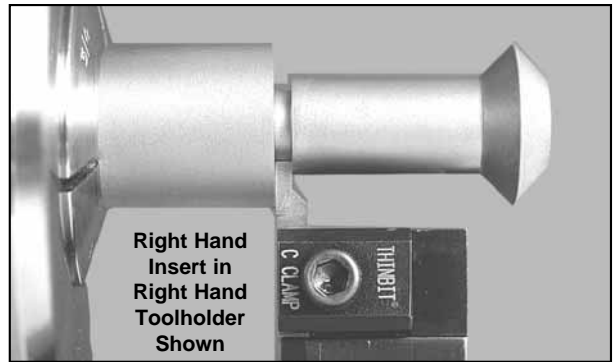


INSERT SIZES AND APPLICATIONS

- External grooving and turning.
- Internal grooving and boring with 1.250" minimum bore diameter.
- .004" through .150" in .001" increments available.



INSERT GRADES AND COATINGS

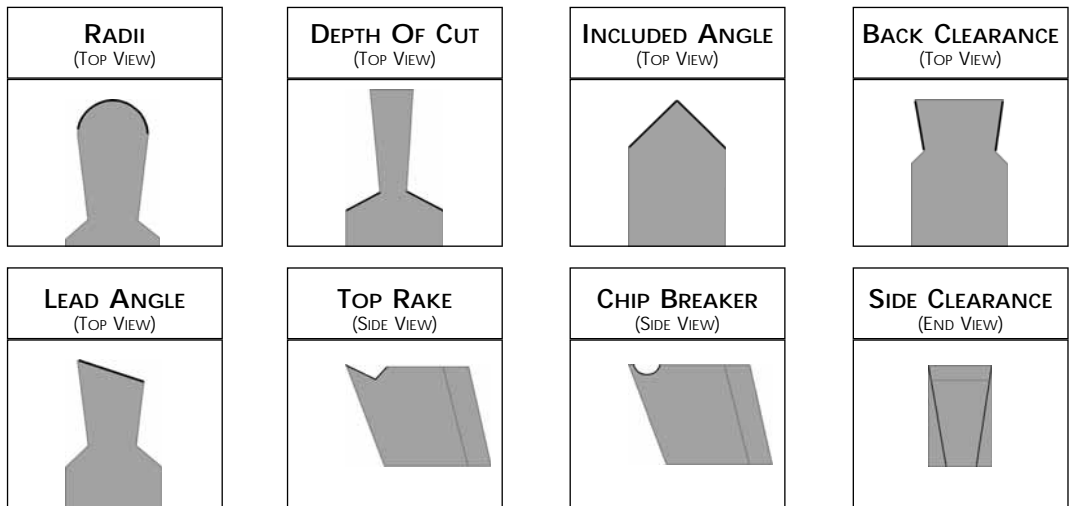
- Sub-micron grain **DURA-MAX[®] 2000** and **5000** Carbides and High Speed Steel.
- Inserts available with TiN, TiAlN, TiCN and Diamond coating.

GENERAL INFORMATION

- Uncoated, TiN and TiAlN **DURA-MAX[®] 2000** and **5000** Carbides and uncoated High Speed Steel stocked for fast, 24 - 48 hour shipment.

MODIFICATIONS

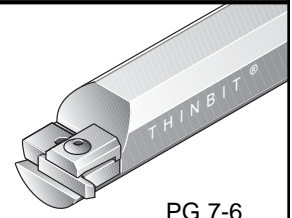
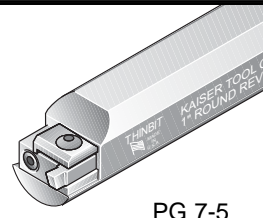
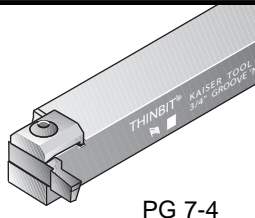
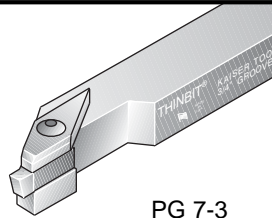
SEE PAGE 8-3 FOR ADDITIONAL INFORMATION



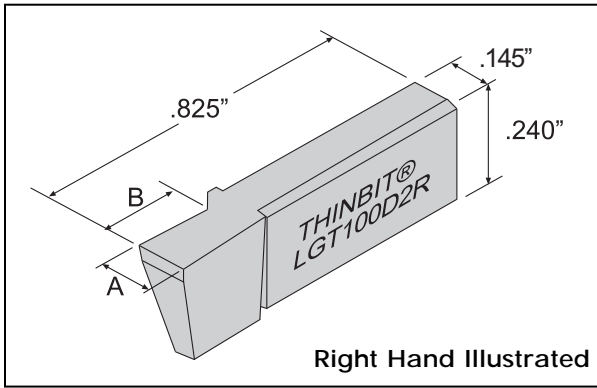
TOOLHOLDER SELECTIONS

CNC, SWISS, CONVENTIONAL STYLE

ROUND STYLE



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: None or .007" standard; all sizes available

TOP RAKE: 0°

LEAD ANGLE: 0°

NOTE: .004"-.019" inserts are not designed for turning

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

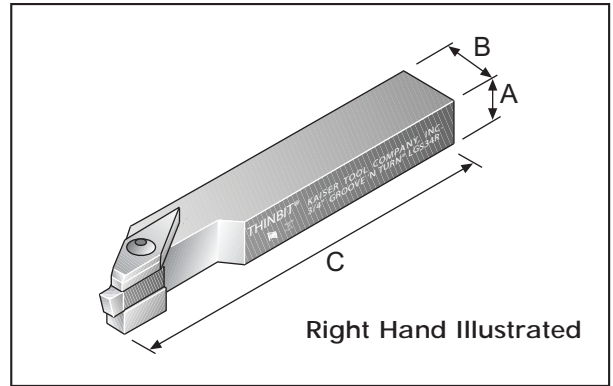
Specify the Insert Width 'A'

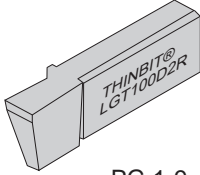
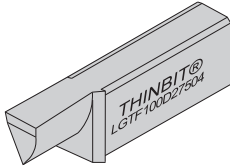
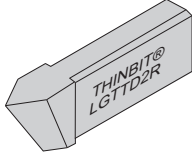
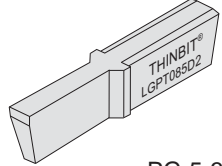
SPECIFICATIONS			ORDER CODE			INFO.			
Insert Orientation & Radius	Insert Width 'A' +.0009/-.0000	Depth of Cut 'B' Width DOC .004"-.033" = 3 x 'A' .034"-.039" = .100" .040"-.100" = 2.5 x 'A' .101"-.150" = .250"	Insert Grades See Page 9-5 for expanded material descriptions and Page 9-10 for speeds and feeds information			Add-ons Use 'Order Code' and Add			Toolholder Catalog Section 7 Use Toolholders Beginning With
			DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Non-ferrous	High Speed Steel	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6	
Right Hand; No Radius	.004"-.150"		LGT ___ D2R	LGT ___ D5R	LGT ___ HSR	add 'FR'	add 'CR___' (indicate size in .xxx")	TiN add 'C' TiCN add 'D'	"L" Use right hand straight holder or left hand 90° holder
Left Hand; No Radius	.004"-.150"		LGT ___ D2L	LGT ___ D5L	LGT ___ HSL	add 'FR'	add 'CR___' (indicate size in .xxx")	TiAIN add 'E' Diamond add 'F'	"L" Use left hand straight holder or right hand 90° holder

KAISER TOOL COMPANY, INC.

SHANK SIZES AND APPLICATIONS	<ul style="list-style-type: none"> Shank sizes 3/8", 1/2", 5/8", 3/4", 1" and 1-1/4". Designed for CNC machines.
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GENERAL INFORMATION	<ul style="list-style-type: none"> All toolholders shipped in 24 hours.
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	GROOVING	FACE GROOVING	THREADING	PARTING
INSERT SELECTIONS	 PG 1-9	 PG 2-9	 PG 4-9	 PG 5-3

MODIFICATIONS	Modifications can be provided on any of our tooling. Please contact us with your application requirements.
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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	.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				
Use left hand holder with left hand inserts	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					

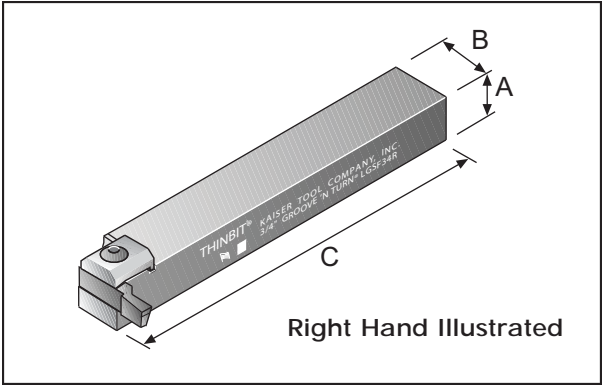
KAISER TOOL COMPANY, INC.

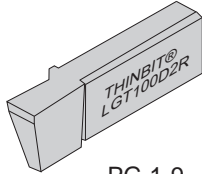
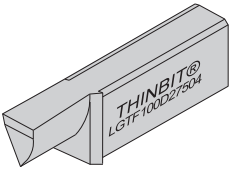
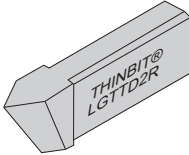
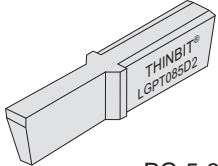
SHANK SIZES AND APPLICATIONS

- Shank sizes 3/8", 1/2", 5/8", 3/4", 1" and 1-1/4".
- Designed for CNC machines.

GENERAL INFORMATION

- All toolholders shipped in 24 hours.



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

MODIFICATIONS Modifications can be provided on any of our tooling. Please contact us with your application requirements.

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

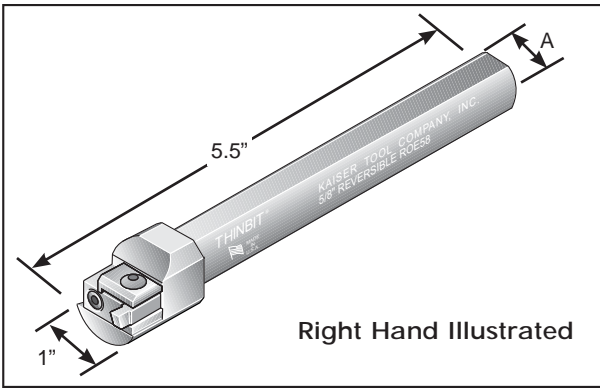
SPECIFICATIONS				ORDER CODE					
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Clamp and Hardware For Inserts Beginning With 'L'		Replacement Parts			
	'A'	'B'	'C'	RIGHT HAND	LEFT HAND	Clamp	Screw	Wrench	Pin
90° Use right hand holder with left hand inserts	.312"	.500"	4.840"	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				
Use left hand holder with right hand inserts	1.250"	1.250"	4.840"	LGSF14R	LGSF14L				
	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				

KAISER TOOL COMPANY, INC.



SHANK SIZES AND APPLICATIONS	<ul style="list-style-type: none"> • Shank sizes 1/2", 5/8", 3/4" and 1". • Designed for boring bar positions on all machines. • Can be used with a boring head to trepan on a mill.
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GENERAL INFORMATION	<ul style="list-style-type: none"> • All toolholders shipped in 24 hours. • Toolholder reversible by removing face and bottom screws and rotating head 1/2 turn. • All 1/2", 5/8" and 3/4" shanks are made from 1" shank.
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INSERT SELECTIONS	<i>GROOVING</i>	<i>FACE GROOVING</i>	<i>THREADING</i>	<i>PARTING</i>

MODIFICATIONS Modifications can be provided on any of our tooling. Please contact us with your application requirements.

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					
			Head Only Includes Clamp and Hardware For Inserts Beginning With 'L'	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"	LROE12	LROEH	1 each: S5806 S2810	1 each: W1006 W1009	RROE12	ClampC	Screw: S3808 Wrench: W1005
	.625"	LROE58				RROE58		
	.750"	LROE34				RROE34		
	1.000"	LROE01				RROE01		

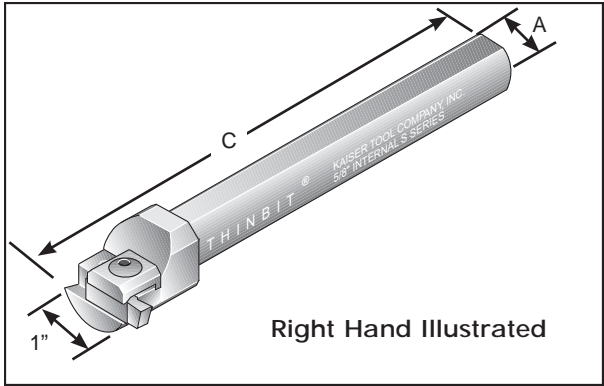
KAISER TOOL COMPANY, INC.

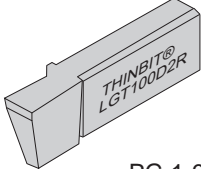
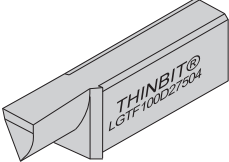
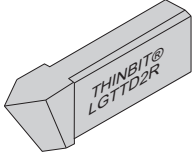
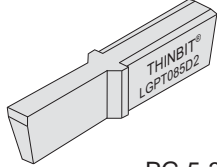
SHANK SIZES AND APPLICATIONS

- Shank sizes 1/2", 5/8", 3/4" and 1".
- Designed for boring bar positions on all machines.

GENERAL INFORMATION

- All toolholders shipped in 24 hours.
- Toolholder reversible for left and right hand orientation.
- 1/2", 5/8", 3/4" shank is made from 1" shank.



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

MODIFICATIONS Modifications can be provided on any of our tooling. Please contact us with your application requirements.

ORDERING INSTRUCTIONS

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

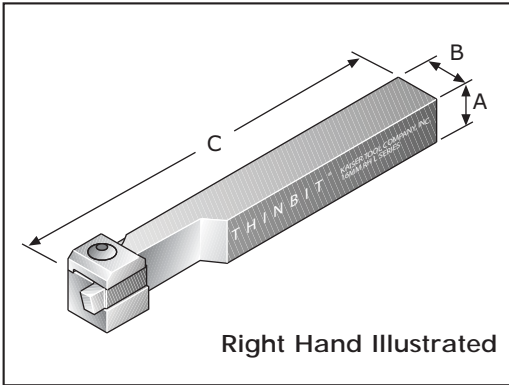
EXAMPLE:

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'	Clamp	Screw	Wrench
	without 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"	LRO106				
			11.875"	LRO112				



KAISER TOOL COMPANY, INC.



SWISS SCREW ORDERING INSTRUCTIONS

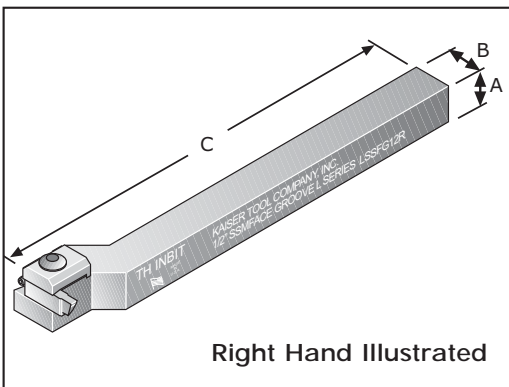
Select the **ORDER CODE** in the table below that represents your selection of shank orientation and dimensions.

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	P0206
	.500"	.500"		SSS12R	LSS12R	A	C	S5608	S3808		
	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	P0206
	.500"	.500"		SSS12L	LSS12L	A	C	S5608	S3808		
	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.