

GROOVE 'N TURN® INSERTS

U.S. PATENT NOS. 6,688,816 and 6,824,333

PRODUCT INFORMATION

- Face grooving for major diameters .300", .750", 1.250", 3" and greater.
- Face grooving with a central hub, recessed or flat face.
- .004" - .150" in .001" increments available.
- Sub-micron grain **DURA-MAX® 2000** and **5000** Carbides.
- Inserts available with TiN, TiAlN, TiCN and Diamond coating.



MODIFICATIONS

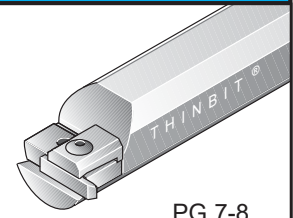
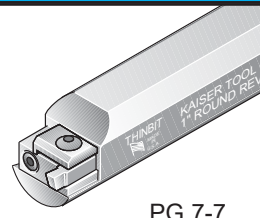
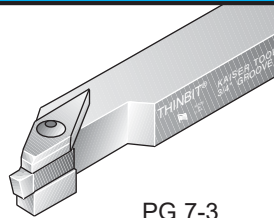
SEE PAGES 8-2 & 8-3 FOR ADDITIONAL INFORMATION

RADII (TOP VIEW)	DEPTH OF CUT (TOP VIEW)	SIZING (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

ROUND STYLE



45° STYLE

SWISS FACE STYLE



TECHNICAL SECTIONS

PRODUCT DEMONSTRATION



www.thinbit.com/qr2-9

SPEEDS AND FEEDS

PG 9-12

APPLICATION REFERENCE

PGS 9-3 & 9-4

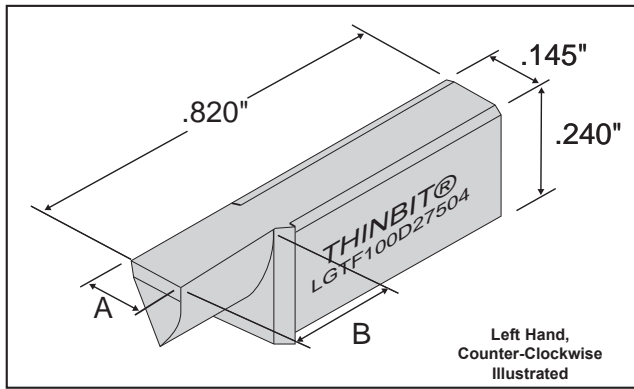
TROUBLESHOOTING

PG 9-7

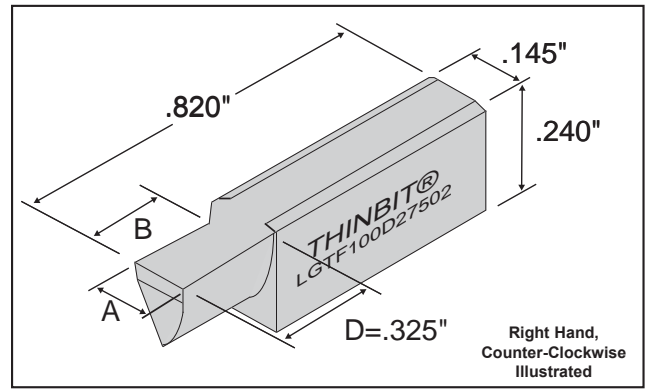
KAISER TOOL COMPANY, INC.

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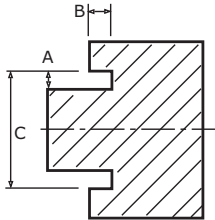
FACE GROOVING INSERTS



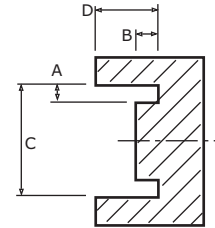
Left Hand,
Counter-Clockwise
Illustrated



Right Hand,
Counter-Clockwise
Illustrated



FRONT RAKE: Primary 10° honed, Secondary 15°
 BACK CLEARANCE: 2-1/2° both sides
 SIDE CLEARANCE: .004" - .019" - 0° ID side
 .020" - .150" - 5° ID side
 RADIUS: Sharp corner through full radius available
 TOP RAKE: 0°
 LEAD ANGLE: 0°



Cut with a LH CCW Insert

NOTE: Capable of grooving along a shoulder

Cut with a RH CCW Insert

ORDERING INSTRUCTIONS

EXAMPLE:

Sample **ORDER CODE** for a left hand/counter-clockwise, .100" wide insert in **DURA-MAX® 2000**, with a .750" major diameter and no corner radius is:

LGTF 100 D27504

Specify the Insert Width 'A' ↑

SPECIFICATIONS				ORDER CODE			INFO.		
Insert Orientation	Insert Width	Depth of Cut	Major Diameter	Insert Grades <small>See Page 9-5 for expanded material descriptions and Page 9-12 for Speeds and Feeds information</small>		Add-ons <small>Use 'Order Code' and Add</small>			Toolholder Catalog Section 7 Use Toolholders Beginning With 'L'
	'A'	'B'	Can be used on any diameter equal to or greater than listed	DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Nonferrous	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6	
Left Hand/ Counter-Clockwise	.004" - .150"	Width D.O.C. .004"-.033" = 3 x 'A' .034"-.039" = .100" .040"-.100" = 2.5 x 'A' .101"-.150" = .250"	.300"	LGTF ___ D23004	LGTF ___ D53004	add 'FR'	(indicate size in .xxx")	TiN add 'C' TiCN add 'D' TiAIN add 'E' Diamond add 'F'	For shoulder cutting use left hand straight holder or right hand 90° holder
			.750"	LGTF ___ D27504	LGTF ___ D57504				
			1.250"	LGTF ___ D212504	LGTF ___ D512504				
			* 3.000"	LGT ___ D2L	LGT ___ D5L				
Right Hand/ Counter-Clockwise	.004" - .150"	Width D.O.C. .004"-.033" = 3 x 'A' .034"-.039" = .100" .040"-.100" = 2.5 x 'A' .101"-.150" = .250"	.300"	LGTF ___ D23002	LGTF ___ D53002	add 'FR'	(indicate size in .xxx")	TiN add 'C' TiCN add 'D' TiAIN add 'E' Diamond add 'F'	Use right hand or left hand straight holder or right hand 90° holder
			.750"	LGTF ___ D27502	LGTF ___ D57502				
			1.250"	LGTF ___ D212502	LGTF ___ D512502				
			* 3.000"	LGT ___ D2R	LGT ___ D5R				

* 3.000" Major Diameter Excludes .004" - .019" Insert Width Due to Side Clearance

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INSERTS
FACE GROOVING

THINBIT®



GROOVING • FACE GROOVING • THREADING • PARTING
BORING • TURNING • SPECIALS • FORM TOOLS • MILLING

Milling Tool

THINBIT® is pleased to announce the MILL A GROOVE™ line of cutting tools. Designed to trepan on a CNC or conventional milling machine. This tool will make your machine more productive. Advantages are better sealing surfaces, groove diameters concentric to spindle rotation, lower cost per groove and increased strength.



New Products & Promotions

Kaiser Tool Company, Inc. | 888-THINBIT | 888-THINFAX

Promotions effective September 1st to December 31st, 2018

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MILL A GROOVE™



The New
Mill A Groove™
Trepanning Tool
by THINBIT®.



Inserts available (.004" through .150") in .001" increments.
(See pages 2-9 & 2-10 in the 2018 THINBIT® catalog)

Shank Orientation	Shank Dimensions	Toolholder Package (Includes Shank, head, clamp and hardware)	Overall Length	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" Ø X 1.50" long	LRMAG12	2.35"	Clamp C	Screw: S2808
	.750" Ø X 1.63" long	LRMAG34	2.48"		Wrench: W1009
	1.00" Ø X 1.92" long	LRMAG01	2.77"		Pin: P0305

SPECIAL INSERT PROFILES AVAILABLE!
Email your part print to quotes@thinbit.com

MILL A GROOVE™

THINBIT®, from Kaiser Tool Company, announces the Mill A Groove™ line for trepanning on a CNC or conventional milling machine.

The tool enables machining groove diameters that are concentric to the spindle rotation and not the table movement and eliminates secondary lathe operations for face grooving.

The insert does not rotate about its own center, so the groove can be symmetrical or asymmetrical. One insert can make convex and concave radius grooves, chamfered edges, angles and special profiles.

More info available at www.thinbit.com.

