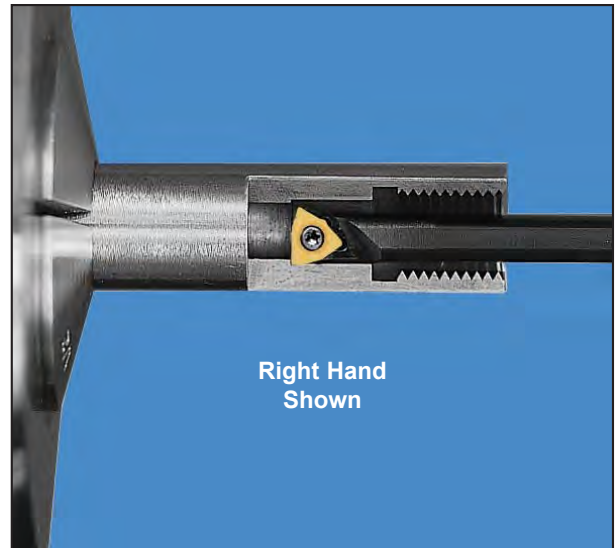


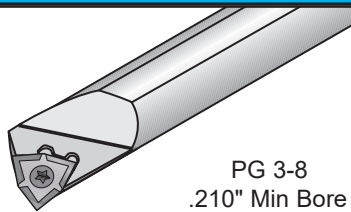
PRODUCT INFORMATION

- Boring with .210" minimum bore diameter.
- 'K' angle increases strength in insert pocket by increasing the cross-sectional area below the insert.
- Boring bars for WCGT insert style.
- Variety of diameters made from Steel, Heavy Metal and Carbide.
- Bars and inserts are compatible with other ANSI standard bars and inserts. Call for cross-overs.
- Sub-micron grain **DURA-MAX[®] 4000** and **5000** Carbide.
- Tools available with TiN, TiAlN, TiCN and Diamond coating.
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.

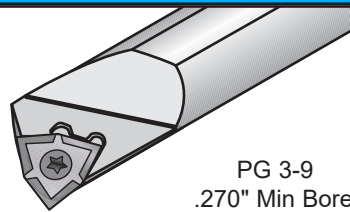


TOOLHOLDER SELECTIONS

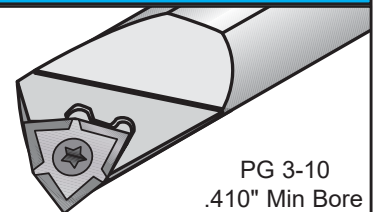
WCGT STYLE - MBE SERIES



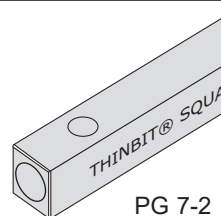
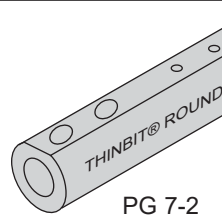
WCGT STYLE - MBF SERIES



WCGT STYLE - MBG SERIES

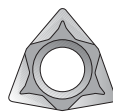


ADAPTER STYLES

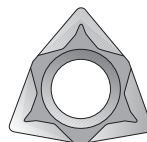


INSERT SELECTIONS

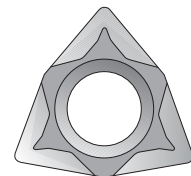
WCGT STYLE - MBE SERIES



WCGT STYLE - MBF SERIES



WCGT STYLE - MBG SERIES



PG 3-8

PG 3-9

PG 3-10

PG 3-10

PG 3-10

TECHNICAL SECTIONS

PRODUCT DEMONSTRATION



www.thinbit.com/qr3-7

SPEEDS AND FEEDS

PG 9-14

APPLICATION REFERENCE

PG 9-4

TROUBLESHOOTING

PG 9-7

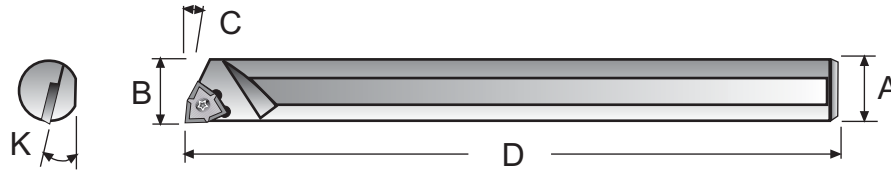
KAISER TOOL COMPANY, INC.


TO ORDER WCGT STYLE - MBE SERIES BORING BARS

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

EXAMPLE:

The **ORDER CODE** for a .270" minimum bore, right hand, heavy metal shank with a 3° lead angle is:
MBEH132527R



 Minimum Bore 'B' With .008" radius insert	TOOL SPECIFICATIONS						ORDER CODE			
	Material	Bar Diameter 'A'	Length 'D'	Lead Angle 'C'	'K' Angle 'K' see page 3-2	Boring Bar Includes Screw and Wrench	Replacement Parts			
.156" I.C.	Right Hand Bars	Steel	.188"	3.500"	3°	17°	MBES131821R	F15	W11	
		Heavy Metal	.188"	3.976"	3°	17°	MBEH131821R	F15	W11	
		Carbide	.188"	4.474"	3°	17°	MBEC131821R	F15	W11	
	.220"	Steel	.188"	3.500"	0°	17°	MBES101822R	F15	W11	
		Heavy Metal	.188"	3.976"	0°	17°	MBEH101822R	F15	W11	
	.270"	Steel	.250"	4.000"	0°	12°	MBES102527R	F15	W11	
					3°	12°	MBES132527R	F15	W11	
		Heavy Metal	.250"	3.976"	0°	12°	MBEH102527R	F15	W11	
	Left Hand Bars Use inserts beginning with 'MBEIW' and ANSI 'WCGT 1.21' inserts	.210"	Steel	.188"	3.500"	3°	17°	MBES131821L	F15	W11
			Heavy Metal	.188"	3.976"	3°	17°	MBEH131821L	F15	W11
.270"		Steel	.250"	4.000"	3°	12°	MBES132527L	F15	W11	
		Heavy Metal	.250"	3.976"	3°	12°	MBEH132527L	F15	W11	

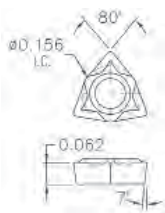
MBE TRIGON BORING

TO ORDER WCGT STYLE - MBE SERIES INSERTS

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

EXAMPLE:

The **ORDER CODE** for a **DURA-MAX® 4000** insert with .008" radius and TiN coating is:
MBEIW08D4C

WCGT Style MBE Series Use toolholders beginning with 'MBE'	SPECIFICATIONS		ORDER CODE			
	Insert Material	Corner Radius	Coating See Page 9-5 for expanded material description and Page 9-14 for speeds and feeds			
			Uncoated	TiN	TiCN Non-stock	TiAlN Non-stock
	DURA-MAX® 4000 carbide For Steel & Interrupted Cutting	.004"	MBEIW04D4U	MBEIW04D4C	MBEIW04D4D	MBEIW04D4E
		.008"	MBEIW08D4U	MBEIW08D4C	MBEIW08D4D	MBEIW08D4E
		.015"	MBEIW15D4U	MBEIW15D4C	MBEIW15D4D	MBEIW15D4E
DURA-MAX® 5000 carbide For Aluminum & Nonferrous	.004"	MBEIW04D5U	MBEIW04D5C	MBEIW04D5D	MBEIW04D5E	
	.008"	MBEIW08D5U	MBEIW08D5C	MBEIW08D5D	MBEIW08D5E	
	.015"	MBEIW15D5U	MBEIW15D5C	MBEIW15D5D	MBEIW15D5E	

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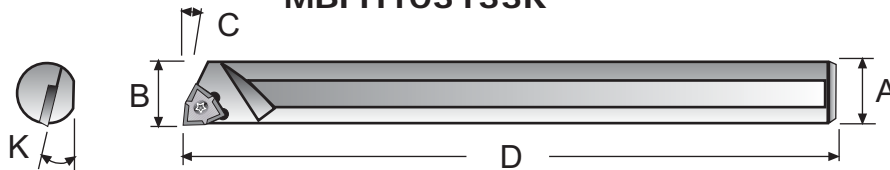
TO ORDER WCGT STYLE - MBF SERIES BORING BARS


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

EXAMPLE:

The **ORDER CODE** for a .330" minimum bore, right hand, heavy metal shank with a 0° lead angle is:

MBFH103133R



 .187" I.C.	TOOL SPECIFICATIONS						ORDER CODE		
	Minimum Bore 'B' <small>With .008" radius insert</small>	Material <small>Extension Ratios: Steel: 4 x ø Heavy Metal: 6 x ø Carbide: 8 x ø</small>	Bar Diameter 'A'	Length 'D'	Lead Angle 'C'	'K' Angle 'K' <small>See Page 3-2</small>	Boring Bar <small>Includes Screw and Wrench</small>	Replacement Parts <small>Screw Wrench</small>	
Right Hand Bars <small>Use inserts beginning with 'MBFIW' and ANSI 'WCGT 1.51.5' inserts</small>	.270"	Steel	.250"	4.000"	0°	15°	MBFS102527R	F15	W11
					3°	15°	MBFS132527R	F15	W11
		Heavy Metal	.250"	3.976"	0°	15°	MBFH102527R	F15	W11
					3°	15°	MBFH132527R	F15	W11
	.330"	Steel	.312"	4.000"	0°	15°	MBFS103133R	F15	W11
					3°	15°	MBFS133133R	F15	W11
		Heavy Metal	.312"	5.500"	0°	15°	MBFH103133R	F15	W11
					3°	15°	MBFH133133R	F15	W11
Left Hand Bars <small>Use inserts beginning with 'MBFIW' and ANSI 'WCGT 1.51.5' inserts</small>	.270"	Steel	.250"	4.000"	3°	15°	MBFS132527L	F15	W11
		Heavy Metal	.250"	3.976"	3°	15°	MBFH132527L	F15	W11
	.330"	Steel	.312"	4.000"	3°	15°	MBFS133133L	F15	W11
		Heavy Metal	.312"	5.500"	3°	15°	MBFH133133L	F15	W11


TO ORDER WCGT STYLE - MBF SERIES INSERTS

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

EXAMPLE:

The **ORDER CODE** for a **DURA-MAX® 4000** insert with .008" radius and TiN coating is:

MBFIW08D4C

WCGT Style MBF Series Use toolholders beginning with 'MBF'	SPECIFICATIONS		ORDER CODE			
	Insert Material	Corner Radius	Coating <small>See Page 9-5 for expanded material description and Page 9-14 for Speeds and Feeds</small>			
			Uncoated	TIN	TiCN <small>Non-stock</small>	TiAlN <small>Non-stock</small>
	DURA-MAX® 4000 carbide <small>For Steel & Interrupted Cutting</small>	.004"	MBFIW04D4U	MBFIW04D4C	MBFIW04D4D	MBFIW04D4E
		.008"	MBFIW08D4U	MBFIW08D4C	MBFIW08D4D	MBFIW08D4E
		.015"	MBFIW15D4U	MBFIW15D4C	MBFIW15D4D	MBFIW15D4E
	DURA-MAX® 5000 carbide <small>For Aluminum & Nonferrous</small>	.004"	MBFIW04D5U	MBFIW04D5C	MBFIW04D5D	MBFIW04D5E
		.008"	MBFIW08D5U	MBFIW08D5C	MBFIW08D5D	MBFIW08D5E
		.015"	MBFIW15D5U	MBFIW15D5C	MBFIW15D5D	MBFIW15D5E

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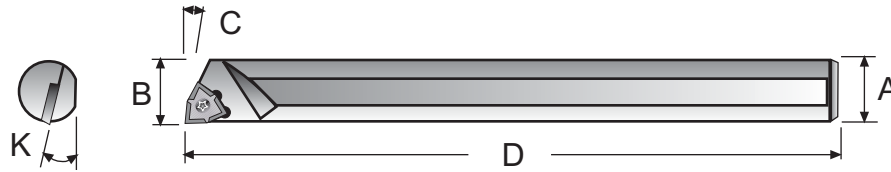
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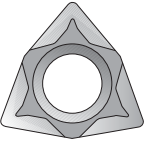
TO ORDER WCGT STYLE - MBG SERIES BORING BARS

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

EXAMPLE:

The **ORDER CODE** for a .410" minimum bore, right hand, heavy metal shank with a 3° lead angle is:
MBGH133741R



 .250" I.C.	TOOL SPECIFICATIONS						ORDER CODE		
	Minimum Bore 'B' <small>With .008" radius insert</small>	Material <small>Extension Ratios: Steel: 4 x ø Heavy Metal: 6 x ø Carbide: 8 x ø</small>	Bar Diameter 'A'	Length 'D'	Lead Angle 'C'	'K' Angle 'K' <small>See Page 3-2</small>	Boring Bar <small>Includes Screw and Wrench</small>	Replacement Parts	
								Screw	Wrench
Right Hand Bars <small>Use inserts beginning with 'MBGIW' and ANSI 'WCGT 21.5' inserts</small>	.410"	Steel	.375"	5.500"	0°	8°	MBGS103741R	F26	W26
					3°	8°	MBGS133741R	F26	W26
		Heavy Metal	.375"	5.500"	0°	8°	MBGH103741R	F26	W26
					3°	8°	MBGH133741R	F26	W26
	.530"	Steel	.500"	5.500"	0°	8°	MBGS105053R	F26	W26
					3°	8°	MBGS135053R	F26	W26
		Heavy Metal	.500"	5.500"	0°	8°	MBGH105053R	F26	W26
					3°	8°	MBGH135053R	F26	W26
Left Hand Bars <small>Use inserts beginning with 'MBGIW' and ANSI 'WCGT 21.5' inserts</small>	.410"	Steel	.375"	5.500"	3°	8°	MBGS133741L	F26	W26
		Heavy Metal	.375"	5.500"	3°	8°	MBGH133741L	F26	W26
	.530"	Steel	.500"	5.500"	3°	8°	MBGS135053L	F26	W26
		Heavy Metal	.500"	5.500"	3°	8°	MBGH135053L	F26	W26


MBF & MBG TRIGON BORING

TO ORDER WCGT STYLE - MBG SERIES INSERTS

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

EXAMPLE:

The **ORDER CODE** for a **DURA-MAX® 4000** insert with .008" radius and TiN coating is:
MBGIW08D4C

WCGT Style MBG Series Use toolholders beginning with 'MBG'	SPECIFICATIONS		ORDER CODE			
	Insert Material	Corner Radius	Coating <small>See Page 9-5 for expanded material description and Page 9-14 for Speeds and Feeds</small>			
			Uncoated	TiN	TiCN <small>Non-stock</small>	TiAlN <small>Non-stock</small>
	DURA-MAX® 4000 carbide <small>For Steel & Interrupted Cutting</small>	.004"	MBGIW04D4U	MBGIW04D4C	MBGIW04D4D	MBGIW04D4E
		.008"	MBGIW08D4U	MBGIW08D4C	MBGIW08D4D	MBGIW08D4E
		.015"	MBGIW15D4U	MBGIW15D4C	MBGIW15D4D	MBGIW15D4E
	DURA-MAX® 5000 carbide <small>For Aluminum & Nonferrous</small>	.004"	MBGIW04D5U	MBGIW04D5C	MBGIW04D5D	MBGIW04D5E
		.008"	MBGIW08D5U	MBGIW08D5C	MBGIW08D5D	MBGIW08D5E
		.015"	MBGIW15D5U	MBGIW15D5C	MBGIW15D5D	MBGIW15D5E

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