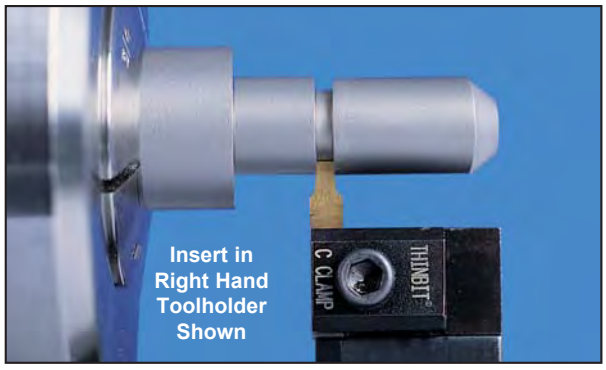
Product Information

- External grooving.
- Internal Static O-Ring grooving with 1.250" minimum bore diameter.
- Sub-micron grain **DURA-MAX® 2000** and **5000** Carbides.
- Inserts available with TiN, TiAlN, TiCN and Diamond coating.



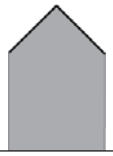
Modifications

SEE PAGE 8-3 FOR ADDITIONAL INFORMATION

Radii (Top View)

Depth Of Cut (Top View)

Included Angle (Top View)



Back Clearance (Top View)

Lead Angle (Top View)

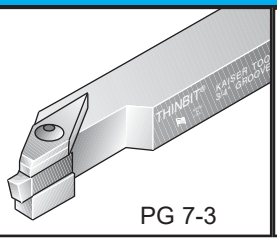
Top Rake (Side View)

Chip Breaker (Side View)

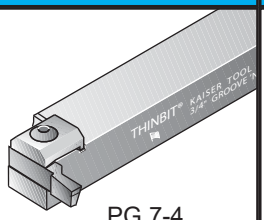
Side Clearance (End View)

Toolholder Selections

CNC, Swiss, Conventional Style

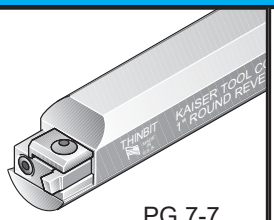


PG 7-3

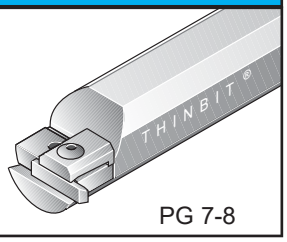


PG 7-4

Round Style



PG 7-7



PG 7-8

Technical Sections

Product Demonstration	Speeds and Feeds	Application Reference	Troubleshooting
www.thinbit.com/qr1-11	PG 9-10	PG 9-3	PG 9-7

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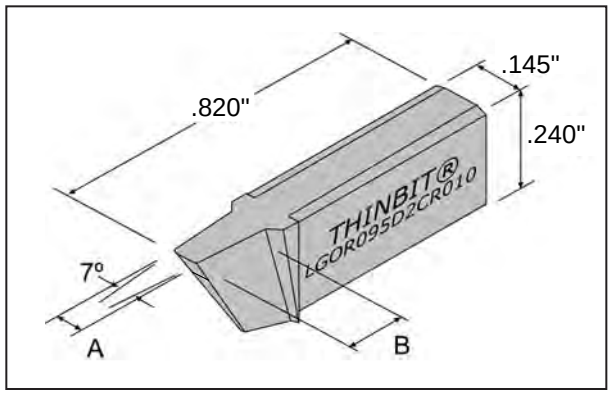
O.D. STATIC O-RING INSERTS



FRONT RAKE: Primary 10° honed, Secondary 15°
BACK CLEARANCE: 7° included angle
SIDE CLEARANCE: 5° both sides
RADIUS: .010" or .020"
TOP RAKE: 0°
LEAD ANGLE: 0°
DEPTH OF CUT: .200" or .250"

ORDERING INSTRUCTIONS

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

EXAMPLE:

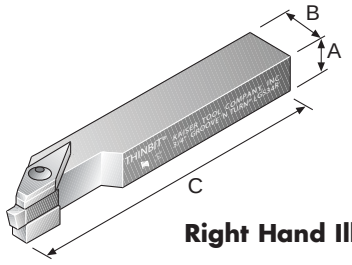
The **ORDER CODE** for a .095" insert width in **DURA-MAX® 2000** is:

LGOR095D2CR010

SPECIFICATIONS			ORDER CODE			INFO.
Insert Orientation & Radius	Insert Width 'A' ± .001"	Depth of Cut 'B'	Insert Grades See Page 9-5 for expanded material descriptions and Page 9-10 for Speeds and Feeds information: DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Non-ferrous	Add-ons Use 'Order Code' and Add Coating Page 9-6	Toolholder Catalog Section 7 Use Toolholders Beginning With
Centered .010" Corner Radius	.095"	.250"	LGOR095D2CR010	LGOR095D5CR010	TiN add 'C' TiCN add 'D' TiAlN add 'E' Diamond add 'F'	'L'
	.142"	.200"	LGOR142D2CR010	LGOR142D5CR010		
Centered .020" Corner Radius	.125"	.250"	LGOR125D2CR020	LGOR125D5CR020		

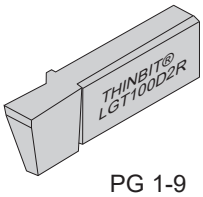
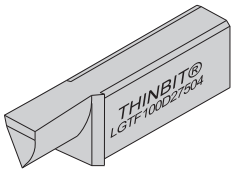
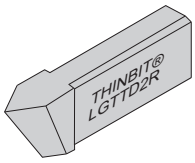
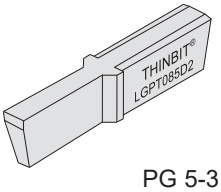
PRODUCT INFORMATION

- 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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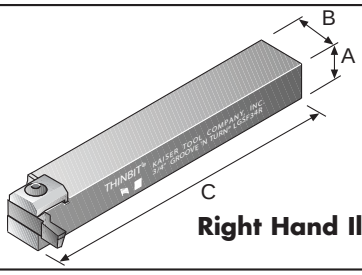
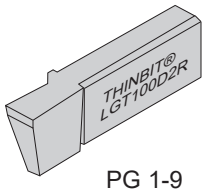
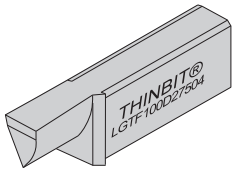
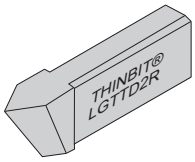
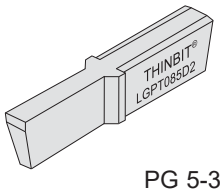
PRODUCT INFORMATION

- 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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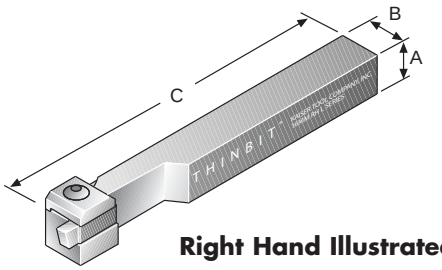
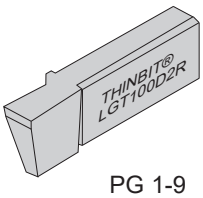
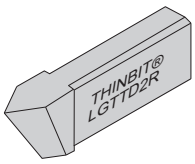
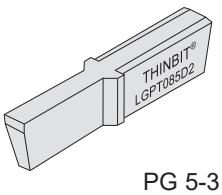
PRODUCT INFORMATION

- Designed for 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.



Right Hand Illustrated

INSERT SELECTIONS

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

Scan this code for additional information.

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

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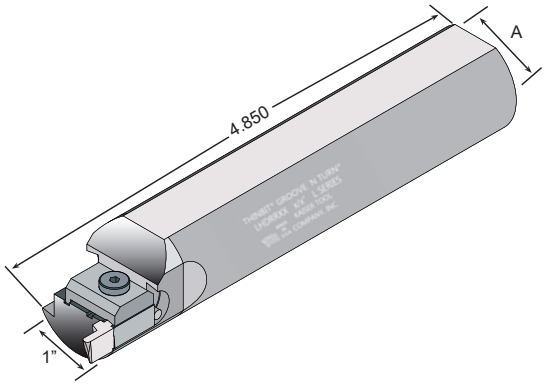
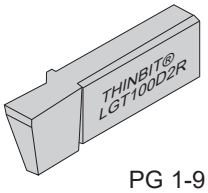
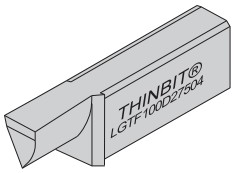
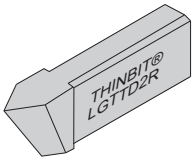
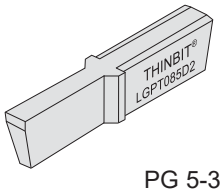
Product Information

- 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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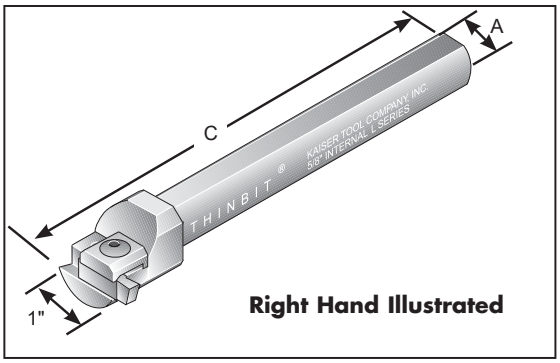
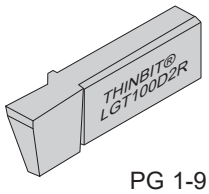
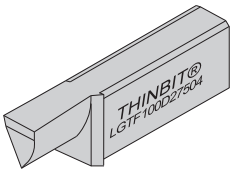
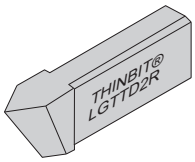
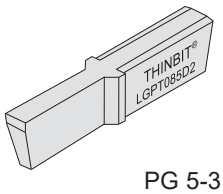
Product Information

- 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				