


FRONT RAKE:  
 CARBIDE: Primary 7° honed, Secondary 15°  
 HIGH SPEED STEEL: 15° on SPT025HS,  
 7° all others  
 BACK CLEARANCE: 0° SPT045HS and  
 SPT062HS; 1° all others  
 SIDE CLEARANCE: 1°  
 RADIUS: None  
 TOP RAKE: 0°  
 LEAD ANGLE: 0°  
 'A' TOLERANCE: .025" - .115": +.001"/-.001"

GROOVING & PARTING INSERTS

<b>PRODUCT INFORMATION</b>	<ul style="list-style-type: none"> <li>This insert style will cut to within 1/16" of a shoulder.</li> <li>.025", .045", .062", .085" and .115"</li> <li>Parting off up to 1" diameter</li> <li>Centered</li> <li>Sub-micron grain <b>DURA-MAX® 2000</b> and <b>5000</b> Carbides and High Speed Steel.</li> <li>Inserts available with TiN, TiAlN, TiCN and Diamond coating.</li> </ul>
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TECHNICAL SECTIONS	PRODUCT DEMONSTRATION	SPEEDS AND FEEDS	APPLICATION REFERENCE	TROUBLESHOOTING
	 <a href="http://www.thinbit.com/qr10-2">www.thinbit.com/qr10-2</a>	PG 9-20	PG 9-4	PG 9-7

## ORDERING INSTRUCTIONS

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

**EXAMPLE:**

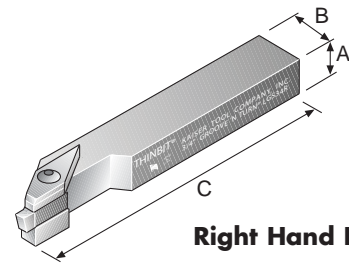
The **ORDER CODE** for an .085" wide parting insert in **DURA-MAX® 5000** is:  
**LPT085D5**

SPECIFICATIONS		ORDER CODE				INFORMATION						
Groove Width	Depth of Cut	Insert Grades See Pages 9-5 for expanded material descriptions and Page 9-20 for Speeds and Feeds information			Coatings See Page 9-6 for expanded coating descriptions				Blank Width	Overall Length	Blank Height	Toolholder Catalog Section 7 & 10
'A'	'B'	DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Nonferrous	High Speed Steel	Use uncoated part number and add coating code				'C'	'D'	'E'	Use Toolholders Beginning With
					TIN	TICN	TiAlN	Diamond				
.025"	.200"	SPT025D2	SPT025D5	SPT025HS						.650"		'S' 'EM' 'ROM'
.045"	.500"	SPT045D2	SPT045D5	SPT045HS	add 'C'	add 'D'	add 'E'	add 'F'	.068"	1.000"	.240"	Page 10-5 through 10-8
.062"		SPT062D2	SPT062D5	SPT062HS								
.085"	.500"	LPT085D2	LPT085D5						.125"	1.000"	.238"	'L' 'EM' 'ROM'
.115"		LPT115D2	LPT115D5		add 'C'	add 'D'	add 'E'	add 'F'				

## KAISER TOOL COMPANY, INC.

## PRODUCT INFORMATION

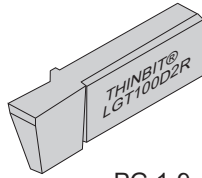
- Designed for CNC, conventional and top slide position on Swiss screw machines.
- Shank sizes 5/16", 3/8", 1/2", 5/8", 3/4", 1" and 1-1/4". Metric sizes also available.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



Right Hand Illustrated

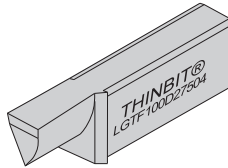
## INSERT SELECTIONS

### GROOVING



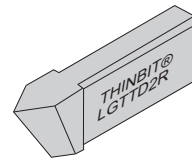
PG 1-9

### FACE GROOVING



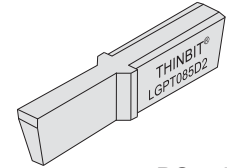
PG 2-9

### THREADING



PG 4-9

### PARTING



PG 5-3



Scan this code for additional information.

[www.thinbit.com/qr7-3](http://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:

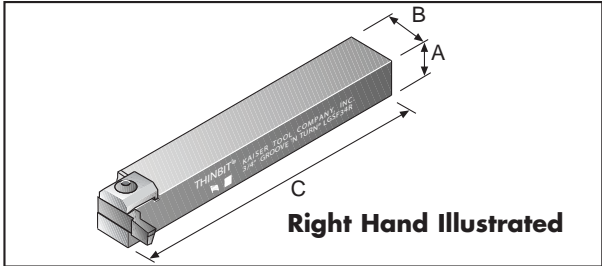
**LGS34R**

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					

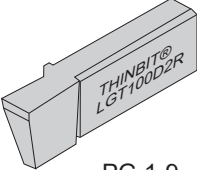
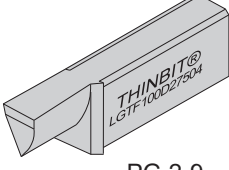
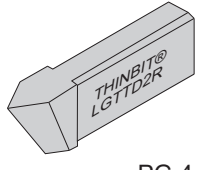
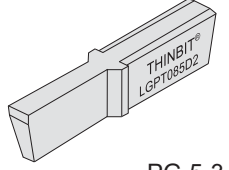
## KAISER TOOL COMPANY, INC.

**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](http://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 <small>Includes Shank, Clamp and Hardware For Inserts Beginning With 'L'</small>		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				

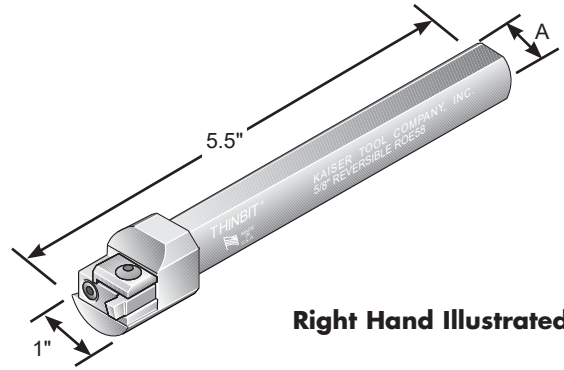
**GROOVE 'N TURN**®  
**TOOLHOLDERS**

**KAISER TOOL COMPANY, INC.**

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](mailto:thinbit@kaisertool.com) • Orders: [orders@thinbit.com](mailto:orders@thinbit.com) • Quotes: [quotes@thinbit.com](mailto:quotes@thinbit.com)

**PRODUCT INFORMATION**

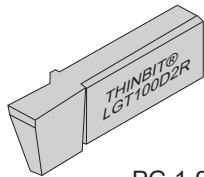
- Designed for boring bar positions on all machines.
- Can be used with a boring head to trepan on a mill. Shank may need to be shortened.
- Toolholder reversible by removing face and bottom screws and rotating head 1/2 turn.
- Shank sizes 1/2", 5/8", 3/4" and 1".
- All 1/2", 5/8" and 3/4" shanks are made from 1" shank.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



**Right Hand Illustrated**

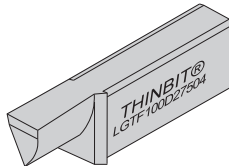
**INSERT SELECTIONS**

**GROOVING**



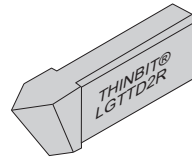
PG 1-9

**FACE GROOVING**



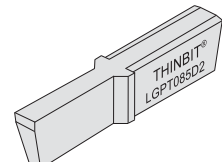
PG 2-9

**THREADING**



PG 4-9

**PARTING**



PG 5-3



Scan this code for additional information.

[www.thinbit.com/qr7-7](http://www.thinbit.com/qr7-7)

**ORDERING INSTRUCTIONS**

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

**EXAMPLE:**

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

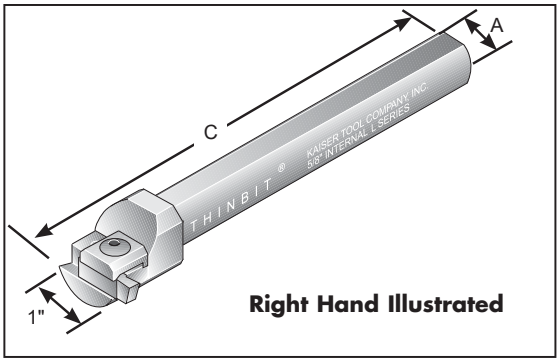
**LROE58**

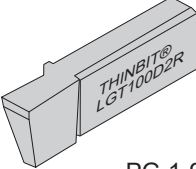
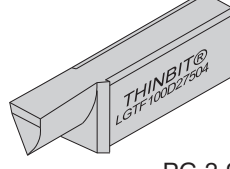
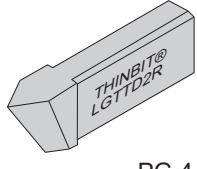
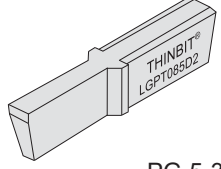
SPECIFICATIONS		ORDER CODE						
Shank Orientation	Shank Dimensions  'A'	Toolholder Package Includes Shank, Head, Clamp and Hardware  For Inserts Beginning With  'L'	Replacement Parts					Clamp Hardware
			Head Only Includes Clamp and Hardware For Inserts Beginning With  'L'	Head Screws	Head Wrenches	Shank	Clamp	
Right Hand or Left Hand  Use as right hand with right hand inserts; Use as left hand with left hand inserts; Use as either hand with centered inserts.	.500"	LROE12	LROEH	1 each: S5806 S2810	1 each: W1006 W1009	RROE12	Clamp C	Screw: S3808  Wrench: W1005
	.625"	LROE58				RROE58		
	.750"	LROE34				RROE34		
	1.000"	LROE01				RROE01		

**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](http://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:**

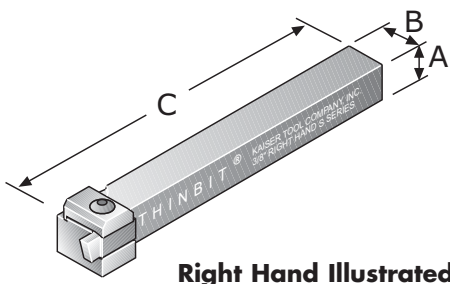
The **ORDER CODE** for a .625" right hand shank for inserts beginning with 'L' is:

**LR5806**

SPECIFICATIONS				ORDER CODE				
Shank Orientation	Minimum Bore Diameter	Shank Dimensions		Toolholder Package Includes Shank, Clamp and Hardware	Replacement Parts			
		'A'	'C'		For Inserts Beginning With 'L'			
	without pin				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.**



**Right Hand Illustrated**

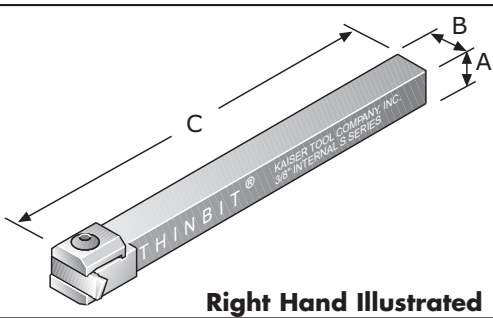
### FLUSHTOP ORDERING INSTRUCTIONS

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

**EXAMPLE:**

The **ORDER CODE** for a .375" shank, right hand flushtop tool for inserts beginning with 'L' is:  
**LFT38R**

SPECIFICATIONS				ORDER CODE							
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Clamp and Hardware		Replacement Parts					
	'A'	'B'	'C'	For Inserts Beginning With		Clamp	Screw	Wrench	Pin		
				'S'	'L'						
Right Hand  Use with right hand and centered inserts	.312"	.312"	4.840"	SFT56R	- - -	Clamp A	S5608	W1005	P0308		
				- - -	LFT56R					Clamp C	S3808
	.375"	.375"	4.840"	SFT38R	- - -					Clamp A	S5608
				- - -	LFT38R					Clamp C	S3808
	.500"	.500"	4.840"	SFT12R	LFT12R					Clamp C	S3808
.625"	.625"	4.840"	SFT58R	LFT58R	Clamp C	S3808					
Left Hand  Use with left hand and centered inserts	.312"	.312"	4.840"	SFT56L	- - -	Clamp A	S5608	W1005	P0308		
				- - -	LFT56L	Clamp C	S3808				
	.375"	.375"	4.840"	SFT38L	- - -	Clamp A	S5608				
				- - -	LFT38L	Clamp C	S3808				
	.500"	.500"	4.840"	SFT12L	LFT12L	Clamp C	S3808				
.625"	.625"	4.840"	SFT58L	LFT58L	Clamp C	S3808					



**Right Hand Illustrated**

### HARDINGE ORDERING INSTRUCTIONS

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

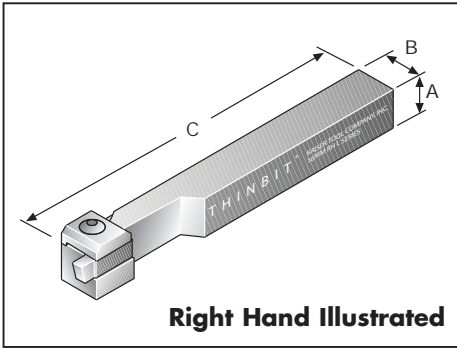
**EXAMPLE:**

The **ORDER CODE** for a .375" shank, right hand tool for inserts beginning with 'L' is:  
**LHA38**

SPECIFICATIONS					ORDER CODE								
Shank Orientation	Shank Dimensions			Minimum Bore Diameter  with 'S' inserts; add .071" for 'L' inserts	Toolholder Package Includes Shank, Clamp and Hardware		Replacement Parts						
	'A'	'B'	'C'		For Inserts Beginning With		Clamp	Screw	Wrench	Pin			
					'S'	'L'							
Right Hand  Use with left hand and centered inserts	.375"	.375"	4.840"	1.050"	SHA38	- - -	Clamp C	S3808	W1005	P0204			
					- - -	LHA38							
.500"	.500"	4.840"	1.290"	SHA12	LHA12								
Left Hand  Use with right hand and centered inserts	.375"	.375"	4.840"	1.050"	SHA38	- - -							
					- - -	LHA38							
	.500"	.500"	4.840"	1.290"	SHA12	LHA12							

### KAISER TOOL COMPANY, INC.





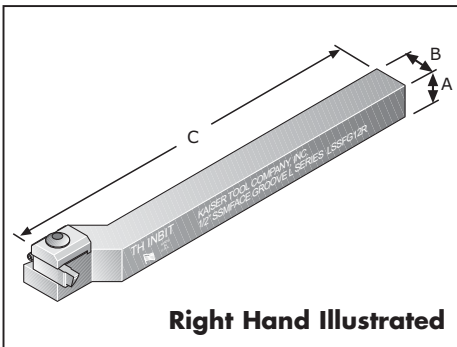
### SWISS SCREW ORDERING INSTRUCTIONS

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		Replacement Parts					
	'A'	'B'	'C'	For Inserts Beginning With		Clamp		Screw		Wrench	Pin
				'S'	'L'	'S'	'L'	'S'	'L'		
Right Hand  Use with right hand and centered inserts	.375"	.375"	4.840"	SSS38R	---	A	--	S5608	---	W1005	P0305
	.500"	.500"		SSS12R	LSS12R	A	C	S5608	S3808		
	8mm	8mm		SSS08RM	---	A	--	S5608	---		
	10mm	10mm		SSS10RM	---	A	--	S5608	---		
	12mm	12mm		SSS12RM	LSS12RM	A	C	S5608	S3808		
	16mm	16mm		SSS16RM	LSS16RM	C	C	S3808	S3808		
Left Hand  Use with left hand and centered inserts	.375"	.375"	4.840"	SSS38L	---	A	--	S5608	---	W1005	P0305
	.500"	.500"		SSS12L	LSS12L	A	C	S5608	S3808		
	8mm	8mm		SSS08LM	---	A	--	S5608	---		
	10mm	10mm		SSS10LM	---	A	--	S5608	---		
	12mm	12mm		SSS12LM	LSS12LM	A	C	S5608	S3808		
	16mm	16mm		SSS16LM	LSS16LM	C	C	S3808	S3808		



### SWISS FACE ORDERING INSTRUCTIONS

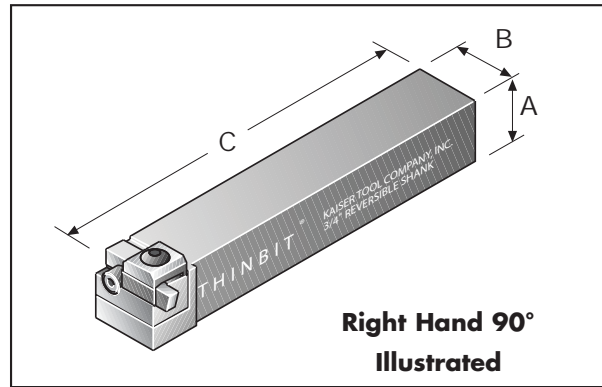
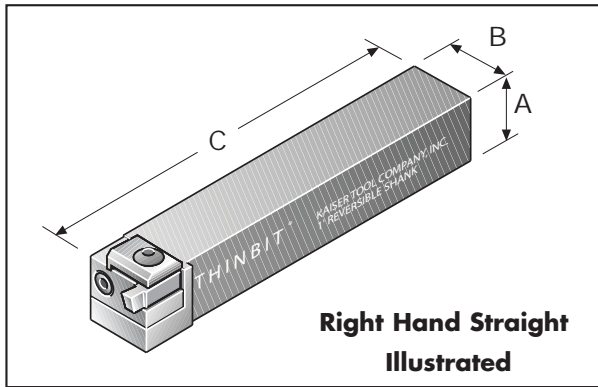
Select the **ORDER CODE** in the table below that represents your selection of shank orientation and dimensions.

**EXAMPLE:**

The **ORDER CODE** for a .375" shank, right hand tool for inserts beginning with 'L' is:  
**LSSFG38R**

SPECIFICATIONS				ORDER CODE							
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Clamp and Hardware		Replacement Parts					
	'A'	'B'	'C'	For Inserts Beginning With		Clamp	Screw		Wrench	Pin	
				'S'	'L'		'S'	'L'			
Right Hand  Use with left hand and centered inserts for counter-clockwise rotation	.375"	.375"	4.840"	SSSFG38R	LSSFG38R	Clamp C		S3808	S3808	W1005	P0203
	.500"	.500"	4.840"	SSSFG12R	LSSFG12R		S3808				
	10mm	10mm	4.840"	SSSFG10RM	LSSFG10RM		S5452				
	12mm	12mm	4.840"	SSSFG12RM	LSSFG12RM		S5452				
	16mm	16mm	4.840"	SSSFG16RM	LSSFG16RM		S3808				

### KAISER TOOL COMPANY, INC.



## ORDERING INSTRUCTIONS

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

**EXAMPLE:**

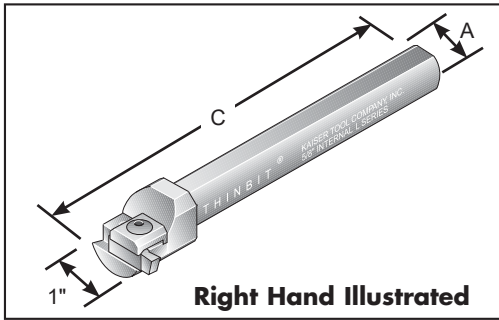
The **ORDER CODE** for a .750" shank and a 90° right hand tool for inserts beginning with 'L' is:

**LRI3434R**

SPECIFICATIONS				ORDER CODE									
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Head, Clamp and Hardware		Head Only Includes Clamp and Hardware For Inserts Beginning With		Replacement Parts					
	'A'	'B'	'C'	For Inserts Beginning With		Beginning With		Head Screws	Head Wrenches	Head Pin	Shank	Clamp	Clamp Hardware
				'S'	'L'	'S'	'L'						
<b>Straight</b> Right Hand or Left Hand  Use as right hand with right hand inserts; Use as left hand with left hand inserts; Use as either hand with centered inserts.	.375"	.750"	4.840"	SRE3438	LRE3438	SREH34	LREH34	1 each: S3808 S2808	1 each: W1005 W1009		RS3438	Clamp C	Screw: S3808  Wrench: W1005
	.500"			SRE3412	LRE3412						RS3412		
	.625"			SRE3458	LRE3458						RS3458		
	.750"			SRE3434	LRE3434						RS3434		
	.750"	1.000"	4.840"	SRE0134	LRE0134	SREH01	LREH01	1 each: S3812 S2808	1 each: W1005 W1009	P0305	RS0134	Clamp C	Screw: S3808  Wrench: W1005
	1.000"			SRE0101	LRE0101						RS0101		
	1.000"			SRE1401	LRE1401						RS1401		
	1.250"	1.250"	4.840"	SRE1414	LRE1414	SREH14	LREH14	1 each: S3816 S2808	1 each: W1005 W1009		RS1401	Clamp C	
<b>90°</b> Right Hand Use with left hand and centered inserts	.375"	.750"	4.840"	SRI3438R	LRI3438R	SRIH34R	LRIH34R	1 each: S3808 S2812	1 each: W1005 W1009		RS3438	Clamp C	Screw: S3808  Wrench: W1005
	.500"			SRI3412R	LRI3412R						RS3412		
	.625"			SRI3458R	LRI3458R						RS3458		
	.750"			SRI3434R	LRI3434R						RS3434		
	.750"	1.000"	4.840"	SRI0134R	LRI0134R	SRIH01R	LRIH01R	1 each: S3812 S2812	1 each: W1005 W1009	P0305	RS0134	Clamp C	Screw: S3808  Wrench: W1005
	1.000"			SRI0101R	LRI0101R						RS0101		
<b>90°</b> Left Hand Use with right hand and centered inserts	.375"	.750"	4.840"	SRI3438L	LRI3438L	SRIH34L	LRIH34L	1 each: S3808 S2812	1 each: W1005 W1009		RS3438	Clamp C	Wrench: W1005
	.500"			SRI3412L	LRI3412L						RS3412		
	.625"			SRI3458L	LRI3458L						RS3458		
	.750"			SRI3434L	LRI3434L						RS3434		
	.750"	1.000"	4.840"	SRI0134L	LRI0134L	SRIH01L	LRIH01L	1 each: S3812 S2812	1 each: W1005 W1009	P0305	RS0134	Clamp C	Wrench: W1005
	1.000"			SRI0101L	LRI0101L						RS0101		

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### ROUND INTERNAL ORDERING INSTRUCTIONS

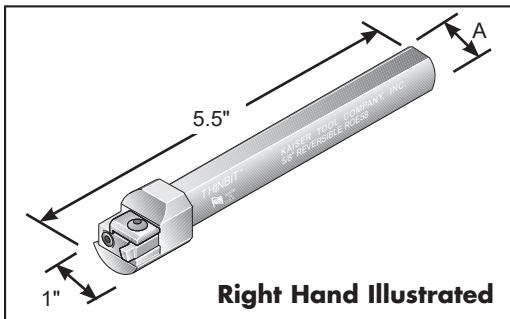
Select the **ORDER CODE** in the table below that represents your selection of shank orientation and dimensions.

**EXAMPLE:**

The **ORDER CODE** for a .625", 5.5" long round shank for inserts beginning with 'L' is:

**LR5806**

SPECIFICATIONS				ORDER CODE					
Shank Orientation	Minimum Bore Diameter without pin	Shank Dimensions		Toolholder Package Includes Shank, Clamp and Hardware For Inserts Beginning With		Replacement Parts			
		'A'	'C'	'S'	'L'	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.	1.125"	.500"	5.500"	SR1206	---	Clamp C	S3808	W1005	P0305
		.625"		SR5806	---				
		.750"		SR3406	---				
		1.000"		SR0106	---				
	1.187" (1.250" for insert beginning with 'LGT')	.500"	5.500"	---	LR1206				
		.625"		---	LR5806				
		.750"		---	LR3406				
		1.000"		---	LR0106				
		11.875"	---	LR0112					



### ROUND REVERSIBLE ORDERING INSTRUCTIONS

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

**EXAMPLE:**

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

**LROE58**

SPECIFICATIONS			ORDER CODE							
Shank Orientation	Shank Dimensions 'A'	Toolholder Package Includes Shank, Head, Clamp and Hardware For Inserts Beginning With		Replacement Parts						
		'S'	'L'	Head Only Includes Clamp and Hardware For Inserts Beginning With		Head Screws	Head Wrenches	Shank	Clamp	Clamp Hardware
Right Hand or Left Hand  Use as right hand with right hand inserts; Use as left hand with left hand inserts; Use as either hand with centered inserts.	.500"	SROE12	LROE12	SROEH	LROEH	1 each: S5806 S2810	1 each: W1006 W1009	RROE12	Clamp C	Screw: S3808  Wrench: W1005
	.625"	SROE58	LROE58					RROE58		
	.750"	SROE34	LROE34					RROE34		
	1.000"	SROE01	LROE01					RROE01		

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