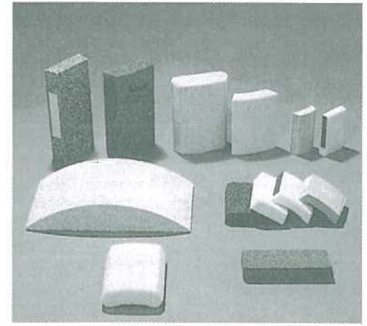
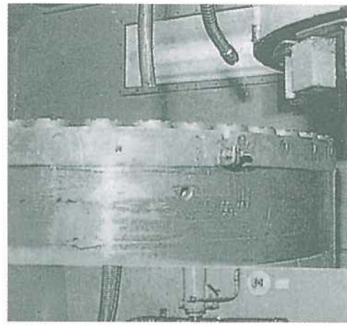


Segments

Tel: 508-987-0121
Fax: 508-987-1233
www.gmsgroup.com

Segments are used for surface grinding and achieve:
free cutting, (better discharge of chips and penetration
of coolant) more stock removal, better grinding results
(better dimensional accuracy, flatness, and surface
finish)



Standard Segment marking (Example):

Shape No.	SG11
Specification	C24-K8V
Dimensions	56 x 16 x 100
Lot No.	H108-V81011

Recommendations

Material	Standard	Free Cutting	Long Life
Cast Iron	C30-J8V	C24-I8V	FSA30-J8V
Mild Steel	FSA30-J8V	WA24-I8V	FA30-J8V
Hardened Steel	WA36-H8V	WA30-H12V	PSA36-I8V
Stainless Steel	WA30-I8V	WA30-H12V	WA36-I8V

Note: In order to selection the proper type of segment, please consider the following point:

1. Type and size of grinding machine.
2. Material of workpiece.
3. Required metal removal rate and surface finish.
4. Operating speed and coolant used.

Note: 1. Select free cutting segment for broader contact grinding.

2. Select long life segment for narrow contact interrupted grinding.

3. Select standard specification for general purpose.

Standard Shapes & Sizes

No.	SHAPE	No.	SHAPE	No.	SHAPE	No.	SHAPE
SG-01 (SD)		SG-08		SG-21		SG-31 (SF)	
SG-02 (SG)		SG-10 (SA)		SG-22		SG-32 (RO)	
SG-03		SG-11 (SO)		SG-23 (SB)		SG-35	
SG-04 (BL)		SG-12		SG-24 (SC)		SG-36 (STG)	
SG-05 (CD)		SG-13		SG-25		SG-37 (SE)	
SG-07		SG-14 (SA)		SG-26		SG-38 (SEI)	

Note: 1. C: Height D: Chuck diameter

2. Please place order according to dimensions marked in above drawing.

3. Please inform the numbers of segments per set in your order.

4. Additional shapes are available or request.

Shape	Size (mm)				Size (inch)				Drawing No.	Shape NO.	Remark			
	A	B	C	A1	A	B	C	A1						
SG01 	60	16	100	42	2-3/8"	0.63"	4"	12-1/32"	M11-01-022	SG01-017				
	68	24	100	38	21-1/16"	15/16"	4"	1-1/2"	M11-01-066	SG01-029				
	75	18	95	52	3"	3/4"	33/4"	2"	M11-00-002	SG01-044				
	75	25	112	46	3"	1"	47/16"	1-13/16"	M11-01-072	SG01-054				
	95	25	120	72	3-3/4"	1"	43/4"	22-7/32"	M11-01-029	SG01-119	Gockel			
	115	30	180	80	4-1/2"	1-3/16"	7"	3-1/8"	M11-01-048	SG01-160				
	127	32	127	100	5"	1-1/4"	5"	4"	M11-01-063	SG01-171				
	127	38	180	96	5"	1-1/2"	7"	3-3/4"	M11-01-023	SG01-178				
	152	33	127	127	6"	1-1/4"	5"	5"	M11-01-011	SG01-194				
	268	92	180	225	10-9/64"	3-5/8"	7"	8-7/8"	M11-01-045	SG01-212				
	75	20	140	54					M11-01-088	SG01-050				
	75	24	127	52					M11-01-008	SG01-051				
	75	25	100	65					M11-01-035	SG01-053				
	76	20	106	46					M11-01-044	SG01-063				
	84	25	120	79					M11-01-056	SG01-087				
	93	19	125	74					M11-01-014	SG01-111				
	95	30	120	67					M11-01-019	SG01-124				
	103	25	150	78.5					M11-01-007	SG01-133				
	122	35.5	150	84					M11-01-025	SG01-168				
	130	42	180	120					M11-02-030	SG01-182				
	185	40	200	143					M11-02-005	SG01-203				
	128	35	200	93					M11-00-012	SG01-180				
	250	100	80	150					M11-00-503	SG01-210	M12 x 1.75P x 15h			
	110	40	52	98					M11-00-505	SG01-150				
	103	25	200	78.5					M11-01-099	SG01-134				
SG02 	97	32	125	80	313/16"	11/4"	5"	35/32"	M11-01-051	SG02-004				
	117	44	152	95	45/8"	13/4"	6"	33/4"	M11-01-067	SG02-011				
	127	38	152	115	5"	11/2"	6"	41/2"	M11-01-006	SG02-018				
SG03 	141	32	127	96	59/16"	11/4"	5"	33/4"	M11-01-507	SG03-003				
	174	38	150	157	627/32"	11/2"	6"	63/16"	M11-01-517	SG03-004				
	187	38	127	165	711/32"	11/2"	5"	61/2"	M11-01-002	SG03-006				
	187	38	159	165	711/32"	11/2"	61/4"	61/2"	M11-01-003	SG03-007				
SG04 	145	50	150		511/16"	2"	6"		M11-01-058	SG04-003				
	152	32	159		6"	11/4"	61/4"		M11-01-040	SG04-004	Blanchard			
	159	32	159		61/4"	11/4"	61/4"		M11-01-012	SG04-007				
	180	44	152		71/16"	13/4"	6"		M11-01-013	SG04-014				
SG05 	70	15	150		23/4"	19/32"	6"		M11-01-518	SG05-005				
	230	76	67		9"	3"	25/8"		M11-00-004	SG05-029				
	257	48.5	127		101/8"	17/8"	5"		M11-02-001	SG05-030				
	286	57	152		111/4"	21/4"	6"		M11-01-020	SG05-033	Blanchard			
	286	76	203		111/4"	3"	8"		M11-02-004	SG05-048	Blanchard			
SG07 	184	39	140	19.5	71/4"	117/32"	51/2"	3/4"	M11-01-032	SG07-001				
SG08 	70.5	15	150		23/4"	19/32	6"		M11-01-053	SG08-001				

■ Standard Shapes & Sizes

Shape	Size (mm)				Size (inch)				Drawing No.	Shape NO.	Remark				
	A	B	C	A1	A	B	C	A1							
SG10	48.5	25	120		1-7/8"	1"	4-23/32"			SG10-005	Ichikawa				
	49	25							M11-06-520	SG10-005					
	49.5	25	125		1-15/16"	1"	5"			SG10-007	Ichikawa				
	51	51	203		2"	2"	8"			SG10-014	Miscellaneous				
	66	40	230						M11-02-011	SG10-020					
	76	25	152		3"	1"	6"			SG10-029	Schneider				
	76	25	178		3"	1"	7"			SG10-030	Podasky				
	76	35	178		3"	13/8"	7"			SG10-031	Miscellaneous				
	77	50.8	114						M11-01-093	SG10-032					
	79	24	152		3-1/8"	15/16"	6"			SG10-033	Schneider				
	79	25	152		31/8"	1"	6"			SG10-034	T.O.S.				
	79	30.5	180						M11-01-080	SG10-035					
	80	25	150		3-5/32"	1"	6"			SG10-036	Refarm				
	81	19	152		3-3/16"	3/4"	6"			SG10-041	Billeter				
	81	25	152		3-3/16"	1"	6"			SG10-042	Billeter				
	86	22	152		3-3/8"	7/8"	6"			SG10-044	Praehomawerk				
	90	35	200						M11-02-014	SG10-050					
	90	37	197		3-9/16"	1-7/16"	7-3/4"			SG10-052	Gockel				
	91	35.5	155						M11-01-075	SG10-053					
	108	40	160		4-1/4"	1-9/16"	6-5/16"			SG10-056	Schneider				
	110	40	160		4-11/32"	1-9/16"	6-5/16"			SG10-059	Gockel				
	120	25	300		4-23/32"	1"	11-13/16"		M11-01-078	SG10-062	Reform				
	120	30	180		4-23/32"	1-3/16"	7"			SG10-064	Miscellaneous				
	120	35	180		4-23/32"	1-3/4"	7"			SG10-065	Miscellaneous				
	120	40	180		4-23/32"	1-9/16"	7"		M11-01-078	SG10-066	Naxos				
SG11	50	25	110	43	2"	1"	4-11/32"	1-11/16"	M11-01-074	SG11-012					
	51	16	108	48	2"	5/8"	4-1/4"	1-7/8"	M11-01-071	SG11-011					
	55	15	90	50	2-11/64"	1-9/32"	3-17/32"	2"	M11-01-013	SG11-017	Miscellaneous				
	56	16	100	45	2-13/64"	5/8"	4"	1-25/32"	M11-01-027	SG11-024	AMC-Berco				
	58	20	115	49	2-9/32"	3/4"	4-9/16"	1-15/16"	M11-01-511	SG11-027	Alpha				
	60	22	110	54	2-3/8"	7/8"	4-3/8"	2-1/8"	M11-01-028	SG11-033	Albant				
	65	20	60	60	2-9/16"	3/4"	2-3/8"	2-3/8"	M11-00-009	SG11-041	Zanrosso				
	65	20	100	45	2-9/16"	3/4"	4"	1-3/4"	M11-01-	SG11-042	Cimar				
	65	20	100	48	2-9/16"	3/4"	4"	1-7/8"	M11-01-090	SG11-043	Matra				
	70	25	110	64	2-3/4"	1"	43/8"	2-9/16"	M11-01-097	SG11-048					
	70	25	150	65	2-3/4"	1"	6"	2-9/16"	M11-01-081	SG11-050					
	87	30	160	76	3-7/16"	1-3/16"	6-5/16"	3"	M11-01-083	SG11-054					
	90	30	160	80	3-17/32"	1-3/16"	6-5/16"	3-5/32"	M11-01-016	SG11-060					
	90	30	190	80	3-17/32"	1-3/16"	7-1/2"	3-5/32"	M11-01-079	SG11-062					
	90	35	210	80	3-17/32"	1-3/4"	8-1/4"	3-5/32"	M11-02-009	SG11-064					
	92	30	190	82					M11-01-084	SG11-066					
	100	35	150	85	4"	1-3/4"	6"	3-7/32"	M11-01-089	SG11-068					
	102	34	203	90	4"	1-11/32"	8"	3-17/32"	M11-01-076	SG11-070					
	102	41	125	82	4"	1-5/8"	5"	3-11/32"	M11-01-024	SG11-073					
	103	38	180	94					M11-00-508	SG11-075					
	103	38	200	94					M11-02-016	SG11-076					
	106	64	160	95	4-11/64"	2-1/2"	6-5/16"	3-3/4"	M11-01-018	SG11-078					
	120	41	250	106	4-23/32"	1-5/8"	9-7/8"	4-11/64"	M11-01-094	SG11-080					
	120	45	115	76	4-23/32"	1-3/4"	4-9/16"	3"	M11-01-085	SG11-082					

■ Standard Shapes & Sizes

Shape	Size (mm)				Size (inch)				Drawing No.	Products Code				Remark
	A	B	C	A1	A	B	C	A1		WA		3KG		
	SG14	110	45	140					M11-01-069	SG14-002-WA		SG14-002-3KG		
		112	45	150		4-1/2"	1-3/4"	6"	M11-01-042	SG14-003-WA		SG14-003-3KG		
		117	45	152		4-5/8"	1-3/4"	6"	M11-01-064	SG14-008-WA		SG14-008-3KG		Snow
		117	45	203		4-5/8"	1-3/4"	8"	M11-02-006	SG14-009-WA		SG14-009-3KG		Snow
	SG22	65	20	65					M11-00-010	SG22-002-WA		SG22-002-3KG		
		65	20	80					M11-00-011	SG22-003-WA		SG22-003-3KG		
		65	22	76		2-9/16"	7/8"	3"	M11-00-052	SG22-004-WA		SG22-004-3KG		
		85	32	100		3-11/32"	1-1/4"	4"	M11-01-061	SG22-005-WA		SG22-005-3KG		
	SG23	65	24	80					M11-01-086	SG23-018-WA		SG23-018-3KG		
		65	25	105		2-9/16"	1"	4-1/8"	M10-01-096	SG23-019-WA		SG23-019-3KG		Berco, Zanrosso
		65	25	150		2-9/16"	1"	6"	M11-01-087	SG23-021-WA		SG23-021-3KG		Miscellaneous
		68	27	112					M11-01-510	SG23-025-WA		SG23-025-3KG		
		70	30	110					M11-01-026	SG23-030-WA		SG23-030-3KG		
		71	28.5	150					M11-01-073	SG23-032-WA		SG23-032-3KG		
		76	32	127		3"	1-1/4"	5"	M11-01-044	SG23-035-WA		SG23-035-3KG		
		80	32	150					M11-01-516	SG23-037-WA		SG23-037-3KG		
		87	30	130					M11-01-054	SG23-040-WA		SG23-040-3KG		
		87	32	100		3-7/16"	1-1/4"	4"	M11-01-038	SG23-041-WA		SG23-041-3KG		
		90	30	127					M11-01-010	SG23-042-WA		SG23-042-3KG		Berco, Zanrosso
		100	38	150		4"	1-1/2"	6"	M11-01-098	SG23-045-WA		SG23-045-3KG		
		103	38	153		4-1/16"	1-1/2"	6"	M11-01-059	SG23-051-WA		SG23-051-3KG		Churchill
		103	38	155	84				M11-01-053	SG23-052-WA		SG23-052-3KG		
		103	38	180		4-1/16"	1-1/2"	7"	M11-01-043	SG23-054-WA		SG23-054-3KG		Churchill
		103	38	203		4-1/16"	1-1/2"	8"	M11-01-007	SG23-056-WA		SG23-056-3KG		Churchill
		103	38	205	84				M11-02-013	SG23-057-WA		SG23-057-3KG		
		103	38	228		4-1/16"	1-1/2"	9"	M11-02-003	SG23-059-WA		SG23-059-3KG		Churchill
		106	40	150					M11-01-041	SG23-061-WA		SG23-061-3KG		
	SG24	106	44.5	150		4-3/16"	1-3/4"	6"	M11-01-015	SG24-016-WA		SG24-016-3KG		
		117	45	152		4-5/8"	1-3/4"	6"	M11-01-077	SG24-029-WA		SG24-029-3KG		Lumsden
		117	45	203	79	4-5/8"	1-3/4"	8"	M11-02-002	SG24-030-WA		SG24-030-3KG		Lumsden
		168	57	228		6-5/8"	2-1/4"	9"	M11-02-010	SG24-041-WA		SG24-041-3KG		Lumsden
	SG25	55	28	120					M11-01-091	SG25-001-WA		SG25-001-3KG		
		55	28	150					M11-01-092	SG25-003-WA		SG25-003-3KG		
		84	34	150	14				M11-01-082	SG25-008-WA		SG25-008-3KG		
		110	45	150	27				M11-01-050	SG25-010-WA		SG25-010-3KG		
		112	44	150					M11-01-053	SG25-012-WA		SG25-012-3KG		
		113.5	45	135	77				M11-01-037	SG25-014-WA		SG25-014-3KG		
		117	44	205					M11-01-008	SG25-017-WA		SG25-017-3KG		
	SG32	105	32	108	98.5	4-1/8"	1-1/4"	4-1/4"	M11-01-021	SG32-007-WA		SG32-007-3KG		Rogers
		50	15.5	50	48				M11-00-016	SG32-002-WA		SG32-002-3KG		

[illegible]