**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.

---

**TECHNICAL SECTIONS**

<table>
<thead>
<tr>
<th>PRODUCT DEMONSTRATION</th>
<th>SPEEDS AND FEEDS</th>
<th>APPLICATION REFERENCE</th>
<th>TROUBLESHOOTING</th>
</tr>
</thead>
<tbody>
<tr>
<td><a href="http://www.thinbit.com/qr2-5">www.thinbit.com/qr2-5</a></td>
<td>PG 9-12</td>
<td>PGS 9-3 &amp; 9-4</td>
<td>PG 9-7</td>
</tr>
</tbody>
</table>

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**

<table>
<thead>
<tr>
<th>Insert Orientation</th>
<th>Insert Width</th>
<th>Depth of Cut</th>
<th>Insert Grades</th>
<th>Add-ons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Right Hand</td>
<td>'A'</td>
<td>'B'</td>
<td>DURA-MAX® 2000 Carbide For Steel &amp; Interrupted Cutting</td>
<td>Full Radius Page 8-3</td>
</tr>
</tbody>
</table>
| For ID grooving use left hand 'MGT' Page 1-5 | .004"-.063" Width DOC | Width DOC 'A' .032"-.063" = .063" | MGTI _ _ _D2R | add 'CR' (indicate size in .xxx")
| For face grooving use right hand 'MGTF' Page 2-6 | .064"-.125" Width DOC | Width DOC 'A' .084"-.125" = .125" | MGTI _ _ _D5R | add 'FR' |

<table>
<thead>
<tr>
<th>Left Hand</th>
<th>'A'</th>
<th>'B'</th>
<th>DURA-MAX® 5000 Carbide For Aluminum &amp; Nonferrous</th>
<th>Corner Radius Page 8-3</th>
</tr>
</thead>
</table>
| For ID grooving use right hand 'MGT' Page 1-5 | .004"-.063" Width DOC | Width DOC 'A' .032"-.063" = .063" | MGTI _ _ _D2L | TIN add 'C'
| For face grooving use left hand 'MGTF' Page 2-6 | .064"-.125" Width DOC | Width DOC 'A' .084"-.125" = .125" | MGTI _ _ _D5L | TiCN add 'D'

Coating Page 9-6

<table>
<thead>
<tr>
<th>Add-ons Use 'Order Code' and Add</th>
</tr>
</thead>
<tbody>
<tr>
<td>TIN add 'C'</td>
</tr>
<tr>
<td>TiCN add 'D'</td>
</tr>
<tr>
<td>TiAIN add 'E'</td>
</tr>
<tr>
<td>Diamond add 'F'</td>
</tr>
</tbody>
</table>
I.D. FACE GROOVING TOOLS

Right Hand Insert and Toolholder Illustrated

Note:
- 1/2" and 5/8" toolholders are reversible for right hand or left hand orientation.
- For face grooving:

<table>
<thead>
<tr>
<th>Insert Width</th>
<th>Depth of Cut</th>
</tr>
</thead>
<tbody>
<tr>
<td>.004&quot;-.031&quot;</td>
<td>2 x width</td>
</tr>
<tr>
<td>.032&quot;-.063&quot;</td>
<td>.063&quot;</td>
</tr>
<tr>
<td>.064&quot;-.083&quot;</td>
<td>1.5 x width</td>
</tr>
<tr>
<td>.084&quot;-.125&quot;</td>
<td>.125&quot;</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>SPECIFICATIONS</th>
<th>ORDER CODE</th>
<th>INFORMATION</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum Bore &amp; Major Diameter</td>
<td>Orientation &amp; Toolholder Material</td>
<td>Toolholder Package</td>
</tr>
<tr>
<td>.415&quot;</td>
<td>Right Hand Steel</td>
<td>MGTF38R</td>
</tr>
<tr>
<td></td>
<td>Right Hand Heavy Metal</td>
<td>MGTF38RHM</td>
</tr>
<tr>
<td></td>
<td>Left Hand Steel</td>
<td>MGTF38L</td>
</tr>
<tr>
<td></td>
<td>Left Hand Heavy Metal</td>
<td>MGTF38LHM</td>
</tr>
<tr>
<td>.530&quot;</td>
<td>Steel</td>
<td>MGTF12</td>
</tr>
<tr>
<td></td>
<td>Heavy Metal</td>
<td>MGTF12HM</td>
</tr>
<tr>
<td>.650&quot;</td>
<td>Steel</td>
<td>MGTF58</td>
</tr>
</tbody>
</table>

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