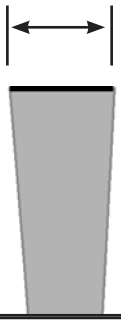
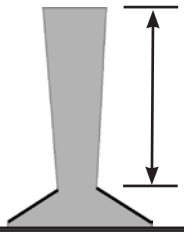


Sizing

Looking at the top of the insert, sizing is the width of the cutting edge.

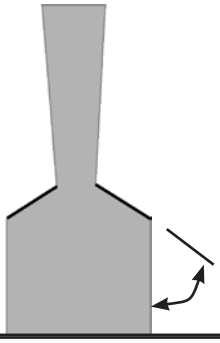
Radius

Looking at the top of the insert, the radii are the rounded corners of the cutting edge. A full radius means each radius is one half the width of the insert.



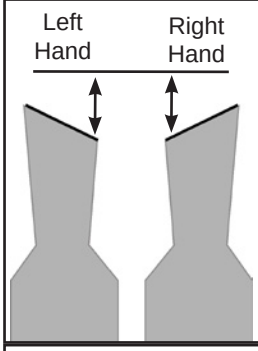
Depth Of Cut

Looking at the top of the insert, depth of cut is the depth the insert will cut into part before edge(s) drag.



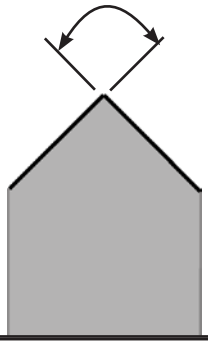
Chamfer

Looking at the top of the insert, chamfer is a secondary cutting edge. Standard angle is 45º.



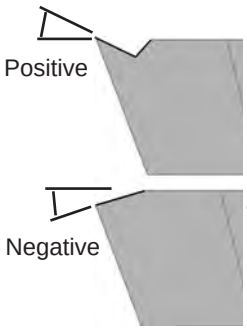
Lead Angle

Looking at the top of the insert, lead angle is the angle along the cutting edge of the insert.



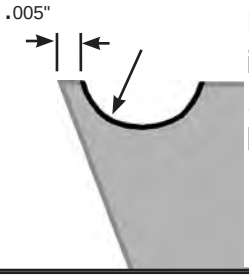
Included Angle

Looking at the top of the insert, the included angle is the angle between the cutting edges.



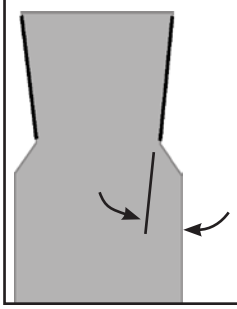
Top Rake

Looking at the side of the insert, top rake is the angle between the top of the insert and the cutting edge.



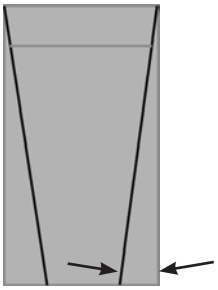
Chipbreaker

Looking at the side of the insert, a chipbreaker is a 1/32" radius ground .005" back from the cutting edge.



Back Clearance

Looking at the top of the insert, back clearance is the angle behind the cutting edge.



Side Clearance

Looking at the front of the insert, side clearance is the angle from the top of the insert to the bottom of the insert.

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*

THINBIT® MODIFICATION SPECIFICATION SHEET

Base Tool:

_____

Material being machined:

_____

Coating Options: (Select 1 only)

❒ TiN ❒ TiCN

❒ TiAIN ❒ Diamond

Toolholder Options: Size _____

❒ Square ❒ Straight ❒ Right Hand

❒ Round ❒ 90° ❒ Left Hand

Spindle Rotation (Looking at spindle face)

❒ Clockwise ❒ Counter-Clockwise

Sketch Area

Submitting this form will generate a quotation within 48 hours which will include price, delivery and CAD drawing(s) for your review and approval. If you would like additional assistance include your application print or sketch.

Return quotation to:

Name:_____

Company:_____

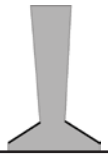
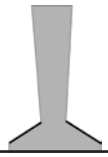
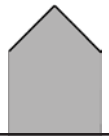
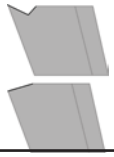
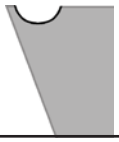
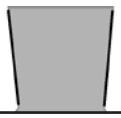
Address:_____

_____

Phone: (_____) -_____-_____

Fax: (_____) -_____-_____

Email Address:_____

	Left Hand Side Geometry	Right Hand Side Geometry
	_____ Insert Width in .xxx" _____ Tolerance in + .xxx"/-.xxx" (± .001" standard)	
	❒ Full Radius	
	_____ Corner Radius in .xxx" _____ Tolerance in +.xxx"/-.xxx" (± .002" standard)	_____ Corner Radius in .xxx" _____ Tolerance in +.xxx"/-.xxx" (± .002" standard)
	_____ Total Depth of Cut in .xxx"	_____ Total Depth of Cut in .xxx"
	_____ Chamfer Angle in x° _____ Total Depth of Chamfer required in .xxx" _____ Tolerance in + .xxx"/-.xxx" (± .001" standard)	_____ Chamfer Angle in x° _____ Total Depth of Chamfer required in .xxx" _____ Tolerance in + .xxx"/-.xxx" (± .001" standard)
	_____ Lead Angle in x° _____ Tolerance in +x°/-x° (± .5° standard)	_____ Lead Angle in x° _____ Tolerance in +x°/-x° (± .5° standard)
	_____ Included Angle in x° _____ Tolerance in +x°/-x° (± .5° standard)	
	_____ Top Rake Angle in x° ❒ Positive ❒ Negative _____ Tolerance in +x°/-x° (± .5° standard)	
	❒ 1/32" Radius Chipbreaker with .005" land	
	_____ Back Clearance in x° _____ Tolerance in +x°/-x° (± .5° standard)	_____ Back Clearance in x° _____ Tolerance in +x°/-x° (± .5° standard)
	_____ Side Clearance in x° _____ Tolerance in +x°/-x° (± .5° standard)	_____ Side Clearance in x° _____ Tolerance in +x°/-x° (± .5° standard)

SPEC SHEET MODIFICATIONS