

**PRODUCT INFORMATION**

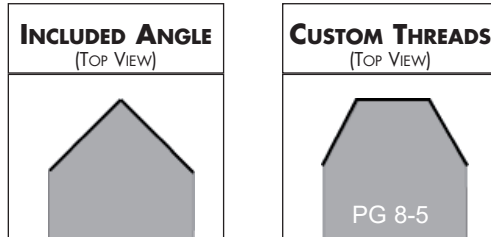
- Internal threading for diameters .325" and larger.
- 9 threads per inch and greater.
- Sub-micron grain **DURA-MAX® 2000** and **5000** Carbides.
- Inserts available coated with TiN, TiAlN, TiCN and Diamond coating.



Right Hand Toolholder with Left Hand Insert Shown

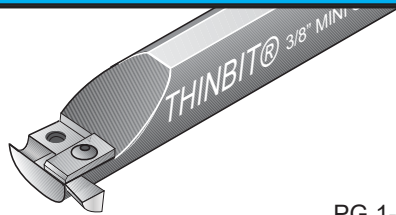
**MODIFICATIONS**

SEE PAGE 8-3 FOR ADDITIONAL INFORMATION





**TOOLHOLDER SELECTION**

**ROUND STYLES**



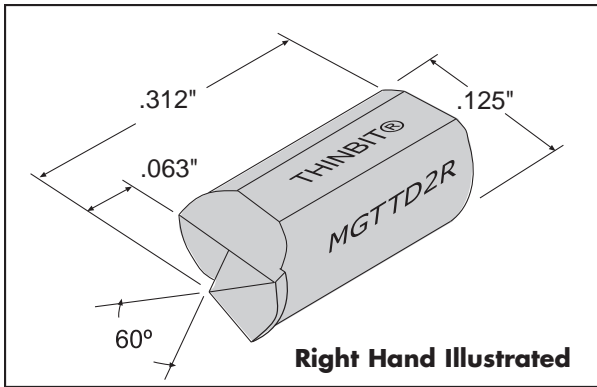
PG 1-6

**TECHNICAL SECTIONS**

	PRODUCT DEMONSTRATION	SPEEDS AND FEEDS	APPLICATION REFERENCE	TROUBLESHOOTING
<div style="text-align: center;">   <a href="http://www.thinbit.com/qr4-7">www.thinbit.com/qr4-7</a> </div>	 PG 9-18	PG 9-18	PG 9-4	PG 9-7

**KAISER TOOL COMPANY, INC.**

# I.D. THREADING TOOLS



FRONT RAKE: 15°  
 RADIUS: .002" or .000"  
 TOP RAKE: 0°

## ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of insert specifications.

**EXAMPLE:**

The **ORDER CODE** for a right hand, 9 to 56 Threads Per Inch **DURA-MAX® 2000** Carbide insert with TiN coating is:  
**MGTTD2RC**

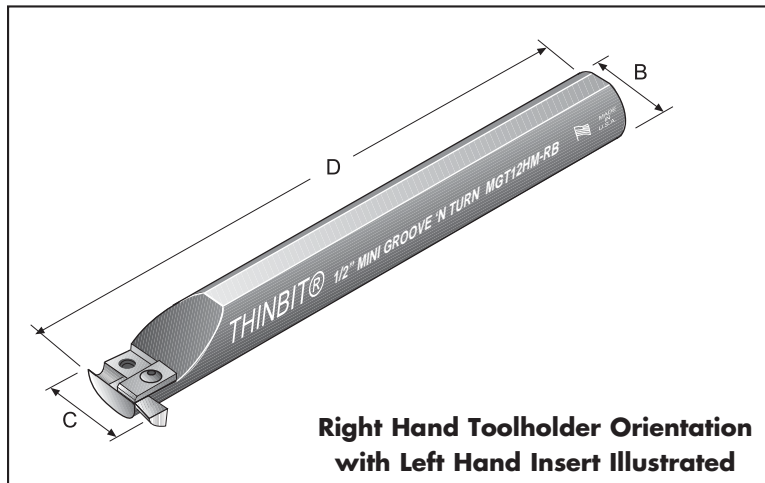
I.D. TOOLS  
THREADING

SPECIFICATIONS		ORDER CODE						INFO.
Insert Orientation	Threads per Inch	Insert Grades See Page 9-5 for Expanded Material Descriptions and Page 9-18 for Speeds and Feeds		Coatings See Page 9-6 for Expanded Coating Descriptions				Toolholder Page 1-6  Use Toolholders Beginning With
		DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Nonferrous	Use Uncoated Part Number and Add Coating Code				
				TiN	TiCN	TiAlN	Diamond	
Right Hand	9 to 56	MGTTD2R	MGTTD5R	add 'C'	add 'D'	add 'E'	add 'F'	'MGT'
	Greater than 56	MGTTD2R1	MGTTD5R1					Use left hand holder
Left Hand	9 to 56	MGTTD2L	MGTTD5L	add 'C'	add 'D'	add 'E'	add 'F'	'MGT'
	Greater than 56	MGTTD2L1	MGTTD5L1					Use right hand holder

### KAISER TOOL COMPANY, INC.

Phone: 888-THINBIT (888-844-6248) or (260) 484-3620 • Fax: 888-THINFAX (888-844-6329) or (260) 482-1881  
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# I.D. GROOVING TOOLS



Note:

- All toolholders are reversible for right hand or left hand orientation.

- For grooving:

Insert Width	Depth of Cut
.004"-.031"	2 x width
.032"-.063"	.063"
.064"-.083"	1.5 x width
.084"-.125"	.125"

I.D.  
GROOVING

## ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of tool specifications.

**EXAMPLE:**

The **ORDER CODE** for a .575" minimum bore toolholder with a 1/2" steel shank is:

**MGT12**

SPECIFICATIONS		ORDER CODE				INFORMATION		
Minimum Bore	Toolholder Material	Toolholder Package	Replacement Parts			Overall Length	Shank Diameter	Inserts
'C'	Extension Ratios: Steel: 4x Heavy Metal: 6x Carbide: 8x	Includes Shank, Clamp and Hardware	Clamp Only	Screw Only	Wrench Only	'D'	'B'	Use Inserts Beginning With
.325" .063" Insert Width Maximum (Threading & Groove Widths .004"-.063")	Steel	MGT14	MGC1	F31	W31	4.000"	1/4"	Grooving: 'MGT1' Page 1-5  Threading: 'MGTT' Page 4-8  Use right hand inserts for clockwise or left hand inserts for counter- clockwise
	Heavy Metal	MGT14HM				3.965"		
	Carbide	MGT14C				6.504"		
.450" .063" Insert Width Maximum (Threading & Groove Widths .004"-.063")	Steel	MGT38	MGC1	F31	W31	5.500"	3/8"	
	Heavy Metal	MGT38HM				5.485"		
	Carbide	MGT38C				6.768"		
.575" (Threading & Groove Widths .004"-.063") or .640" (Groove Widths .064"-.125")	Steel	MGT12	MGC1	F31	W31	5.500"	1/2"	
	Heavy Metal	MGT12HM				5.485"		
.690" (Threading & Groove Widths .004"-.063") or .755" (Groove Widths .064"-.125")	Steel	MGT58	MGC1	F31	W31	5.500"	5/8"	

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