

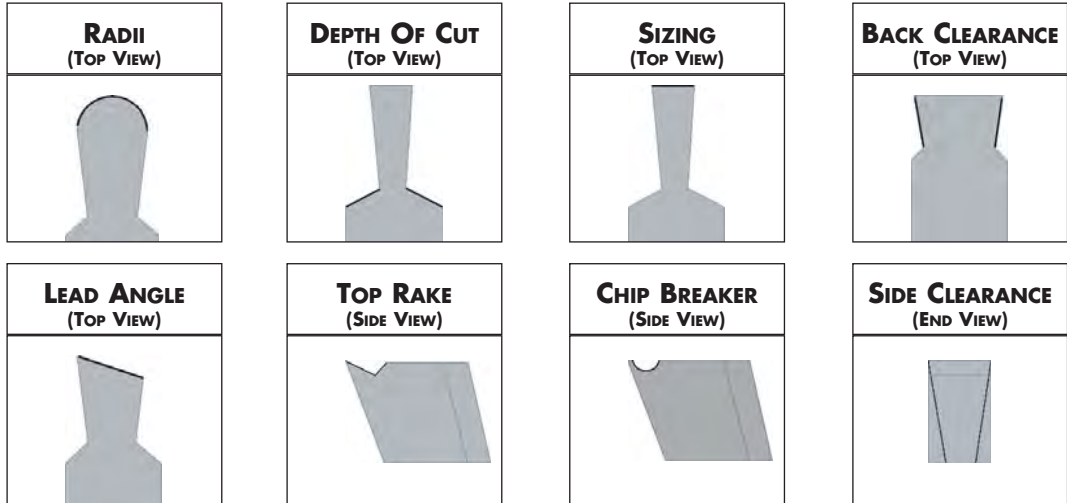
PRODUCT INFORMATION

- For Static O-Ring Face Grooving.
- Groove widths .086", .103", .122", .125" & .138".
- 7° included angle.
- Major diameters starting from .300".
- Sub-micron grain **DURA-MAX® 2000** and **5000** Carbides.
- Inserts available with TiN, TiCN, TiAlN or Diamond film coating.



MODIFICATIONS

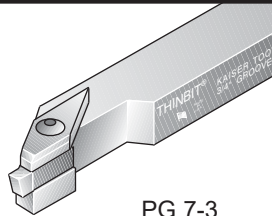
SEE PAGES
8-2 & 8-3
FOR ADDITIONAL
INFORMATION



TOOLHOLDER SELECTIONS

CNC, SWISS, CONVENTIONAL STYLE

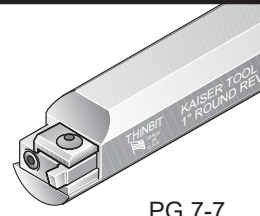
ROUND STYLE



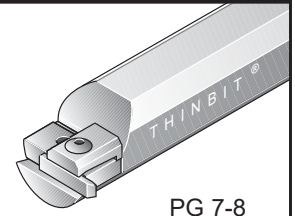
PG 7-3



PG 7-4



PG 7-7



PG 7-8

45° STYLE

SWISS FACE STYLE



PG 7-12



PG 7-6

TECHNICAL SECTIONS

PRODUCT DEMONSTRATION



www.thinbit.com/qr2-13

SPEEDS AND FEEDS

PG 9-12

APPLICATION REFERENCE

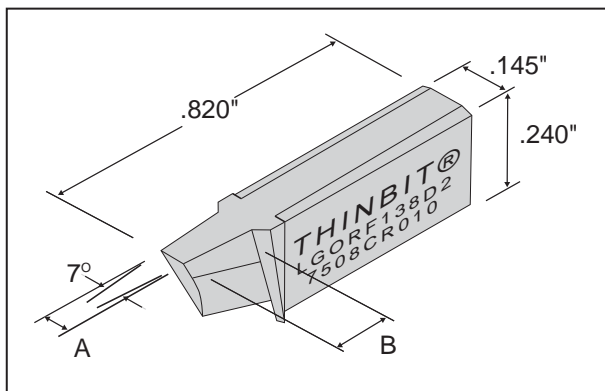
PGS 9-3 & 9-4

TROUBLESHOOTING

PG 9-7

KAISER TOOL COMPANY, INC.

STATIC O-RING FACE GROOVING 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: .170" or .250"

STATIC O-RING
FACE GROOVING

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 counter-clockwise, .138" wide insert in **DURA-MAX® 2000**, with a .750" major diameter and a .010" corner radius is:

LGORF138D27508CR010

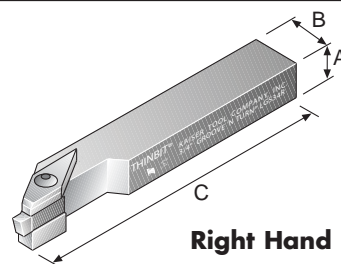
SPECIFICATIONS				ORDER CODE		INFO.	
Insert Orientation & Radius	Insert Width 'A' ± .001"	Depth of Cut 'B'	Major Diameter Can be used on any diameter equal to or greater than listed	Insert Grades See Page 9-5 for expanded material descriptions and Page 9-12 for Speeds and Feeds information		Add-ons Use 'Order Code' and Add Coating Page 9-6	Toolholder Catalog Section 7 Use Toolholders Beginning With
				DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Non-ferrous		
Counter-Clockwise; .010" Corner Radius	.086"	.250"	.300"	LGORF086D23008CR010	LGORF086D53008CR010	TiN add 'C' TiCN add 'D' TiAlN add 'E' Diamond add 'F'	'L' Use left hand straight holder or right hand 90° holder
			.750"	LGORF086D27508CR010	LGORF086D57508CR010		
	.103"	.250"	.300"	LGORF103D23008CR010	LGORF103D53008CR010		
			.750"	LGORF103D27508CR010	LGORF103D57508CR010		
	.122"	.250"	.300"	LGORF122D23008CR010	LGORF122D53008CR010		
			.750"	LGORF122D27508CR010	LGORF122D57508CR010		
	.138"	.170"	.300"	LGORF138D23008CR010	LGORF138D53008CR010		
			.750"	LGORF138D27508CR010	LGORF138D57508CR010		
Counter-Clockwise; .020" Corner Radius	.125"	.250"	.300"	LGORF125D23008CR020	LGORF125D53008CR020		
			.750"	LGORF125D27508CR020	LGORF125D57508CR020		

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

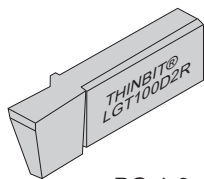
- Designed for CNC, conventional and top slide position on Swiss screw machines.
- Shank sizes 5/16", 3/8", 1/2", 5/8", 3/4", 1" and 1-1/4". Metric sizes also available.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



Right Hand Illustrated

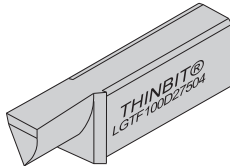
INSERT SELECTIONS

GROOVING



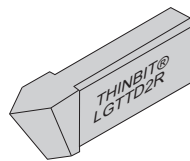
PG 1-9

FACE GROOVING



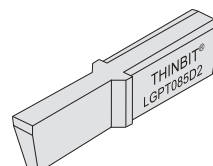
PG 2-9

THREADING



PG 4-9

PARTING



PG 5-3



Scan this code for additional information.

www.thinbit.com/qr7-3

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:

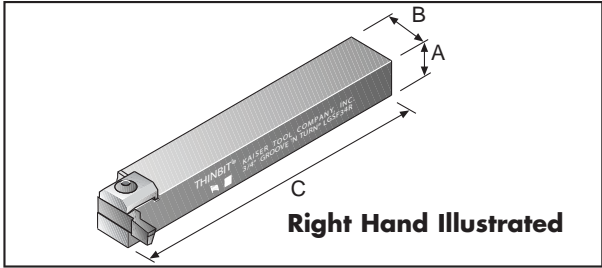
LGS34R

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

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				

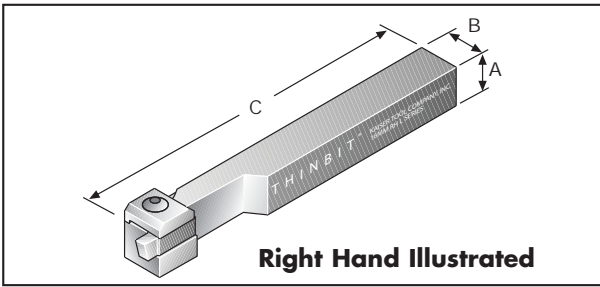
**GROOVE 'N TURN®
TOOLHOLDERS**

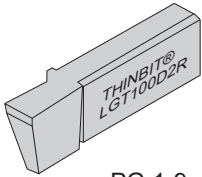
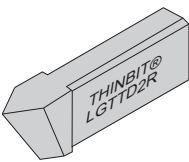
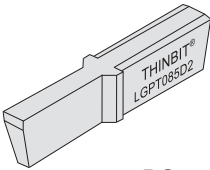
KAISER TOOL COMPANY, INC.

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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

ORDERING INSTRUCTIONS

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

EXAMPLE:

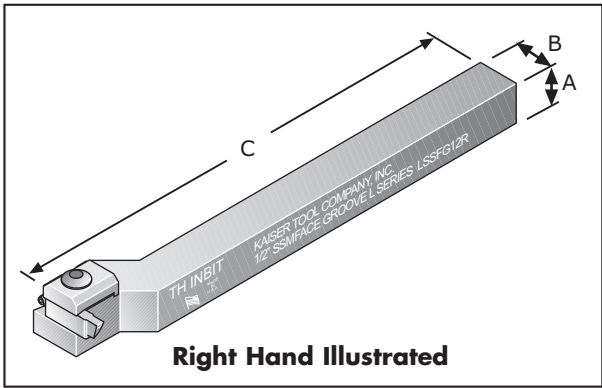
The **ORDER CODE** for a .500" shank, right hand tool for inserts beginning with 'L' is:
LSS12R

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 top slide position on Swiss screw machines.
- Shank sizes 3/8", 1/2", 10mm, 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

FACE GROOVING

PG 2-9



Scan this code for additional information.

www.thinbit.com/qr7-6

ORDERING INSTRUCTIONS

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

EXAMPLE:

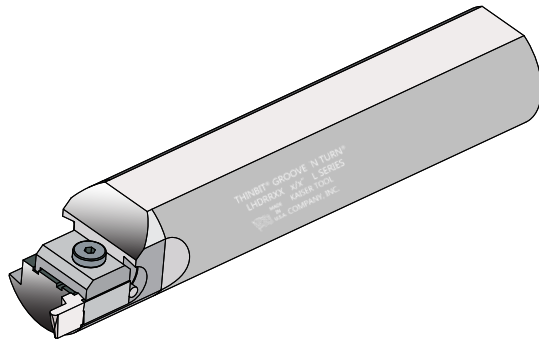
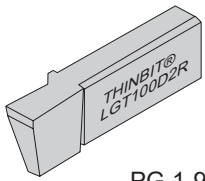
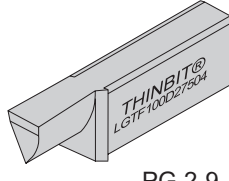
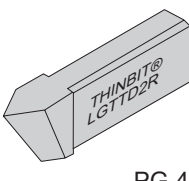
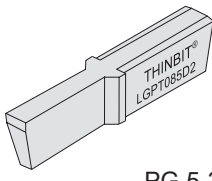
The **ORDER CODE** for a .375" Right Hand shank for inserts beginning with 'L' is:

LSSFG38R

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 Use with left hand and centered inserts for counter-clockwise rotation	.375"	.375"	4.840"	LSSFG38R	Clamp C	S3808	W1005	P0203
	.500"	.500"	4.840"	LSSFG12R				
	10mm	10mm	4.840"	LSSFG10RM				
	12mm	12mm	4.840"	LSSFG12RM				
	16mm	16mm	4.840"	LSSFG16RM				

SWISS
TOOLHOLDERS

KAISER TOOL COMPANY, INC.

PRODUCT INFORMATION	<ul style="list-style-type: none"> • 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. 				 <p>Heavy Duty Round Reversible Toolholder</p>	
	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:

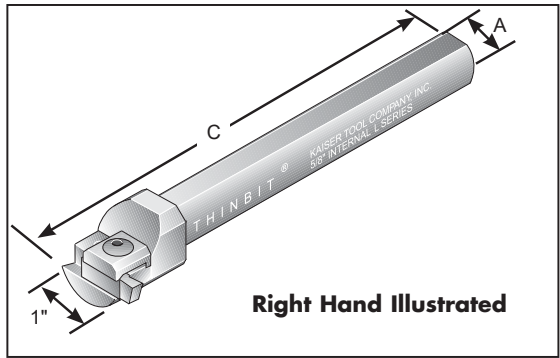
LHDRR34

SPECIFICATIONS		ORDER CODE		
Shank Orientation	Shank Dimensions	Toolholder Package Includes Shank, Clamp and Hardware		
	'A'	For Inserts Beginning With	Clamp	Clamp Hardware
		'L'		
<p style="text-align: center;">Right Hand or Left Hand</p> <p>Use as right hand with right hand inserts</p> <p>Use as left hand with left hand inserts</p> <p>Use as either hand with centered inserts</p>	1/2"	LHDRR12	Clamp C	Screw: S3808 Wrench: W1005 Pin: P0305
	5/8"	LHDRR58		
	3/4"	LHDRR34		
	1"	LHDRR01		
	12 mm	LHDRR12M		
	16 mm	LHDRR16M		
	20 mm	LHDRR20M		
	22 mm	LHDRR22M		
25 mm	LHDRR25M			

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



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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

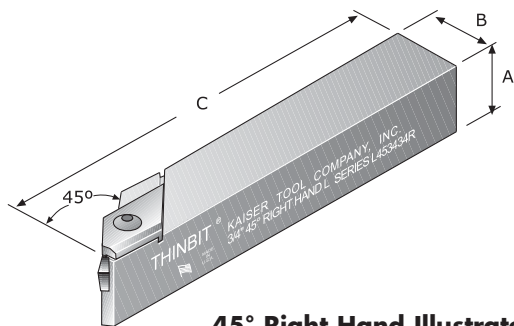
SPECIFICATIONS			ORDER CODE					
Shank Orientation	Minimum Bore Diameter	Shank Dimensions		Toolholder Package Includes Shank, Clamp and Hardware	Replacement Parts			
		'A'	'C'		For Inserts Beginning With 'L'			
	without pin				Clamp	Screw	Wrench	Pin
Right Hand or Left Hand Use as right hand with left 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.

PRODUCT INFORMATION

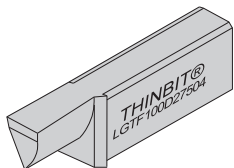
- Designed for making angled undercuts.
- Toolholder must be used with inserts that have radial relief.
- Groove widths less than .080" may require a special insert.
- Shank sizes 3/8", 1/2", 5/8", 3/4" and 1".
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



45° Right Hand Illustrated

INSERT SELECTIONS

FACE GROOVING



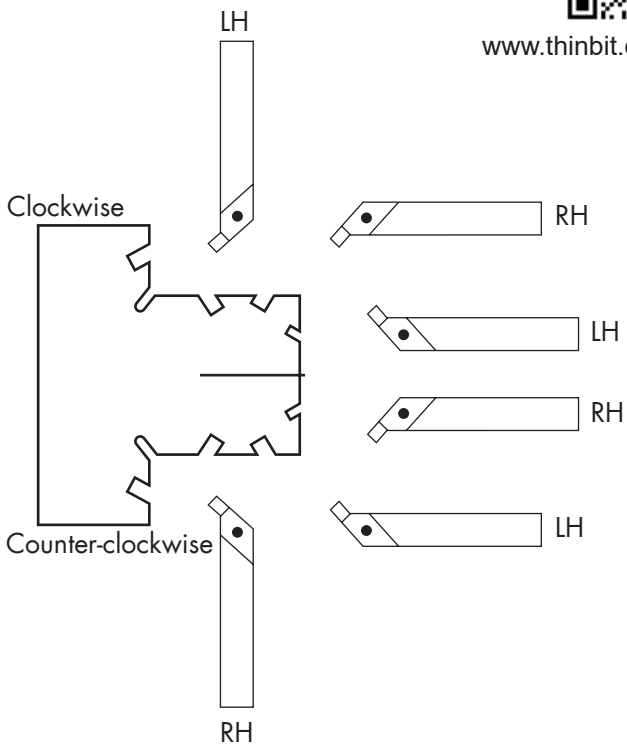
PG 2-9

Due to the potential complexity of configuring these toolholders, we recommend calling for assistance.

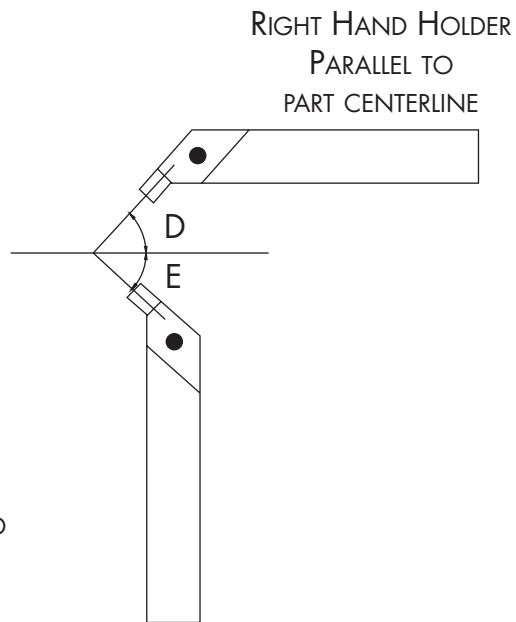


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APPLICATION EXAMPLES
TOP VIEW, CUTTING EDGE UP



45° ILLUSTRATED

RIGHT HAND HOLDER
PERPENDICULAR TO
PART CENTERLINE

KAISER TOOL COMPANY, INC.

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