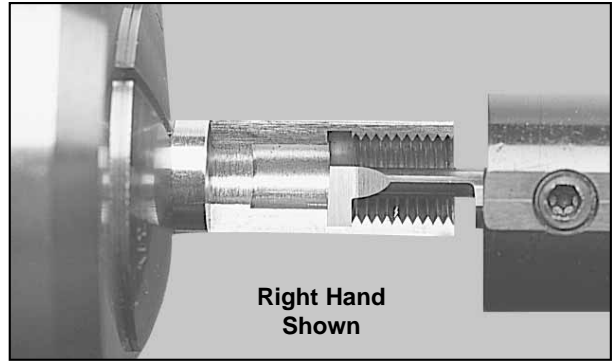


MICROBIT®

TOOL SIZES AND APPLICATIONS

- Internal grooving for diameters .125" and larger.
- .004" through .250" groove widths in .001" increments.
- 1/8", 3/16", 1/4", 5/16", 3/8" and 1/2" shanks.



INSERT GRADES AND COATINGS

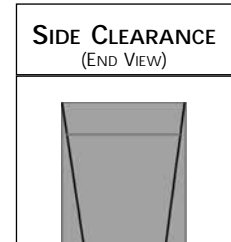
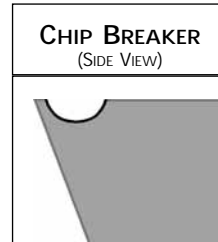
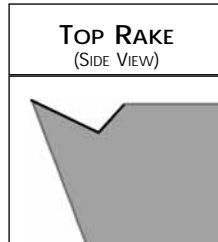
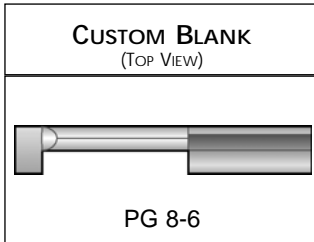
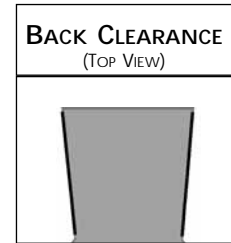
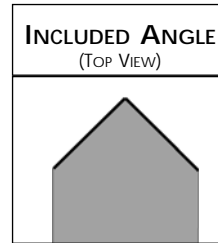
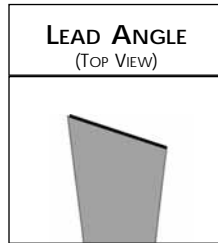
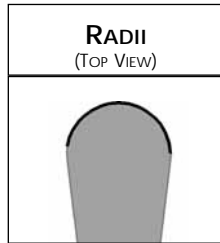
- Sub-micron grain **DURA-MAX® 2000** Carbide.
- Tools available with TiN, TiAlN, TiCN and Diamond coating.

GENERAL INFORMATION

- Short neck lengths for greater rigidity; long neck lengths for greater reach.
- Elliptically ground necks for greater strength.
- Uncoated **DURA-MAX® 2000** stocked for **fast**, 24-48 hour shipment.

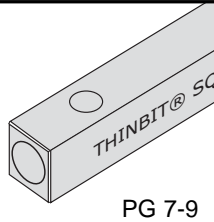
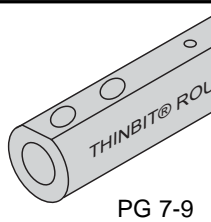
MODIFICATIONS

SEE PAGE
8-3
FOR ADDITIONAL
INFORMATION



ADAPTER STYLES

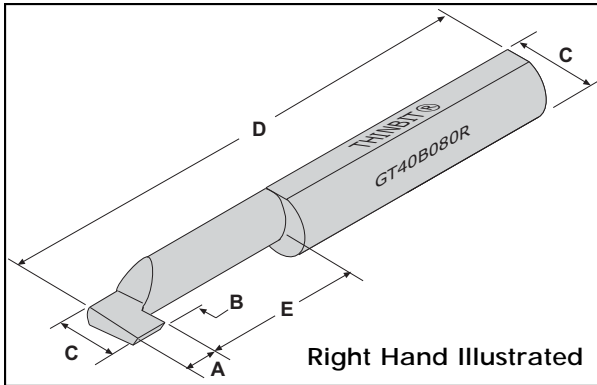
TOOLHOLDER SELECTIONS



KAISER TOOL COMPANY, INC.

Phone: 888-THINBIT (888-844-6248) or (260) 484-3620 • Fax: 888-THINFAX (888-844-6329) or (260) 482-1881
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I.D. GROOVING TOOLS



FRONT RAKE: Primary 21°
 BACK CLEARANCE: 2°
 SIDE CLEARANCE: 2°
 RADIUS: None
 TOP RAKE: 0°
 LEAD ANGLE: 0°

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" shank, right hand tool with an .080" tool width, .110" Depth of Cut and .500" long neck is:

GT40B 0 8 0 R

Specify the Tool Width 'A' _____ ↑

SPECIFICATIONS				ORDER CODE			INFORMATION												
Minimum Bore & Shank 'C'	Tool Width Range 'A' +.0009/-.0000	Depth of Cut 'B'	Neck Length 'E'	DURA-MAX® 2000 Carbide See Page 9-10 for speeds and feeds		Add-ons Use 'Order Code' and Add			Overall Length 'D'	Toolholder Page 7-9 Use Toolholders Beginning With									
				Right Hand	Left Hand	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6											
1/8"	.004"-.063"	.004"-.006" = 3 x 'A'	.250"	GT20C ___ R	GT20C ___ L	* See Note	add 'FR'	(indicate size in .xxx")	TIN add 'C'	1.365" + 'A'	"AD"								
		.007"-.063" = .020"	.375"	GT21C ___ R	GT21C ___ L														
		.004"-.016" = 3 x 'A'	.250"	GT20B ___ R	GT20B ___ L														
		.017"-.063" = .050"	.375"	GT21B ___ R	GT21B ___ L														
3/16"	.004"-.093"	.004"-.011" = 3 x 'A'	.375"	GT30C ___ R	GT30C ___ L					* See Note	add 'CR___'	TiCN add 'D'	1.865" + 'A'	"AD"					
		.012"-.093" = .035"	.625"	GT31C ___ R	GT31C ___ L														
		.004"-.026" = 3 x 'A'	.375"	GT30B ___ R	GT30B ___ L														
		.027"-.093" = .080"	.625"	GT31B ___ R	GT31B ___ L														
1/4"	.004"-.125"	.004"-.016" = 3 x 'A'	.500"	GT40C ___ R	GT40C ___ L								* See Note	* See Note	Diamond add 'F'	2.365" + 'A'	"AD"		
		.017"-.125" = .050"	.750"	GT41C ___ R	GT41C ___ L														
		.004"-.036" = 3 x 'A'	.500"	GT40B ___ R	GT40B ___ L														
		.037"-.125" = .110"	.750"	GT41B ___ R	GT41B ___ L														
5/16"	.004"-.156"	.004"-.021" = 3 x 'A'	.625"	GT50C ___ R	GT50C ___ L	* See Note	* See Note	Diamond add 'F'	2.330" + 'A'							"AD"			
		.022"-.156" = .063"	1.000"	GT51C ___ R	GT51C ___ L														
		.004"-.046" = 3 x 'A'	.625"	GT50B ___ R	GT50B ___ L														
		.047"-.156" = .140"	1.000"	GT51B ___ R	GT51B ___ L														
3/8"	.004"-.187"	.004"-.036" = 3 x 'A'	.750"	GT60C ___ R	GT60C ___ L				* See Note	* See Note	Diamond add 'F'	2.800" + 'A'				"AD"			
		.037"-.187" = .110"	1.250"	GT61C ___ R	GT61C ___ L														
1/2"	.004"-.250"	.004"-.050" = 3 x 'A'	1.000"	GT80C ___ R	GT80C ___ L							* See Note				* See Note	Diamond add 'F'	3.240" + 'A'	"AD"
		.051"-.250" = .150"	1.750"	GT81C ___ R	GT81C ___ L														

* Maximum radius limited to Depth of Cut

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