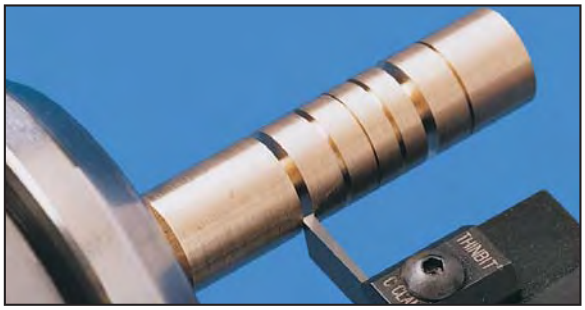
Product Information

- .025", .045", .062", .085" and .115"
- Parting off up to 1" diameter
- 0° or 7° lead angle
- Centered or Offset
- Sub-micron grain **DURA-MAX® 2000** and **5000** Carbides and High Speed Steel.
- Inserts available with TiN, TiAlN, TiCN and Diamond coating.



Modifications

SEE PAGE 8-3 FOR ADDITIONAL INFORMATION

Radii (Top View)

Depth Of Cut (Top View)

Insert Width (Top View)

Back Clearance (Top View)

Lead Angle (Top View)

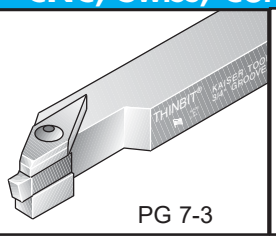
Top Rake (Side View)

Chip Breaker (Side View)

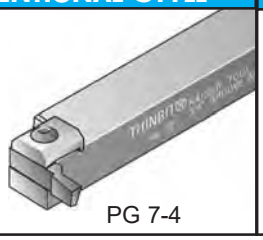
Side Clearance (End View)

Toolholder Selections

CNC, Swiss, Conventional Style

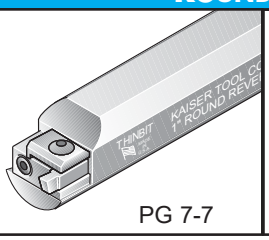


PG 7-3

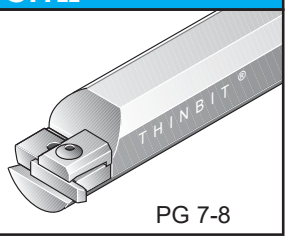


PG 7-4

Round Style



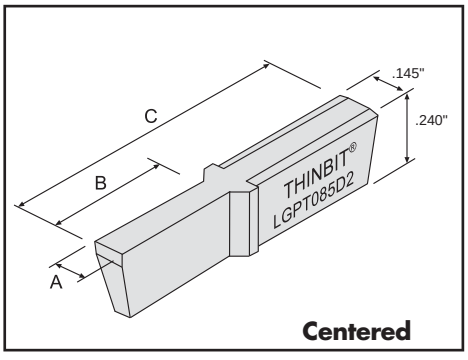
PG 7-7



PG 7-8

Technical Sections

Product Demonstration	Speeds and Feeds	Application Reference	Troubleshooting
www.thinbit.com/qr5-3	PG 9-20	PGS 9-3 & 9-4	PG 9-7



Centered

FRONT RAKE:

CARBIDE: Primary 7° honed, Secondary 15°

HIGH SPEED STEEL: 15°

BACK CLEARANCE:

0° LGPT045HS & LGPT062HS

1° all others

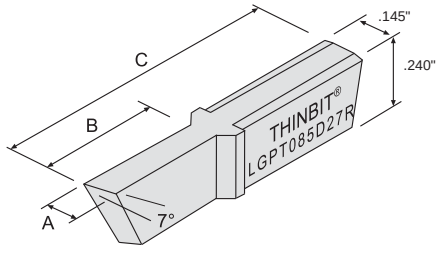
SIDE CLEARANCE: 1°

RADIUS: None

TOP RAKE: 0°

LEAD ANGLE: 0° or 7°

Parting Tools with Lead Angle



Centered Right Hand Lead

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ORDERING INSTRUCTIONS

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

EXAMPLE:

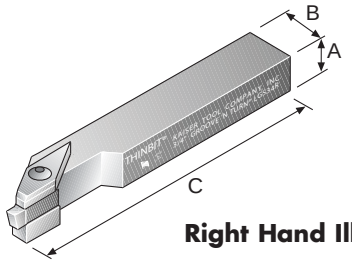
The **ORDER CODE** for an .085" wide parting insert in **DURA-MAX® 2000** is:

LGPT085D2

SPECIFICATIONS				ORDER CODE							INFORMATION	
Insert Width 'A' ±.001"	Insert Orientation	Lead Angle Orientation (Right Hand / Left Hand)	Depth of Cut 'B'	Insert Grades (See Page 9-5 for expanded material descriptions and Page 9-20 for Speeds and Feeds information) DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Non-ferrous	High Speed Steel	Coatings (See Page 9-6 for expanded coating descriptions) Use uncoated part number and add coating code: TiN	TiCN	TiAlN	Diamond	Overall Length 'C'	Toolholder Catalog Section 7 Use Toolholders Beginning With
.025"	Centered	0°	.200"	LGPT025D2	LGPT025D5	LGPT025HS	add 'C'	add 'D'	add 'E'	add 'F'	.820" Carbide .825" HSS	'L' Series Centered Use any straight holder or 90° holder. Right Hand Use right hand straight holder or left hand 90° holder. Left Hand Use left hand straight holder or right hand 90° holder.
		7° Right Hand		LGPT025D27R	LGPT025D57R	LGPT025HS7R						
		7° Left Hand		LGPT025D27L	LGPT025D57L	LGPT025HS7L						
	Right Hand	0°		LGPT025D2R	LGPT025D5R	LGPT025HSR						
		7° Right Hand		LGPT025D2R7R	LGPT025D5R7R	LGPT025HSR7R						
		7° Left Hand		LGPT025D2R7L	LGPT025D5R7L	LGPT025HSR7L						
	Left Hand	0°		LGPT025D2L	LGPT025D5L	LGPT025HSL						
		7° Right Hand		LGPT025D2L7R	LGPT025D5L7R	LGPT025HSL7R						
		7° Left Hand		LGPT025D2L7L	LGPT025D5L7L	LGPT025HSL7L						
.045"	Centered	0°	.500"	LGPT045D2	LGPT045D5	LGPT045HS					1.062" Carbide 1.078" HSS	
		7° Right Hand		LGPT045D27R	LGPT045D57R	LGPT045HS7R						
		7° Left Hand		LGPT045D27L	LGPT045D57L	LGPT045HS7L						
	Right Hand	0°		LGPT045D2R	LGPT045D5R	LGPT045HSR						
		7° Right Hand		LGPT045D2R7R	LGPT045D5R7R	LGPT045HSR7R						
		7° Left Hand		LGPT045D2R7L	LGPT045D5R7L	LGPT045HSR7L						
	Left Hand	0°		LGPT045D2L	LGPT045D5L	LGPT045HSL						
		7° Right Hand		LGPT045D2L7R	LGPT045D5L7R	LGPT045HSL7R						
		7° Left Hand		LGPT045D2L7L	LGPT045D5L7L	LGPT045HSL7L						
.062"	Centered	0°	.500"	LGPT062D2	LGPT062D5	LGPT062HS						
		7° Right Hand		LGPT062D27R	LGPT062D57R	LGPT062HS7R						
		7° Left Hand		LGPT062D27L	LGPT062D57L	LGPT062HS7L						
	Right Hand	0°		LGPT062D2R	LGPT062D5R	LGPT062HSR						
		7° Right Hand		LGPT062D2R7R	LGPT062D5R7R	LGPT062HSR7R						
		7° Left Hand		LGPT062D2R7L	LGPT062D5R7L	LGPT062HSR7L						
	Left Hand	0°		LGPT062D2L	LGPT062D5L	LGPT062HSL						
		7° Right Hand		LGPT062D2L7R	LGPT062D5L7R	LGPT062HSL7R						
		7° Left Hand		LGPT062D2L7L	LGPT062D5L7L	LGPT062HSL7L						
.085"	Centered	0°	.500"	LGPT085D2	LGPT085D5	LGPT085HS						
		7° Right Hand		LGPT085D27R	LGPT085D57R	LGPT085HS7R						
		7° Left Hand		LGPT085D27L	LGPT085D57L	LGPT085HS7L						
	Right Hand	0°		LGPT085D2R	LGPT085D5R	LGPT085HSR						
		7° Right Hand		LGPT085D2R7R	LGPT085D5R7R	LGPT085HSR7R						
		7° Left Hand		LGPT085D2R7L	LGPT085D5R7L	LGPT085HSR7L						
	Left Hand	0°		LGPT085D2L	LGPT085D5L	LGPT085HSL						
		7° Right Hand		LGPT085D2L7R	LGPT085D5L7R	LGPT085HSL7R						
		7° Left Hand		LGPT085D2L7L	LGPT085D5L7L	LGPT085HSL7L						
.115"	Centered	0°	.500"	LGPT115D2	LGPT115D5	LGPT115HS						
		7° Right Hand		LGPT115D27R	LGPT115D57R	LGPT115HS7R						
		7° Left Hand		LGPT115D27L	LGPT115D57L	LGPT115HS7L						
	Right Hand	0°		LGPT115D2R	LGPT115D5R	LGPT115HSR						
		7° Right Hand		LGPT115D2R7R	LGPT115D5R7R	LGPT115HSR7R						
		7° Left Hand		LGPT115D2R7L	LGPT115D5R7L	LGPT115HSR7L						
	Left Hand	0°		LGPT115D2L	LGPT115D5L	LGPT115HSL						
		7° Right Hand		LGPT115D2L7R	LGPT115D5L7R	LGPT115HSL7R						
		7° Left Hand		LGPT115D2L7L	LGPT115D5L7L	LGPT115HSL7L						

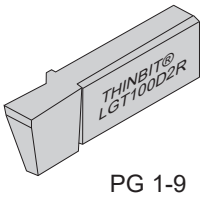
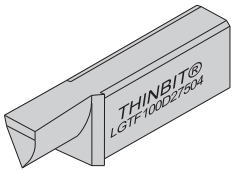
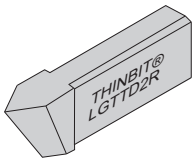
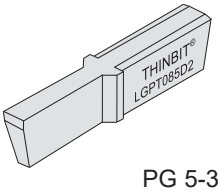
PRODUCT INFORMATION

- 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	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/qr7-3

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' RIGHT HAND	LEFT HAND	Clamp	Screw	Wrench	Pin
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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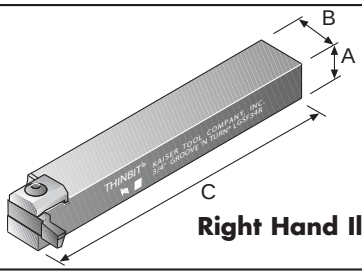
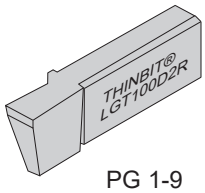
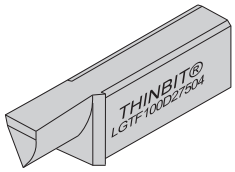
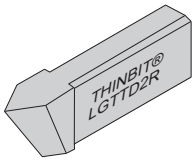
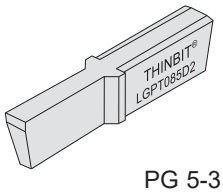
PRODUCT INFORMATION

- 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.



Right Hand Illustrated

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

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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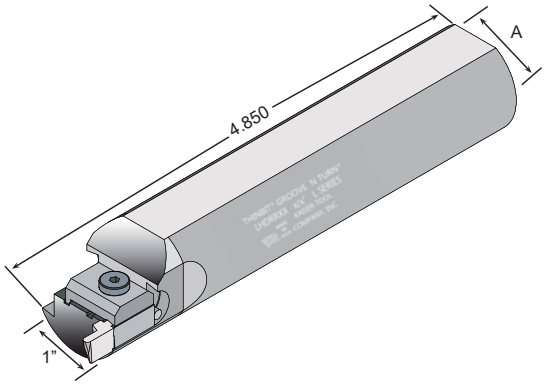
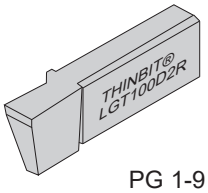
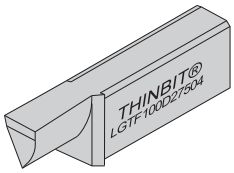
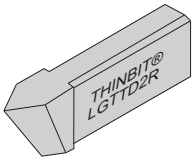
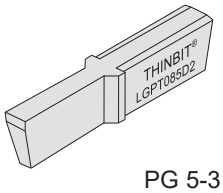
Product Information

- Designed for 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.



Heavy Duty Round Reversible Toolholder

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:

LHDRR34

SPECIFICATIONS		ORDER CODE		
Shank Orientation	Shank Dimensions 'A'	Toolholder Package Includes Shank, Clamp and Hardware — 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"	LHDRR12	Clamp C	Screw: S3808 Wrench: W1005 Pin: P0305
	.625"	LHDRR58		
	.750"	LHDRR34		
	1.00"	LHDRR01		
	12 mm	LHDRR12M		
	16 mm	LHDRR16M		
	20 mm	LHDRR20M		
	22 mm	LHDRR22M		
	25 mm	LHDRR25M		

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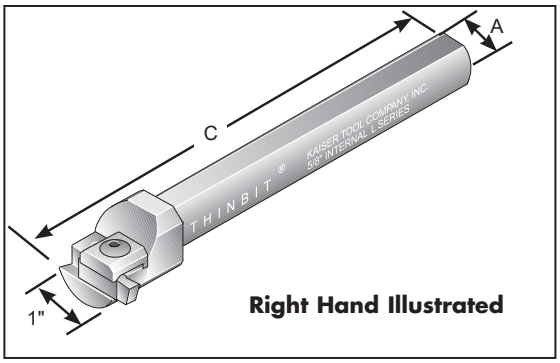
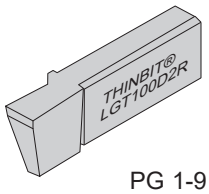
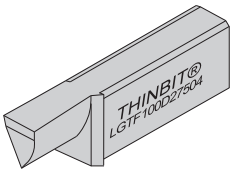
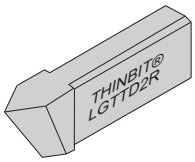
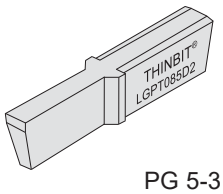
Product Information

- 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.



Right Hand Illustrated

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 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 without pin	Shank Dimensions 'A'	Shank Dimensions 'C'	Toolholder Package Includes Shank, Clamp and Hardware For Inserts Beginning With 'L'	Replacement Parts Clamp	Replacement Parts Screw	Replacement Parts Wrench	Replacement Parts 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				