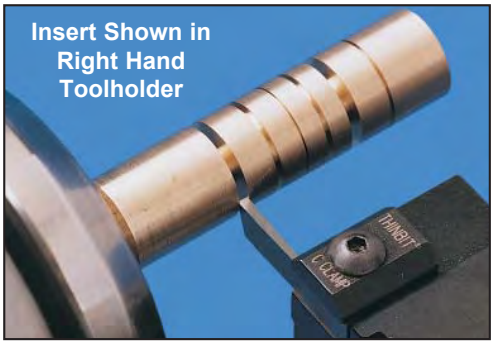
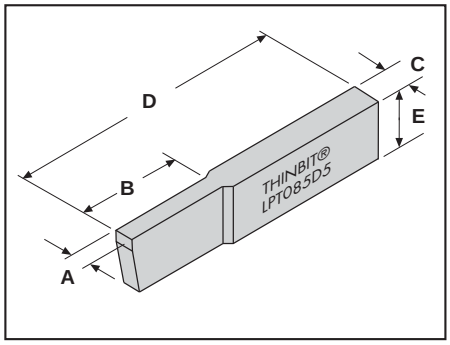




FRONT RAKE:
CARBIDE: Primary 7° honed, Secondary 15°
HIGH SPEED STEEL: 15° on SPT025HS, 7° all others
BACK CLEARANCE: 0° SPT045HS and SPT062HS; 1° all others
SIDE CLEARANCE: 1°
RADIUS: None
TOP RAKE: 0°
LEAD ANGLE: 0°
'A' TOLERANCE: .025" - .115": +.001"/-.001"

PRODUCT INFORMATION

- This insert style will cut to within 1/16" of a shoulder.
- .025", .045", .062", .085" and .115"
- Parting off up to 1" diameter
- Centered
- Sub-micron grain **DURA-MAX® 2000** and **5000** Carbides and High Speed Steel.
- Inserts available with TiN, TiAlN, TiCN and Diamond coating.

TECHNICAL SECTIONS

PRODUCT DEMONSTRATION	SPEEDS AND FEEDS	APPLICATION REFERENCE	TROUBLESHOOTING
www.thinbit.com/qr10-2	PG 9-20	PG 9-4	PG 9-7

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® 5000** is:

LPT085D5

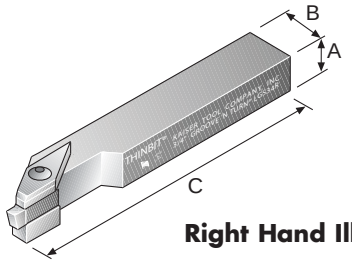
SPECIFICATIONS		ORDER CODE							INFORMATION			
Groove Width	Depth of Cut	Insert Grades (See Pages 9-5 for expanded material descriptions and Page 9-20 for Speeds and Feeds information)			Coatings (See Page 9-6 for expanded coating descriptions)				Blank Width	Overall Length	Blank Height	Toolholder Catalog Section 7 & 10
'A'	'B'	DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Nonferrous	High Speed Steel	Use uncoated part number and add coating code: TiN	TiCN	TiAlN	Diamond	'C'	'D'	'E'	Use Toolholders Beginning With
.025"	.200"	SPT025D2	SPT025D5	SPT025HS	add 'C'	add 'D'	add 'E'	add 'F'	.068"	.650"	.240"	'S' 'EM' 'ROM' Page 10-5 through 10-8
.045"	.500"	SPT045D2	SPT045D5	SPT045HS						1.000"		
.062"		SPT062D2	SPT062D5	SPT062HS								
.085"	.500"	LPT085D2	LPT085D5		add 'C'	add 'D'	add 'E'	add 'F'	.125"	1.000"	.238"	'L' 'EM' 'ROM' Section 7 Page 10-5 through 10-8
.115"		LPT115D2	LPT115D5								.232"	

KAISER TOOL COMPANY, INC.

Phone: 888-THINBIT (888-844-6248) or (260) 484-3620 • Fax: 888-THINFAX (888-844-6329) or (260) 482-1881
www.thinbit.com • General E-mail: *thinbit@kaisertool.com* • Orders: *orders@thinbit.com* • Quotes: *quotes@thinbit.com*

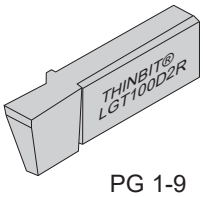
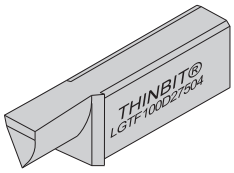
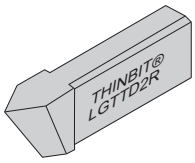
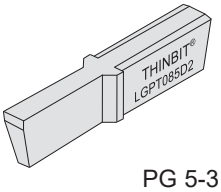
PRODUCT INFORMATION

- 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

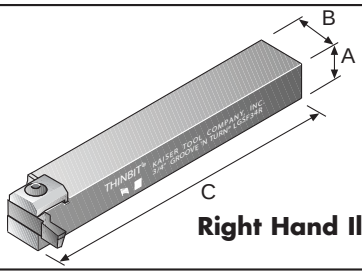
SPECIFICATIONS				ORDER CODE					
Shank Orientation	Shank Dimensions			Toolholder Package Includes Shank, Clamp and Hardware		Replacement Parts			
	'A'	'B'	'C'	For Inserts Beginning With 'L' RIGHT HAND	LEFT HAND	Clamp	Screw	Wrench	Pin
Straight Use right hand holder with right hand inserts Use left hand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

KAISER TOOL COMPANY, INC.

Phone: 888-THINBIT (888-844-6248) or (260) 484-3620 • Fax: 888-THINFAX (888-844-6329) or (260) 482-1881
www.thinbit.com • General E-mail: *thinbit@kaisertool.com* • Orders: *orders@thinbit.com* • Quotes: *quotes@thinbit.com*

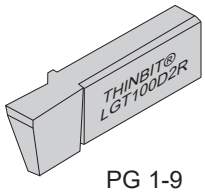
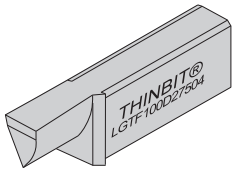
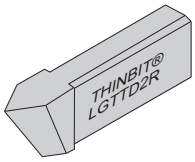
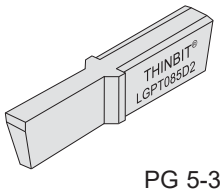
PRODUCT INFORMATION

- 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:

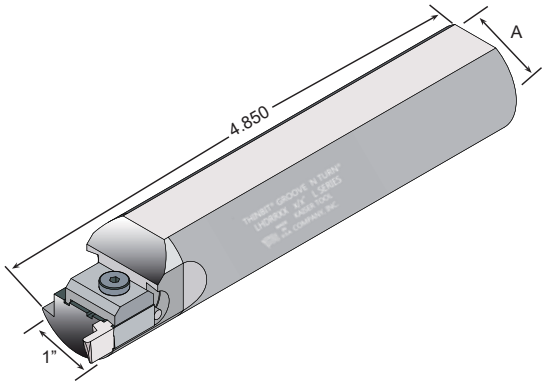
LGSF34R

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				

KAISER TOOL COMPANY, INC.
Phone: 888-THINBIT (888-844-6248) or (260) 484-3620 • Fax: 888-THINFAX (888-844-6329) or (260) 482-1881
www.thinbit.com • General E-mail: *thinbit@kaisertool.com* • Orders: *orders@thinbit.com* • Quotes: *quotes@thinbit.com*

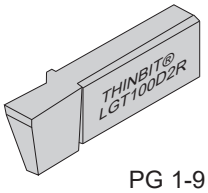
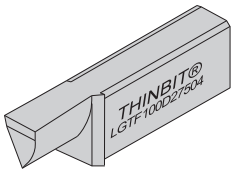
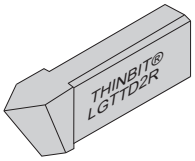
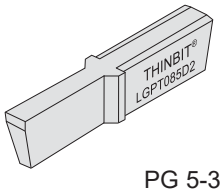
Product Information

- 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:

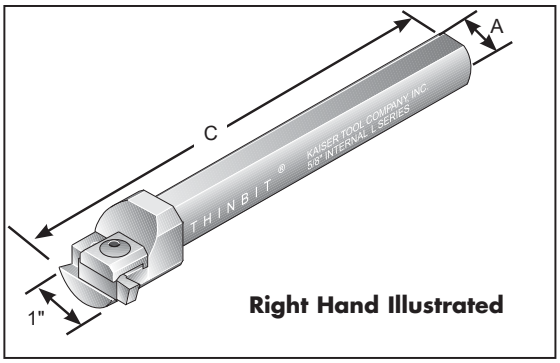
LHDRR34

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		

KAISER TOOL COMPANY, INC.
Phone: 888-THINBIT (888-844-6248) or (260) 484-3620
www.thinbit.com • Orders: *orders@thinbit.com* • Quotes: *quotes@thinbit.com*

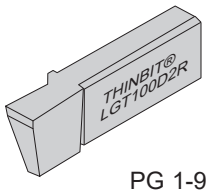
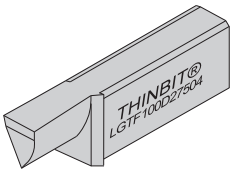
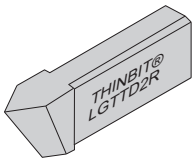
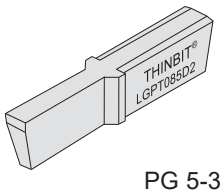
Product Information

- 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

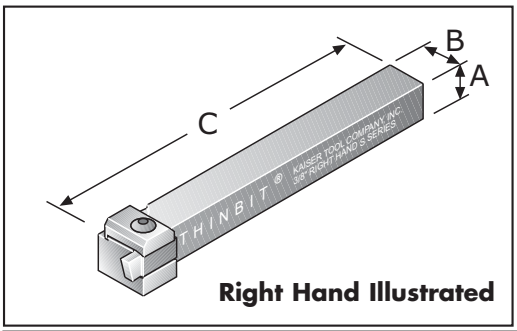
Select the **ORDER CODE** in the table below that represents your selection of shank orientation and dimensions.

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				



Right Hand Illustrated

FLUSHTOP ORDERING INSTRUCTIONS

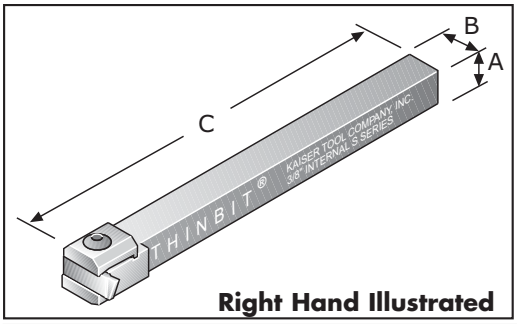
Select the **ORDER CODE** in the table below that represents your selection of shank orientation and dimensions.

EXAMPLE:

The **ORDER CODE** for a .375" shank, right hand flushtop tool for inserts beginning with 'L' is:

LFT38R

SPECIFICATIONS				ORDER CODE					
Shank Orientation	Shank Dimensions 'A'	'B'	'C'	Toolholder Package Includes Shank, Clamp and Hardware For Inserts Beginning With 'S'	'L'	Replacement Parts Clamp	Screw	Wrench	Pin
Right Hand Use with right hand and centered inserts	.312"	.312"	4.840"	SFT56R	- - -	Clamp A	S5608	W1005	P0308
				- - -	LFT56R	Clamp C	S3808		
	.375"	.375"	4.840"	SFT38R	- - -	Clamp A	S5608		
				- - -	LFT38R	Clamp C	S3808		
	.500"	.500"	4.840"	SFT12R	LFT12R	Clamp C	S3808		
	.625"	.625"	4.840"	SFT58R	LFT58R	Clamp C	S3808		
Left Hand Use with left hand and centered inserts	.312"	.312"	4.840"	SFT56L	- - -	Clamp A	S5608		
				- - -	LFT56L	Clamp C	S3808		
	.375"	.375"	4.840"	SFT38L	- - -	Clamp A	S5608		
				- - -	LFT38L	Clamp C	S3808		
	.500"	.500"	4.840"	SFT12L	LFT12L	Clamp C	S3808		
	.625"	.625"	4.840"	SFT58L	LFT58L	Clamp C	S3808		



Right Hand Illustrated

HARDINGE ORDERING INSTRUCTIONS

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

EXAMPLE:

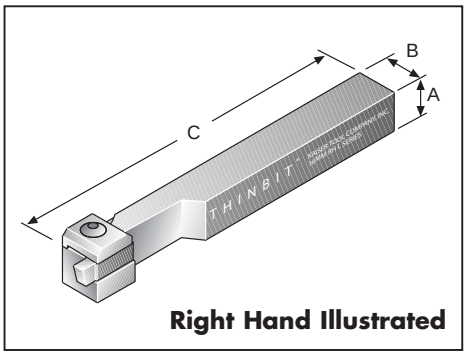
The **ORDER CODE** for a .375" shank, right hand tool for inserts beginning with 'L' is:

LHA38

SPECIFICATIONS					ORDER CODE					
Shank Orientation	Shank Dimensions 'A'	'B'	'C'	Minimum Bore Diameter with 'S' inserts; add .071" for 'L' inserts	Toolholder Package Includes Shank, Clamp and Hardware For Inserts Beginning With 'S'	'L'	Replacement Parts Clamp	Screw	Wrench	Pin
Right Hand Use with left hand and centered inserts	.375"	.375"	4.840"	1.050"	SHA38	- - -	Clamp C	S3808	W1005	P0204
					- - -	LHA38				
	.500"	.500"	4.840"	1.290"	SHA12	LHA12				
Left Hand Use with right hand and centered inserts	.375"	.375"	4.840"	1.050"	SHA38	- - -				
					- - -	LHA38				
	.500"	.500"	4.840"	1.290"	SHA12	LHA12				

KAISER TOOL COMPANY, INC.

Phone: 888-THINBIT (888-844-6248) or (260) 484-3620 • Fax: 888-THINFAX (888-844-6329) or (260) 482-1881
www.thinbit.com • General E-mail: *thinbit@kaisertool.com* • Orders: *orders@thinbit.com* • Quotes: *quotes@thinbit.com*



Right Hand Illustrated

SWISS SCREW ORDERING INSTRUCTIONS

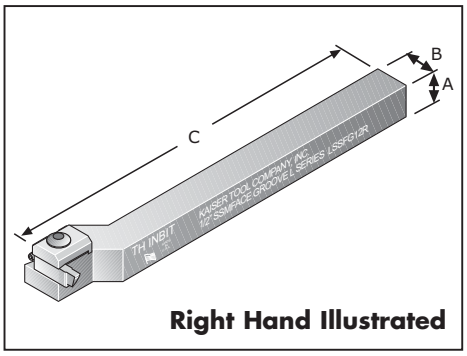
Select the **ORDER CODE** in the table below that represents your selection of shank orientation and dimensions.

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 'A'	'B'	'C'	Toolholder Package Includes Shank, Clamp and Hardware For Inserts Beginning With 'S'	'L'	Replacement Parts Clamp 'S'	Clamp 'L'	Screw 'S'	Screw 'L'	Wrench	Pin
Right Hand Use with right hand and centered inserts	.375"	.375"	4.840"	SSS38R	- - -	A	- -	S5608	- - -	W1005	P0305
	.500"	.500"		SSS12R	LSS12R	A	C	S5608	S3808		
	8mm	8mm		SSS08RM	- - -	A	- -	S5608	- - -		
	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	- - -		
	.500"	.500"		SSS12L	LSS12L	A	C	S5608	S3808		
	8mm	8mm		SSS08LM	- - -	A	- -	S5608	- - -		
	10mm	10mm		SSS10LM	- - -	A	- -	S5608	- - -		
	12mm	12mm		SSS12LM	LSS12LM	A	C	S5608	S3808		
	16mm	16mm		SSS16LM	LSS16LM	C	C	S3808	S3808		



Right Hand Illustrated

SWISS FACE ORDERING INSTRUCTIONS

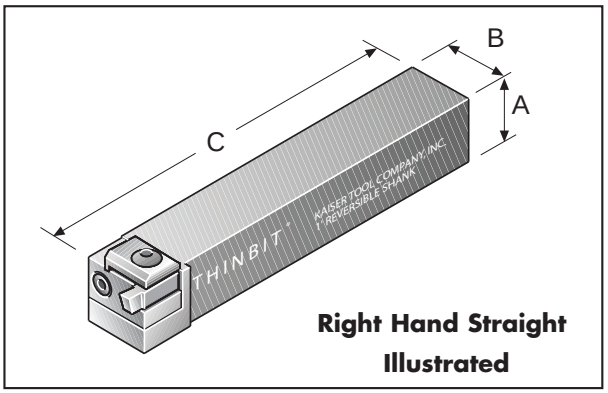
Select the **ORDER CODE** in the table below that represents your selection of shank orientation and dimensions.

EXAMPLE:

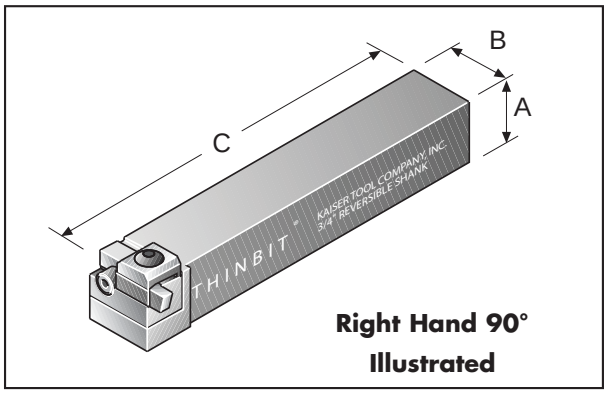
The **ORDER CODE** for a .375" shank, right hand tool for inserts beginning with 'L' is:

LSSFG38R

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



Right Hand Straight Illustrated



Right Hand 90° Illustrated

ORDERING INSTRUCTIONS

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

EXAMPLE:

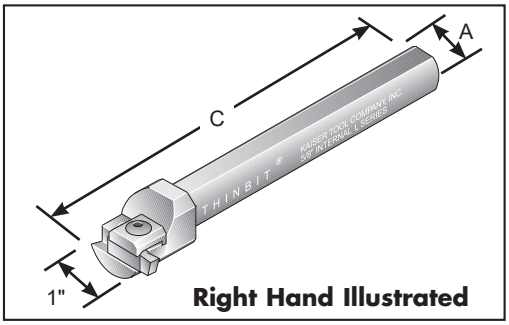
The **ORDER CODE** for a .750" shank and a 90° right hand tool for inserts beginning with 'L' is:

LRI3434R

SPECIFICATIONS				ORDER CODE									
	Shank Dimensions			Toolholder Package Includes Shank, Head, Clamp and Hardware For Inserts Beginning With		Head Only Includes Clamp and Hardware For Inserts Beginning With		Replacement Parts					
Shank Orientation	'A'	'B'	'C'	'S'	'L'	'S'	'L'	Head Screws	Head Wrenches	Head Pin	Shank	Clamp	Clamp Hardware
Straight 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.	.375"	.750"	4.840"	SRE3438	LRE3438	SREH34	LREH34	1 each: S3808 S2808	1 each: W1005 W1009		RS3438	Clamp C	Screw: S3808 Wrench: W1005
	.500"			SRE3412	LRE3412						RS3412		
	.625"			SRE3458	LRE3458						RS3458		
	.750"			SRE3434	LRE3434						RS3434		
	.750"	1.000"	4.840"	SRE0134	LRE0134	SREH01	LREH01	1 each: S3812 S2808	1 each: W1005 W1009		RS0134		
	1.000"			SRE0101	LRE0101						RS0101		
	1.000"	1.250"	4.840"	SRE1401	LRE1401	SREH14	LREH14	1 each: S3816 S2808	1 each: W1005 W1009		RS1401		
	1.250"			SRE1414	LRE1414						RS1414		
90° Right Hand Use with left hand and centered inserts	.375"	.750"	4.840"	SRI3438R	LRI3438R	SRIH34R	LRIH34R	1 each: S3808 S2812	1 each: W1005 W1009		RS3438	Clamp C	Screw: S3808 Wrench: W1005
	.500"			SRI3412R	LRI3412R						RS3412		
	.625"			SRI3458R	LRI3458R						RS3458		
	.750"			SRI3434R	LRI3434R						RS3434		
	.750"	1.000"	4.840"	SRI0134R	LRI0134R	SRIH01R	LRIH01R	1 each: S3812 S2812	1 each: W1005 W1009	P0305	RS0134		
	1.000"			SRI0101R	LRI0101R						RS0101		
90° Left Hand Use with right hand and centered inserts	.375"	.750"	4.840"	SRI3438L	LRI3438L	SRIH34L	LRIH34L	1 each: S3808 S2812	1 each: W1005 W1009		RS3438		
	.500"			SRI3412L	LRI3412L						RS3412		
	.625"			SRI3458L	LRI3458L						RS3458		
	.750"			SRI3434L	LRI3434L						RS3434		
	.750"	1.000"	4.840"	SRI0134L	LRI0134L	SRIH01L	LRIH01L	1 each: S3812 S2812	1 each: W1005 W1009	P0305	RS0134		
	1.000"			SRI0101L	LRI0101L						RS0101		

KAISER TOOL COMPANY, INC.

Phone: 888-THINBIT (888-844-6248) or (260) 484-3620 • Fax: 888-THINFAX (888-844-6329) or (260) 482-1881
www.thinbit.com • General E-mail: *thinbit@kaisertool.com* • Orders: *orders@thinbit.com* • Quotes: *quotes@thinbit.com*



Right Hand Illustrated

ROUND INTERNAL ORDERING INSTRUCTIONS

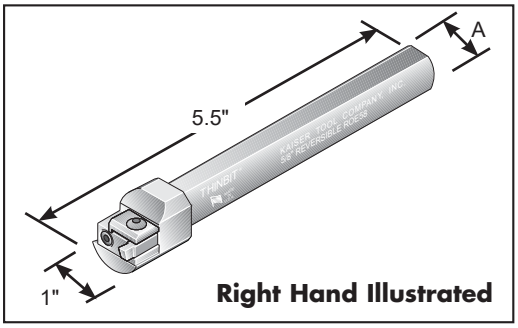
Select the **ORDER CODE** in the table below that represents your selection of shank orientation and dimensions.

EXAMPLE:

The **ORDER CODE** for a .625", 5.5" long round 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 'S'	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.	1.125"	.500"	5.500"	SR1206	- - -	Clamp C	S3808	W1005	P0305
		.625"		SR5806	- - -				
		.750"		SR3406	- - -				
		1.000"		SR0106	- - -				
			11.875"	SR0112	- - -				
	1.187" (1.250" for insert beginning with 'LGT')	.500"	5.500"	- - -	LR1206				
		.625"		- - -	LR5806				
		.750"		- - -	LR3406				
		1.000"		- - -	LR0106				
			11.875"	- - -	LR0112				



Right Hand Illustrated

ROUND REVERSIBLE 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 'S'	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 'S'	Replacement Parts Head Only Includes Clamp and Hardware For Inserts Beginning With 'L'	Replacement Parts Head Screws	Replacement Parts Head Wrenches	Replacement Parts Shank	Replacement Parts Clamp	Replacement Parts 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"	SROE12	LROE12	SROEH	LROEH	1 each: S5806 S2810	1 each: W1006 W1009	RROE12	Clamp C	Screw: S3808 Wrench: W1005
	.625"	SROE58	LROE58					RROE58		
	.750"	SROE34	LROE34					RROE34		
	1.000"	SROE01	LROE01					RROE01		