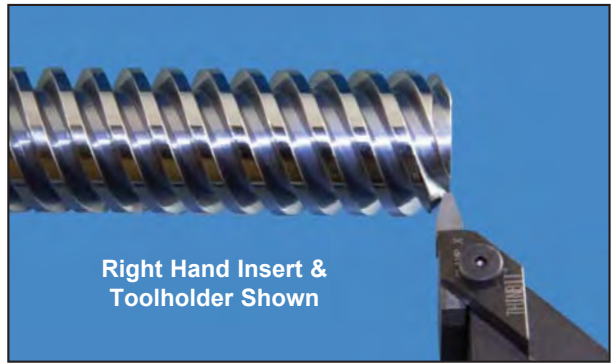


## PRODUCT INFORMATION

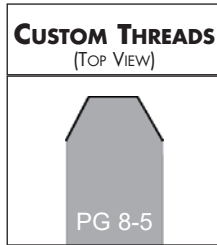
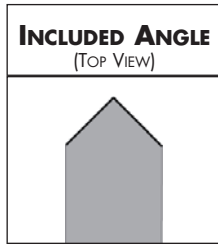
- External threading within .070" of a shoulder.
- Internal ACME threading with 1.250" minimum bore diameter.
- 4 threads per inch and greater.
- Sub-micron grain **DURA-MAX® 2000** and **5000** Carbides and High Speed Steel.
- Inserts can be coated with TiN, TiAlN, TiCN and Diamond coating.



Right Hand Insert & Toolholder Shown

## MODIFICATIONS

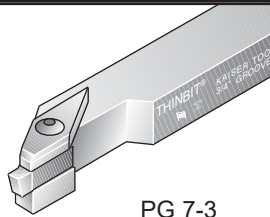
SEE PAGE  
**8-3**  
FOR ADDITIONAL  
INFORMATION



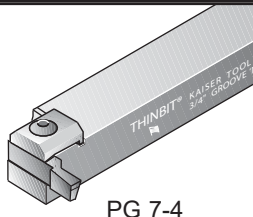
## CNC, SWISS, CONVENTIONAL STYLE

## ROUND STYLE

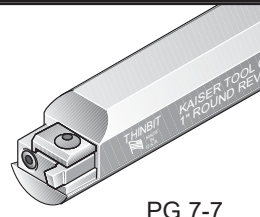
## TOOLHOLDER SELECTIONS



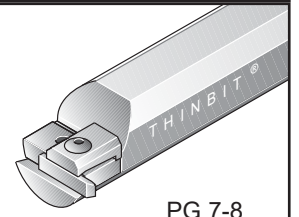
PG 7-3



PG 7-4



PG 7-7



PG 7-8

## PRODUCT DEMONSTRATION

## SPEEDS AND FEEDS

## APPLICATION REFERENCE

## TROUBLESHOOTING

## TECHNICAL SECTIONS



[www.thinbit.com/qr4-11](http://www.thinbit.com/qr4-11)

PG 9-18

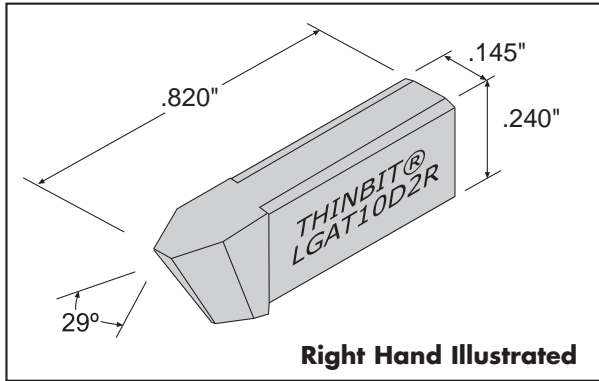
PGS 9-3 & 9-4

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

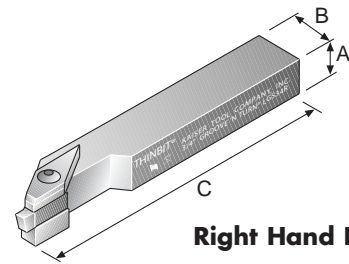
SPECIFICATIONS			ORDER CODE				INFO.			
Insert Orientation	Threads per Inch	Flat at Tip	Insert Grades See Page 9-5 for expanded material selections and Page 9-18 for Speeds and Feeds information			Coatings See page 9-6 for expanded coating descriptions Use Uncoated Part Number and Add Coating Code				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					
	6	.057"	LGAT06D2R	LGAT06D5R	LGAT06HSR					
	8	.041"	LGAT08D2R	LGAT08D5R	LGAT08HSR					
	10	.032"	LGAT10D2R	LGAT10D5R	LGAT10HSR					
	12	.028"	LGAT12D2R	LGAT12D5R	LGAT12HSR					
	14	.024"	LGAT14D2R	LGAT14D5R	LGAT14HSR					
	16	.021"	LGAT16D2R	LGAT16D5R	LGAT16HSR					
										Use right hand straight holder, or left hand 90° holder, for right hand external threads or left hand internal threads  or Use left hand straight holder, or right hand 90° holder, for left hand external threads or right hand internal threads

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## PRODUCT INFORMATION

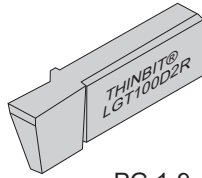
- Designed for CNC, conventional and top slide position on Swiss screw machines.
- Shank sizes 5/16", 3/8", 1/2", 5/8", 3/4", 1" and 1-1/4". Metric sizes also available.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



Right Hand Illustrated

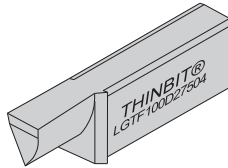
## INSERT SELECTIONS

### GROOVING



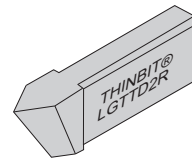
PG 1-9

### FACE GROOVING



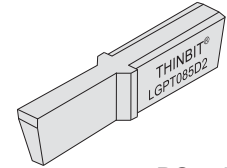
PG 2-9

### THREADING



PG 4-9

### PARTING



PG 5-3



Scan this code for additional information.

[www.thinbit.com/qr7-3](http://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:

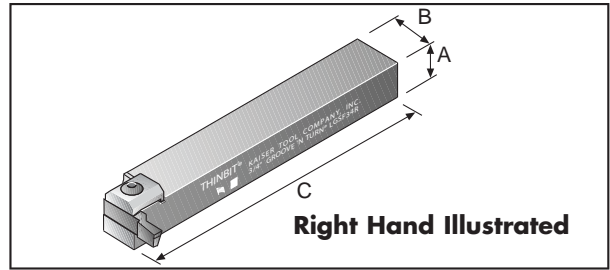
**LGS34R**

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					

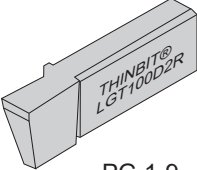
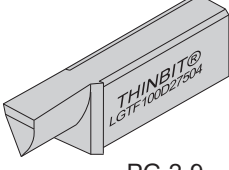
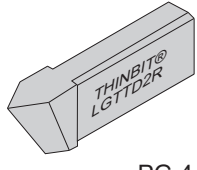
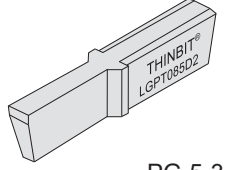
## KAISER TOOL COMPANY, INC.

## 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

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



Scan this code for additional information.

[www.thinbit.com/qr7-4](http://www.thinbit.com/qr7-4)

## 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	.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				
Use left hand holder with right hand inserts	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				

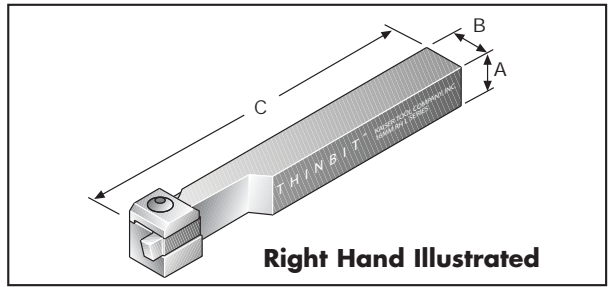
GROOVE 'N TURN® TOOLHOLDERS

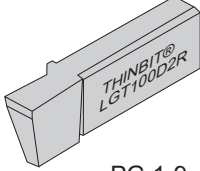
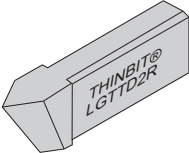
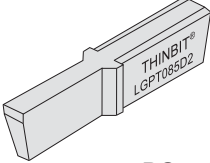
## KAISER TOOL COMPANY, INC.

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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	THREADING	PARTING
	 PG 1-9	 PG 4-9	 PG 5-3



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[www.thinbit.com/qr7-5](http://www.thinbit.com/qr7-5)

**ORDERING INSTRUCTIONS**

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

**EXAMPLE:**

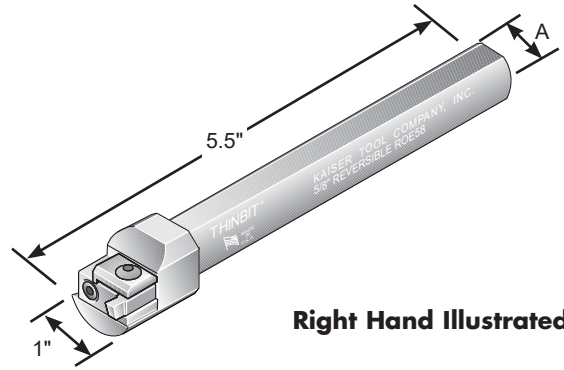
The **ORDER CODE** for a .500" shank, right hand tool for inserts beginning with 'L' is:  
**LSS12R**

SPECIFICATIONS				ORDER CODE				
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Clamp and Hardware  For Inserts Beginning With  'L'	Replacement Parts			
	'A'	'B'	'C'		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				

**KAISER TOOL COMPANY, INC.**

**PRODUCT INFORMATION**

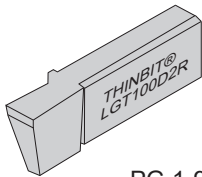
- Designed for boring bar positions on all machines.
- Can be used with a boring head to trepan on a mill. Shank may need to be shortened.
- Toolholder reversible by removing face and bottom screws and rotating head 1/2 turn.
- Shank sizes 1/2", 5/8", 3/4" and 1".
- All 1/2", 5/8" and 3/4" shanks are made from 1" shank.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



**Right Hand Illustrated**

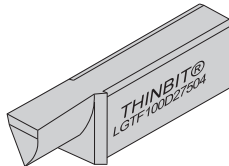
**INSERT SELECTIONS**

**GROOVING**



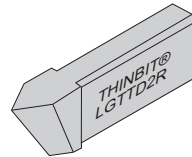
PG 1-9

**FACE GROOVING**



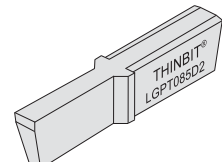
PG 2-9

**THREADING**



PG 4-9

**PARTING**



PG 5-3



Scan this code for additional information.

[www.thinbit.com/qr7-7](http://www.thinbit.com/qr7-7)

**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:

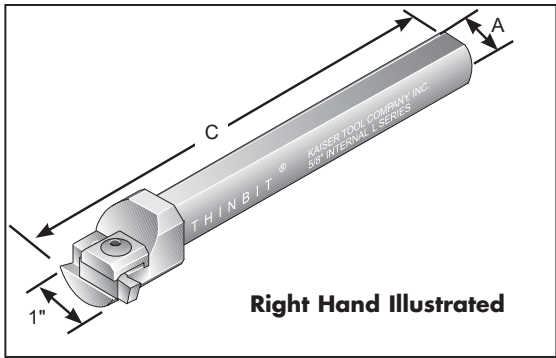
**LROE58**

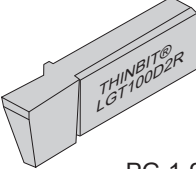
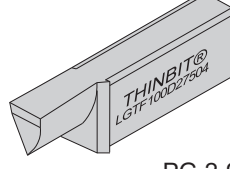
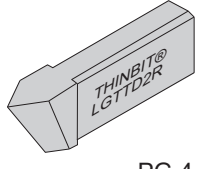
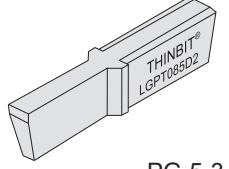
SPECIFICATIONS		ORDER CODE						
Shank Orientation	Shank Dimensions  'A'	Toolholder Package Includes Shank, Head, Clamp and Hardware  For Inserts Beginning With  'L'	Replacement Parts					Clamp Hardware
			Head Only Includes Clamp and Hardware For Inserts Beginning With  'L'	Head Screws	Head Wrenches	Shank	Clamp	
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	Clamp C	Screw: S3808  Wrench: W1005
	.625"	LROE58				RROE58		
	.750"	LROE34				RROE34		
	1.000"	LROE01				RROE01		

**KAISER TOOL COMPANY, INC.**

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



Scan this code for additional information.

[www.thinbit.com/qr7-8](http://www.thinbit.com/qr7-8)

**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'			
	without pin				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				

**ROUND TOOLHOLDERS**

**KAISER TOOL COMPANY, INC.**