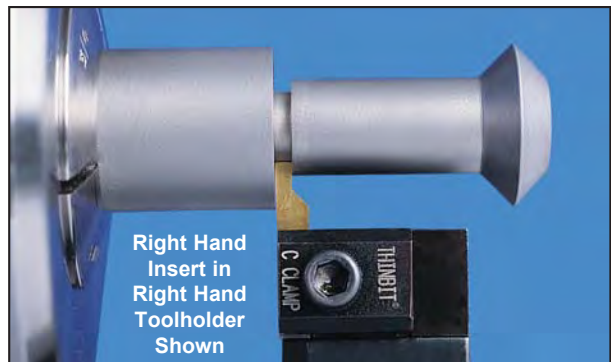


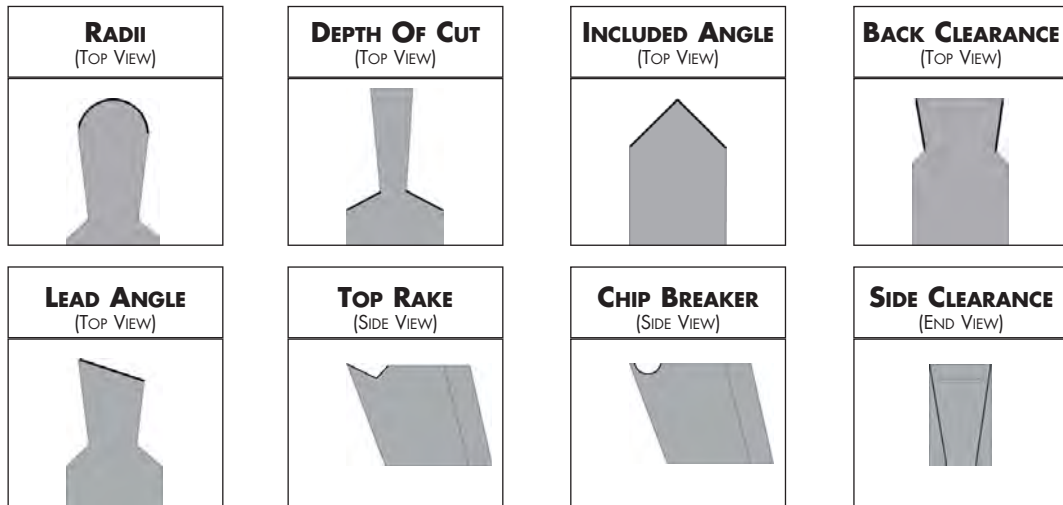
PRODUCT INFORMATION

- External grooving and turning.
- Internal grooving and boring with 1.250" minimum bore diameter.
- .004" through .150" in .001" increments available.
- Sub-micron grain **DURA-MAX[®] 2000** and **5000** Carbides and High Speed Steel.
- Inserts available with TiN, TiAlN, TiCN and Diamond coating.



MODIFICATIONS

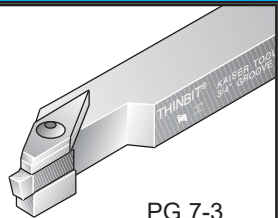
SEE PAGE 8-3 FOR ADDITIONAL INFORMATION



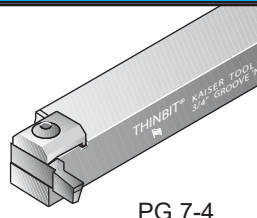
TOOLHOLDER SELECTIONS

CNC, SWISS, CONVENTIONAL STYLE

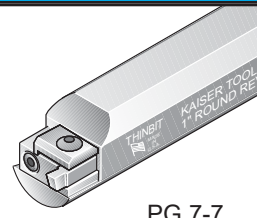
ROUND STYLE



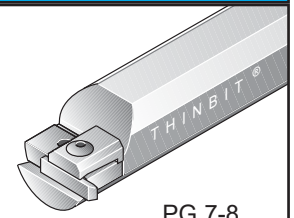
PG 7-3



PG 7-4



PG 7-7



PG 7-8

TECHNICAL SECTIONS

PRODUCT DEMONSTRATION



www.thinbit.com/qr1-9

SPEEDS AND FEEDS

PG 9-10

APPLICATION REFERENCE

PG 9-3

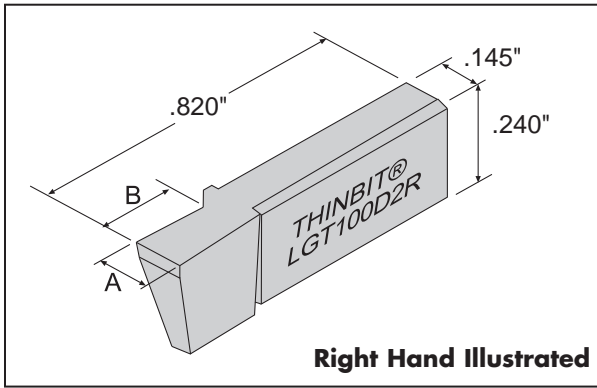
TROUBLESHOOTING

PG 9-7

KAISER TOOL COMPANY, INC.

Phone: 888-THINBIT (888-844-6248) or (260) 484-3620 • Fax: 888-THINFAX (888-844-6329) or (260) 482-1881
www.thinbit.com • General E-mail: thinbit@kaisertool.com • Orders: orders@thinbit.com • Quotes: quotes@thinbit.com

O.D./I.D. GROOVING AND TURNING INSERTS



FRONT RAKE:

CARBIDE: Primary 10° honed, Secondary 15°
 HIGH SPEED STEEL: 15°

BACK CLEARANCE: 2-1/2° both sides

SIDE CLEARANCE: .004" - .019" - 0° both sides
 .020" - .150" - 5° both sides

RADIUS: Sharp corner through full radius available

TOP RAKE: 0°

LEAD ANGLE: 0°

NOTES: Capable of grooving along a shoulder
 .004"-.019" inserts are not designed for turning

**O.D. & I.D.
GROOVING**

ORDERING INSTRUCTIONS

Complete the **ORDER CODE** in the table below that represents your selection of groove width and insert grade.

EXAMPLE:

The **ORDER CODE** for a right hand, .100" insert width in **DURA-MAX® 2000** is:

LGT 1 0 0 D2 R

Specify the Tool Width 'A' _____ ↑

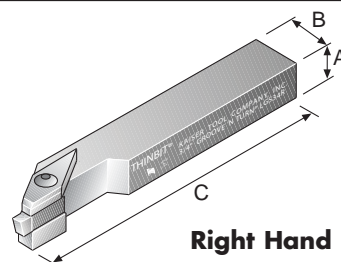
SPECIFICATIONS			ORDER CODE					INFO.	
Insert Orientation	Insert Width 'A' +.0009"/-.0000"	Depth of Cut 'B' Width DOC .004"-.033" = 3 x 'A' .034"-.039" = .100" .040"-.100" = 2.5 x 'A' .101"-.150" = .250"	Insert Grades <small>See Page 9-5 for expanded material descriptions and Page 9-10 for Speeds and Feeds information</small>			Add-ons <small>Use 'Order Code' and Add</small>			Toolholder Catalog Section 7 Use Toolholders Beginning With
			DURA-MAX® 2000 Carbide <small>For Steel & Interrupted Cutting</small>	DURA-MAX® 5000 Carbide <small>For Aluminum & Non-ferrous</small>	High Speed Steel	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6	
Right Hand	.004"-.150"		LGT ___ D2R	LGT ___ D5R	LGT ___ HSR	add 'FR'	add 'CR___' <small>(indicate size in .xxx")</small>	TiN add 'C' TiCN add 'D'	'L' Use right hand straight holder or left hand 90° holder
Left Hand	.004"-.150"		LGT ___ D2L	LGT ___ D5L	LGT ___ HSL	add 'FR'	add 'CR___' <small>(indicate size in .xxx")</small>	TiAIN add 'E' Diamond add 'F'	'L' Use left hand straight holder or right hand 90° holder

KAISER TOOL COMPANY, INC.

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 www.thinbit.com • General E-mail: thinbit@kaisertool.com • Orders: orders@thinbit.com • Quotes: quotes@thinbit.com

PRODUCT INFORMATION

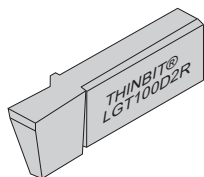
- Designed for CNC, conventional and top slide position on Swiss screw machines.
- Shank sizes 5/16", 3/8", 1/2", 5/8", 3/4", 1" and 1-1/4". Metric sizes also available.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



Right Hand Illustrated

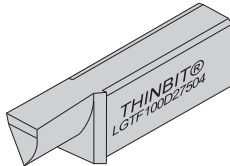
INSERT SELECTIONS

GROOVING



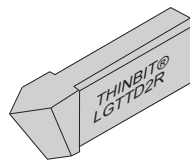
PG 1-9

FACE GROOVING



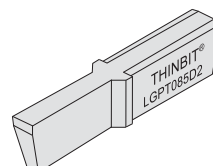
PG 2-9

THREADING



PG 4-9

PARTING



PG 5-3



Scan this code for additional information.

www.thinbit.com/qr7-3

ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of shank dimensions.

EXAMPLE:

The **ORDER CODE** for a .750" Right Hand square shank for inserts beginning with 'L' is:

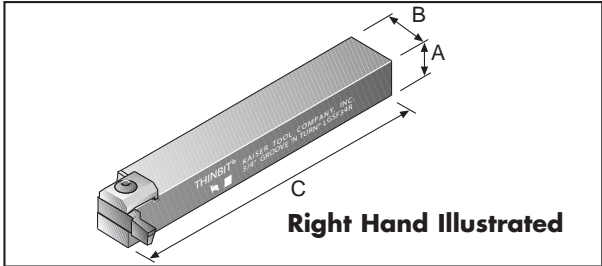
LGS34R

SPECIFICATIONS				ORDER CODE					
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Clamp and Hardware		Replacement Parts			
	'A'	'B'	'C'	For Inserts Beginning With 'L'		Clamp	Screw	Wrench	Pin
RIGHT HAND	LEFT HAND								
Straight Use right hand holder with right hand inserts Use left hand holder with left hand inserts	.312"	.500"	4.840"	LGS56R	LGS56L	Right Hand: Clamp X Left Hand: Clamp Y	S3808	W1005	P0206
	.375"	.500"	4.840"	LGS38R	LGS38L				
	.500"	.500"	4.840"	LGS12R	LGS12L				
	.625"	.625"	4.840"	LGS58R	LGS58L				
	.750"	.750"	4.840"	LGS34R	LGS34L				
	1.000"	1.000"	4.840"	LGS01R	LGS01L				
	1.250"	1.250"	4.840"	LGS14R	LGS14L				
	8mm	.500"	4.840"	LGS08RM	LGS08LM				
	10mm	.500"	4.840"	LGS10RM	LGS10LM				
	12mm	.500"	4.840"	LGS12RM	LGS12LM				
	16mm	.750"	4.840"	LGS16RM	LGS16LM				
	20mm	1.000"	4.840"	LGS20RM	LGS20LM				
25mm	1.000"	4.840"	LGS25RM	LGS25LM					

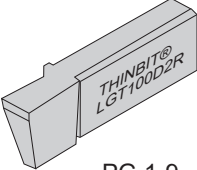
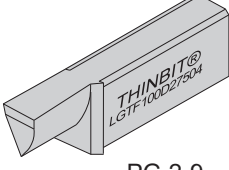
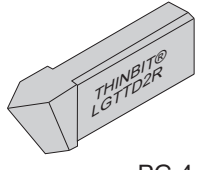
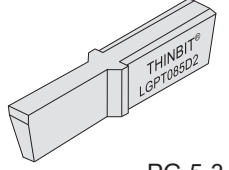
KAISER TOOL COMPANY, INC.

PRODUCT INFORMATION

- Designed for CNC and conventional machines.
- Shank sizes 5/16", 3/8", 1/2", 5/8", 3/4", 1" and 1-1/4". Metric sizes also available.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



INSERT SELECTIONS

GROOVING	FACE GROOVING	THREADING	PARTING
 PG 1-9	 PG 2-9	 PG 4-9	 PG 5-3



Scan this code for additional information.

www.thinbit.com/qr7-4

ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of shank orientation and dimensions.

EXAMPLE:

The **ORDER CODE** for a .750" right hand shank for inserts beginning with 'L' is:
LGSF34R

SPECIFICATIONS				ORDER CODE					
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Clamp and Hardware For Inserts Beginning With 'L'		Replacement Parts			
	'A'	'B'	'C'	RIGHT HAND	LEFT HAND	Clamp	Screw	Wrench	Pin
90° Use right hand holder with left hand inserts	.312"	.500"	4.840"	LGSF56R		Clamp C	S3808	W1005	P0312
	.375"	.500"	4.840"	LGSF38R					
	.500"	.500"	4.840"	LGSF12R					
	.625"	.625"	4.840"	LGSF58R	LGSF58L				
	.750"	.750"	4.840"	LGSF34R	LGSF34L				
	1.000"	1.000"	4.840"	LGSF01R	LGSF01L				
	1.250"	1.250"	4.840"	LGSF14R	LGSF14L				
Use left hand holder with right hand inserts	8mm	.500"	4.840"	LGSF08RM					
	10mm	.500"	4.840"	LGSF10RM					
	12mm	.500"	4.840"	LGSF12RM					
	16mm	.750"	4.840"	LGSF16RM	LGSF16LM				
	20mm	1.000"	4.840"	LGSF20RM	LGSF20LM				
	25mm	1.000"	4.840"	LGSF25RM	LGSF25LM				

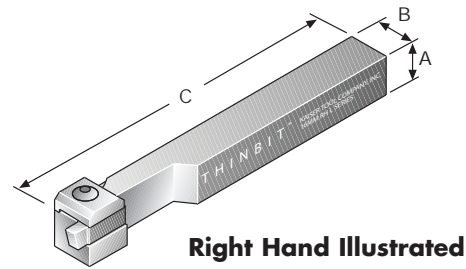
GROOVE 'N TURN®
TOOLHOLDERS

KAISER TOOL COMPANY, INC.

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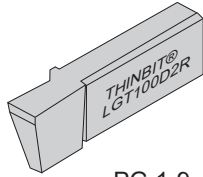
PRODUCT INFORMATION

- Designed for top slide position on Swiss screw machines.
- Shank sizes 1/2", 12mm and 16mm in right hand orientation.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



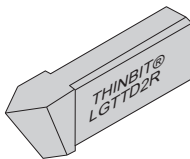
INSERT SELECTIONS

GROOVING



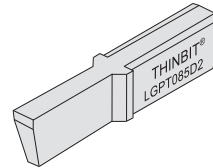
PG 1-9

THREADING



PG 4-9

PARTING



PG 5-3



Scan this code for additional information.

www.thinbit.com/qr7-5

ORDERING INSTRUCTIONS

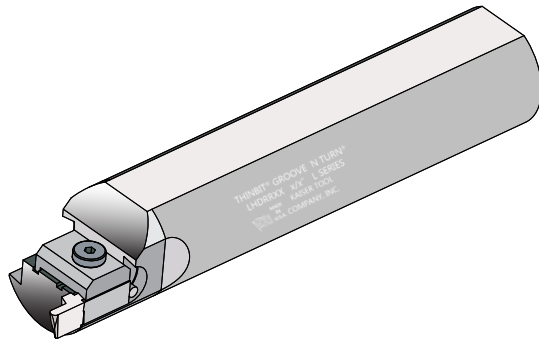
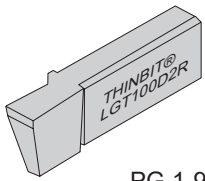
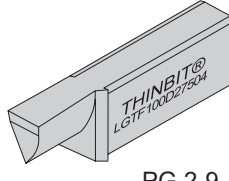
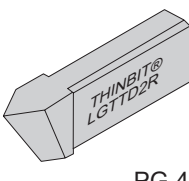
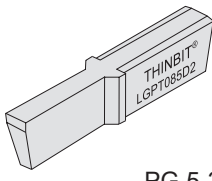
Select the **ORDER CODE** in the table below that represents your selection of shank orientation and dimensions.

EXAMPLE:

The **ORDER CODE** for a .500" shank, right hand tool for inserts beginning with 'L' is:
LSS12R

SPECIFICATIONS				ORDER CODE				
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Clamp and Hardware For Inserts Beginning With 'L'	Replacement Parts			
	'A'	'B'	'C'		Clamp	Screw	Wrench	Pin
Right Hand	.500"	.500"	4.840"	LSS12R	Clamp C	S3808	W1005	P0305
Use with right hand and centered inserts	12mm	12mm		LSS12RM				
	16mm	16mm		LSS16RM				
Left Hand	.500"	.500"	4.840"	LSS12L				
Use with left hand and centered inserts	12mm	12mm		LSS12LM				
	16mm	16mm		LSS16LM				

KAISER TOOL COMPANY, INC.

PRODUCT INFORMATION	<ul style="list-style-type: none"> Designed for boring bar positions on all machines. Can be used with a boring head to trepan on a mill. Shank may need to be shortened. Toolholder reversible by changing clamp to other side. Shank sizes 12mm, 1/2", 5/8", 16mm, 3/4" 20mm, 22mm, 25mm and 1". All 1/2", 5/8" and 3/4" shanks are made from 1" shank. For a shortened shank see page 11-2. Modifications can be provided on any of our tooling. Please contact us with your application requirements. 				 <p>Heavy Duty Round Reversible Toolholder</p>		
	INSERT SELECTIONS	GROOVING	FACE GROOVING	THREADING	PARTING		
 PG 1-9		 PG 2-9		 PG 4-9		 PG 5-3	

ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of shank dimensions.

EXAMPLE:

The **ORDER CODE** for a 3/4" round shank for inserts beginning with 'L' is:

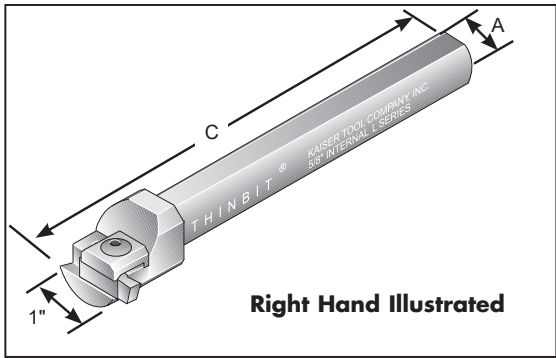
LHDRR34

SPECIFICATIONS		ORDER CODE		
Shank Orientation	Shank Dimensions	Toolholder Package Includes Shank, Clamp and Hardware		
		For Inserts Beginning With	Clamp	Clamp Hardware
	'A'	'L'		
<p style="text-align: center;">Right Hand or Left Hand</p> <p>Use as right hand with right hand inserts</p> <p>Use as left hand with left hand inserts</p> <p>Use as either hand with centered inserts</p>	1/2"	LHDRR12	Clamp C	Screw: S3808 Wrench: W1005 Pin: P0305
	5/8"	LHDRR58		
	3/4"	LHDRR34		
	1"	LHDRR01		
	12 mm	LHDRR12M		
	16 mm	LHDRR16M		
	20 mm	LHDRR20M		
	22 mm	LHDRR22M		
25 mm	LHDRR25M			

KAISER TOOL COMPANY, INC.

PRODUCT INFORMATION

- Designed for boring bar positions on all machines.
- Toolholder reversible for left and right hand orientation.
- Shank sizes 1/2", 5/8", 3/4" and 1".
- All 1/2", 5/8" and 3/4" shanks are made from 1" shank.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



INSERT SELECTIONS

GROOVING	FACE GROOVING	THREADING	PARTING
 PG 1-9	 PG 2-9	 PG 4-9	 PG 5-3



Scan this code for additional information.

www.thinbit.com/qr7-8

ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of shank orientation and dimensions.

EXAMPLE:

The **ORDER CODE** for a .625" right hand shank for inserts beginning with 'L' is:

LR5806

SPECIFICATIONS			ORDER CODE					
Shank Orientation	Minimum Bore Diameter	Shank Dimensions		Toolholder Package Includes Shank, Clamp and Hardware For Inserts Beginning With 'L'	Replacement Parts			
		'A'	'C'		Clamp	Screw	Wrench	Pin
Right Hand or Left Hand Use as right hand with left hand inserts; Use as left hand with right hand inserts; Use as either hand with centered inserts.	1.250"	.500"	5.500"	LR1206	Clamp C	S3808	W1005	P0305
		.625"		LR5806				
		.750"		LR3406				
		1.000"	5.500"	LR0106				
			11.875"	LR0112				

ROUND TOOLHOLDERS

KAISER TOOL COMPANY, INC.