



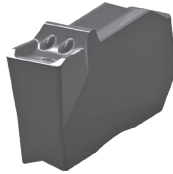
Grip-Lok

High Performance Part-Off Tooling

Geometry- GA

First choice for part-off on Steel & Cast Iron

- Insert with narrow negative chamfer
- Suitable for all steel materials with high strength
- Suitable for all applications
- For steel & grey cast iron



Insert Designation	Insert Width	Coated Grades		
		MP40P	MP30C	MP45P
SEPO-2-0079-00-GA	2mm	□	□	□
SEPO-3-0079-00-GA	3mm	✳	✳	✳
SEPO-4-0118-00-GA	4mm	✳	✳	✳
SEPO-5-0118-00-GA	5mm	□	□	□
SEPO-6-0157-00-GA	6mm	✳	✳	✳

Geometry- PT

First choice for use in varying materials

- For parting-off, grooving, & turning
- Suitable for all steel & cast iron materials
- Very good chip control

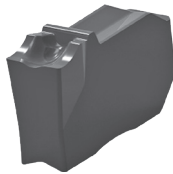


SEPO-2-0079-00-PT	2mm	□	□	□
SEPO-3-0118-00-PT	3mm	✳	✳	✳
SEPO-4-0157-00-PT	4mm	✳	✳	✳
SEPO-5-0157-00-PT	5mm	□	□	□
SEPO-6-0197-00-PT	6mm	✳	✳	✳

Geometry- SS

First choice for Stainless Steel

- For parting-off & grooving
- Especially for stainless steel
- Problem solver for steel machining
- Soft cutting chipbreaker



SEPO-2-0079-00-SS	2mm	□	□	□
SEPO-3-0079-00-SS	3mm	✳	✳	✳
SEPO-4-0157-00-SS	4mm	✳	✳	✳
SEPO-5-0157-00-SS	5mm	□	□	□
SEPO-6-0157-00-SS	6mm	✳	✳	✳

Geometry- AL

First choice for Aluminum & Non-Ferrous Materials

- Insert with highly positive cutting chipbreaker & sharp cutting edge
- Extra smooth rake face for reduced built-up edge



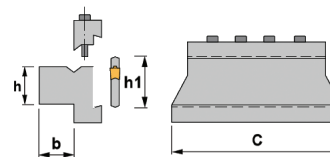
Insert Designation	Insert Width	Un-Coated Grade		
			RTN25	
SEPO-2-0079-00-AL	2mm		□	
SEPO-3-0118-00-AL	3mm		✳	
SEPO-4-0157-00-AL	4mm		✳	

✳ Standard Stock Item □ Non Stock Item



Double Ended Part-Off Blades

Tool Designation	Insert Size	Blade Height	Max. Depth	Directional
BL-SEPOL-26-2MM	2mm	1.02"	1.00"	Left Hand
BL-SEPOR-26-2MM		Right Hand		
BL-SEPOL-32-2MM		1.26"		Left Hand
BL-SEPOR-32-2MM		Right Hand		
BL-SEPON-26-3MM	3mm	1.02"	1.40"	Neutral
BL-SEPON-32-3MM		1.26"	2.00"	Neutral
BL-SEPON-26-4MM	4mm	1.02"	1.60"	Neutral
BL-SEPON-32-4MM		1.26"	2.00"	Neutral
BL-SEPON-32-5MM	5mm	1.26"	2.20"	Neutral
BL-SEPON-32-6MM	6mm	1.26"	2.35"	Neutral



Part-Off Blocks

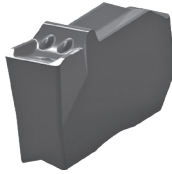
Tool Designation	h1	C	h	b
225.12.216-26I	1.02"	3.43	.625	.625
225.12.220-26I		3.43	.750	.750
225.12.220-32I	1.26"	3.94	.750	.750
225.12.225-32I		4.33	1.000	1.000
225.12.232-32I		4.75	1.250	1.250
225.12.240-32I		4.75	1.500	1.640

Clamp Screw	C-1076	Ejector	2 & 3mm	KEY-GK3
Hex Key	C-5005	Keys	4-6mm	KEY-GK4

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Work Piece Material	Material Specification	Hardness HB	MP40P vc (sfm)	MP30C vc (sfm)	MP45P vc (sfm)
P Steel	non-alloyed steels .15% - .45% C	150 - 250	260 - 590	360 - 620	260 - 490
	Low alloyed steel / tempered	250 - 300	200 - 490	360 - 590	230 - 390
	High alloyed steel /tempered	350	160 - 390	230 - 520	200 - 330
	Corrosion resistant steel annealed	200	160 - 660	390 - 660	300 - 520
K Cast Iron	Grey cast iron	180	330 - 660	300 - 590	---
	Spheroidal	160	330 - 590	330 - 520	---
	Malleable ferritic	130	260 - 520	260 - 490	---

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Work Piece Material	Material Specification	Hardness HB	MP40P vc (sfm)	MP30C vc (sfm)	MP45P vc (sfm)
M Stainless Steel	Annealed ferritic	200	160 - 660	390 - 660	330 - 590
	Quenched austenitic	180	160 - 590	330 - 560	260 - 490
	Quenched duplex	230 - 260	160 - 330	230 - 360	230 - 360
	Hardened martensitic	330	160 - 260	200 - 300	200 - 300
S Exotic	Fe base	200	---	---	70 - 150
	Nickel or cobalt base	250	---	---	50 - 80
	Titanium	Rm440	---	---	160 - 390

Geometry- AL

First choice for Aluminum & Non-Ferrous Materials

- Insert with highly positive cutting chipbreaker & sharp cutting edge
- Extra smooth rake face for reduced built-up edge



Work Piece Material	Material Specification	Hardness HB	---	RTN25 vc (sfm)	---
N Non-Ferrous	Aluminum wrought alloys	100	---	660 - 6560	---
	Aluminum cast alloys <12% Si	90	---	1300 - 4920	---
	Copper alloys (Bronze)	90	---	660 - 1970	---

Grade Descriptions

MP40P

HC-P30 | HC-M25 | HC-K30 | HC-S30

Recommended application:

The universal high-performance grade for steel, austenitic steel, cast iron & heat-resistant alloys

MP30C

HC-P35 | HC-K35 | HC-M30

Recommended application:

The reliable choice for the machining of steel and cast iron.

MP45P

HC-P45 | HC-M40 | HC-S40

Recommended application:

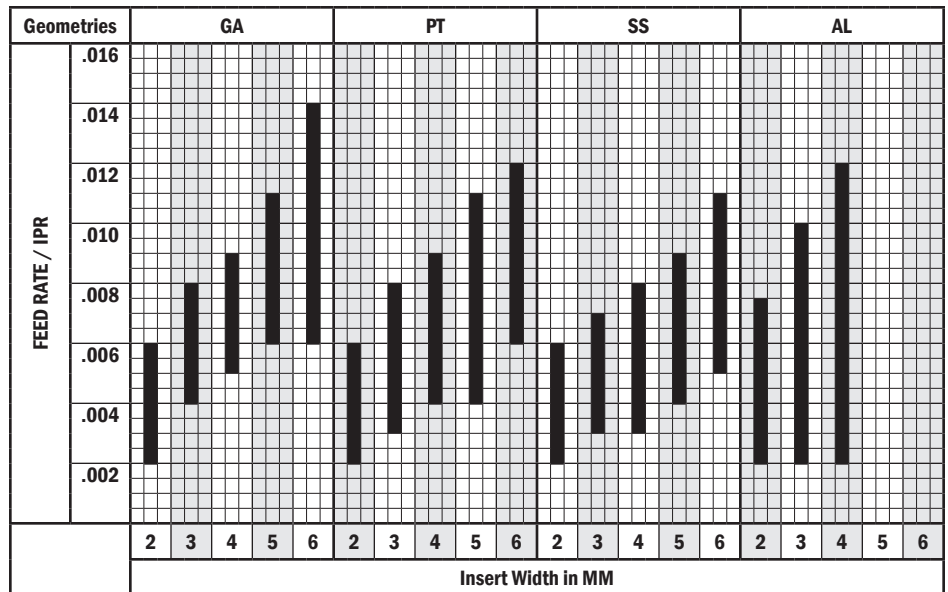
The reliable solution for steel and austenitic steels under unstable conditions.

RTN25

HW-N15 | HW-K15

Recommended application:

The uncoated carbide grade for the machining of aluminium and other non-ferrous metals.



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