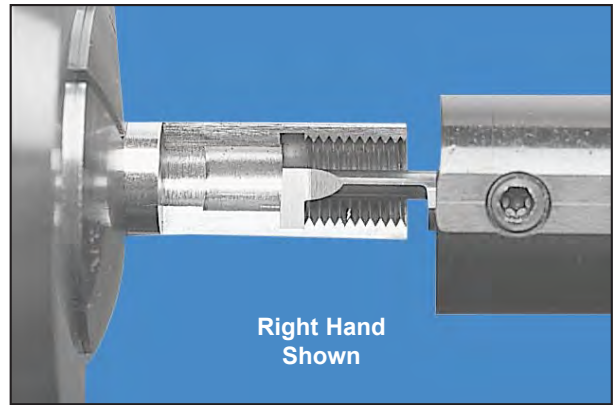


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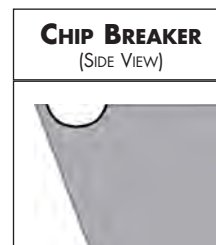
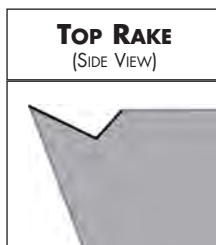
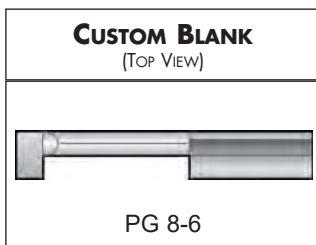
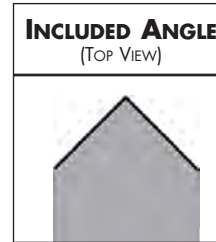
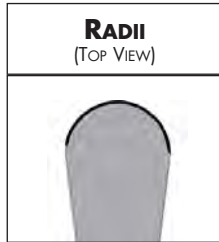
PRODUCT INFORMATION

- Internal grooving for diameters .125" and larger.
- .004" through .250" groove widths in .001" increments.
- 1/8", 3/16", 1/4", 5/16", 3/8" and 1/2" shanks.
- Sub-micron grain **DURA-MAX® 2000** Carbide.
- Tools available with TiN, TiAlN, TiCN and diamond coating.
- Short neck lengths for greater rigidity; long neck lengths for greater reach.
- Elliptically ground necks for greater strength.



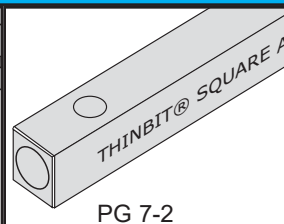
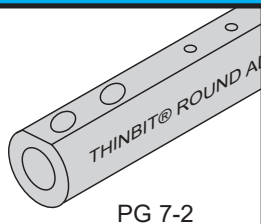
MODIFICATIONS

SEE PAGE
8-3
FOR ADDITIONAL
INFORMATION



TOOLHOLDER SELECTIONS

ADAPTER STYLES



TECHNICAL SECTIONS

PRODUCT DEMONSTRATION



www.thinbit.com/qr1-3

SPEEDS AND FEEDS

PG 9-10

APPLICATION REFERENCE

PG 9-4

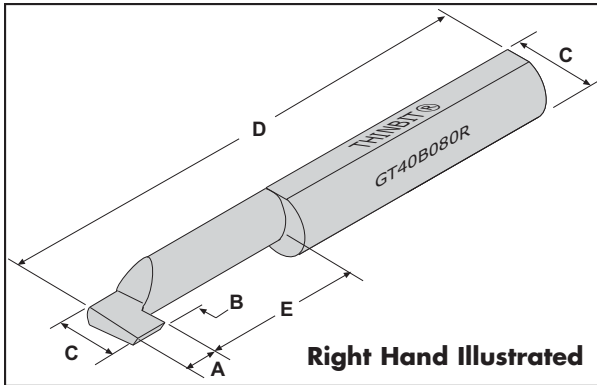
TROUBLESHOOTING

PG 9-7

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I.D. GROOVING TOOLS



FRONT RAKE: Primary 21°
 BACK CLEARANCE: 2°
 SIDE CLEARANCE: 2°
 RADIUS: Sharp corner through full radius available
 TOP RAKE: 0°
 LEAD ANGLE: 0°
 'A' TOLERANCE: .004" - .250": +.0009"/-.0000"

I.D. GROOVING

ORDERING INSTRUCTIONS

Complete the **ORDER CODE** in the table below that represents your selection of groove width and tool dimensions.

EXAMPLE:

The **ORDER CODE** for a 1/4" shank, right hand tool with an .080" tool width, .110" depth of cut and .500" long neck is:

GT40B 0 8 0 R

Specify the Tool Width 'A' ↑

SPECIFICATIONS				ORDER CODE					INFORMATION										
Minimum Bore & Shank Diameter 'C'	Tool Width Range 'A'	Depth of Cut 'B'	Neck Length 'E'	DURA-MAX® 2000 Carbide See Page 9-10 for speeds and feeds		Add-ons Use 'Order Code' and Add			Overall Length 'D'	Toolholder Page 7-2 Use Toolholders Beginning With									
				Right Hand	Left Hand	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6											
1/8"	.004"-.063"	.004"-.006" = 3 x 'A'	.250"	GT20C ___ R	GT20C ___ L	Maximum radius limited to depth of cut * See Note	add 'FR'	(indicate size in .xxx") Maximum radius limited to depth of cut * See Note	TiN add 'C'	1.365" + 'A'	'AD'								
		.007"-.063" = .020"	.375"	GT21C ___ R	GT21C ___ L														
		.004"-.016" = 3 x 'A'	.250"	GT20B ___ R	GT20B ___ L														
		.017"-.063" = .050"	.375"	GT21B ___ R	GT21B ___ L														
3/16"	.004"-.093"	.004"-.011" = 3 x 'A'	.375"	GT30C ___ R	GT30C ___ L					Maximum radius limited to depth of cut * See Note	add 'CR ___'	TiCN add 'D'	1.865" + 'A'	'AD'					
		.012"-.093" = .035"	.625"	GT31C ___ R	GT31C ___ L														
		.004"-.026" = 3 x 'A'	.375"	GT30B ___ R	GT30B ___ L														
		.027"-.093" = .080"	.625"	GT31B ___ R	GT31B ___ L														
1/4"	.004"-.125"	.004"-.016" = 3 x 'A'	.500"	GT40C ___ R	GT40C ___ L								Maximum radius limited to depth of cut * See Note	(indicate size in .xxx") Maximum radius limited to depth of cut * See Note	TiAIN add 'E'	2.365" + 'A'	'AD'		
		.017"-.125" = .050"	.750"	GT41C ___ R	GT41C ___ L														
		.004"-.036" = 3 x 'A'	.500"	GT40B ___ R	GT40B ___ L														
		.037"-.125" = .110"	.750"	GT41B ___ R	GT41B ___ L														
5/16"	.004"-.156"	.004"-.021" = 3 x 'A'	.625"	GT50C ___ R	GT50C ___ L	Maximum radius limited to depth of cut * See Note	(indicate size in .xxx") Maximum radius limited to depth of cut * See Note	Diamond add 'F'	2.330" + 'A'							'AD'			
		.022"-.156" = .063"	1.000"	GT51C ___ R	GT51C ___ L														
		.004"-.046" = 3 x 'A'	.625"	GT50B ___ R	GT50B ___ L														
		.047"-.156" = .140"	1.000"	GT51B ___ R	GT51B ___ L														
3/8"	.004"-.187"	.004"-.036" = 3 x 'A'	.750"	GT60C ___ R	GT60C ___ L				Maximum radius limited to depth of cut * See Note	(indicate size in .xxx") Maximum radius limited to depth of cut * See Note	Diamond add 'F'	2.800" + 'A'				'AD'			
		.037"-.187" = .110"	1.250"	GT61C ___ R	GT61C ___ L														
1/2"	.004"-.250"	.004"-.050" = 3 x 'A'	1.000"	GT80C ___ R	GT80C ___ L							Maximum radius limited to depth of cut * See Note				(indicate size in .xxx") Maximum radius limited to depth of cut * See Note	Diamond add 'F'	3.240" + 'A'	'AD'
		.051"-.250" = .150"	1.750"	GT81C ___ R	GT81C ___ L														

* Example: GT31C093R - max radius would be .035"

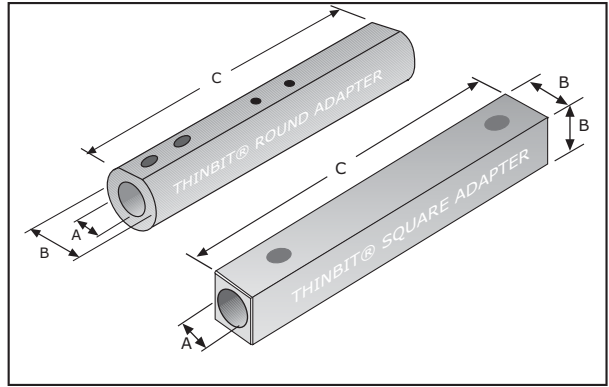
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ROUND & SQUARE ADAPTERS

PRODUCT INFORMATION

- Designed to adapt round tooling to lathe workholding
- ID sizes 1/8", 5/32", 3/16", 1/4", 5/16" and 3/8".
- Round sizes 1/4", 3/8", 1/2", 5/8" and 3/4".
- Square sizes 5/16", 3/8", 1/2", 5/8", 3/4", 1" and 1-1/4".
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



TOOL SELECTIONS

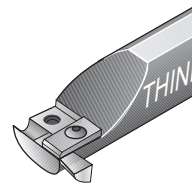
SOLID CARBIDE

- Grooving Page 1-3
- Face Grooving Page 2-3
- Boring Page 3-3
- Threading Page 4-3 & 4-5



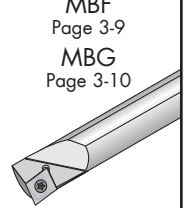
GROOVING BARS

- Grooving Page 1-5
- Face Grooving Page 2-5



BORING BARS

- MBA Page 3-13
- MBB Page 3-15
- MBC Page 3-17
- MBE Page 3-8
- MBF Page 3-9
- MBG Page 3-10



Scan this code for additional information.

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ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of adapter dimensions.

EXAMPLE:

The **ORDER CODE** for a .375" ID x .625" OD round adapter is:

AD3762

SPECIFICATIONS				ORDER CODE				SPECIFICATIONS				ORDER CODE			
Adapter Style	Shank Dimensions			Adapter	Replacement Parts			Adapter Style	Shank Dimensions			Adapter	Replacement Parts		
	'A'	'B'	'C'		Includes Adapter and Hardware	Screw	Wrench		Pin	'A'	'B'		'C'	Includes Adapter and Hardware	Screw
Round	.125"	.250"	3.000"	AD1225	S1402M	W0050	P0203	Round	.312"	.500"	4.000"	AD3150	S1802	W1005	P0204
				AD1237	S1402	W0050	P0203			.625"		AD3162	S1802	W1005	P0206
				AD1250	S1402	W0050	P0204			.750"		AD3175	S1802	W1005	P0206
				AD1262	S1404	W0050	P0204			1.000"		AD3110	S1804	W1005	P0206
				AD1275	S1404	W0050	P0204		.375"	.625"	AD3762	S1802	W1005	P0206	
				AD1210	S1404	W0050	P0204			.750"	AD3775	S1802	W1005	P0206	
	.156"	.375"	3.000"	AD1537	S1402M	W0050	---	Round	.500"	.750"	4.000"	AD3710	S1804	W1005	P0206
				AD1550	S1402	W0050	---					AD5075	S1802	W1005	P0206
				AD1562	S1403	W0050	---					AD5010	S1804	W1005	P0206
	.187"	.375"	3.000"	AD1837	S1402M	W0050	P0203	Round	.750"	1.000"	4.000"	AD7510	S1802	W1005	---
				AD1850	S1802	W1005	P0204								
				AD1862	S1802	W1005	P0206								
				AD1875	S1804	W1005	P0206								
	.250"	.625"	4.000"	AD1810	S1404	W0050	P0206	Square	.250"	.312"	3.000"	AD56	---	---	---
				AD2537	S1402M	W0050	P0203			.375"		AD38	S1802	W1005	---
				AD2550	S1802	W1005	P0204			.500"		AD12	S1802	W1005	---
				AD2562	S1802	W1005	P0206			.625"		AD58	S1802	W1005	---
				AD2575	S1804	W1005	P0206			.750"		AD34	S1802	W1005	---
	AD2510	S1804	W1005	P0206	1.000"	AD01	S1802	W1005	---						
									1.250"		AD14	S1802	W1005	---	

TOOLHOLDERS

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