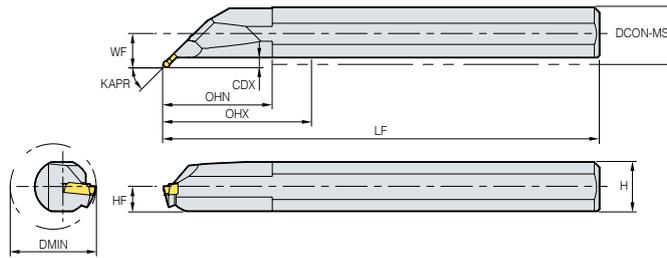
▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

MGIUR/L

Internal Copying, Relief



PRMN



- R type holder

(mm)

Designation	Stock		DMIN	DCON-MS	HF	H	KAPR (°)	CDX	WF	OHN	LF	Applicable insert	Screw	Wrench
	R	L												
MGIUR/L 3520-3	○	○	35	20	9	18	45	3.5	13	45	150	PRMN300-□	MHA0512	HW40L
	●	○	40	25	11.5	23	45	3.5	15.5	50	200			
	○	○	50	32	15	30	45	3.5	19	65	250			
3520-4	○	○	35	20	9	18	45	3.5	13	45	150	PRMN400-□	MHA0512	HW40L
	●	○	40	25	11.5	23	45	3.5	15.5	50	200			
	●	○	50	32	15	30	45	3.5	19	65	250			
4025-5	○	○	40	25	11.5	23	45	3.5	15.5	45	200	PRMN500-□	BHA0512	HW40L
	●	○	50	32	15	30	45	3.5	19	65	250		MHA0512	HW40L
4025-6	○	○	40	25	11.5	23	45	3.5	15.5	50	200	PRMN600-□	BHA0616	HW50L
	●	○	50	32	15	30	45	3.5	19	65	250		MHA0512	HW40L
4025-8	○	○	40	25	11.5	23	45	6.5	18.5	45	200	PRMN800-□	MHA0512	HW40L
	●	○	50	32	15	30	45	6.5	22	65	250		BHA0620	HW50L

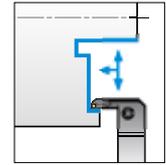
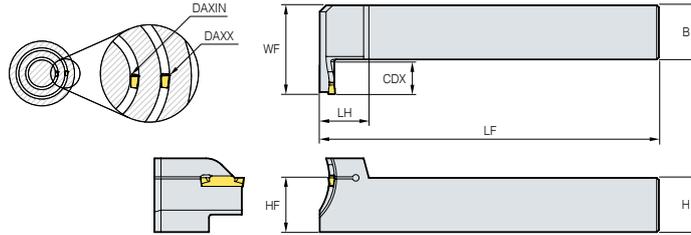
▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

MGFVR/L

Facing Grooving, Turning



PGMN PRMN



· R type holder

(mm)

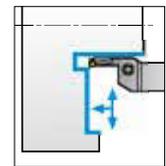
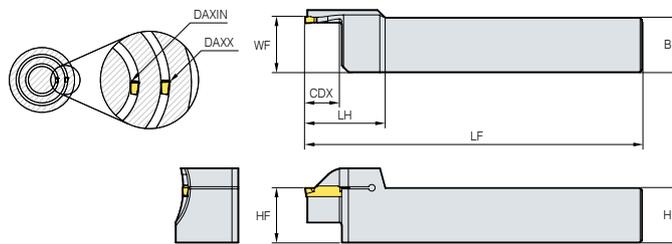
Designation	Stock		H = HF	B	CDX	WF	LH	LF	DAXIN	DAXX	Applicable insert	Screw	Wrench
	R	L											
MGFVR/L	325-24/35-T10	●	○	25	25	10	36	18	150	24	35	BHA0616	HW50L
	325-29/40-T10	●	○	25	25	10	36	18	150	29	40		
	325-34/50-T10	●	○	25	25	10	36	18	150	34	50		
	325-44/70-T10	●	○	25	25	10	36	18	150	44	70		
	325-64/99-T10	●	○	25	25	10	36	18	150	64	99		
	425-44/60-T15	●	○	25	25	15	41	25	150	44	60		
	425-60/120-T15	●	○	25	25	15	41	25	150	60	120		
	425-112/200-T15	●	○	25	25	15	41	25	150	112	200		

MGFHR/L

Facing Grooving, Turning



PGMN PRMN



· R type holder

(mm)

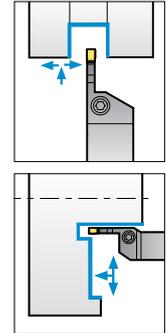
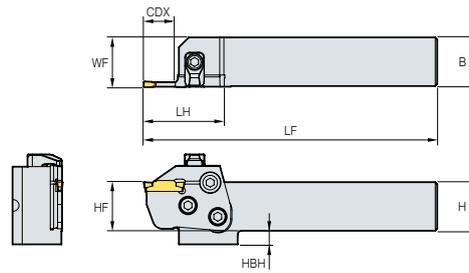
Designation	Stock		H = HF	B	CDX	WF	LH	LF	DAXIN	DAXX	Applicable insert	Screw	Wrench
	R	L											
MGFHR/L	325-24/35-T10	●	○	25	25	10	25.6	32	150	24	35	BHA0616	HW50L
	325-29/40-T10	●	○	25	25	10	25.6	32	150	29	40		
	325-34/50-T10	●	○	25	25	10	25.6	32	150	34	50		
	325-44/70-T10	●	○	25	25	10	25.6	32	150	44	70		
	325-64/99-T10	●	○	25	25	10	25.6	32	150	64	99		
	425-42/63-T15	●	○	25	25	15	25.6	46.5	150	42	63		
	425-62/120-T15	●	○	25	25	15	25.6	39	150	62	120		
	425-112/200-T15	●	○	25	25	15	25.6	39	150	112	200		

MCHR/L

External, Facing Cartridge shank



MCER/L MCFR/L



- R type holder

(mm)

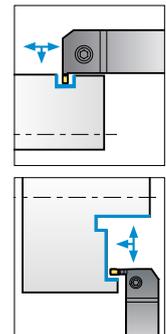
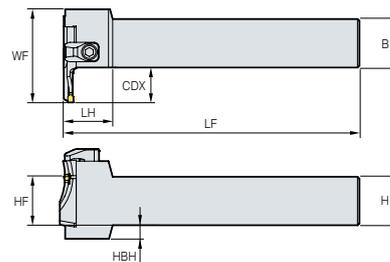
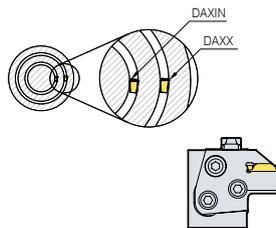
Designation	Stock		H = HF	B	WF	LH	LF	HBH	Applicable cartridge	Clamp	Clamp screw	Hinge screw	Clamping Screw	Wrench
	R	L												
MCHR/L	2020	● ●	20	20	20.7	30	133	12	MCER/L MCFR/L	CHX8N	DHA0818F	RHA0613	FHGA0618	HW40L
	2525	▲ ▲	25	25	25.7	30	133	7						
	3232	● ●	32	32	32.7	-	153	-						

MCVR/L

External, Facing Cartridge shank



MCER/L MCFR/L

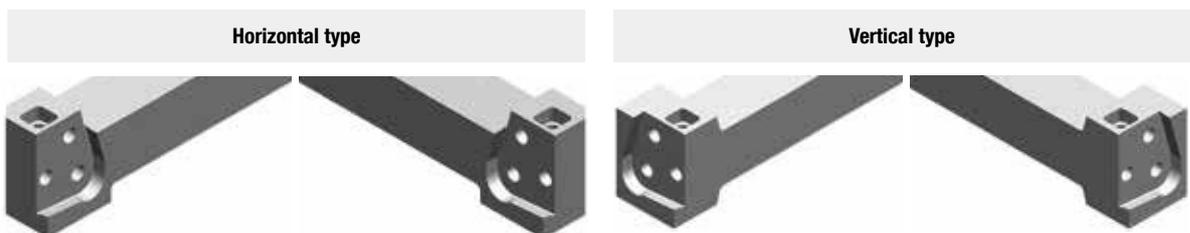


- R type holder

(mm)

Designation	Stock		H = HF	B	WF	LH	LF	HBH	Applicable cartridge	Clamp	Clamp screw	Hinge screw	Clamping Screw	Wrench
	R	L												
MCVR/L	2020	● ●	20	20	38	30	150	12	MCER/L MCFR/L	CXH8N	DHA0818F	RHA0613	FHGA0618	HW40L
	2525	▲ ▲	25	25	43	30	150	7						
	3232	● ●	32	32	50	-	170	-						

Cartridge selection guide



Applicable cartridge	Horizontal type		Vertical type	
	MCHR	MCHL	MCVR	MCVL
	External: MCER Facing: MCFL	External: MCEL Facing: MCFR	External: MCEL Facing: MCFR	External: MCER Facing: MCFL

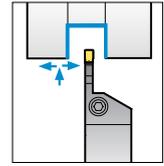
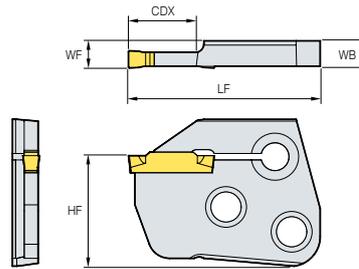
▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

MCER/L

External, Cartridge



PGMN PRMN



· R type holder

(mm)

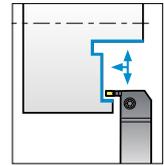
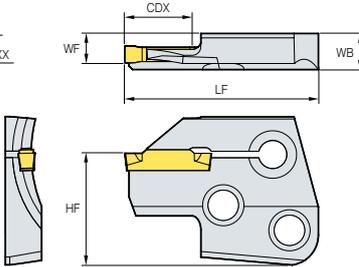
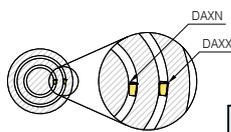
Designation	Stock		HF	CDX	WF	WB	LF	CW	Applicable insert	Applicable holder	
	R	L									
MCER/L	3-T16	▲	▲	25.83	16	6.35	6.00	44.5	3.00	PGMN300-□-□ PRMN300-□	MCHR/L MCVR/L
	4-T16	●	▲	25.83	16	6.35	5.97	44.5	4.00	PGMN400-□-□ PRMN400-□	
	5-T20	●	▲	25.83	20	6.35	5.87	48.5	5.00	PGMN500-□-□ PRMN500-□	
	6-T20	○	○	25.83	20	6.35	5.82	48.5	6.00	PGMN600-□-□ PRMN600-□	

MCFR/L

Facing Cartridge



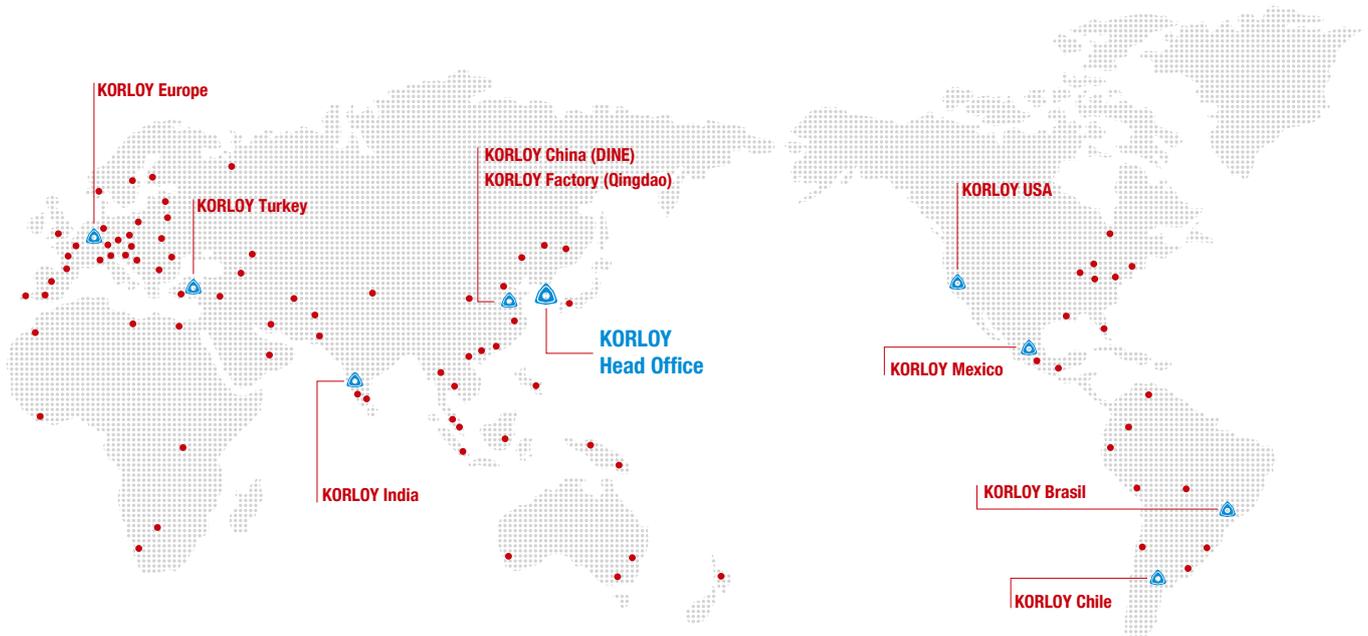
PGMN PRMN



· R type holder

(mm)

Designation	Stock		HF	CDX	WF	WB	LF	DAXIN	DAXX	Applicable insert	Applicable holder
	R	L									
MCFR/L	4-44/60-T16	○	○	25.83	16	6.35	8.35	44	60	PGMN400-□-□ PRMN400-□	MCHR/L MCVR/L
	4-60/120-T16	●	●	25.83	16	6.35	8.35	60	120		
	4-112/200-T16	●	○	25.83	16	6.35	8.35	112	200		



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