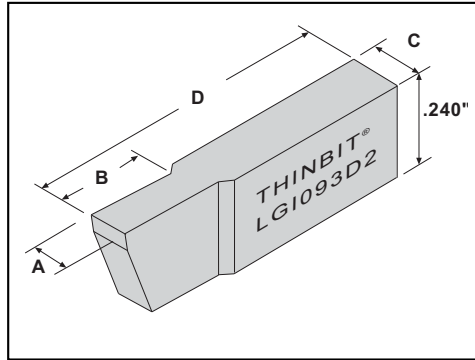



# LITTLE BIT® O.D./I.D. GROOVING INSERTS



FRONT RAKE:  
 CARBIDE: Primary 10° honed, Secondary 15°  
 HIGH SPEED STEEL: 15°  
 BACK CLEARANCE: 2-1/2° both sides  
 SIDE CLEARANCE: 0° both sides  
 RADIUS: Sharp corner through full radius available  
 TOP RAKE: 0°  
 LEAD ANGLE: 0°  
 'A' TOLERANCE:  
 .004" - .063": +.0009"/-.0000"  
 .064" - .125": +.001"/-.001"

<b>PRODUCT INFORMATION</b>	<ul style="list-style-type: none"> <li>This insert style will cut to within 1/16" of a shoulder. To work against a shoulder see Page 1-10.</li> <li>Sub-micron grain <b>DURA-MAX® 2000</b> and <b>5000</b> Carbides and High Speed Steel.</li> <li>Inserts available with TiN, TiAlN, TiCN and Diamond coating.</li> </ul>
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TECHNICAL SECTIONS	PRODUCT DEMONSTRATION	SPEEDS AND FEEDS	APPLICATION REFERENCE	TROUBLESHOOTING
	 <a href="http://www.thinbit.com/gr10-1">www.thinbit.com/gr10-1</a>	PG 9-10	PGS 9-3 & 9-4	PG 9-7

## ORDERING INSTRUCTIONS

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

**EXAMPLE:**

The **ORDER CODE** for an .045" groove width insert in **DURA-MAX® 2000** is:

**SGI 045 D2**

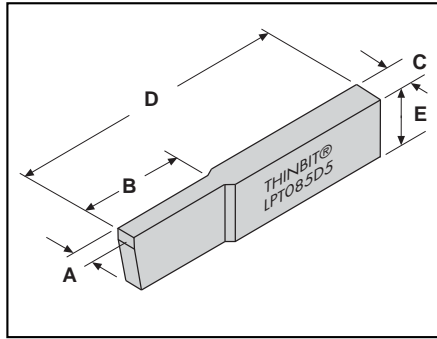
Specify the Tool Width 'A' \_\_\_\_\_ ↑

SPECIFICATIONS		ORDER CODE						INFORMATION		
Insert Width Range 'A'	Depth of Cut 'B'	Insert Grades See Page 9-5 for expanded material descriptions and Page 9-10 for Speeds and Feeds information			Add-ons Use 'Order Code' and Add			Blank Width 'C'	Overall Length 'D'	Toolholder Catalog Section 7 & 10  Use Toolholders Beginning With
		DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Nonferrous	High Speed Steel	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6			
.004"-.034"	3 x 'A'									
.035"-.063"	.100"	SGI ___ D2	SGI ___ D5	SGI ___ HS	add 'FR'	add 'CR_ _ _' (indicate size in .xxx")	TiN add 'C' TiCN add 'D' TiAlN add 'E' Diamond add 'F'	.068"	.650"	'S' 'EM' 'ROM'  Page 10-5 through 10-8

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# LITTLE BIT® PARTING INSERTS



FRONT RAKE:  
 CARBIDE: Primary 7° honed, Secondary 15°  
 HIGH SPEED STEEL: 15° on SPT025HS,  
 7° all others  
 BACK CLEARANCE: 0° SPT045HS and  
 SPT062HS; 1° all others  
 SIDE CLEARANCE: 1°  
 RADIUS: None  
 TOP RAKE: 0°  
 LEAD ANGLE: 0°  
 'A' TOLERANCE: .025" - .115": +.001"/-.001"

GROOVING & PARTING INSERTS

<b>PRODUCT INFORMATION</b>	<ul style="list-style-type: none"> <li>This insert style will cut to within 1/16" of a shoulder.</li> <li>.025", .045", .062", .085" and .115"</li> <li>Parting off up to 1" diameter</li> <li>Centered</li> <li>Sub-micron grain <b>DURA-MAX® 2000</b> and <b>5000</b> Carbides and High Speed Steel.</li> <li>Inserts available with TiN, TiAlN, TiCN and Diamond coating.</li> </ul>
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TECHNICAL SECTIONS	PRODUCT DEMONSTRATION	SPEEDS AND FEEDS	APPLICATION REFERENCE	TROUBLESHOOTING
	 <a href="http://www.thinbit.com/qr10-2">www.thinbit.com/qr10-2</a>	PG 9-20	PG 9-4	PG 9-7

## ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of groove width and insert grade.

**EXAMPLE:**

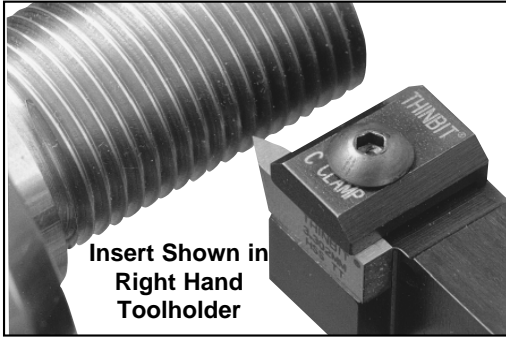
The **ORDER CODE** for an .062" wide parting insert in **DURA-MAX® 5000** is:  
**SPT062D5**

SPECIFICATIONS		ORDER CODE				INFORMATION						
Groove Width	Depth of Cut	Insert Grades See Pages 9-5 for expanded material descriptions and Page 9-20 for Speeds and Feeds information			Coatings See Page 9-6 for expanded coating descriptions				Blank Width	Overall Length	Blank Height	Toolholder Catalog Section 7 & 10
'A'	'B'	DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Nonferrous	High Speed Steel	Use uncoated part number and add coating code				'C'	'D'	'E'	Use Toolholders Beginning With
					TIN	TICN	TiAlN	Diamond				
.025"	.200"	SPT025D2	SPT025D5	SPT025HS						.650"		'S' 'EM' 'ROM'  Page 10-5 through 10-8
.045"	.500"	SPT045D2	SPT045D5	SPT045HS	add 'C'	add 'D'	add 'E'	add 'F'	.068"	1.000"	.240"	
.062"		SPT062D2	SPT062D5	SPT062HS								

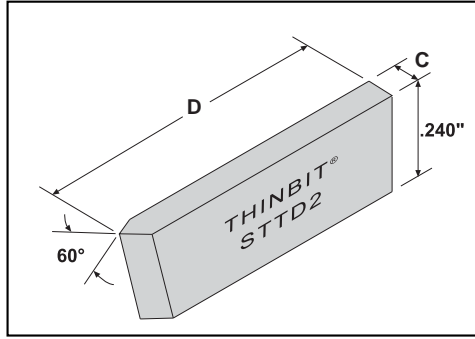
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# LITTLE BIT<sup>®</sup> O.D./I.D. THREADING INSERTS




Insert Shown in Right Hand Toolholder



FRONT RAKE: 15°  
RADIUS: .002" or .000"  
TOP RAKE: 0°

<b>PRODUCT INFORMATION</b>	<ul style="list-style-type: none"> <li>• External threading within .046" of a shoulder.</li> <li>• Internal threading with 1.250" minimum bore diameter.</li> <li>• 8 Threads Per Inch and greater.</li> <li>• Sub-micron grain <b>DURA-MAX<sup>®</sup> 2000</b> and <b>5000</b> Carbides and High Speed Steel.</li> <li>• Inserts can be coated with TiN, TiAlN, TiCN and Diamond coating.</li> </ul>
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<b>TECHNICAL SECTIONS</b>	<b>PRODUCT DEMONSTRATION</b>	<b>SPEEDS AND FEEDS</b>	<b>APPLICATION REFERENCE</b>	<b>TROUBLESHOOTING</b>
	 <a href="http://www.thinbit.com/qr10-3">www.thinbit.com/qr10-3</a>	PG 9-18	PG 9-4	PG 9-7

## ORDERING INSTRUCTIONS

Complete the **ORDER CODE** in the table below that represents your selection of Threads Per Inch and insert grade.

**EXAMPLE:**

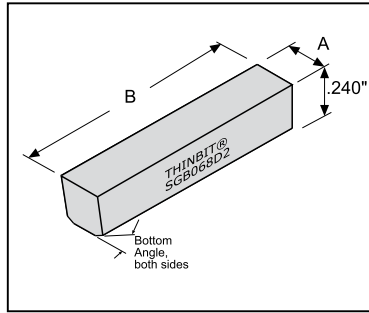
The **ORDER CODE** for an 15-56 TPI insert in **DURA-MAX<sup>®</sup> 2000** is:  
**STTD2**

SPECIFICATIONS		ORDER CODE							INFO.		
Insert Orientation	Threads Per Inch	Insert Grades <small>See Page 9-5 for expanded material selections and Page 9-18 for Speeds and Feeds information</small>			Coatings <small>See Page 9-6 for Expanded Coating Descriptions</small>				Blank Width 'C'	Overall Length 'D'	Toolholder Catalog Section 7 & 10  Use Toolholders Beginning With
		DURA-MAX <sup>®</sup> 2000 Carbide <small>For Steel &amp; Interrupted Cutting</small>	DURA-MAX <sup>®</sup> 5000 Carbide <small>For Aluminum &amp; Non-ferrous</small>	High Speed Steel	TIN	TiCN	TiAlN	Diamond			
Centered For either right hand or left hand	15 to 56	STTD2	STTD5	STTHS					.068"	.650"	'S'  Page 10-5 through 10-8
	Greater than 56	STTD21	STTD51	STTHS1	add 'C'	add 'D'	add 'E'	add 'F'			

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FRONT RAKE: 7° on SGP068HS; 15° all others



## GROUND BLANK ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of blank width and insert grade.

**EXAMPLE:**

The **ORDER CODE** for a .068" wide blank and .654" length in

**DURA-MAX® 2000** is:

**SGB068D2**

SPECIFICATIONS			ORDER CODE			INFO.
Blank Width 'A'	Overall Length 'B'	Bottom Angle	Insert Grades See Page 9-5 for expanded material descriptions			Use Toolholders Beginning With
			DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Nonferrous	High Speed Steel	
.068"	.654"	0°	SGB068D2	SGB068D5	SGB068HS	'S'
	1.004"	0°	SGP068D2	SGP068D5	SGP068HS	

## SET ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of insert width(s) and insert grade.

For '1 Each' set types, specify the size range with the '**Order Code**'

**EXAMPLE:**

The **ORDER CODE** for a '1 Each' set type, in **DURA-MAX® 2000**

with a groove width range of .010"- .030" is: **SSET2D2**



SPECIFICATIONS			ORDER CODE		
Toolholder Type	Set Type	Insert Width 'A' See Page 10-1	Insert Grades See Page 9-5 for expanded material descriptions and Page 9-10 for Speeds and Feeds information		
			DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting Uncoated	DURA-MAX® 5000 Carbide For Aluminum & Non-ferrous Uncoated	High Speed Steel
Inserts only; Use toolholders beginning with 'S'  Page 10-5 through 10-8	1 Each, by .001" increments Inserts Only	.004"-.009"	SSET1D2	SSET1D5	SSET1HS
		.010"-.030"	SSET2D2	SSET2D5	SSET2HS
		.031"-.050"	SSET3D2	SSET3D5	SSET3HS
		.051"-.063"	SSET4D2	SSET4D5	SSET4HS

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