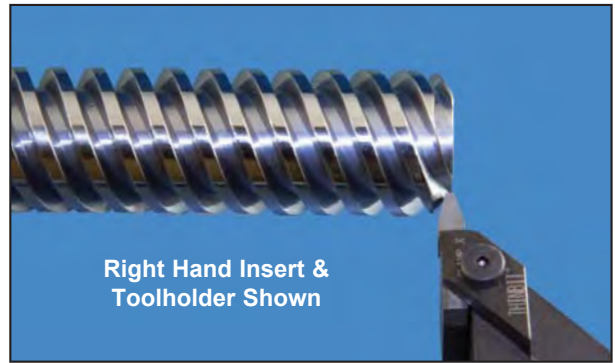


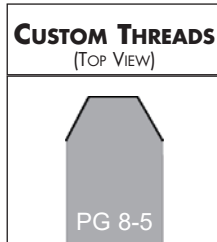
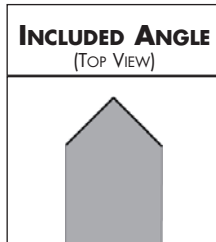
PRODUCT INFORMATION

- External threading within .070" of a shoulder.
- Internal ACME threading with 1.250" minimum bore diameter.
- 4 threads per inch and greater.
- Sub-micron grain **DURA-MAX[®] 2000** and **5000** Carbides and High Speed Steel.
- Inserts can be coated with TiN, TiAlN, TiCN and Diamond coating.



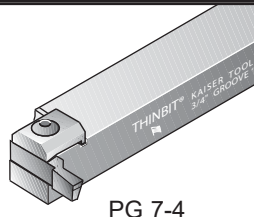
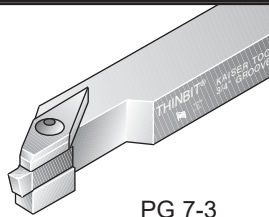
MODIFICATIONS

SEE PAGE 8-3 FOR ADDITIONAL INFORMATION

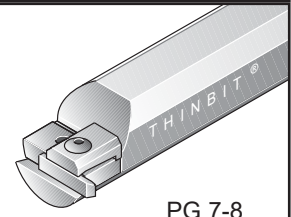
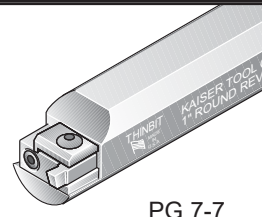


TOOLHOLDER SELECTIONS

CNC, SWISS, CONVENTIONAL STYLE



ROUND STYLE



TECHNICAL SECTIONS

PRODUCT DEMONSTRATION



www.thinbit.com/qr4-11

SPEEDS AND FEEDS

PG 9-18

APPLICATION REFERENCE

PGS 9-3 & 9-4

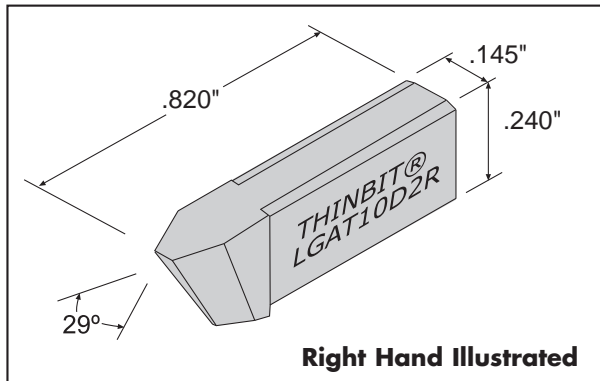
TROUBLESHOOTING

PG 9-7

KAISER TOOL COMPANY, INC.

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ACME THREADING INSERTS



FRONT RAKE: 15°

TOP RAKE: 0°

- 29° ACME threading inserts for internal and external applications.
- ACME threading tools can be used to cut other thread profiles by over cutting.
- Single lead

ORDERING INSTRUCTIONS

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

EXAMPLE:

The **ORDER CODE** for a right hand ACME threading insert in **DURA-MAX® 2000** with 10 or fewer T.P.I. is:
LGAT10D2R

ACME INSERTS
THREADING

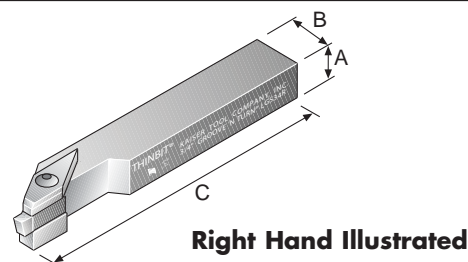
SPECIFICATIONS			ORDER CODE							INFO.
Insert Orientation	Threads per Inch	Flat at Tip	Insert Grades See Page 9-5 for expanded material selections and Page 9-18 for Speeds and Feeds information			Coatings See page 9-6 for expanded coating descriptions Use Uncoated Part Number and Add Coating Code				Toolholder Catalog Section 7 Use Toolholders Beginning With
			DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Nonferrous	High Speed Steel	TIN	TICN	TIAlN	Diamond	
Centered right hand, left hand, internal and external threads	4	.087"	LGAT04D2R	LGAT04D5R	LGAT04HSR	add 'C'	add 'D'	add 'E'	add 'F'	'L'
	5	.069"	LGAT05D2R	LGAT05D5R	LGAT05HSR					Use right hand straight holder, or left hand 90° holder, for right hand external threads or left hand internal threads
	6	.057"	LGAT06D2R	LGAT06D5R	LGAT06HSR					
	8	.041"	LGAT08D2R	LGAT08D5R	LGAT08HSR					or Use left hand straight holder, or right hand 90° holder, for left hand external threads or right hand internal threads
	10	.032"	LGAT10D2R	LGAT10D5R	LGAT10HSR					
	12	.028"	LGAT12D2R	LGAT12D5R	LGAT12HSR					
	14	.024"	LGAT14D2R	LGAT14D5R	LGAT14HSR					
	16	.021"	LGAT16D2R	LGAT16D5R	LGAT16HSR					

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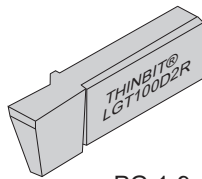
PRODUCT INFORMATION

- 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.



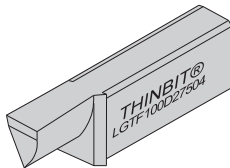
INSERT SELECTIONS

GROOVING



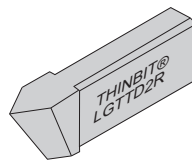
PG 1-9

FACE GROOVING



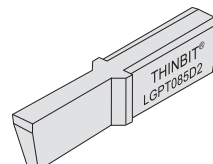
PG 2-9

THREADING



PG 4-9

PARTING



PG 5-3



Scan this code for additional information.

www.thinbit.com/qr7-3

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

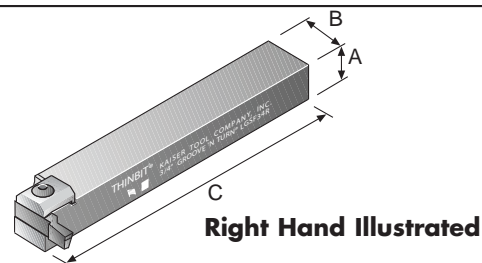
SPECIFICATIONS				ORDER CODE					
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Clamp and Hardware		Replacement Parts			
	'A'	'B'	'C'	For Inserts Beginning With 'L'		Clamp	Screw	Wrench	Pin
				RIGHT HAND	LEFT HAND				
Straight Use right hand holder with right hand inserts Use 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				

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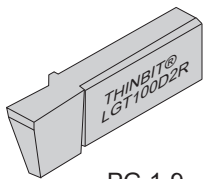
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**PRODUCT
INFORMATION**

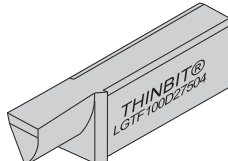
- Designed for CNC and conventional machines.
- Shank sizes 5/16", 3/8", 1/2", 5/8", 3/4", 1" and 1-1/4". Metric sizes also available.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



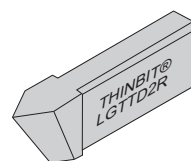
**INSERT
SELECTIONS**



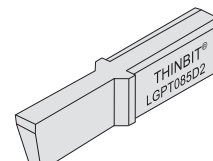
PG 1-9



PG 2-9



PG 4-9



PG 5-3



Scan this code for additional information.

www.thinbit.com/qc7-4

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

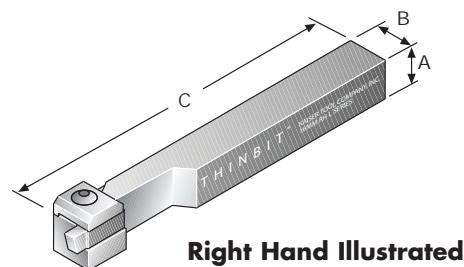
SPECIFICATIONS				ORDER CODE					
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Clamp and Hardware For Inserts Beginning With 'L'		Replacement Parts			
	'A'	'B'	'C'	RIGHT HAND	LEFT HAND	Clamp	Screw	Wrench	Pin
90° Use right hand holder with left hand inserts Use left hand holder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

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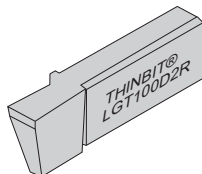
**PRODUCT
INFORMATION**

- Designed for top slide position on Swiss screw machines.
- Shank sizes 1/2", 12mm and 16mm in right hand orientation.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



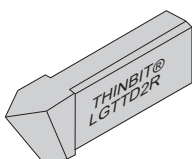
**INSERT
SELECTIONS**

GROOVING



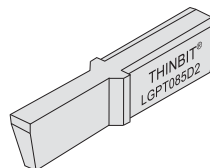
PG 1-9

THREADING



PG 4-9

PARTING



PG 5-3



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ORDERING INSTRUCTIONS

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

EXAMPLE:

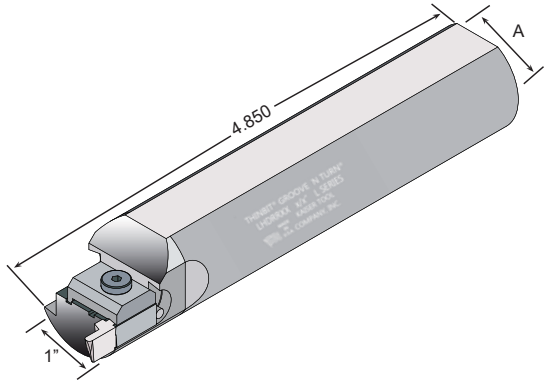
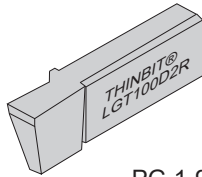
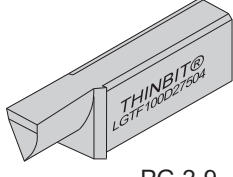
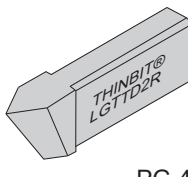
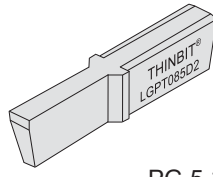
The **ORDER CODE** for a .500" shank, right hand tool for inserts beginning with 'L' is:

LSS12R

SPECIFICATIONS				ORDER CODE				
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Clamp and Hardware	Replacement Parts			
	'A'	'B'	'C'	For Inserts Beginning With 'L'	Clamp	Screw	Wrench	Pin
Right Hand	.500"	.500"	4.840"	LSS12R	Clamp C	S3808	W1005	P0305
Use with right hand and centered inserts	12mm	12mm		LSS12RM				
	16mm	16mm		LSS16RM				
Left Hand	.500"	.500"	4.840"	LSS12L				
Use with left hand and centered inserts	12mm	12mm		LSS12LM				
	16mm	16mm		LSS16LM				

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PRODUCT INFORMATION	<ul style="list-style-type: none"> 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 changing clamp to other side. Shank sizes 12mm, 1/2", 5/8", 16mm, 3/4" 20mm, 22mm, 25mm and 1". All 1/2", 5/8" and 3/4" shanks are made from 1" shank. For a shortened shank see page 11-2. Modifications can be provided on any of our tooling. Please contact us with your application requirements. 	 <p>Heavy Duty Round Reversible Toolholder</p>		
INSERT SELECTIONS	GROOVING	FACE GROOVING	THREADING	PARTING
	 PG 1-9	 PG 2-9	 PG 4-9	 PG 5-3

ORDERING INSTRUCTIONS

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

EXAMPLE:

The **ORDER CODE** for a 3/4" round shank for inserts beginning with 'L' is:

LHDDR34

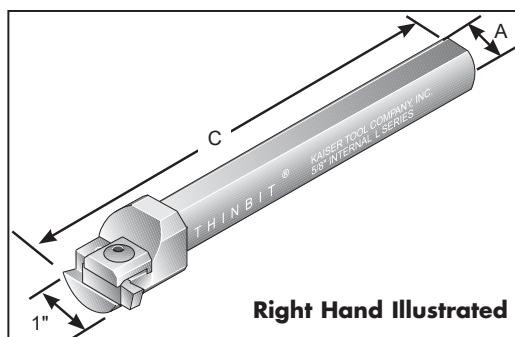
SPECIFICATIONS		ORDER CODE		
Shank Orientation	Shank Dimensions	Toolholder Package Includes Shank, Clamp and Hardware		
	'A'	For Inserts Beginning With 'L'	Clamp	Clamp Hardware
Right Hand or Left Hand Use as right hand with right hand inserts Use as left hand with left hand inserts Use as either hand with centered inserts	.500"	LHDDR12	Clamp C	Screw: S3808 Wrench: W1005 Pin: P0305
	.625"	LHDDR58		
	.750"	LHDDR34		
	1.00"	LHDDR01		
	12 mm	LHDDR12M		
	16 mm	LHDDR16M		
	20 mm	LHDDR20M		
	22 mm	LHDDR22M		
	25 mm	LHDDR25M		

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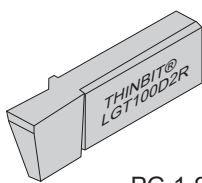
PRODUCT INFORMATION

- 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.



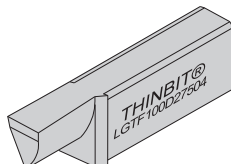
INSERT SELECTIONS

GROOVING



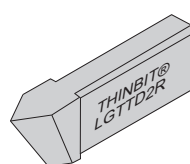
PG 1-9

FACE GROOVING



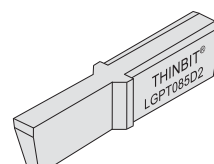
PG 2-9

THREADING



PG 4-9

PARTING



PG 5-3

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 For Inserts Beginning With 'L'	Replacement Parts			
		'A'	'C'		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				
		20mm	5.500"	LRO2015M				
		25mm		LRO2515M				

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