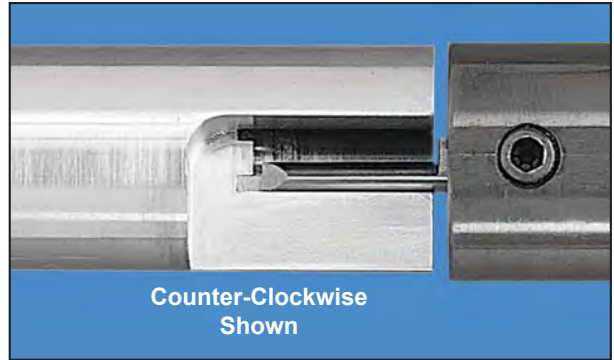


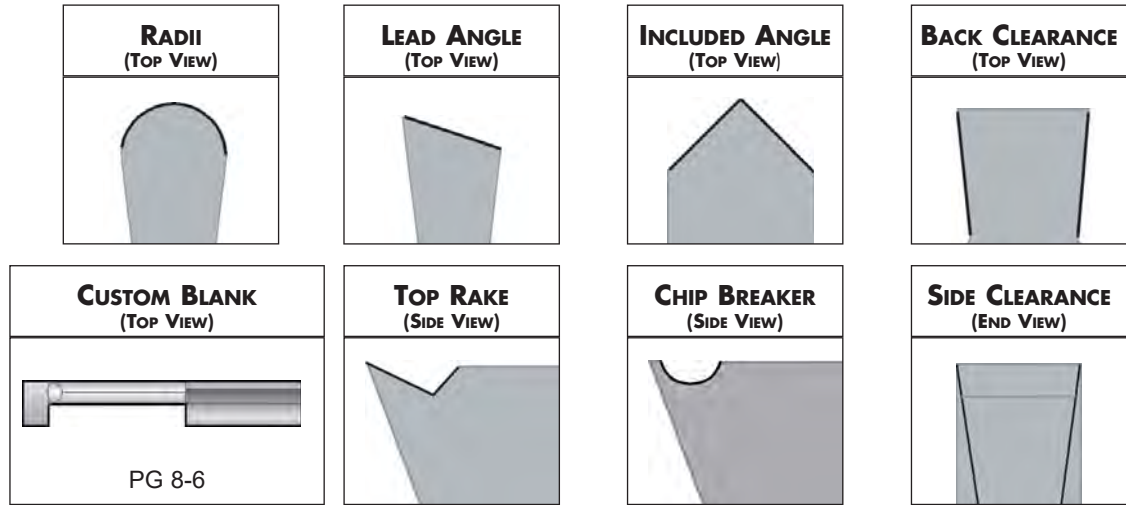
## PRODUCT INFORMATION

- Internal face grooving for diameters .125" and larger.
- Elliptically ground necks for greater strength.
- .004" through .250" in .001" increments available.
- 1/8", 3/16", 1/4", 5/16", 3/8" and 1/2" shanks.
- Sub-micron grain **DURA-MAX® 2000** Carbide.
- Inserts available with TiN, TiAlN, TiCN and Diamond coating.



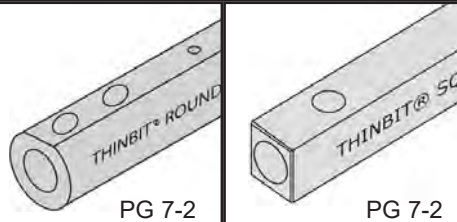
## MODIFICATIONS

SEE PAGE  
8-3  
FOR ADDITIONAL  
INFORMATION



## TOOLHOLDER SELECTIONS

### ADAPTER STYLES



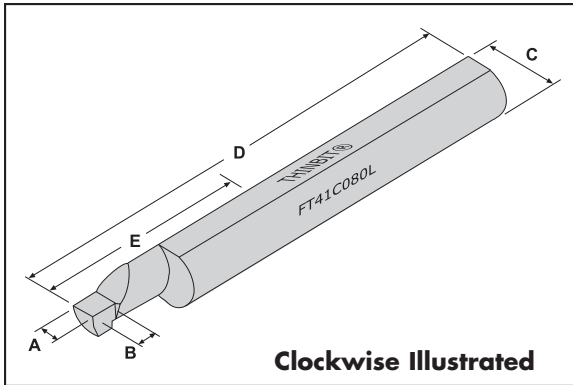
## TECHNICAL SECTIONS

PRODUCT DEMONSTRATION	SPEEDS AND FEEDS	APPLICATION REFERENCE	TROUBLESHOOTING
<p><a href="http://www.thinbit.com/qr2-3">www.thinbit.com/qr2-3</a></p>	PG 9-15	PGS 9-3 & 9-4	PG 9-7

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# INTERNAL FACE GROOVING TOOLS



FRONT RAKE: Primary 10°  
 BACK CLEARANCE: 2° ID side  
 SIDE CLEARANCE: 2° ID side  
 RADIUS: Sharp corner through full radius available  
 TOP RAKE: 0°  
 LEAD ANGLE: 0°

**INTERNAL  
FACE GROOVING**

## ORDERING INSTRUCTIONS

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

**EXAMPLE:**

The **ORDER CODE** for a 1/4" major diameter, clockwise rotation tool with an .080" groove width, .125" depth of cut and .750" reach is:

**FT41C Q 8 Q L**

Specify the Groove Width '**A**'

SPECIFICATIONS				ORDER CODE					INFORMATION	
Minimum Bore & Major Diameter  'C'	Groove Width Range  'A' ± .001"	Depth of Cut  'B'	Reach into Bore  'E'	DURA-MAX® 2000 Carbide See Page 9-15 for Speeds and Feeds		Add-ons Use 'Order Code' and Add			Overall Length  'D'	Toolholder Page 7-2  Use Toolholders Beginning With
				Counter-Clockwise	Clockwise	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6		
1/8"	.004"-.063"	$\frac{\text{Width}}{\text{DOC}}$ .004"-.020" = 3 x 'A' .021"-.063" = .062"	.375"	FT21C ___ R	FT21C ___ L	add 'FR'	add 'CR ___'  (indicate size in .xxx")	TiN add 'C'  TiCN add 'D'  TiAIN add 'E'  Diamond add 'F'	1.365" + 'B'	'AD'
3/16"	.004"-.093"	$\frac{\text{Width}}{\text{DOC}}$ .004"-.030" = 3 x 'A' .031"-.093" = .093"	.625"	FT31C ___ R	FT31C ___ L				1.865" + 'B'	'AD'
1/4"	.004"-.125"	$\frac{\text{Width}}{\text{DOC}}$ .004"-.041" = 3 x 'A' .042"-.125" = .125"	.750"	FT41C ___ R	FT41C ___ L				2.365" + 'B'	'AD'
5/16"	.004"-.156"	$\frac{\text{Width}}{\text{DOC}}$ .004"-.051" = 3 x 'A' .052"-.156" = .156"	1.000"	FT51C ___ R	FT51C ___ L				2.330" + 'B'	'AD'
3/8"	.004"-.187"	$\frac{\text{Width}}{\text{DOC}}$ .004"-.061" = 3 x 'A' .062"-.187" = .187"	1.250"	FT61C ___ R	FT61C ___ L				2.800" + 'B'	'AD'
1/2"	.004"-.250"	$\frac{\text{Width}}{\text{DOC}}$ .004"-.082" = 3 x 'A' .083"-.250" = .250"	1.750"	FT81C ___ R	FT81C ___ L				3.240" + 'B'	'AD'

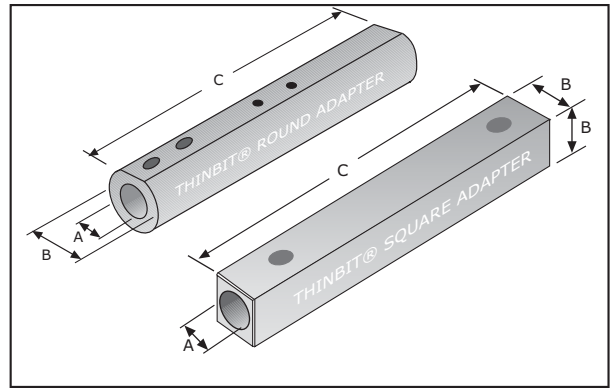
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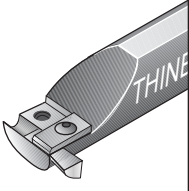
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# ROUND & SQUARE ADAPTERS

**PRODUCT INFORMATION**

- Designed to adapt round tooling to lathe workholding
- ID sizes 1/8", 5/32", 3/16", 1/4", 5/16" and 3/8".
- Round sizes 1/4", 3/8", 1/2", 5/8" and 3/4".
- Square sizes 5/16", 3/8", 1/2", 5/8", 3/4", 1" and 1-1/4".
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



TOOL SELECTIONS	SOLID CARBIDE		GROOVING BARS		BORING BARS		
	Grooving Page 1-3 Face Grooving Page 2-3 Boring Page 3-3 Threading Page 4-3 & 4-5			Grooving Page 1-5 Face Grooving Page 2-5			MBA Page 3-13 MBB Page 3-15 MBC Page 3-17 MBE Page 3-8



Scan this code for additional information.

[www.thinbit.com/qr7-2](http://www.thinbit.com/qr7-2)

## ORDERING INSTRUCTIONS

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

**EXAMPLE:**

The **ORDER CODE** for a .375" ID x .625" OD round adapter is:

**AD3762**

SPECIFICATIONS				ORDER CODE				SPECIFICATIONS				ORDER CODE			
Adapter Style	Shank Dimensions			Adapter	Replacement Parts			Adapter Style	Shank Dimensions			Adapter	Replacement Parts		
	'A'	'B'	'C'		Includes Adapter and Hardware	Screw	Wrench		Pin	'A'	'B'		'C'	Includes Adapter and Hardware	Screw
Round	.125"	.250"	3.000"	AD1225	S1402M	W0050	P0203	Round	.312"	.500"	4.000"	AD3150	S1802	W1005	P0204
				AD1237	S1402	W0050	P0203			.625"		AD3162	S1802	W1005	P0206
				AD1250	S1402	W0050	P0204			.750"		AD3175	S1802	W1005	P0206
				AD1262	S1404	W0050	P0204			1.000"		AD3110	S1804	W1005	P0206
				AD1275	S1404	W0050	P0204		.375"	.625"	AD3762	S1802	W1005	P0206	
				AD1210	S1404	W0050	P0204			.750"	AD3775	S1802	W1005	P0206	
	.156"	.375"	3.000"	AD1537	S1402M	W0050	---	1.000"	AD3710	S1804	W1005	P0206			
				AD1550	S1402	W0050	---	.500"	.750"	AD5075	S1802	W1005	P0206		
				AD1562	S1403	W0050	---		1.000"	AD5010	S1804	W1005	P0206		
	.187"	.375"	3.000"	AD1837	S1402M	W0050	P0203	Square	.250"	.312"	3.000"	AD56	---	---	---
				AD1850	S1802	W1005	P0204			.375"		AD38	S1802	W1005	---
				AD1862	S1802	W1005	P0206		.250" & .375"	.500"	AD12	S1802	W1005	---	
				AD1875	S1804	W1005	P0206			.625"	AD58	S1802	W1005	---	
	.250"	.625"	4.000"	AD1810	S1404	W0050	P0206	1.000"	AD34	S1802	W1005	---			
				AD2537	S1402M	W0050	P0203	.375"	1.000"	AD01	S1802	W1005	---		
				AD2550	S1802	W1005	P0204		1.250"	AD14	S1802	W1005	---		
				AD2562	S1802	W1005	P0206								
				AD2575	S1804	W1005	P0206								
		1.000"	AD2510	S1804	W1005	P0206									

**TOOLHOLDERS**

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