

PRODUCT INFORMATION

- Internal grooving and profiling for diameters .325" and larger.
- Shank sizes 1/4", 3/8", 1/2" and 5/8" in steel, heavy metal or carbide.
- All toolholders are reversible for right and left hand orientation.
- Sub-micron grain **DURA-MAX® 2000** and **5000** Carbides and High Speed Steel.
- Modifications can be provided on any of our tooling.
- Please contact us with your application requirements.



Left Hand Insert in
Right Hand Toolholder
Shown

TECHNICAL SECTIONS

PRODUCT DEMONSTRATION



www.thinbit.com/gr1-5

SPEEDS AND FEEDS

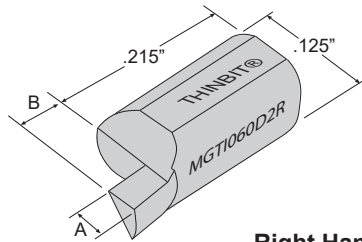
PG 9-10

APPLICATION REFERENCE

PG 9-4

TROUBLESHOOTING

PG 9-7



Right Hand Illustrated

FRONT RAKE: 15°
 BACK CLEARANCE: 2° both sides
 SIDE CLEARANCE: 2° I.D. side
 RADIUS: Sharp corner through
 full radius available
 TOP RAKE: 0°
 LEAD ANGLE: 0°
 'A' TOLERANCE:
 .004" - .063": +.0009"/-.0000"
 .064" - .125": +.001"/-.001"

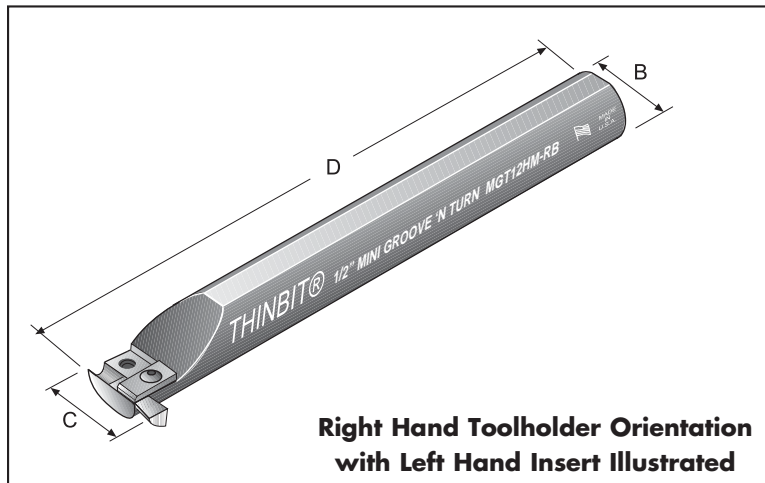
SPECIFICATIONS

ORDER CODE

Insert Orientation	Insert Width 'A'	Depth of Cut 'B'	Insert Grades		Add-ons		
			DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Non-ferrous	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6
Right Hand For ID grooving use left hand 'MGT' Page 1-5 For face grooving use right hand 'MGTF' Page 2-6	.004"-.063"	<u>Width</u> <u>DOC</u> .004"-.031" = 2 x 'A' .032"-.063" = .063"	MGTI ___ _D2R	MGTI ___ _D5R	add 'FR'	add 'CR___' (indicate size in .xxx")	TiN add 'C' TiCN add 'D' TiAlN add 'E' Diamond add 'F'
	.064"-.125"	<u>Width</u> <u>DOC</u> .064"-.083" = 1.5 x 'A' .084"-.125" = .125"					
Left Hand For ID grooving use right hand 'MGT' Page 1-5 For face grooving use left hand 'MGTF' Page 2-6	.004"-.063"	<u>Width</u> <u>DOC</u> .004"-.031" = 2 x 'A' .032"-.063" = .063"	MGTI ___ _D2L	MGTI ___ _D5L	add 'FR'	add 'CR___' (indicate size in .xxx")	TiN add 'C' TiCN add 'D' TiAlN add 'E' Diamond add 'F'
	.064"-.125"	<u>Width</u> <u>DOC</u> .064"-.083" = 1.5 x 'A' .084"-.125" = .125"					

KAISER TOOL COMPANY, INC.

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 'C'	Toolholder Material Extension Ratios: Steel: 4x Heavy Metal: 6x Carbide: 8x	Toolholder Package Includes Shank, Clamp and Hardware	Replacement Parts Clamp Only Screw Only Wrench Only			Overall Length 'D'	Shank Diameter 'B'	Inserts 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"	

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