
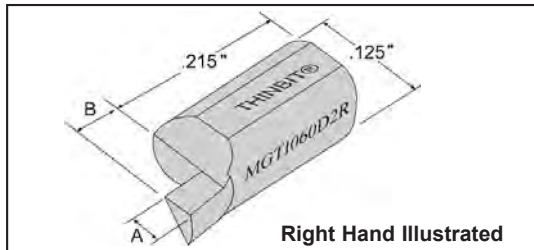


PRODUCT INFORMATION

- Internal face grooving and profiling for diameters of .415" and larger.
- Shank sizes 3/8", 1/2" and 5/8" in steel; 3/8" and 1/2" in heavy metal.
- 1/2" and 5/8" diameter toolholders are reversible for right and left hand orientation.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



	PRODUCT DEMONSTRATION	SPEEDS AND FEEDS	APPLICATION REFERENCE	TROUBLESHOOTING
TECHNICAL SECTIONS	 www.thinbit.com/qr2-5	PG 9-12	PGS 9-3 & 9-4	PG 9-7

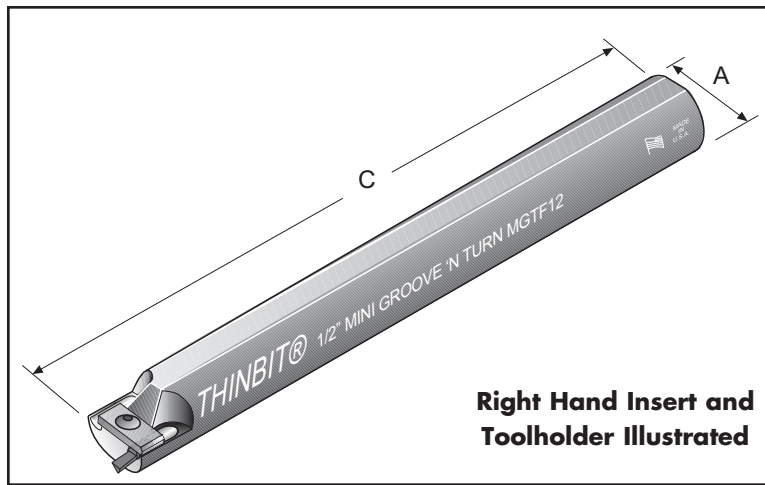


FRONT RAKE: 15°
 BACK CLEARANCE: 2° both sides
 SIDE CLEARANCE: 2° I.D. side
 RADIUS: Sharp corner through full radius available
 TOP RAKE: 0°
 LEAD ANGLE: 0°
 'A' TOLERANCE:
 .004" - .063": +.0009/-.0000
 .064" - .125": +.001/-.001

SPECIFICATIONS			ORDER CODE				
Insert Orientation	Insert Width 'A'	Depth of Cut 'B'	Insert Grades		Add-ons		
			See Page 9-5 for expanded material descriptions and Page 9-10 or 9-12 for speeds and feeds information		Use 'Order Code' and Add		
			DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Nonferrous	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6
Right Hand For ID grooving use left hand 'MGT' Page 1-5	.004"-.063"	<u>Width</u> <u>DOC</u> .004"-.031" = 2 x 'A' .032"-.063" = .063"	MGTI _ _ _D2R	MGTI _ _ _D5R	add 'FR'	add 'CR_ _ _' (indicate size in .xxx")	TiN add 'C' TiCN add 'D' TiAlN add 'E' Diamond add 'F'
	For face grooving use right hand 'MGTF' Page 2-6	.064"-.125"					
Left Hand For ID grooving use right hand 'MGT' Page 1-5	.004"-.063"	<u>Width</u> <u>DOC</u> .004"-.031" = 2 x 'A' .032"-.063" = .063"	MGTI _ _ _D2L	MGTI _ _ _D5L			
	For face grooving use left hand 'MGTF' Page 2-6	.064"-.125"					

KAISER TOOL COMPANY, INC.

I.D. FACE GROOVING TOOLS



Note:

- 1/2" and 5/8" toolholders are reversible for right hand or left hand orientation.

- For face grooving:

<u>Insert Width</u>	<u>Depth of Cut</u>
.004"-.031"	2 x width
.032"-.063"	.063"
.064"-.083"	1.5 x width
.084"-.125"	.125"

I.D. FACE GROOVING

ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of tool specifications.

EXAMPLE:

The **ORDER CODE** for a .530" minimum bore and a 1/2" steel shank is:
MGTF12

SPECIFICATIONS		ORDER CODE				INFORMATION		
Minimum Bore & Major Diameter	Orientation & Toolholder Material	Toolholder Package Includes Shank, Clamp and Hardware	Replacement Parts			Shank Diameter 'A'	Shank Length 'C'	Inserts Page 2-5 Use Inserts Beginning With
			Clamp Only	Screw Only	Wrench Only			
.415"	Right Hand Steel	MGTF38R	MGC1	F31	W31	3/8"	5.500"	'MGTI' Use right hand inserts
	Right Hand Heavy Metal	MGTF38RHM					5.485"	
	Left Hand Steel	MGTF38L					5.500"	'MGTI' Use left hand inserts
	Left Hand Heavy Metal	MGTF38LHM					5.485"	
.530"	Steel	MGTF12				1/2"	5.500"	'MGTI' Use with left hand inserts for clockwise or with right hand inserts for counter-clockwise
	Heavy Metal	MGTF12HM					5.485"	
.650"	Steel	MGTF58				5/8"	5.500"	

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