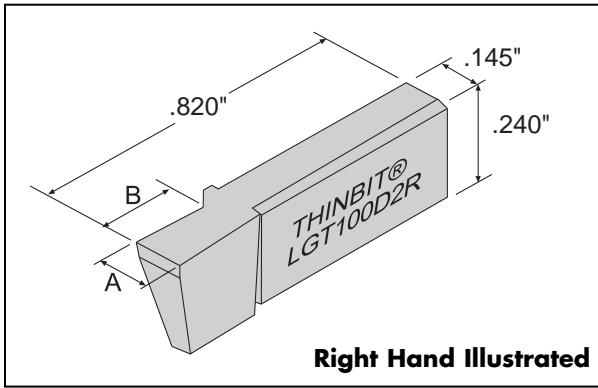


# O.D./I.D. GROOVING AND TURNING INSERTS



**FRONT RAKE:**

CARBIDE: Primary 10° honed, Secondary 15°  
 HIGH SPEED STEEL: 15°

**BACK CLEARANCE:** 2-1/2° both sides

**SIDE CLEARANCE:** .004" - .019" - 0° both sides  
 .020" - .150" - 5° both sides

**RADIUS:** Sharp corner through full radius available

**TOP RAKE:** 0°

**LEAD ANGLE:** 0°

**NOTES:** Capable of grooving along a shoulder  
 .004"-.019" inserts are not designed for turning

**O.D. & I.D.  
GROOVING**

## 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 a right hand, .100" insert width in **DURA-MAX® 2000** is:

**LGT 1 0 0 D2 R**

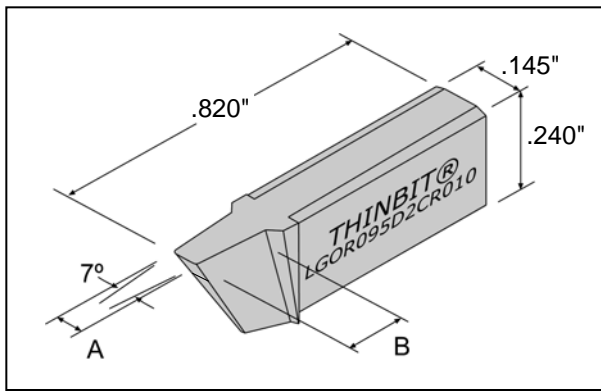
Specify the Tool Width 'A' \_\_\_\_\_ ↑

SPECIFICATIONS			ORDER CODE						INFO.
Insert Orientation	Insert Width  'A'  +.0009"/-.0000"	Depth of Cut  'B'  <u>Width</u> <u>DOC</u> .004"-.033" = 3 x 'A' .034"-.039" = .100" .040"-.100" = 2.5 x 'A' .101"-.150" = .250"	Insert Grades <small>See Page 9-5 for expanded material descriptions and Page 9-10 for Speeds and Feeds information</small>			Add-ons <small>Use 'Order Code' and Add</small>			Toolholder Catalog Section 7  Use Toolholders Beginning With
			DURA-MAX® 2000 Carbide <small>For Steel &amp; Interrupted Cutting</small>	DURA-MAX® 5000 Carbide <small>For Aluminum &amp; Non-ferrous</small>	High Speed Steel	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6	
Right Hand	.004"-.150"		LGT ___ D2R	LGT ___ D5R	LGT ___ HSR	add 'FR'	add 'CR___' <small>(indicate size in .xxx")</small>	TiN add 'C'  TiCN add 'D'	'L'  Use right hand straight holder or left hand 90° holder
Left Hand	.004"-.150"		LGT ___ D2L	LGT ___ D5L	LGT ___ HSL	add 'FR'	add 'CR___' <small>(indicate size in .xxx")</small>	TiAIN add 'E'  Diamond add 'F'	'L'  Use left hand straight holder or right hand 90° holder

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# O.D. STATIC O-RING INSERTS



FRONT RAKE: Primary 10° honed, Secondary 15°  
 BACK CLEARANCE: 7° included angle  
 SIDE CLEARANCE: 5° both sides  
 RADIUS: .010" or .020"  
 TOP RAKE: 0°  
 LEAD ANGLE: 0°  
 DEPTH OF CUT: .200" or .250"

STATIC O-RING  
GROOVING

## ORDERING INSTRUCTIONS

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

**EXAMPLE:**

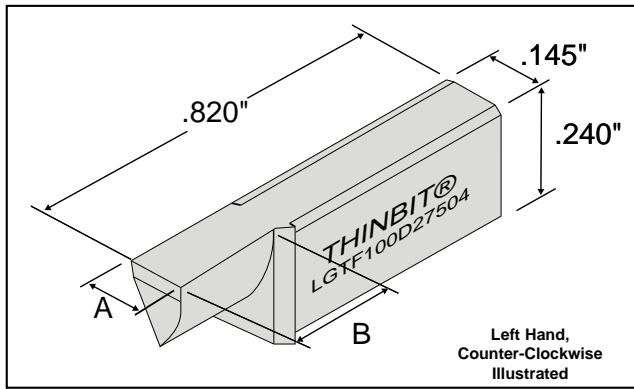
The **ORDER CODE** for a .095" insert width in **DURA-MAX® 2000** is:

**LGOR095D2CR010**

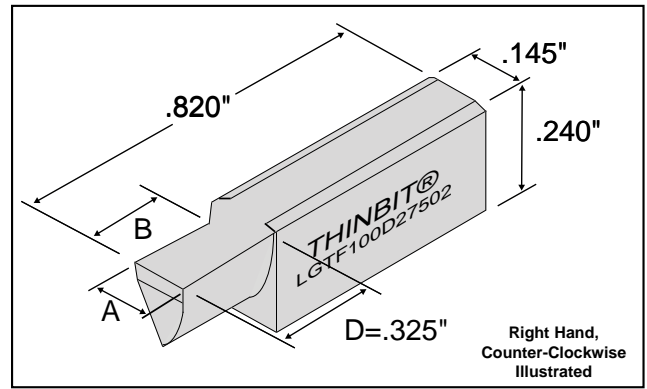
SPECIFICATIONS			ORDER CODE		INFO.	
Insert Orientation & Radius	Insert Width	Depth of Cut	Insert Grades See Page 9-5 for expanded material descriptions and Page 9-10 for Speeds and Feeds information		Add-ons Use 'Order Code' and Add	Toolholder Catalog Section 7  Use Toolholders Beginning With
	'A' ± .001"	'B'	DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Non-ferrous	Coating Page 9-6	
Centered .010" Corner Radius	.095"	.250"	LGOR095D2CR010	LGOR095D5CR010	TiN add 'C'	'L'
	.142"	.200"	LGOR142D2CR010	LGOR142D5CR010	TiCN add 'D' TiAlN add 'E'	
Centered .020" Corner Radius	.125"	.250"	LGOR125D2CR020	LGOR125D5CR020	Diamond add 'F'	

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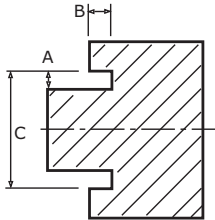
# FACE GROOVING INSERTS



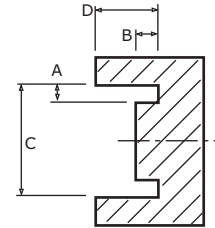
Left Hand,  
Counter-Clockwise  
Illustrated



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

INSERTS  
FACE GROOVING

## 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 1 0 0 D27504**

Specify the Insert Width 'A' ↑

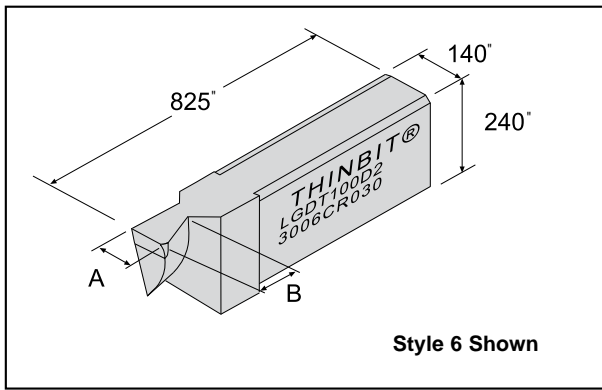
SPECIFICATIONS				ORDER CODE				INFO.	
Insert Orientation	Insert Width  'A'  ± .001"	Depth of Cut  'B'	Major Diameter  Can be used on any diameter equal to or greater than listed	Insert Grades <small>See Page 9-5 for expanded material descriptions and Page 9-12 for Speeds and Feeds information</small>		Add-ons <small>Use 'Order Code' and Add</small>			Toolholder Catalog Section 7  Use Toolholders Beginning With 'L'
				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'	add 'CR___'	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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# DOVETAIL O-RING FACE GROOVING INSERTS



Style 6 Shown

FRONT RAKE: Primary 10° honed, Secondary 15°  
 BACK CLEARANCE: 24° one side  
 SIDE CLEARANCE: Depends on major diameter  
 RADIUS: On 24° side only  
 TOP RAKE: 0°  
 LEAD ANGLE: 0°

**Notes:**

- For best performance, form undercut by profiling.
- If using on either an ID Bore or OD Shaft contact us for assistance.
- Half dovetail form requires a radius on both corners.

DOVE TAIL  
FACE GROOVING

## ORDERING INSTRUCTIONS

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

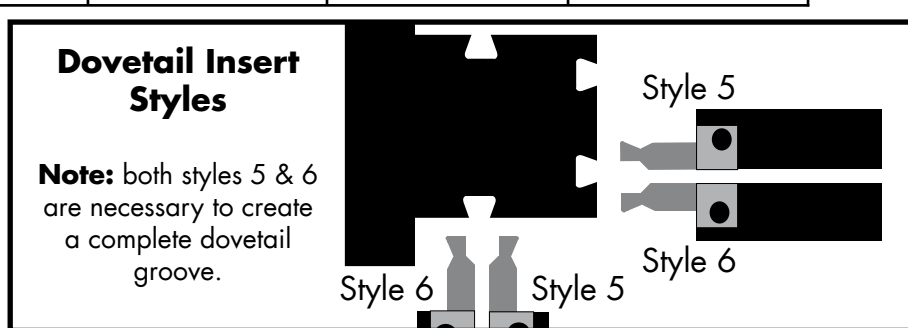
**EXAMPLE:**

The **ORDER CODE** for a left hand/counter-clockwise, .100" wide OD side insert in **DURA-MAX® 2000**, with a .300" major diameter and a .030" corner radius is:  
**LGDT100D23006CR030**

SPECIFICATIONS				ORDER CODE				INFO.	
Insert Orientation & Radius	Insert Width 'A' ± .001"	Depth of Cut 'B'	Radius	Insert Grades See Page 9-5 for expanded material descriptions and Page 9-12 for Speeds and Feeds information				Add-ons Use 'Order Code' and Add Coating Page 9-6	Toolholder Catalog Section 7  Use Toolholders Beginning With
				DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting		DURA-MAX® 5000 Carbide For Aluminum & Nonferrous			
				Style 5	Style 6	Style 5	Style 6		
Left Hand/ Counter-Clockwise	.030"	.030"	.015"	LGDT030D2__5CR015	LGDT030D2__6CR015	LGDT030D5__5CR015	LGDT030D5__6CR015	TiN add 'C'  TiCN add 'D'  TiAlN add 'E'  Diamond add 'F'	'L'
	.050"	.070"	.015"	LGDT050D2__5CR015	LGDT050D2__6CR015	LGDT050D5__5CR015	LGDT050D5__6CR015		
	.060"	.070"	.015"	LGDT060D2__5CR015	LGDT060D2__6CR015	LGDT060D5__5CR015	LGDT060D5__6CR015		
	.070"	.100"	.015"	LGDT070D2__5CR015	LGDT070D2__6CR015	LGDT070D5__5CR015	LGDT070D5__6CR015		
	.080"	.100"	.015"	LGDT080D2__5CR015	LGDT080D2__6CR015	LGDT080D5__5CR015	LGDT080D5__6CR015		
	.090"	.115"	.015"	LGDT090D2__5CR015	LGDT090D2__6CR015	LGDT090D5__5CR015	LGDT090D5__6CR015		
	.100"	.125"	.015"	LGDT100D2__5CR015	LGDT100D2__6CR015	LGDT100D5__5CR015	LGDT100D5__6CR015		
	.100"	.125"	.030"	LGDT100D2__5CR030	LGDT100D2__6CR030	LGDT100D5__5CR030	LGDT100D5__6CR030		
	.125"	.190"	.030"	LGDT125D2__5CR030	LGDT125D2__6CR030	LGDT125D5__5CR030	LGDT125D5__6CR030		
	.150"	.200"	.030"	LGDT150D2__5CR030	LGDT150D2__6CR030	LGDT150D5__5CR030	LGDT150D5__6CR030		

Major Diameter Code

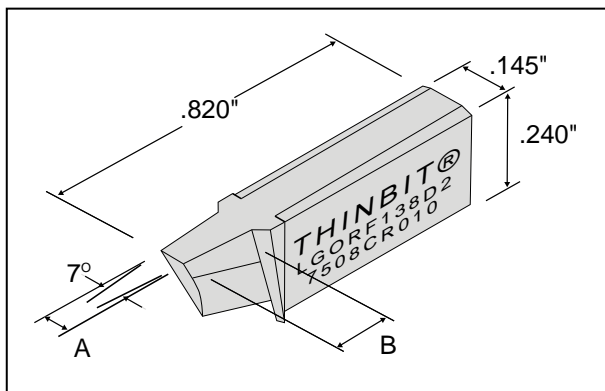
Major Diameter	Code
.300"	300
.500"	500
1.000"	1000
1.500"	1500
2.000"	2000
3.000"	3000



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# STATIC O-RING FACE GROOVING INSERTS



FRONT RAKE: Primary 10° honed, Secondary 15°  
 BACK CLEARANCE: 7° included angle  
 SIDE CLEARANCE: 5° both sides  
 RADIUS: .010" or .020"  
 TOP RAKE: 0°  
 LEAD ANGLE: 0°  
 DEPTH OF CUT: .170" or .250"

STATIC O-RING  
FACE GROOVING

## 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 a counter-clockwise, .138" wide insert in **DURA-MAX® 2000**, with a .750" major diameter and a .010" corner radius is:

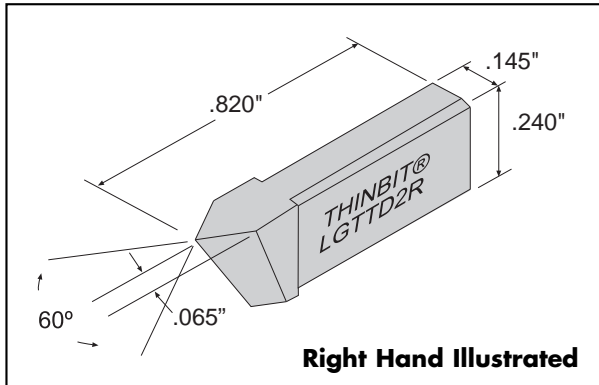
**LGORF138D27508CR010**

SPECIFICATIONS				ORDER CODE		INFO.	
Insert Orientation & Radius	Insert Width  'A'  ± .001"	Depth of Cut  'B'	Major Diameter  Can be used on any diameter equal to or greater than listed	Insert Grades See Page 9-5 for expanded material descriptions and Page 9-12 for Speeds and Feeds information		Add-ons Use 'Order Code' and Add  Coating Page 9-6	Toolholder Catalog Section 7  Use Toolholders Beginning With
				DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Non-ferrous		
Counter-Clockwise; .010" Corner Radius	.086"	.250"	.300"	LGORF086D23008CR010	LGORF086D53008CR010	TiN add 'C' TiCN add 'D' TiAlN add 'E' Diamond add 'F'	'L'  Use left hand straight holder or right hand 90° holder
			.750"	LGORF086D27508CR010	LGORF086D57508CR010		
	.103"	.250"	.300"	LGORF103D23008CR010	LGORF103D53008CR010		
			.750"	LGORF103D27508CR010	LGORF103D57508CR010		
	.122"	.250"	.300"	LGORF122D23008CR010	LGORF122D53008CR010		
			.750"	LGORF122D27508CR010	LGORF122D57508CR010		
	.138"	.170"	.300"	LGORF138D23008CR010	LGORF138D53008CR010		
			.750"	LGORF138D27508CR010	LGORF138D57508CR010		
Counter-Clockwise; .020" Corner Radius	.125"	.250"	.300"	LGORF125D23008CR020	LGORF125D53008CR020		
			.750"	LGORF125D27508CR020	LGORF125D57508CR020		

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# THREADING INSERTS



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

## ORDERING INSTRUCTIONS

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

**EXAMPLE:**

The **ORDER CODE** for a right hand, 8 to 56 Threads Per Inch threading insert in **DURA-MAX® 2000** is:  
**LGTTD2R**

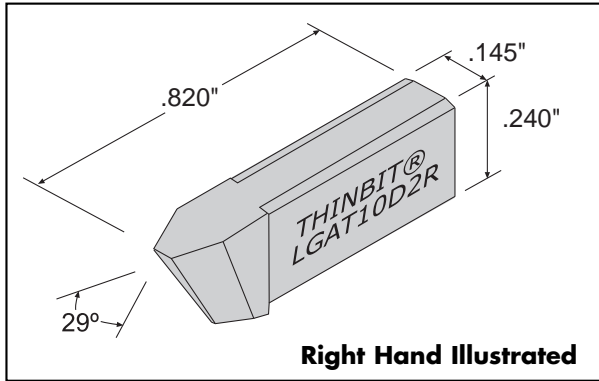
INSERTS  
THREADING

SPECIFICATIONS		ORDER CODE						INFO.	
Insert Orientation	Threads per Inch	Insert Grades See Page 9-5 for expanded material selections and Page 9-18 for Speeds and Feeds information			Coatings See Page 9-6 for Expanded Coating Descriptions				Toolholder Catalog Section 7  Use Toolholders Beginning With
		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				
					TiN	TiCN	TiAlN	Diamond	
Right Hand For right hand external threads or left hand internal threads	8 to 56	LGTTD2R	LGTTD5R	LGTTHSR					'L'  Use right hand straight holder or left hand 90° holder
	Greater than 56	LGTTD2R1	LGTTD5R1	LGTTHSR1	add 'C'	add 'D'	add 'E'	add 'F'	
Left Hand For left hand external threads or right hand internal threads	8 to 56	LGTTD2L	LGTTD5L	LGTTHSL					'L'  Use left hand straight holder or right hand 90° holder
	Greater than 56	LGTTD2L1	LGTTD5L1	LGTTHSL1	add 'C'	add 'D'	add 'E'	add 'F'	

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# ACME THREADING INSERTS



FRONT RAKE: 15°

TOP RAKE: 0°

- 29° ACME threading inserts for internal and external applications.
- ACME threading tools can be used to cut other thread profiles by over cutting.
- Single lead

## ORDERING INSTRUCTIONS

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

**EXAMPLE:**

The **ORDER CODE** for a right hand ACME threading insert in **DURA-MAX® 2000** with 10 or fewer T.P.I. is:  
**LGAT10D2R**

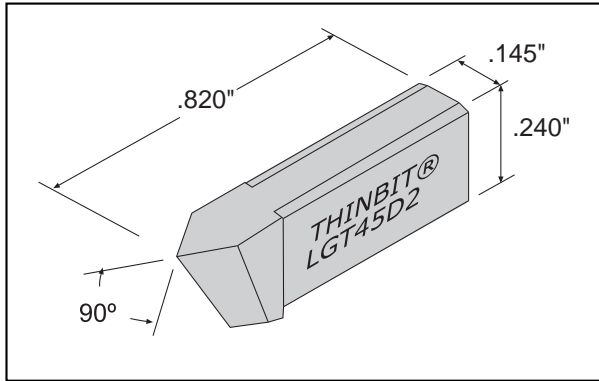
ACME INSERTS  
THREADING

SPECIFICATIONS			ORDER CODE				INFO.			
Insert Orientation	Threads per Inch	Flat at Tip	Insert Grades See Page 9-5 for expanded material selections and Page 9-18 for Speeds and Feeds information			Coatings See page 9-6 for expanded coating descriptions Use Uncoated Part Number and Add Coating Code				Toolholder Catalog Section 7  Use Toolholders Beginning With
			DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Nonferrous	High Speed Steel	TiN	TiCN	TiAlN	Diamond	
Centered right hand, left hand, internal and external threads	4	.087"	LGAT04D2R	LGAT04D5R	LGAT04HSR	add 'C'	add 'D'	add 'E'	add 'F'	'L'
	5	.069"	LGAT05D2R	LGAT05D5R	LGAT05HSR					Use right hand straight holder, or left hand 90° holder, for right hand external threads or left hand internal threads  or Use left hand straight holder, or right hand 90° holder, for left hand external threads or right hand internal threads
	6	.057"	LGAT06D2R	LGAT06D5R	LGAT06HSR					
	8	.041"	LGAT08D2R	LGAT08D5R	LGAT08HSR					
	10	.032"	LGAT10D2R	LGAT10D5R	LGAT10HSR					
	12	.028"	LGAT12D2R	LGAT12D5R	LGAT12HSR					
	14	.024"	LGAT14D2R	LGAT14D5R	LGAT14HSR					
	16	.021"	LGAT16D2R	LGAT16D5R	LGAT16HSR					

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# CHAMFERING INSERTS



FRONT RAKE: 15°  
 MAXIMUM RADIUS: .002"  
 TOP RAKE: 0°

## ORDERING INSTRUCTIONS

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

**EXAMPLE:**

The **ORDER CODE** for a chamfering insert in **DURA-MAX® 2000** is:

**LGT45D2**

CHAMFERING INSERTS  
THREADING

SPECIFICATIONS		ORDER CODE						INFO.	
Insert Orientation	Flat at Tip	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>				Toolholder Catalog Section 7  Use Toolholders Beginning With
		DURA-MAX® 2000 Carbide <small>For Steel &amp; Interrupted Cutting</small>	DURA-MAX® 5000 Carbide <small>For Aluminum &amp; Nonferrous</small>	High Speed Steel	Use Uncoated Part Number and Add Coating Code				
					TiN	TiCN	TiAlN	Diamond	
Centered	None	LGT45D2	LGT45D5	LGT45HS	add 'C'	add 'D'	add 'E'	add 'F'	'L'

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














# PARTING INSERTS

## 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 .085" wide parting insert in **DURA-MAX® 2000** is: **LGPT085D2**

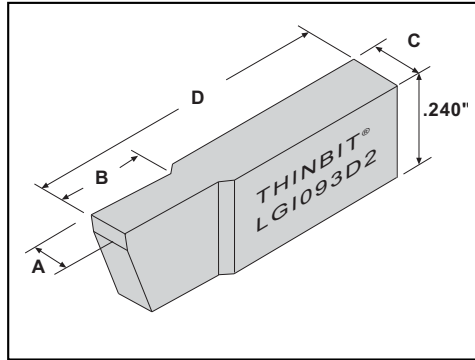
SPECIFICATIONS				ORDER CODE				INFORMATION												
Insert Width  'A'  ±.001"	Insert Orientation	Lead Angle Orientation  Right Hand Left Hand	Depth of Cut  'B'	Insert Grades See Page 9-5 for expanded material descriptions and Page 9-20 for Speeds and Feeds information			Coatings See Page 9-6 for expanded coating descriptions				Overall Length  'C'	Toolholder Catalog Section 7  Use Toolholders Beginning With								
				DURA-MAX® 2000 Carbide For Steel & Interrupted Cutting	DURA-MAX® 5000 Carbide For Aluminum & Non-ferrous	High Speed Steel	TIN	TICN	TIAlN	Diamond										
.025"	Centered 	0°	.200"	LGPT025D2	LGPT025D5	LGPT025HS	add 'C'	add 'D'	add 'E'	add 'F'	.820" Carbide  .825" HSS	'L' Series  Centered Use any straight holder or 90° holder  Right Hand Use right hand straight holder or left hand 90° holder  Left Hand Use left hand straight holder or right hand 90° holder								
		7° Right Hand		LGPT025D27R	LGPT025D57R	LGPT025HS7R														
		7° Left Hand		LGPT025D27L	LGPT025D57L	LGPT025HS7L														
	Right Hand 	0°		LGPT025D2R	LGPT025D5R	LGPT025HSR														
		7° Right Hand		LGPT025D2R7R	LGPT025D5R7R	LGPT025HSR7R														
		7° Left Hand		LGPT025D2R7L	LGPT025D5R7L	LGPT025HSR7L														
	Left Hand 	0°		LGPT025D2L	LGPT025D5L	LGPT025HSL														
		7° Right Hand		LGPT025D2L7R	LGPT025D5L7R	LGPT025HSL7R														
		7° Left Hand		LGPT025D2L7L	LGPT025D5L7L	LGPT025HSL7L														
	.045"	Centered 		0°	.500"	LGPT045D2							LGPT045D5	LGPT045HS	add 'C'	add 'D'	add 'E'	add 'F'	1.062" Carbide  1.078" HSS	'L' Series  Centered Use any straight holder or 90° holder  Right Hand Use right hand straight holder or left hand 90° holder  Left Hand Use left hand straight holder or right hand 90° holder
				7° Right Hand		LGPT045D27R							LGPT045D57R	LGPT045HS7R						
				7° Left Hand		LGPT045D27L							LGPT045D57L	LGPT045HS7L						
Right Hand 		0°	LGPT045D2R	LGPT045D5R		LGPT045HSR														
		7° Right Hand	LGPT045D2R7R	LGPT045D5R7R		LGPT045HSR7R														
		7° Left Hand	LGPT045D2R7L	LGPT045D5R7L		LGPT045HSR7L														
Left Hand 		0°	LGPT045D2L	LGPT045D5L		LGPT045HSL														
		7° Right Hand	LGPT045D2L7R	LGPT045D5L7R		LGPT045HSL7R														
		7° Left Hand	LGPT045D2L7L	LGPT045D5L7L		LGPT045HSL7L														
.062"		Centered 	0°	.500"		LGPT062D2	LGPT062D5	LGPT062HS	add 'C'	add 'D'	add 'E'	add 'F'	1.062" Carbide  1.078" HSS	'L' Series  Centered Use any straight holder or 90° holder  Right Hand Use right hand straight holder or left hand 90° holder  Left Hand Use left hand straight holder or right hand 90° holder						
			7° Right Hand			LGPT062D27R	LGPT062D57R	LGPT062HS7R												
			7° Left Hand			LGPT062D27L	LGPT062D57L	LGPT062HS7L												
	Right Hand 	0°	LGPT062D2R		LGPT062D5R	LGPT062HSR														
		7° Right Hand	LGPT062D2R7R		LGPT062D5R7R	LGPT062HSR7R														
		7° Left Hand	LGPT062D2R7L		LGPT062D5R7L	LGPT062HSR7L														
	Left Hand 	0°	LGPT062D2L		LGPT062D5L	LGPT062HSL														
		7° Right Hand	LGPT062D2L7R		LGPT062D5L7R	LGPT062HSL7R														
		7° Left Hand	LGPT062D2L7L		LGPT062D5L7L	LGPT062HSL7L														
	.085"	Centered 	0°		.500"	LGPT085D2	LGPT085D5	LGPT085HS							add 'C'	add 'D'	add 'E'	add 'F'	1.062" Carbide  1.078" HSS	'L' Series  Centered Use any straight holder or 90° holder  Right Hand Use right hand straight holder or left hand 90° holder  Left Hand Use left hand straight holder or right hand 90° holder
			7° Right Hand			LGPT085D27R	LGPT085D57R	LGPT085HS7R												
			7° Left Hand			LGPT085D27L	LGPT085D57L	LGPT085HS7L												
Right Hand 		0°	LGPT085D2R	LGPT085D5R		LGPT085HSR														
		7° Right Hand	LGPT085D2R7R	LGPT085D5R7R		LGPT085HSR7R														
		7° Left Hand	LGPT085D2R7L	LGPT085D5R7L		LGPT085HSR7L														
Left Hand 		0°	LGPT085D2L	LGPT085D5L		LGPT085HSL														
		7° Right Hand	LGPT085D2L7R	LGPT085D5L7R		LGPT085HSL7R														
		7° Left Hand	LGPT085D2L7L	LGPT085D5L7L		LGPT085HSL7L														
.115"		Centered 	0°	.500"		LGPT115D2	LGPT115D5	LGPT115HS	add 'C'	add 'D'	add 'E'	add 'F'	1.062" Carbide  1.078" HSS	'L' Series  Centered Use any straight holder or 90° holder  Right Hand Use right hand straight holder or left hand 90° holder  Left Hand Use left hand straight holder or right hand 90° holder						
			7° Right Hand			LGPT115D27R	LGPT115D57R	LGPT115HS7R												
			7° Left Hand			LGPT115D27L	LGPT115D57L	LGPT115HS7L												
	Right Hand 	0°	LGPT115D2R		LGPT115D5R	LGPT115HSR														
		7° Right Hand	LGPT115D2R7R		LGPT115D5R7R	LGPT115HSR7R														
		7° Left Hand	LGPT115D2R7L		LGPT115D5R7L	LGPT115HSR7L														
	Left Hand 	0°	LGPT115D2L		LGPT115D5L	LGPT115HSL														
		7° Right Hand	LGPT115D2L7R		LGPT115D5L7R	LGPT115HSL7R														
		7° Left Hand	LGPT115D2L7L		LGPT115D5L7L	LGPT115HSL7L														

INSERTS PARTING

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



Insert Shown in Right Hand Toolholder



**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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<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/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 .093" groove width insert in **DURA-MAX® 2000** is:

LGI 0 9 3 D2

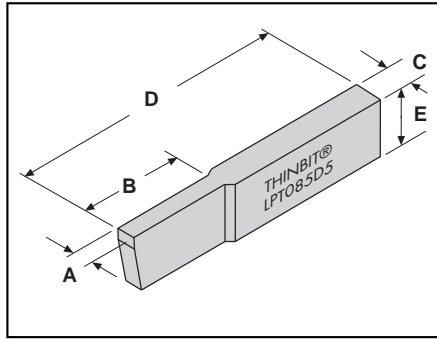
Specify the Tool Width 'A' \_\_\_\_\_ ↑

SPECIFICATIONS		ORDER CODE						INFORMATION		
Insert Width Range	Depth of Cut	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	Overall Length	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	Full Radius Page 8-3	Corner Radius Page 8-3	Coating Page 9-6	'C'	'D'	Use Toolholders Beginning With
.064"-.095"	1.5 x 'A'	LGI ___ D2	LGI ___ D5	LGI ___ HS	add 'FR'	add 'CR' ___  (indicate size in .xxx")	TiN add 'C'	.130"	.721"	'L' 'EM' 'ROM'  Section 7 Page 10-5 through 10-8
.096"-.125"							TiCN add 'D'			

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# LITTLEBIT® 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 .085" wide parting insert in **DURA-MAX® 5000** is:  
**LPT085D5**

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				
.085"	.500"	LPT085D2	LPT085D5								.238"	'L' 'EM' 'ROM'
.115"		LPT115D2	LPT115D5		add 'C'	add 'D'	add 'E'	add 'F'	.125"	1.000"	.232"	

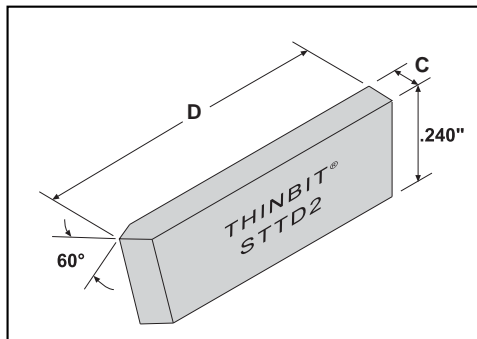
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# LITTLE BIT<sup>®</sup> O.D./I.D. THREADING INSERTS




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:**

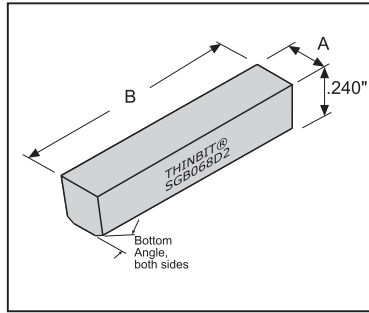
The **ORDER CODE** for an 8-56 TPI insert in **DURA-MAX<sup>®</sup> 2000** is:  
**LTTD2**

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	8 to 56	LTTD2	LTTD5	LTTHS							'L'
	Greater than 56	LTTD21	LTTD51	LTTHS1	add 'C'	add 'D'	add 'E'	add 'F'	.130"	.721"	Section 7 Page 10-5 through 10-8

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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	
.125"	1.004"	0°	LGP125D2	LGP125D5		'L'
.130"	.725"	10°	LGB130D2	LGB130D5	LGB130HS	

## SET ORDERING INSTRUCTIONS

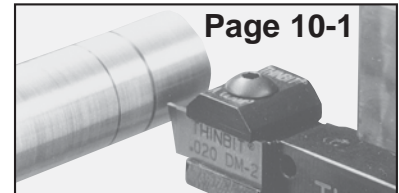
Select the **ORDER CODE** in the table below that represents your selection of insert width(s) and insert grade.

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 'L'  Section 7 Page 10-5 through 10-8	1 Each, by .001" increments Inserts Only	.064"-.084"	LSET1D2	LSET1D5	LSET1HS
		.085"-.105"	LSET2D2	LSET2D5	LSET2HS
		.106"-.125"	LSET3D2	LSET3D5	LSET3HS

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