

GROOVING SOLUTIONS MADE SIMPLE

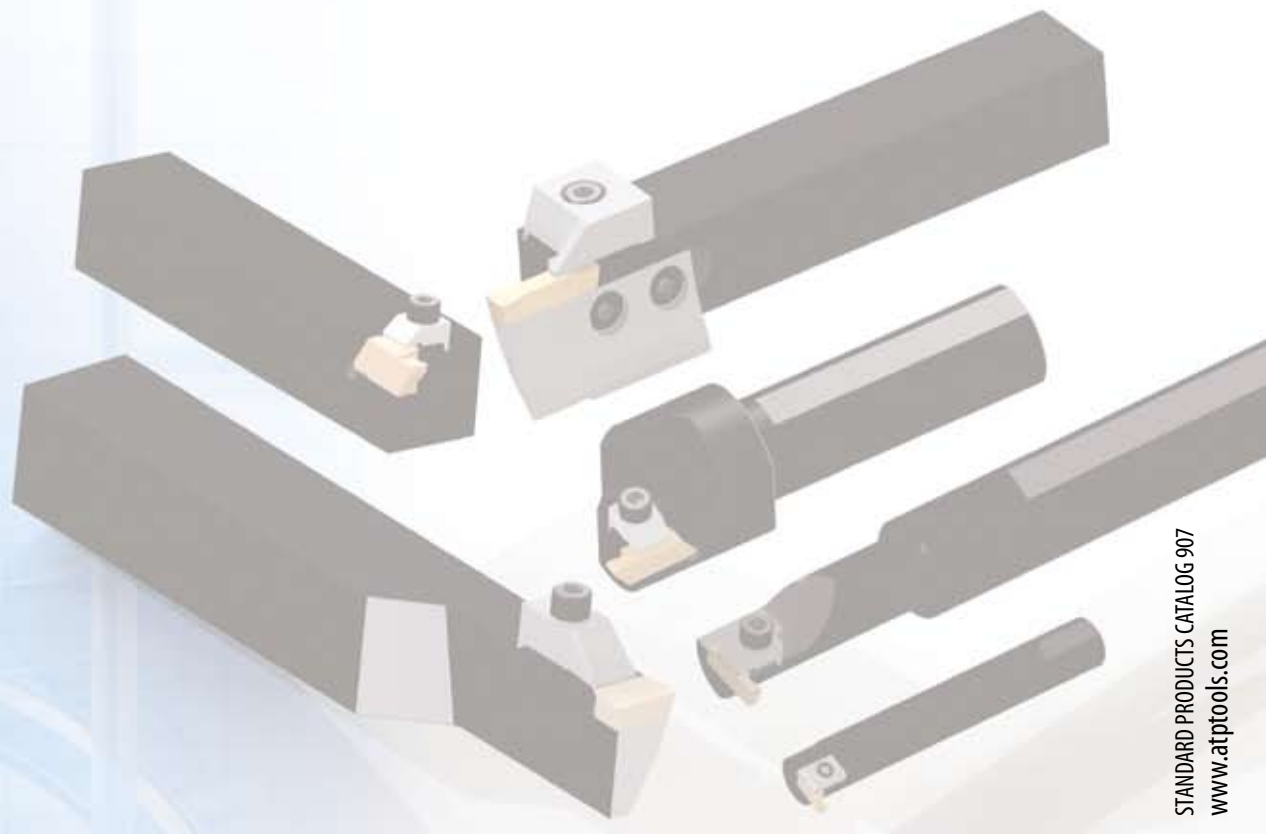


GROOVING SOLUTIONS MADE SIMPLE



STATIC AND ROTATING HIGH PERFORMANCE TOOLS

FACE GROOVING
O.D. GROOVING
I.D. GROOVING





Since 1953, Allied Tool Products has produced grooving tools for a wide range of industries and thousands of customers nationwide.

We carry many standard tools, for all applications, from our in-stock inventory. But our true strength continues to lie in our ability to solve problems and propose solutions to difficult grooving challenges.

Our experienced engineers respond quickly to your special request with a high quality concept drawing of your tool along with a competitive quote.

Allied Tool Products takes pride in providing short lead times for all specials and altered standards. In the spirit of our tradition of quality work, we are committed to providing our customers with cost-effective tooling systems, a superior level of service, and professional support in the field.

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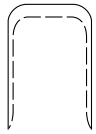
FACE GROOVING SYSTEMS

OD (EXTERNAL) GROOVING SYSTEMS

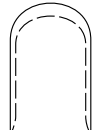
ID (INTERNAL) GROOVING SYSTEMS

FORM GRINDING – GROVE SHAPES

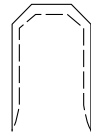
Samples of Special Insert Forms



Corner Radii



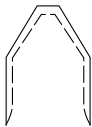
Full Ball Radius



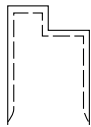
Corner Chamfer



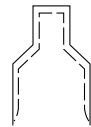
Face or Undercut



Profile



Step Groove



Groove Even Chamfers



Groove Uneven Chamfers

PRODUCTS

Samples of Standard and Special Tools

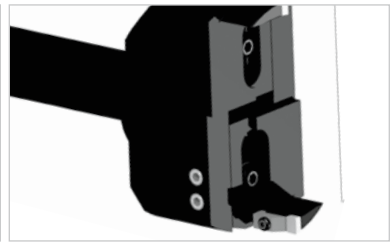
Sample A-1



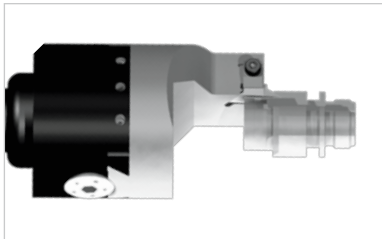
Sample A-2



Sample A-3



Sample A-4



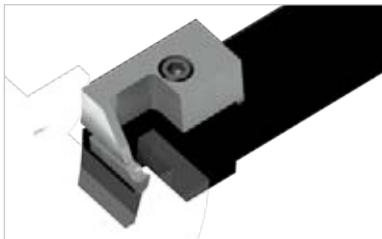
Sample A-5



Sample A-6



Sample A-7



Sample A-8



Sample A-9



PRODUCTS

Samples of Standard and Special Tools

Sample A-10



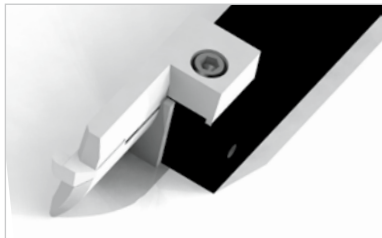
Sample A-12



Sample A-13



Sample A-14



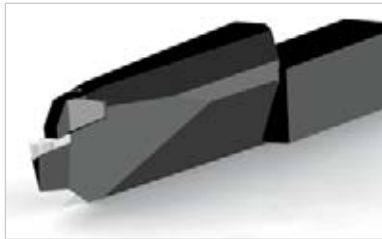
Sample A-15



Sample A-16



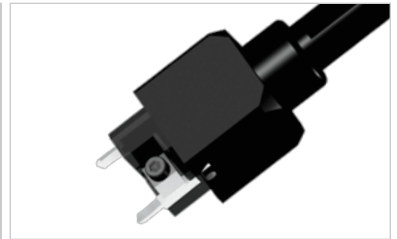
Sample A-17



Sample A-18



Sample A-19



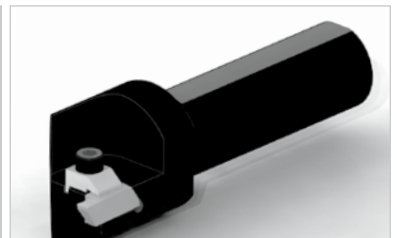
Sample A-20



Sample A-21



Sample A-22



Samples A-23



ALLIED TOOL PRODUCTS CARBIDE INSERT SELECTION CHART

INSERT DESIGNATIONS FOR CARBIDE GRADES, COATINGS AND GEOMETRIES ARE THE SAME FOR ANY APPLICATION

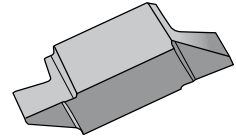
KEY: FG = (FACE GROOVING); OD = (EXTERNAL GROOVING); ID = (INTERNAL GROOVING); RH = (RIGHT HAND), LH = (LEFT HAND)

EXAMPLE: TO ORDER HG - ATLOC (RH) INSERT FOR .125" FACE GROOVE IN 316 STAINLESS STEEL,
SPECIFY: X2- HG-FG + (.125" Wide Insert No.) 13125R

INSERT DESIGNATION

HG - ATLOCK - INSERT OPTIONS: FG = (FACE GROOVING), OD = (EXTERNAL GROOVING), ID = (INTERNAL GROOVING)

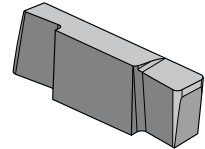
- X1-HG** GENERAL PURPOSE APPLICATIONS; GOOD IN ALL STEELS AND 400 SERIES STAINLESS STEELS
High quality FINE GRAIN carbide substrate with the Multi layer universal TiAlN coating; 6 DEGREES POSITIVE top rake
- X2-HG** STEEL ALLOYS, 300 SERIES STAINLESS STEELS, HIGH TEMP ALLOYS, TITANIUM AND NICKEL BASED ALLOYS
High quality EXTRA FINE GRAIN carbide substrate with the Multi layer universal TiAlN coating; 6 degrees positive top rake
- AL2-HG** CAST IRON, GREY IRON, COMPACTED GRAPHITE IRON
A Superior hardness carbide substrate with a special high-performance AlTiN coating with neutral 0 degrees top rake
- ZN2-HG** ALUMINUM ALLOYS, MAGNESIUM, COPPER AND ZINC ALLOYS, COMPOSITES, AND NON-FERROUS MATERIALS
An exceptional combination of EXTRA fine carbide substrate and superior ZrN coating with 12 degrees positive top rake



HG - ATLOCK

GI - ATLOCK - INSERT OPTIONS: FG = (FACE GROOVING), OD = (EXTERNAL GROOVING), ID = (INTERNAL GROOVING)

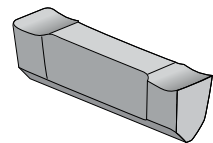
- X1-GI** GENERAL PURPOSE APPLICATIONS; GOOD IN ALL STEELS AND 400 SERIES STAINLESS STEELS
High quality FINE GRAIN carbide substrate with the Multi layer universal TiAlN coating; 6 DEGREES POSITIVE top rake
- X2-GI** STEEL ALLOYS, 300 SERIES STAINLESS STEELS, HIGH TEMP ALLOYS, TITANIUM AND NICKEL BASED ALLOYS
High quality EXTRA FINE GRAIN carbide substrate with the Multi layer universal TiAlN coating; 6 degrees positive top rake
- AL2-GI** CAST IRON, GREY IRON, COMPACTED GRAPHITE IRON
A Superior hardness carbide substrate with a special high-performance AlTiN coating with neutral 0 degrees top rake
- ZN2-GI** ALUMINUM ALLOYS, MAGNESIUM, COPPER AND ZINC ALLOYS, COMPOSITES, AND NON-FERROUS MATERIALS
An exceptional combination of EXTRA fine carbide substrate and superior ZrN coating with 12 degrees positive top rake



GI - ATLOCK

DB - INSERT OPTIONS: FG = (FACE GROOVING), OD = (EXTERNAL GROOVING), ID = (INTERNAL GROOVING)

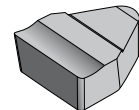
- X1-DB** GENERAL PURPOSE APPLICATIONS; GOOD IN ALL STEELS AND 400 SERIES STAINLESS STEELS
High quality FINE GRAIN carbide substrate with the Multi layer universal TiAlN coating; 6 DEGREES POSITIVE top rake
- X2-DB** STEEL ALLOYS, 300 SERIES STAINLESS STEELS, HIGH TEMP ALLOYS, TITANIUM AND NICKEL BASED ALLOYS
High quality EXTRA FINE GRAIN carbide substrate with the Multi layer universal TiAlN coating; 6 degrees positive top rake
- AL2-DB** CAST IRON, GREY IRON, COMPACTED GRAPHITE IRON
A Superior hardness carbide substrate with a special high-performance AlTiN coating with neutral 0 degrees top rake
- ZN2-DB** ALUMINUM ALLOYS, MAGNESIUM, COPPER AND ZINC ALLOYS, COMPOSITES, AND NON-FERROUS MATERIALS
An exceptional combination of EXTRA fine carbide substrate and superior ZrN coating with 12 degrees positive top rake



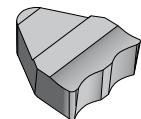
DB (DOG BONE)

GTH - HOG / GTH - DUCK FEET - INSERT OPTIONS: FG = (FACE GROOVING), OD = (EXTERNAL GROOVING)

- X1-GTH** GENERAL PURPOSE APPLICATIONS; GOOD IN ALL STEELS AND 400 SERIES STAINLESS STEELS
High quality FINE GRAIN carbide substrate with the Multi layer universal TiAlN coating; 6 DEGREES POSITIVE top rake
- X2-GTH** STEEL ALLOYS, 300 SERIES STAINLESS STEELS, HIGH TEMP ALLOYS, TITANIUM AND NICKEL BASED ALLOYS
High quality EXTRA FINE GRAIN carbide substrate with the Multi layer universal TiAlN coating; 6 degrees positive top rake
- AL2-GTH** CAST IRON, GREY IRON, COMPACTED GRAPHITE IRON
A Superior hardness carbide substrate with a special high-performance AlTiN coating with neutral 0 degrees top rake
- ZN2-GTH** ALUMINUM ALLOYS, MAGNESIUM, COPPER AND ZINC ALLOYS, COMPOSITES, AND NON-FERROUS MATERIALS
An exceptional combination of EXTRA fine carbide substrate and superior ZrN coating with 12 degrees positive top rake



GTH - HOG



GTH - DUCK FEET

TOLERANCES: UNLESS OTHERWISE SPECIFIED, INSERT TOLERANCES FOR STANDARDS AND SPECIAL FORMS: **W (WIDTH) +/- .001" ANGLES +/- 30"**

NOTE: OTHER CARBIDE GRADES, INSERT FORMS, GEOMETRIES AND COATINGS AVAILABLE PER REQUEST

Other Coatings: TiN - Very good general purpose coating for a variety of materials

TiCN - Excellent coating for multi purpose tough applications and interrupted cuts
NANO-TEK - Special NEW nanocomposite structure coating. This coating marks a breakthrough in PVD coatings for improving wear resistance in very hard work materials, 40 HRC and higher. Excellent in Titanium and Super Alloys

APPLICATION GUIDELINES

(FEEDS AN SPEEDS CHART)

MATERIAL	SFM	IPR
Carbon Steels		
Low Carbon Steels (Less than .30% C)	250 - 700	.002 - .008
Construction steel / case hardening	200 - 500	.002 - .008
High Carbon (Greater than .30% C)	120 - 400	.002 - .007
AISI 1000 & 1100 Steels	250 - 700	.002 - .008
1200 Series	200 - 700	.002 - .007
Alloy Steels		
AISI 1300, 4000	250 - 700	.002 - .008
AISI 4100 - 9000 Series	120 - 400	.002 - .006
Tool Steels		
Examples: A-2, D-2, M-2, H-13	100 - 250	.001 - .006
Stainless Steels		
Martensitic Stainless Steel 400 Series	100 - 350	.001 - .006
Austenitic Stainless Steel 300 Series	150 - 350	.002 - .006
15-5 PH, 17-4 PH	100 - 300	.002 - .006
Cast Irons		
Grey Iron	100 - 600	.002 - .006
Nodular Graphite Iron	200 - 600	.002 - .006
Malleable Cast Iron	150 - 800	.002 - .010
Aluminum / Magnesium		
Aluminum Cast Alloys > 6% Si	400 - 900	.002 - .010
Aluminum Cast Alloys < 6% Si	300 - 800	.002 - .010
Aluminum Wrought Alloys	400 - 900	.002 - .010
Magnesium Alloys	300 - 900	.002 - .010
Titanium and Nickel Alloys	100 - 250	.001 - .006
Plastics / Composites	100 - 600	.001 - .008

HG – ATLOC GROOVING SYSTEM / BUSY BODY HOLDERS

FACE GROOVING AND OD GROOVING Depth of cut: Up to .21" (5.33 mm)

This versatile system offers a superior side locking dove-tail pocket fit, an extremely rigid assembly without a support blade (anvil).

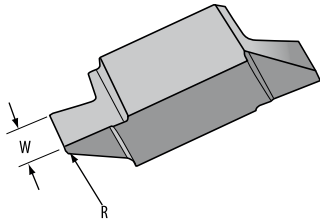
FACE GROOVING O.D. 1" (25.4 mm) DIA MINIMUM

All holders could be used interchangeably for FaceGrooving, OD Grooving Applications

HG - ATLOCK (RH) INSERTS, DOUBLE ENDED

.031" (0.79 mm) - .187" (4.75 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

HOLDER OPTIONS FOR RH (Right Hand)

END CUTTING (Square Shank)	HG 4-3RH	.25" H x .50" W x 3.0"	
	HG 6-3RH	.375" H x .50" W x 3.0"	
	HG 8-3RH	.50" SQ x 3.0"	
	HG 10-3RH	.625" SQ x 6.0"	
	HG 12-3RH	.75" SQ x 5.0"	
	HG 16-3RH	1.00" SQ x 6.0"	
	HG 20-3RH	1.25" SQ x 6.0"	
RIGHT ANGLE (Square Shank)	HGEX 4-3	.25" H x .75" W x 3.0"	
	HGEX 6-3	.375" H x .75" W x 3.0"	
	HGEX 8-3	.50" H x .75" W x 3.0"	
	HGEX 10-3	.625" H x .75" W x 3.0"	
	HGEX 12-3	.75" H x 1" W x 5.0"	
	HGEX 16-3	1.00" SQ x 6.0"	
	HGEX 20-3	1.25" SQ x 6.0"	
END CUT (Round Mount)	H5-R3 12J	Shank DIA = .75" Dia. x 4.0" Oal	
	H5-R3 16J	Shank DIA = 1.00" Dia. x 4.0" Oal	
	H5-R3 20J	Shank DIA = 1.25" Dia. x 4.0" Oal	

OD INSERTS

HG-OD ATLOCK (RH) RIGHT HAND

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
03031R	0.031	0.125
03062R	0.062	
03093R	0.093	0.187
03125R	0.125	0.210
03156R	0.156	
03187R	0.187	

OD INSERTS FULL RADIUS (BALL NOSE)

HG-OD ATLOCK (RH) RIGHT HAND

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
33031R	0.031	0.125
33062R	0.062	
33093R	0.093	0.187
33125R	0.125	0.210
33156R	0.156	
33187R	0.187	

FACE GROOVING INSERTS MIN O.D. 1" (25.4 mm)

HG-FG ATLOCK (RH) RIGHT HAND

Part Rotation Counter-Clockwise (CCW)

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
13031R	0.031	0.062
13062R	0.062	0.093
13093R	0.093	0.187
13125R	0.125	0.210
13156R	0.156	
13187R	0.187	

FACE GROOVING INSERTS MIN O.D. 1" (25.4 mm)

HG-FG ATLOCK (RH) RIGHT HAND

Part Rotation Clockwise (CW)

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
23031R	0.031	0.062
23062R	0.062	0.093
23093R	0.093	0.187
23125R	0.125	0.210
23156R	0.156	
23187R	0.187	

SPARE PARTS: CLAMP NUMBER (C-1) - SCREW NUMBER (C15)

HG – ATLOC GROOVING SYSTEM / BUSY BODY HOLDERS

FACE GROOVING AND OD GROOVING Depth of cut: Up to .21" (5.33 mm)

This versatile system offers a superior side locking dove-tail pocket fit, an extremely rigid assembly without a support blade (anvil).

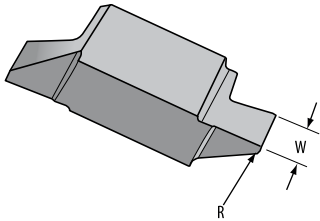
FACE GROOVING O.D. 1" (25.4 mm) DIA MINIMUM

All holders could be used interchangeably for FaceGrooving, OD Grooving Applications

HG - ATLOCK (LH) INSERTS, DOUBLE ENDED

.031" (0.79 mm) - .187" (4.75 mm) WIDE




All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

HOLDER OPTIONS FOR LH (Left Hand)

END CUTTING (Square Shank)	HG 4-3LH	.25" H x .50" W x 3.0"	
	HG 6-3LH	.375" H x .50" W x 3.0"	
	HG 8-3LH	.50" SQ x 3.0"	
	HG 10-3LH	.625" SQ x 6.0"	
	HG 12-3LH	.75" SQ x 5.0"	
	HG 16-3LH	1.00" SQ x 6.0"	
	HG 20-3LH	1.25" SQ x 6.0"	
RIGHT ANGLE (Square Shank)	HGIN 4-3	.25" H x .75" W x 3.0"	
	HGIN 6-3	.375" H x .75" W x 3.0"	
	HGIN 8-3	.50" H x .75" W x 3.0"	
	HGIN 10-3	.625" H x .75" W x 3.0"	
	HGIN 12-3	.75" H x 1" W x 5.0"	
	HGIN 16-3	1.00" SQ x 6.0"	
	HGIN 20-3	1.25" SQ x 6.0"	
END CUT (Round Mount)	H5-L3 12J	Shank DIA = .75" Dia. x 4.0" Oal	
	H5-L3 16J	Shank DIA = 1.00" Dia. x 4.0" Oal	
	H5-L3 20J	Shank DIA = 1.25" Dia. x 4.0" Oal	

OD INSERTS

HG-OD ATLOCK (LH) LEFT HAND

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
03031L	0.031	0.125
03062L	0.062	
03093L	0.093	0.187
03125L	0.125	0.210
03156L	0.156	
03187L	0.187	

OD INSERTS FULL RADIUS (BALL NOSE)

HG-OD ATLOCK (LH) LEFT HAND

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
33031L	0.031	0.125
33062L	0.062	
33093L	0.093	0.187
33125L	0.125	0.210
33156L	0.156	
33187L	0.187	

FACE GROOVING INSERTS MIN O.D. 1" (25.4 mm)

HG-FG ATLOCK (LH) LEFT HAND

Part Rotation Counter-Clockwise (CCW)

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
13031L	0.031	0.062
13062L	0.062	0.093
13093L	0.093	0.187
13125L	0.125	0.210
13156L	0.156	
13187L	0.187	

FACE GROOVING INSERTS MIN O.D. 1" (25.4 mm)

HG-FG ATLOCK (LH) LEFT HAND

Part Rotation Clockwise (CW)

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
23031L	0.031	0.062
23062L	0.062	0.093
23093L	0.093	0.187
23125L	0.125	0.210
23156L	0.156	
23187L	0.187	

SPARE PARTS: CLAMP NUMBER (C-1) - SCREW NUMBER (C1S)

HG – ATLOC GROOVING SYSTEM / BUSY BODY HOLDERS

FACE GROOVING AND OD GROOVING Depth of cut: Up to .31" (7.87 mm)

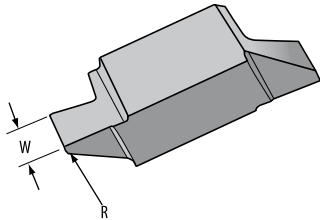
This versatile system offers a superior side locking dove-tail pocket fit, an extremely rigid assembly without a support blade (anvil).

FACE GROOVING O.D. 1" (25.4 mm) DIA MINIMUM

All holders could be used interchangeably for FaceGrooving, OD Grooving Applications

HG - ATLOCK (RH) INSERTS, DOUBLE ENDED




.031" (0.79 mm) - .250" (6.35 mm) WIDE
All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

HOLDER OPTIONS FOR RH (Right Hand)

END CUTTING (Square Shank)	HG 12-4RH	.75" SQ x 5.0"	
	HG 16-4RH	1.00" SQ x 6.0"	
	HG 20-4RH	1.25" SQ x 6.0"	
RIGHT ANGLE (Square Shank)	HGEX 12-4	.75" H x 1.00" W x 5.0"	
	HGEX 16-4	1.00" SQ x 6.0"	
	HGEX 20-4	1.25" SQ x 6.0"	
END CUT (Round Mount)	H5-R4 16J	Shank DIA = 1.00" x 4.0" Oal	
	H5-R4 20J	Shank DIA = 1.25" x 4.0" Oal	
	H5-R4 24J	Shank DIA = 1.50" x 4.0" Oal	

OD INSERTS

HG-OD ATLOCK (RH) RIGHT HAND

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
04062R	0.062	0.310
04093R	0.093	
04125R	0.125	
04156R	0.156	
04187R	0.187	
04218R	0.218	
04250R	0.250	

OD INSERTS FULL RADIUS (BALL NOSE)

HG-OD ATLOCK (RH) RIGHT HAND

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
34062R	0.062	0.310
34093R	0.093	
34125R	0.125	
34156R	0.156	
34187R	0.187	
34218R	0.218	
34250R	0.250	

FACE GROOVING INSERTS MIN O.D. 1" (25.4 mm)

HG-FG ATLOCK (RH) RIGHT HAND

Part Rotation Counter-Clockwise (CCW)

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
14062R	0.062	0.093
14093R	0.093	0.125
14125R	0.125	0.250
14156R	0.156	0.310
14187R	0.187	
14218R	0.218	
14250R	0.250	

FACE GROOVING INSERTS MIN O.D. 1" (25.4 mm)

HG-FG ATLOCK (RH) RIGHT HAND

Part Rotation Clockwise (CW)

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
24062R	0.062	0.093
24093R	0.093	0.125
24125R	0.125	0.250
24156R	0.156	0.310
24187R	0.187	
24218R	0.218	
24250R	0.250	

SPARE PARTS: CLAMP NUMBER (C-1) - SCREW NUMBER (C15)

HG – ATLOC GROOVING SYSTEM / BUSY BODY HOLDERS

FACE GROOVING AND OD GROOVING Depth of cut: Up to .31" (7.87 mm)

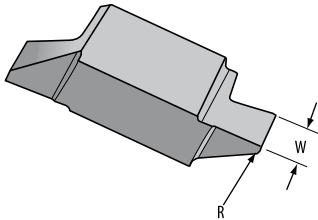
This versatile system offers a superior side locking dove-tail pocket fit, an extremely rigid assembly without a support blade (anvil).

FACE GROOVING O.D. 1" (25.4 mm) DIA MINIMUM

All holders could be used interchangeably for FaceGrooving, OD Grooving Applications

HG - ATLOCK (LH) INSERTS, DOUBLE ENDED




.031" (0.79 mm) - .250" (6.35 mm) WIDE
All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

HOLDER OPTIONS FOR LH (Left Hand)

END CUTTING (Square Shank)	HG 12-4LH	.75" SQ x 5.0"	
	HG 16-4LH	1.00" SQ x 6.0"	
	HG 20-4LH	1.25" SQ x 6.0"	
RIGHT ANGLE (Square Shank)	HGIN 12-4	.75" H x 1.00" W x 5.0"	
	HGIN 16-4	1.00" SQ x 6.0"	
	HGIN 20-4	1.25" SQ x 6.0"	
END CUT (Round Mount)	H5-L4 16J	Shank DIA = 1.00" x 4.0" Oal	
	H5-L4 20J	Shank DIA = 1.25" x 4.0" Oal	
	H5-L4 24J	Shank DIA = 1.50" x 4.0" Oal	

OD INSERTS

HG-OD ATLOCK (LH) LEFT HAND

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
04062L	0.062	0.310
04093L	0.093	
04125L	0.125	
04156L	0.156	
04187L	0.187	
04218L	0.218	
04250L	0.250	

OD INSERTS FULL RADIUS (BALL NOSE)

HG-OD ATLOCK (LH) LEFT HAND

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
34062L	0.062	0.310
34093L	0.093	
34125L	0.125	
34156L	0.156	
34187L	0.187	
34218L	0.218	
34250L	0.250	

FACE GROOVING INSERTS MIN O.D. 1" (25.4 mm)

HG-FG ATLOCK (LH) LEFT HAND

Part Rotation Counter-Clockwise (CCW)

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
14062L	0.062	0.093
14093L	0.093	0.125
14125L	0.125	0.250
14156L	0.156	0.310
14187L	0.187	
14218L	0.218	
14250L	0.250	

FACE GROOVING INSERTS MIN O.D. 1" (25.4 mm)

HG-FG ATLOCK (LH) LEFT HAND

Part Rotation Clockwise (CW)

INSERT NUMBER	WIDTH (INCH)	MAX DEPTH OF CUT
24062L	0.062	0.093
24093L	0.093	0.125
24125L	0.125	0.250
24156L	0.156	0.310
24187L	0.187	
24218L	0.218	
24250L	0.250	

SPARE PARTS: CLAMP NUMBER (C-1) - SCREW NUMBER (C1S)

M5 SYSTEM – FACE GROOVING

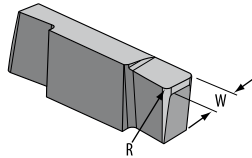
OD RANGE 1.0" (25.4mm) and GREATER
Depth of cut: Up to .210" (5.33 mm))

M5 SYSTEM offers a superior side locking dove-tail pocket fit, an extremely rigid assembly without a support blade (anvil).

GI-FG-M5 ATLOCK INSERTS, DOUBLE ENDED

.062" (1.57 mm) - .250" (6.35 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

HOLDER OPTIONS FOR RH (Right Hand)



DIA x 3.5" OAL

HOLDER BODY INCLUDES CLAMPS AND CLAMP SCREWS

PART ROTATION - COUNTER-CLOCKWISE (CCW)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA
1MRJ02	0.062	.125"	M5-R1-05J	.500"	M5-R1-06J	.625"	M5-R1-07J	.750"	M5-R1-10J	1.00"
1MRJ03	0.093	.156"								
1MRJ04	0.125	.210"								
1MRJ05	0.156	.210"	M5-R2-05J	.500"	M5-R2-06J	.625"	M5-R2-07J	.750"	M5-R2-10J	1.00"
1MRJ06	0.187									
1MRJ07	0.218	.210"	M5-R3-05J	.500"	M5-R3-06J	.625"	M5-R3-07J	.750"	M5-R3-10J	1.00"
1MRJ08	0.250									

PART ROTATION - CLOCKWISE (CW)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA
2MRJ02	0.062	.125"	M5-R1-05J	.500"	M5-R1-06J	.625"	M5-R1-07J	.750"	M5-R1-10J	1.00"
2MRJ03	0.093	.156"								
2MRJ04	0.125	.210"								
2MRJ05	0.156	.210"	M5-R2-05J	.500"	M5-R2-06J	.625"	M5-R2-07J	.750"	M5-R2-10J	1.00"
2MRJ06	0.187									
2MRJ07	0.218	.210"	M5-R3-05J	.500"	M5-R3-06J	.625"	M5-R3-07J	.750"	M5-R3-10J	1.00"
2MRJ08	0.250									

SPARE PARTS:

CLAMP (C1) - SCREW (C1S)

M5 SYSTEM – FACE GROOVING

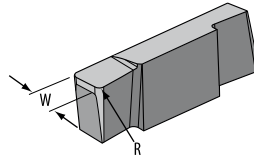
OD RANGE 1" (25.4mm) AND GREATER
Depth of cut: Up to .210" (5.33 mm))

M5 SYSTEM offers a superior side locking dove-tail pocket fit, an extremely rigid assembly without a support blade (anvil).

GI-FG-M5 ATLOCK INSERTS, DOUBLE ENDED

.062" (1.57 mm) - .250" (6.35 mm) WIDE

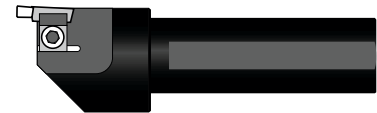
All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

HOLDER OPTIONS FOR LH (Left Hand)



DIA x 3.5" OAL

HOLDER BODY INCLUDES CLAMPS AND CLAMP SCREWS

PART ROTATION - COUNTER-CLOCKWISE (CCW)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA
1MLJ02	0.062	.125"	M5-L1-05J	.500"	M5-L1-06J	.625"	M5-L1-07J	.750"	M5-L1-10J	1.00"
1MLJ03	0.093	.156"								
1MLJ04	0.125	.210"								
1MLJ05	0.156	.210"	M5-L2-05J	.500"	M5-L2-06J	.625"	M5-L2-07J	.750"	M5-L2-10J	1.00"
1MLJ06	0.187									
1MLJ07	0.218	.210"	M5-L3-05J	.500"	M5-L3-06J	.625"	M5-L3-07J	.750"	M5-L3-10J	1.00"
1MLJ08	0.250									

PART ROTATION - CLOCKWISE (CW)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA	HOLDER NO.	SHANK DIA
2MLJ02	0.062	.125"	M5-L1-05J	.500"	M5-L1-06J	.625"	M5-L1-07J	.750"	M5-L1-10J	1.00"
2MLJ03	0.093	.156"								
2MLJ04	0.125	.210"								
2MLJ05	0.156	.210"	M5-L2-05J	.500"	M5-L2-06J	.625"	M5-L2-07J	.750"	M5-L2-10J	1.00"
2MLJ06	0.187									
2MLJ07	0.218	.210"	M5-L3-05J	.500"	M5-L3-06J	.625"	M5-L3-07J	.750"	M5-L3-10J	1.00"
2MLJ08	0.250									

SPARE PARTS:

CLAMP (C1) • SCREW (C1S)

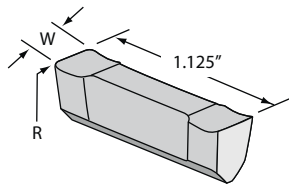
DB SERIES – Face Grooving System for Deep Grooves

OD Range: 1.875" (47.6 mm) and Greater
Depth of Cut: Up to .5" (12.7 mm)

V-Base Insert provides maximum stability and rigidity in Deep Grooving Applications.

DB-FG: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
 All standard inserts come with .008" (0.2 mm) RAD.



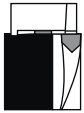
Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Holder Body Options for RH (Right Hand)

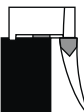
END CUTTING (Square Shank)	DB7-1-5-16R	1" SQ x 6"	
	DB7-1-5-20R	1.25" SQ x 7"	
	DB7-1-5-24R	1.5" SQ x 7"	
RIGHT ANGLE (Square Shank)	DB8-1-5-165	1"H x 1.25 W x 7"	
	DB8-1-5-205	1.25" SQ x 7"	
	DB8-1-5-245	1.50" SQ x 7"	
END CUT (Round Mount)	DB9-1-5-24R	D = 1.50" x 8.5" Long	
	DB9-1-5-32R	D = 2.00" x 8.5" Long	
	DB9-1-5-40R	D = 2.50" x 8.5" Long	

Holder Bodies include anvil and clamp screws.



Right Hand Anvils (Support Blades) • 0.5" Depth • Curve In • Counter-Clockwise Rotation (CCW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875–2.375	2.376–3.125	3.126–4.50	4.501–7.00			7.001–14	14.001 +	
DB1104	0.125	DBA-1104	DBA-1204	DBA-1304	DBA-1404	DB1504	0.125	DBA-1504	DBA-1604	CR1-1-E04
DB1105	0.156	DBA-1105	DBA-1205	DBA-1305	DBA-1405	DB1505	0.156	DBA-1505	DBA-1605	CR1-1-E06
DB1106	0.187					DB1506	0.187			
DB1107	0.218	DBA-1107	DBA-1207	DBA-1307	DBA-1407	DB1507	0.218	DBA-1507	DBA-1607	CR1-1-E07
DB1108	0.250					DB1508	0.250			
DB1109	0.281	DBA-1109	DBA-1209	DBA-1309		DB1509	0.281	DBA-1509		CR1-1-E09
DB1110	0.312					DB1510	0.312			
DB1111	0.343	DBA-1111	DBA-1211	DBA-1311		DB1511	0.343	DBA-1511		CR1-1-E11
DB1112	0.375					DB1512	0.375			



Right Hand Anvils (Support Blades) • 0.5" Depth • Curve Out • Clockwise Rotation (CW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875–2.375	2.376–3.125	3.126–4.50	4.501–7.00			7.001–14	14.001 +	
DB2104	0.125	DBA-2104	DBA-2204	DBA-2304	DBA-2404	DB2504	0.125	DBA-2504	DBA-2604	CR1-1-E04
DB2105	0.156	DBA-2105	DBA-2205	DBA-2305	DBA-2405	DB2505	0.156	DBA-2505	DBA-2605	CR1-1-E06
DB2106	0.187					DB2506	0.187			
DB2107	0.218	DBA-2107	DBA-2207	DBA-2307	DBA-2407	DB2507	0.218	DBA-2507	DBA-2607	CR1-1-E07
DB2108	0.250					DB2508	0.250			
DB2109	0.281	DBA-2109	DBA-2209	DBA-2309		DB2509	0.281	DBA-2509		CR1-1-E09
DB2110	0.312					DB2510	0.312			
DB2111	0.343	DBA-2111	DBA-2211	DBA-2311		DB2511	0.343	DBA-2511		CR1-1-E11
DB2112	0.375					DB2512	0.375			

Spare Parts: Anvil Screws (DAS-41) • Clamp Screws (DCS)

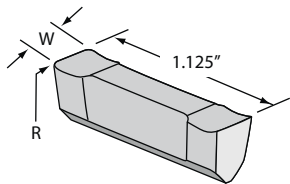
DB SERIES – Face Grooving System for Deep Grooves

OD Range: 1.875" (47.6 mm) and Greater
Depth of Cut: Up to .5" (12.7 mm)

V-Base Insert provides maximum stability and rigidity in Deep Grooving Applications.

DB-FG: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
 All standard inserts come with .008" (0.2 mm) RAD.



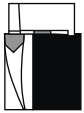
Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Holder Body Options for LH (Left Hand)

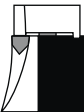
END CUTTING (Square Shank)			
DB7-1-5-16L	1" SQ x 6"		
DB7-1-5-20L	1.25" SQ x 7"		
DB7-1-5-24L	1.5" SQ x 7"		
RIGHT ANGLE (Square Shank)			
DB8-1-5-160	1"H x 1.25 W x 7"		
DB8-1-5-200	1.25" SQ x 7"		
DB8-1-5-240	1.50" SQ x 7"		
END CUT (Round Mount)			
DB9-1-5-24L	D = 1.50" x 8.5" Long		
DB9-1-5-32L	D = 2.00" x 8.5" Long		
DB9-1-5-40L	D = 2.50" x 8.5" Long		

Holder Bodies include anvil and clamp screws.



Left Hand Anvils (Support Blades) • 0.5" Depth • Curve In • Clockwise Rotation (CW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875–2.375	2.376–3.125	3.126–4.50	4.501–7.00			7.001–14	14.001 +	
DB5104	0.125	DBA-5104	DBA-5204	DBA-5304	DBA-5404	DB5504	0.125	DBA-5504	DBA-5604	CL1-1-E04
DB5105	0.156	DBA-5105	DBA-5205	DBA-5305	DBA-5405	DB5505	0.156	DBA-5505	DBA-5605	CL1-1-E06
DB5106	0.187					DB5506	0.187			
DB5107	0.218	DBA-5107	DBA-5207	DBA-5307	DBA-5407	DB5507	0.218	DBA-5507	DBA-5607	CL1-1-E07
DB5108	0.250					DB5508	0.250			
DB5109	0.281	DBA-5109	DBA-5209	DBA-5309		DB5509	0.281	DBA-5509		CL1-1-E09
DB5110	0.312					DB5510	0.312			
DB5111	0.343	DBA-5111	DBA-5211	DBA-5311		DB5511	0.343	DBA-5511		CL1-1-E11
DB5112	0.375					DB5512	0.375			



Left Hand Anvils (Support Blades) • 0.5" Depth • Curve Out • Counter-Clockwise Rotation (CCW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875–2.375	2.376–3.125	3.126–4.50	4.501–7.00			7.001–14	14.001 +	
DB6104	0.125	DBA-6104	DBA-6204	DBA-6304	DBA-6404	DB6504	0.125	DBA-6504	DBA-6604	CL1-1-E04
DB6105	0.156	DBA-6105	DBA-6205	DBA-6305	DBA-6405	DB6505	0.156	DBA-6505	DBA-6605	CL1-1-E06
DB6106	0.187					DB6506	0.187			
DB6107	0.218	DBA-6107	DBA-6207	DBA-6307	DBA-6407	DB6507	0.218	DBA-6507	DBA-6607	CL1-1-E07
DB6108	0.250					DB6508	0.250			
DB6109	0.281	DBA-6109	DBA-6209	DBA-6309		DB6509	0.281	DBA-6509		CL1-1-E09
DB6110	0.312					DB6510	0.312			
DB6111	0.343	DBA-6111	DBA-6211	DBA-6311		DB6511	0.343	DBA-6511		CL1-1-E11
DB6112	0.375					DB6512	0.375			

Spare Parts: Anvil Screws (DAS-41) • Clamp Screws (DCS)

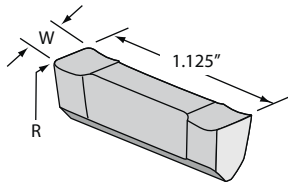
DB SERIES – Face Grooving System for Deep Grooves

OD Range: 1.875" (47.6 mm) and Greater
Depth of Cut: Up to .75" (19.05 mm)

V-Base Insert provides maximum stability and rigidity in Deep Grooving Applications.

DB-FG: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
 All standard inserts come with .008" (0.2 mm) RAD.



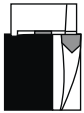
Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Holder Body Options for RH (Right Hand)

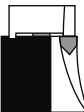
END CUTTING (Square Shank)	DB7-1-7-16R	1" SQ x 6"	
	DB7-1-7-20R	1.25" SQ x 7"	
	DB7-1-7-24R	1.5" SQ x 7"	
RIGHT ANGLE (Square Shank)	DB8-1-7-165	1"H x 1.25 W x 7"	
	DB8-1-7-205	1.25" SQ x 7"	
	DB8-1-7-245	1.50" SQ x 7"	
END CUT (Round Mount)	DB9-1-7-24R	D = 1.50" x 8.5" Long	
	DB9-1-7-32R	D = 2.00" x 8.5" Long	
	DB9-1-7-40R	D = 2.50" x 8.5" Long	

Holder Bodies include anvil and clamp screws.



Right Hand Anvils (Support Blades) • 0.75" Depth • Curve In • Counter-Clockwise Rotation (CCW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875–2.375	2.376–3.125	3.126–4.50	4.501–7.00			7.001–14	14.001 +	
DB1104	0.125	DBA-3104	DBA-3204	DBA-3304	DBA-3404	DB1504	0.125	DBA-3504	DBA-3604	CR1-1-E04A
DB1105	0.156	DBA-3105	DBA-3205	DBA-3305	DBA-3405	DB1505	0.156	DBA-3505	DBA-3605	CR1-1-E06A
DB1106	0.187					DB1506	0.187			
DB1107	0.218	DBA-3107	DBA-3207	DBA-3307	DBA-3407	DB1507	0.218	DBA-3507	DBA-3607	CR1-1-E07A
DB1108	0.250					DB1508	0.250			
DB1109	0.281	DBA-3109	DBA-3209	DBA-3309		DB1509	0.281	DBA-3509		CR1-1-E09A
DB1110	0.312					DB1510	0.312			
DB1111	0.343	DBA-3111	DBA-3211	DBA-3311		DB1511	0.343	DBA-3511		CR1-1-E11A
DB1112	0.375					DB1512	0.375			



Right Hand Anvils (Support Blades) • 0.75" Depth • Curve Out • Clockwise Rotation (CW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875–2.375	2.376–3.125	3.126–4.50	4.501–7.00			7.001–14	14.001 +	
DB2104	0.125	DBA-4104	DBA-4204	DBA-4304	DBA-4404	DB2504	0.125	DBA-4504	DBA-4604	CR1-1-E04A
DB2105	0.156	DBA-4105	DBA-4205	DBA-4305	DBA-4405	DB2505	0.156	DBA-4505	DBA-4605	CR1-1-E06A
DB2106	0.187					DB2506	0.187			
DB2107	0.218	DBA-4107	DBA-4207	DBA-4307	DBA-4407	DB2507	0.218	DBA-4507	DBA-4607	CR1-1-E07A
DB2108	0.250					DB2508	0.250			
DB2109	0.281	DBA-4109	DBA-4209	DBA-4309		DB2509	0.281	DBA-4509		CR1-1-E09A
DB2110	0.312					DB2510	0.312			
DB2111	0.343	DBA-4111	DBA-4211	DBA-4311		DB2511	0.343	DBA-4511		CR1-1-E11A
DB2112	0.375					DB2512	0.375			

Spare Parts: Anvil Screws (DAS-41) • Clamp Screws (DCS)

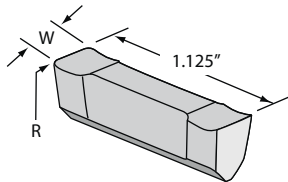
DB SERIES – Face Grooving System for Deep Grooves

OD Range: 1.875" (47.6 mm) and Greater
Depth of Cut: Up to .75" (19.05 mm)

V-Base Insert provides maximum stability and rigidity in Deep Grooving Applications.

DB-FG: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
 All standard inserts come with .008" (0.2 mm) RAD.



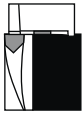
Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Holder Body Options for LH (Left Hand)

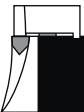
END CUTTING (Square Shank)	DB7-1-7-16L	1" SQ x 6"	
	DB7-1-7-20L	1.25" SQ x 7"	
	DB7-1-7-24L	1.5" SQ x 7"	
RIGHT ANGLE (Square Shank)	DB8-1-7-160	1"H x 1.25 W x 7"	
	DB8-1-7-200	1.25" SQ x 7"	
	DB8-1-7-240	1.50" SQ x 7"	
END CUT (Round Mount)	DB9-1-7-24L	D = 1.50" x 8.5" Long	
	DB9-1-7-32L	D = 2.00" x 8.5" Long	
	DB9-1-7-40L	D = 2.50" x 8.5" Long	

Holder Bodies include anvil and clamp screws.



Left Hand Anvils (Support Blades) • 0.75" Depth • Curve In • Clockwise Rotation (CW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875–2.375	2.376–3.125	3.126–4.50	4.501–7.00			7.001–14	14.001 +	
DB5104	0.125	DBA-7104	DBA-7204	DBA-7304	DBA-7404	DB5504	0.125	DBA-7504	DBA-7604	CL1-1-E04A
DB5105	0.156	DBA-7105	DBA-7205	DBA-7305	DBA-7405	DB5505	0.156	DBA-7505	DBA-7605	CL1-1-E06A
DB5106	0.187					DB5506	0.187			
DB5107	0.218	DBA-7107	DBA-7207	DBA-7307	DBA-7407	DB5507	0.218	DBA-7507	DBA-7607	CL1-1-E07A
DB5108	0.250					DB5508	0.250			
DB5109	0.281	DBA-7109	DBA-7209	DBA-7309		DB5509	0.281	DBA-7509		CL1-1-E09A
DB5110	0.312					DB5510	0.312			
DB5111	0.343	DBA-7111	DBA-7211	DBA-7311		DB5511	0.343	DBA-7511		CL1-1-E11A
DB5112	0.375					DB5512	0.375			



Left Hand Anvils (Support Blades) • 0.75" Depth • Curve Out • Counter-Clockwise Rotation (CCW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875 - 2.375	2.376 - 3.125	3.126 - 4.50	4.501 - 7.00			7.001 - 14	14.001 +	
DB6104	0.125	DBA-8104	DBA-8204	DBA-8304	DBA-8404	DB6504	0.125	DBA-8504	DBA-8604	CL1-1-E04A
DB6105	0.156	DBA-8105	DBA-8205	DBA-8305	DBA-8405	DB6505	0.156	DBA-8505	DBA-8605	CL1-1-E06A
DB6106	0.187					DB6506	0.187			
DB6107	0.218	DBA-8107	DBA-8207	DBA-8307	DBA-8407	DB6507	0.218	DBA-8507	DBA-8607	CL1-1-E07A
DB6108	0.250					DB6508	0.250			
DB6109	0.281	DBA-8109	DBA-8209	DBA-8309		DB6509	0.281	DBA-8509		CL1-1-E09A
DB6110	0.312					DB6510	0.312			
DB6111	0.343	DBA-8111	DBA-8211	DBA-8311		DB6511	0.343	DBA-8511		CL1-1-E11A
DB6112	0.375					DB6512	0.375			

Spare Parts: Anvil Screws (DAS-41) • Clamp Screws (DCS)

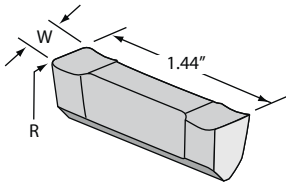
DB SERIES – Face Grooving System for Deep Grooves

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Depth of Cut: Up to 1.00" (25.4 mm)

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DB-FG: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
 All standard inserts come with .008" (0.2 mm) RAD.



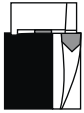
Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Holder Body Options for RH (Right Hand)

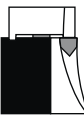
END CUTTING (Square Shank)	DB7-1-1-16R	1" SQ x 6"	
	DB7-1-1-20R	1.25" SQ x 7"	
	DB7-1-1-24R	1.5" SQ x 7"	
RIGHT ANGLE (Square Shank)	DB8-1-1-165	1"H x 1.25 W x 7"	
	DB8-1-1-205	1.25" SQ x 7"	
	DB8-1-1-245	1.50" SQ x 7"	
END CUT (Round Mount)	DB9-1-1-24R	D = 1.50" x 8.5" Long	
	DB9-1-1-32R	D = 2.00" x 8.5" Long	
	DB9-1-1-40R	D = 2.50" x 8.5" Long	

Holder Bodies include anvil and clamp screws.



Right Hand Anvils (Support Blades) • 1.00" Depth • Curve In • Counter-Clockwise Rotation (CCW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875–2.375	2.376–3.125	3.126–4.50	4.501–7.00			7.001–14	14.001 +	
1DB1104	0.125	1DBA-3104	1DBA-3204	1DBA-3304	1DBA-3404	1DB1504	0.125	1DBA-3504	1DBA-3604	CR2-1-H04
1DB1105	0.156	1DBA-3105	1DBA-3205	1DBA-3305	1DBA-3405	1DB1505	0.156	1DBA-3505	1DBA-3605	CR2-1-H06
1DB1106	0.187	1DBA-3106	1DBA-3206	1DBA-3306	1DBA-3406	1DB1506	0.187	1DBA-3506	1DBA-3606	
1DB1108	0.250	1DBA-3108	1DBA-3208	1DBA-3308	1DBA-3408	1DB1508	0.250	1DBA-3508	1DBA-3608	CR2-1-H07
1DB1110	0.312	1DBA-3110	1DBA-3210	1DBA-3310	1DBA-3410	1DB1510	0.312	1DBA-3510	1DBA-3510	CR2-1-H09
1DB1112	0.375	1DBA-3112	1DBA-3212	1DBA-3312	1DBA-3412	1DB1512	0.375	1DBA-3512	1DBA-3512	CR2-1-H11



Right Hand Anvils (Support Blades) • 1.00" Depth • Curve Out • Clockwise Rotation (CW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875–2.375	2.376–3.125	3.126–4.50	4.501–7.00			7.001–14	14.001 +	
1DB2104	0.125	1DBA-4104	1DBA-4204	1DBA-4304	1DBA-4404	1DB2504	0.125	1DBA-4504	1DBA-4604	CR2-1-H04
1DB2105	0.156	1DBA-4105	1DBA-4205	1DBA-4305	1DBA-4405	1DB2505	0.156	1DBA-4505	1DBA-4605	CR2-1-H06
1DB2106	0.187	1DBA-4106	1DBA-4206	1DBA-4306	1DBA-4406	1DB2506	0.187	1DBA-4506	1DBA-4606	
1DB2108	0.250	1DBA-4108	1DBA-4208	1DBA-4308	1DBA-4408	1DB2508	0.250	1DBA-4508	1DBA-4608	CR2-1-H07
1DB2110	0.312	1DBA-4110	1DBA-4210	1DBA-4310	1DBA-4410	1DB2510	0.312	1DBA-4510	1DBA-4510	CR2-1-H09
1DB2112	0.375	1DBA-4112	1DBA-4212	1DBA-4312	1DBA-4412	1DB2512	0.375	1DBA-4512	1DBA-4512	CR2-1-H11

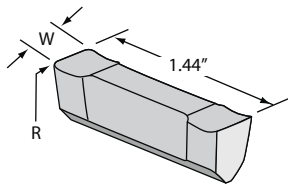
DB SERIES – Face Grooving System for Deep Grooves

OD Range: 1.875" (47.6 mm) and Greater
Depth of Cut: Up to 1.00" (25.4 mm)

V-Base Insert provides maximum stability and rigidity in Deep Grooving Applications.

DB-FG: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
 All standard inserts come with .008" (0.2 mm) RAD.



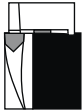
Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Holder Body Options for LH (Left Hand)

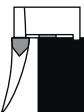
END CUTTING (Square Shank)	DB7-1-1-16L	1" SQ x 6"	
	DB7-1-1-20L	1.25" SQ x 7"	
	DB7-1-1-24L	1.5" SQ x 7"	
RIGHT ANGLE (Square Shank)	DB8-1-1-160	1"H x 1.25 W x 7"	
	DB8-1-1-200	1.25" SQ x 7"	
	DB8-1-1-240	1.50" SQ x 7"	
END CUT (Round Mount)	DB9-1-1-24L	D = 1.50" x 8.5" Long	
	DB9-1-1-32L	D = 2.00" x 8.5" Long	
	DB9-1-1-40L	D = 2.50" x 8.5" Long	

Holder Bodies include anvil and clamp screws.



Left Hand Anvils (Support Blades) • 1.00" Depth • Curve In • Clockwise Rotation (CW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875–2.375	2.376–3.125	3.126–4.50	4.501–7.00			7.001–14	14.001 +	
1DB5104	0.125	1DBA-7104	1DBA-7204	1DBA-7304	1DBA-7404	1DB5504	0.125	1DBA-7504	1DBA-7604	CL2-1-H04
1DB5105	0.156	1DBA-7105	1DBA-7205	1DBA-7305	1DBA-7405	1DB5505	0.156	1DBA-7505	1DBA-7605	
1DB5106	0.187	1DBA-7106	1DBA-7206	1DBA-7306	1DBA-7406	1DB5506	0.187	1DBA-7506	1DBA-7606	CL2-1-H06
1DB5108	0.250	1DBA-7108	1DBA-7208	1DBA-7308	1DBA-7408	1DB5508	0.250	1DBA-7508	1DBA-7608	
1DB5110	0.312	1DBA-7110	1DBA-7210	1DBA-7310	1DBA-7410	1DB5510	0.312	1DBA-7510	1DBA-7510	CL2-1-H09
1DB5112	0.375	1DBA-7112	1DBA-7212	1DBA-7312	1DBA-7412	1DB5512	0.375	1DBA-7512	1DBA-7512	CL2-1-H11



Left Hand Anvils (Support Blades) • 1.00" Depth • Curve Out • Counter-Clockwise Rotation (CCW)

INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE				INSERTS	WIDTH (INCH)	ANVILS O.D. RANGE		CLAMPS
		1.875–2.375	2.376–3.125	3.126–4.50	4.501–7.00			7.001–14	14.001 +	
1DB6104	0.125	1DBA-8104	1DBA-8204	1DBA-8304	1DBA-8404	1DB6504	0.125	1DBA-8504	1DBA-8604	CL2-1-H04
1DB6105	0.156	1DBA-8105	1DBA-8205	1DBA-8305	1DBA-8405	1DB6505	0.156	1DBA-8505	1DBA-8605	
1DB6106	0.187	1DBA-8106	1DBA-8206	1DBA-8306	1DBA-8406	1DB6506	0.187	1DBA-8506	1DBA-8606	CL2-1-H06
1DB6108	0.250	1DBA-8108	1DBA-8208	1DBA-8308	1DBA-8408	1DB6508	0.250	1DBA-8508	1DBA-8608	
1DB6110	0.312	1DBA-8110	1DBA-8210	1DBA-8310	1DBA-8410	1DB6510	0.312	1DBA-8510	1DBA-8510	CL2-1-H09
1DB6112	0.375	1DBA-8112	1DBA-8212	1DBA-8312	1DBA-8412	1DB6512	0.375	1DBA-8512	1DBA-8512	CL2-1-H11

GTH – HOG (HEAVY) GROOVING SYSTEM

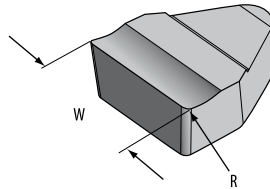
FACE GROOVING AND OD GROOVING OF EXTRA WIDE AND DEEP GROOVES
DEPTH OF CUT UP TO 2.0" (50.8 mm)

GTH - HOG is a heavy duty versatile system designed for high rate of material removal, roughing and finishing operations.

GTH-FG INSERTS

.250" (6.35 mm) - .500" (12.70 mm) WIDE
 All standard inserts come with .02" (0.51mm) RAD.

(FACE GROOVING OD 6" DIA MINIMUM)

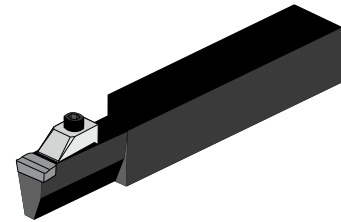


INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	GROOVE DEPTH	HOLDER NO.	CLAMP	CLAMP SCREW
GT250	.250"	2.0"	GTH-1-16-250RH	CL-20	CL-20S
GT312	.312"	2.0"	GTH-1-16-312RH		
GT375	.375"	2.0"	GTH-1-16-375RH		
GT425	.425"	2.0"	GTH-2-20-425RH	CL-30	CL-30S
GT475	.475"	2.0"	GTH-2-20-475RH		
GT500	.500"	2.0"	GTH-2-20-500RH		

HOLDER OPTIONS FOR RH (Right Hand)



END CUTTING (Square shank)

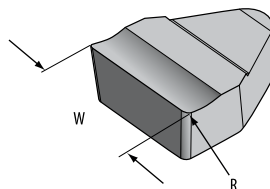
GTH-1-16-250RH	1.00" X 1.00" X 7" LONG
GTH-1-16-312RH	1.00" X 1.00" X 7" LONG
GTH-1-16-375RH	1.00" X 1.00" X 7" LONG
GTH-2-20-425RH	1.25" X 1.25" X 7" LONG
GTH-2-20-475RH	1.25" X 1.25" X 7" LONG
GTH-2-20-500RH	1.25" X 1.25" X 7" LONG

Holder bodies include clamp and clamp screw

GTH-FG INSERTS

.250" (6.35 mm) - .500" (12.70 mm) WIDE
 All standard inserts come with .02" (0.51mm) RAD.

(FACE GROOVING OD 6" DIA MINIMUM)

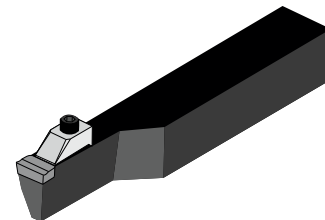


INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	GROOVE DEPTH	HOLDER NO.	CLAMP	CLAMP SCREW
GT250	.250"	2.0"	GTH-1-16-250LH	CL-20	CL-20S
GT312	.312"	2.0"	GTH-1-16-312LH		
GT375	.375"	2.0"	GTH-1-16-375LH		
GT425	.425"	2.0"	GTH-2-20-425LH	CL-30	CL-30S
GT475	.475"	2.0"	GTH-2-20-475LH		
GT500	.500"	2.0"	GTH-2-20-500LH		

HOLDER OPTIONS FOR LH (Left Hand)



END CUTTING (Square shank)

GTH-1-16-250LH	1.00" X 1.00" X 7" LONG
GTH-1-16-312LH	1.00" X 1.00" X 7" LONG
GTH-1-16-375LH	1.00" X 1.00" X 7" LONG
GTH-2-20-425LH	1.25" X 1.25" X 7" LONG
GTH-2-20-475LH	1.25" X 1.25" X 7" LONG
GTH-2-20-500LH	1.25" X 1.25" X 7" LONG

Holder bodies include clamp and clamp screw

GTH – HOG (HEAVY) GROOVING SYSTEM

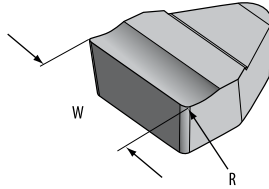
FACE GROOVING AND OD GROOVING OF EXTRA WIDE AND DEEP GROOVES
DEPTH OF CUT UP TO 2.5" (63.5 mm)

GTH - HOG is a heavy duty versatile system designed for high rate of material removal, roughing and finishing operations.

GTH-FG INSERTS

.562" (14.3 mm) - .750" (19.05 mm) WIDE
 All standard inserts come with .03" (0.76mm) RAD.

(FACE GROOVING OD 6" DIA MINIMUM)

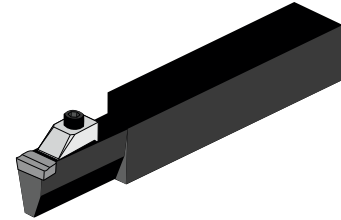


INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	GROOVE DEPTH	HOLDER NO.	CLAMP	CLAMP SCREW
GT562	.562"	2.5"	GTH-3-24-562RH	CL-50	CL-50S
GT625	.625"	2.5"	GTH-3-24-625RH		
GT750	.750"	2.5"	GTH-4-24-750RH	CL-62	CL-62S

HOLDER OPTIONS FOR RH (Right Hand)



END CUTTING (Square shank)

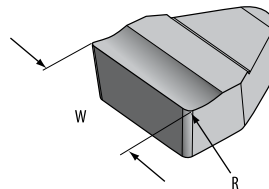
GTH-3-24-562RH	1.50" X 1.50" X 8" LONG
GTH-3-24-625RH	1.50" X 1.50" X 8" LONG
GTH-4-24-750RH	1.50" X 1.50" X 8" LONG

Holder bodies include clamp and clamp screw

GTH-FG INSERTS

.562" (14.3 mm) - .750" (19.05 mm) WIDE
 All standard inserts come with .03" (0.76mm) RAD.

(FACE GROOVING OD 6" DIA MINIMUM)

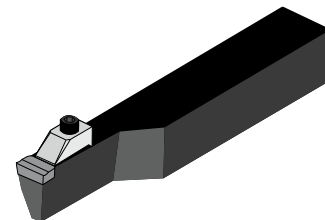


INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	GROOVE DEPTH	HOLDER NO.	CLAMP	CLAMP SCREW
GT562	.562"	2.5"	GTH-3-24-562LH	CL-50	CL-50S
GT625	.625"	2.5"	GTH-3-24-625LH		
GT750	.750"	2.5"	GTH-4-24-750LH	CL-62	CL-62S

HOLDER OPTIONS FOR LH (Left Hand)



END CUTTING (Square shank)

GTH-3-24-562LH	1.50" X 1.50" X 8" LONG
GTH-3-24-625LH	1.50" X 1.50" X 8" LONG
GTH-4-24-750LH	1.50" X 1.50" X 8" LONG

Holder bodies include clamp and clamp screw

GTH – DUCK FEET (EXTRA HEAVY) GROOVING SYSTEM

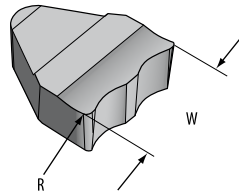
FACE GROOVING AND OD GROOVING OF EXTRA WIDE AND DEEP GROOVES / ROUGHING
DEPTH OF CUT UP TO 2.5" (63.5mm)

GTH - DUCK FEET is a heavy duty versatile system designed for high rate of material removal. Excellent for roughing operations and chatter reduction in heavy cuts.

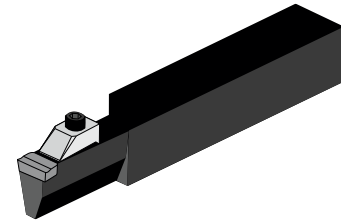
GTH-DF INSERTS

.425" (10.8 mm) - .750" (19.05 mm) WIDE
 All standard inserts come with .02" (0.51mm) RAD.

(FACE GROOVING OD 6" DIA MINIMUM)



HOLDER OPTIONS FOR RH (Right Hand)



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	GROOVE DEPTH	HOLDER NO.	CLAMP	CLAMP SCREW
GT-DF425	.425"	2.0"	GTH-2-20-425RH	CL-30	CL-30S
GT-DF475	.475"	2.0"	GTH-2-20-475RH		
GT-DF500	.500"	2.0"	GTH-2-20-500RH		
GT-DF562	.562"	2.5"	GTH-3-24-562RH	CL-50	CL-50S
GT-DF625	.625"	2.5"	GTH-3-24-625RH		
GT-DF750	.750"	2.5"	GTH-4-24-750RH		

END CUTTING (Square shank)

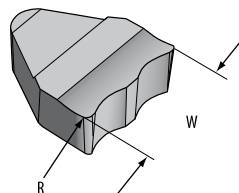
GTH-2-20-425RH	1.25" X 1.25" X 7" LONG
GTH-2-20-475RH	1.25" X 1.25" X 7" LONG
GTH-2-20-500RH	1.25" X 1.25" X 7" LONG
GTH-3-24-562RH	1.50" X 1.50" X 8" LONG
GTH-3-24-625RH	1.50" X 1.50" X 8" LONG
GTH-4-24-750RH	1.50" X 1.50" X 8" LONG

Holder bodies include clamp and clamp screw

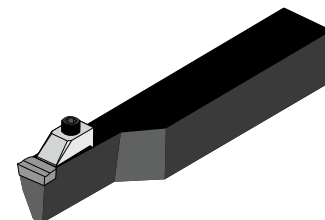
GTH-DF INSERTS

.425" (10.8 mm) - .750" (19.05 mm) WIDE
 All standard inserts come with .02" (0.51mm) RAD.

(FACE GROOVING OD 6" DIA MINIMUM)



HOLDER OPTIONS FOR LH (Left Hand)



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	GROOVE DEPTH	HOLDER NO.	CLAMP	CLAMP SCREW
GT-DF425	.425"	2.0"	GTH-2-20-425LH	CL-30	CL-30S
GT-DF475	.475"	2.0"	GTH-2-20-475LH		
GT-DF500	.500"	2.0"	GTH-2-20-500LH		
GT-DF562	.562"	2.5"	GTH-3-24-562LH	CL-50	CL-50S
GT-DF625	.625"	2.5"	GTH-3-24-625LH		
GT-DF750	.750"	2.5"	GTH-4-24-750LH		

END CUTTING (Square shank)

GTH-2-20-425LH	1.25" X 1.25" X 7" LONG
GTH-2-20-475LH	1.25" X 1.25" X 7" LONG
GTH-2-20-500LH	1.25" X 1.25" X 7" LONG
GTH-3-24-562LH	1.50" X 1.50" X 8" LONG
GTH-3-24-625LH	1.50" X 1.50" X 8" LONG
GTH-4-24-750LH	1.50" X 1.50" X 8" LONG

Holder bodies include clamp and clamp screw

GH SYSTEM – OD GROOVING

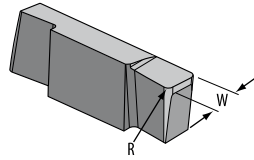
EXTENDED LENGTH SHANKS - GROUP A Depth of cut: Up to .25" (6.35 mm)

GH SYSTEM offers a superior side locking dove-tail pocket fit, an extremely rigid assembly with a support blade (anvil).

GI-OD-GH - ATLOCK INSERTS, DOUBLE ENDED

.031" (0.78 mm) - .125" (3.18 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	ANVIL	HOLDER NO.	HOLDER NO.	HOLDER NO.	HOLDER NO.
GAR01	0.031	.125"	AR01	GH-16-1A-RH	GH-20-1A-RH	GH-24-1A-RH	GH-64-1A-RH
GAR02	0.062	.125"	AR02	GH-16-1A-RH	GH-20-1A-RH	GH-24-1A-RH	GH-64-1A-RH
GAR03	0.093	.187"	AR03	GH-16-1A-RH	GH-20-1A-RH	GH-24-1A-RH	GH-64-1A-RH
GAR04	0.125	.250"	AR04	GH-16-1A-RH	GH-20-1A-RH	GH-24-1A-RH	GH-64-1A-RH

1A

HOLDER OPTIONS FOR RH (Right Hand)



Holder No. (Width x Height x Length)

1A	GH-16-1A-RH	1" X 1" X 6" LONG
	GH-20-1A-RH	1.25" X 1.25" X 6" LONG
	GH-24-1A-RH	1.5" X 1.5" X 6" LONG
	GH-64-1A-RH	.75" X 1" X 6" LONG

HOLDER BODIES INCLUDE CLAMP, CLAMP SCREWS AND ANVIL SCREWS

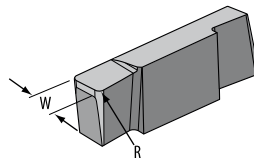
SPARE PARTS:

CLAMP (C1) - CLAMP SCREW (C1S) - ANVIL SCREW (AS2)

GI-OD-GH - ATLOCK INSERTS, DOUBLE ENDED

.031" (0.78 mm) - .125" (3.18 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	ANVIL	HOLDER NO.	HOLDER NO.	HOLDER NO.	HOLDER NO.
GAL01	0.031	.125"	AL01	GH-16-1A-LH	GH-20-1A-LH	GH-24-1A-LH	GH-64-1A-LH
GAL02	0.062	.125"	AL02	GH-16-1A-LH	GH-20-1A-LH	GH-24-1A-LH	GH-64-1A-LH
GAL03	0.093	.187"	AL03	GH-16-1A-LH	GH-20-1A-LH	GH-24-1A-LH	GH-64-1A-LH
GAL04	0.125	.250"	AL04	GH-16-1A-LH	GH-20-1A-LH	GH-24-1A-LH	GH-64-1A-LH

1A

HOLDER OPTIONS FOR LH (Left Hand)



Holder No. (Width x Height x Length)

1A	GH-16-1A-LH	1" X 1" X 6" LONG
	GH-20-1A-LH	1.25" X 1.25" X 6" LONG
	GH-24-1A-LH	1.5" X 1.5" X 6" LONG
	GH-64-1A-LH	.75" X 1" X 6" LONG

HOLDER BODIES INCLUDE CLAMP, CLAMP SCREWS AND ANVIL SCREWS

SPARE PARTS:

CLAMP (C1) - CLAMP SCREW (C1S) - ANVIL SCREW (AS2)

GH SYSTEM – OD GROOVING

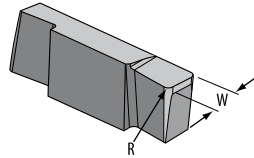
EXTENDED LENGTH SHANKS - GROUP B Depth of cut: Up to .25" (6.35 mm)

GH SYSTEM offers a superior side locking dove-tail pocket fit, an extremely rigid assembly with a support blade (anvil).

GI-OD-GH - ATLOCK INSERTS, DOUBLE ENDED

.031" (0.78 mm) - .250" (6.35 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	ANVIL	HOLDER NO.	HOLDER NO.
GAR01	0.031	.125"	BR01	GH-12-1B-RH	GH-43-1B-RH
GAR02	0.062	.125"	BR02	GH-12-1B-RH	GH-43-1B-RH
GAR03	0.093	.187"	BR03	GH-12-1B-RH	GH-43-1B-RH
GAR04	0.125	.250"	BR04	GH-12-1B-RH	GH-43-1B-RH
GAR05	0.156	.250"	BR05	GH-12-2B-RH	GH-43-2B-RH
GAR06	0.187	.250"	BR06	GH-12-2B-RH	GH-43-2B-RH
GAR07	0.218	.250"	BR07	GH-12-3B-RH	
GAR08	0.250	.250"	BR08	GH-12-3B-RH	

HOLDER OPTIONS FOR RH (Right Hand)



Holder No. (Width x Height x Length)

1B	GH-12-1B-RH	.75" X .75" X 6" LONG
	GH-43-1B-RH	.50" X .75" X 6" LONG
2B	GH-12-2B-RH	.75" X .75" X 6" LONG
	GH-43-2B-RH	.50" X .75" X 6" LONG
3B	GH-12-3B-RH	.75" X .75" X 6" LONG

HOLDER BODIES INCLUDE CLAMP, CLAMP SCREWS AND ANVIL SCREWS

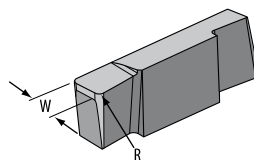
SPARE PARTS:

CLAMP (C1) - CLAMP SCREW (C1S) - ANVIL SCREW (AS2)

GI-OD-GH - ATLOCK INSERTS, DOUBLE ENDED

.031" (0.78 mm) - .250" (6.35 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	ANVIL	HOLDER NO.	HOLDER NO.
GAL01	0.031	.125"	BL01	GH-12-1B-LH	GH-43-1B-LH
GAL02	0.062	.125"	BL02	GH-12-1B-LH	GH-43-1B-LH
GAL03	0.093	.187"	BL03	GH-12-1B-LH	GH-43-1B-LH
GAL04	0.125	.250"	BL04	GH-12-1B-LH	GH-43-1B-LH
GAL05	0.156	.250"	BL05	GH-12-2B-LH	GH-43-2B-LH
GAL06	0.187	.250"	BL06	GH-12-2B-LH	GH-43-2B-LH
GAL07	0.218	.250"	BL07	GH-12-3B-LH	
GAL08	0.250	.250"	BL08	GH-12-3B-LH	

HOLDER OPTIONS FOR LH (Left Hand)



Holder No. (Width x Height x Length)

1B	GH-12-1B-LH	.75" X .75" X 6" LONG
	GH-43-1B-LH	.50" X .75" X 6" LONG
2B	GH-12-2B-LH	.75" X .75" X 6" LONG
	GH-43-2B-LH	.50" X .75" X 6" LONG
3B	GH-12-3B-LH	.75" X .75" X 6" LONG

HOLDER BODIES INCLUDE CLAMP, CLAMP SCREWS AND ANVIL SCREWS

SPARE PARTS:

CLAMP (C1) - CLAMP SCREW (C1S) - ANVIL SCREW (AS2)

GH SYSTEM – OD GROOVING

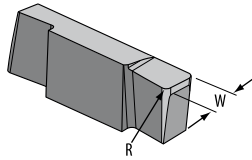
EXTENDED LENGTH SHANKS - GROUP C Depth of cut: Up to .375" (9.525 mm)

GH SYSTEM offers a superior side locking dove-tail pocket fit, an extremely rigid assembly with a support blade (anvil).

GI-OD-GH - ATLOCK INSERTS, DOUBLE ENDED

.062" (1.57 mm) - .125" (3.18 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	ANVIL	HOLDER NO.	HOLDER NO.	HOLDER NO.	HOLDER NO.
GCR02	0.062	.375"	CR02	GH-16-1C-RH	GH-20-1C-RH	GH-24-1C-RH	GH-64-1C-RH
GCR03	0.093	.375"	CR03	GH-16-1C-RH	GH-20-1C-RH	GH-24-1C-RH	GH-64-1C-RH
GCR04	0.125	.375"	CR04	GH-16-1C-RH	GH-20-1C-RH	GH-24-1C-RH	GH-64-1C-RH

1C

HOLDER OPTIONS FOR RH (Right Hand)



Holder No. (Width x Height x Length)

Holder No.	Width x Height x Length
GH-16-1C-RH	1" X 1 X 6" LONG
GH-20-1C-RH	1.25" X 1.25 X 6" LONG
GH-24-1C-RH	1.5" X 1.5 X 6" LONG
GH-64-1C-RH	.75" X 1X 6" LONG

HOLDER BODIES INCLUDE CLAMP, CLAMP SCREWS AND ANVIL SCREWS

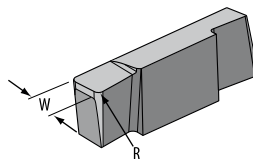
SPARE PARTS:

CLAMP (C1) - CLAMP SCREW (C1S) - ANVIL SCREW (AS2)

GI-OD-GH - ATLOCK INSERTS, DOUBLE ENDED

.062" (1.57 mm) - .125" (3.18 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	ANVIL	HOLDER NO.	HOLDER NO.	HOLDER NO.	HOLDER NO.
GCL02	0.062	.375"	CL02	GH-16-1C-LH	GH-20-1C-LH	GH-24-1C-LH	GH-64-1C-LH
GCL03	0.093	.375"	CL03	GH-16-1C-LH	GH-20-1C-LH	GH-24-1C-LH	GH-64-1C-LH
GCL04	0.125	.375"	CL04	GH-16-1C-LH	GH-20-1C-LH	GH-24-1C-LH	GH-64-1C-LH

1C

HOLDER OPTIONS FOR LH (Left Hand)



Holder No. (Width x Height x Length)

Holder No.	Width x Height x Length
GH-16-1C-LH	1" X 1 X 6" LONG
GH-20-1C-LH	1.25" X 1.25 X 6" LONG
GH-24-1C-LH	1.5" X 1.5 X 6" LONG
GH-64-1C-LH	.75" X 1X 6" LONG

HOLDER BODIES INCLUDE CLAMP, CLAMP SCREWS AND ANVIL SCREWS

SPARE PARTS:

CLAMP (C1) - CLAMP SCREW (C1S) - ANVIL SCREW (AS2)

M8 SYSTEM – OD GROOVING

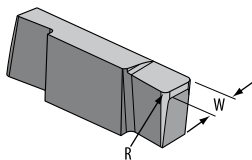
Depth of cut: Up to .25" (6.35 mm)

M8 SYSTEM offers a superior side locking dove-tail pocket fit, an extremely rigid assembly with a support blade (anvil).

GI-OD-M8 - ATLOCK INSERTS, DOUBLE ENDED

.031" (0.78 mm) - .250" (6.35 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	ANVIL	HOLDER NO.	HOLDER NO.	HOLDER NO.	
GAR01	0.031	.125"	BR01	M8-R1-35	M8-R1-55	M8-R1-67	1B
GAR02	0.062	.125"	BR02	M8-R1-35	M8-R1-55	M8-R1-67	
GAR03	0.093	.187"	BR03	M8-R1-35	M8-R1-55	M8-R1-67	
GAR04	0.125	.250"	BR04	M8-R1-35	M8-R1-55	M8-R1-67	
GAR05	0.156	.250"	BR05	M8-R2-35	M8-R2-55	M8-R2-67	2B
GAR06	0.187	.250"	BR06	M8-R2-35	M8-R2-55	M8-R2-67	
GAR07	0.218	.250"	BR07	M8-R3-35	M8-R3-55	M8-R3-67	3B
GAR08	0.250	.250"	BR08	M8-R3-35	M8-R3-55	M8-R3-67	

HOLDER OPTIONS FOR RH (Right Hand)



Holder No. (Width x Height x Length)

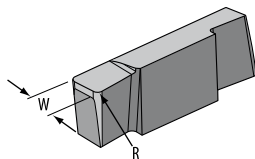
Holder No.	Holder No.	Holder No.
1B	M8-R1-35	.50" X .375" X 3.4" LONG
	M8-R1-55	.50" X .50" X 3.4" LONG
	M8-R1-67	.75" X .625" X 3.4" LONG
2B	M8-R2-35	.50" X .375" X 3.4" LONG
	M8-R2-55	.50" X .50" X 3.4" LONG
	M8-R2-67	.75" X .625" X 3.4" LONG
3B	M8-R3-35	.50" X .375" X 3.4" LONG
	M8-R3-55	.50" X .50" X 3.4" LONG
	M8-R3-67	.75" X .625" X 3.4" LONG

HOLDER BODIES INCLUDE CLAMP, CLAMP SCREW AND ANVIL SCREWS

GI-OD-M8 - ATLOCK INSERTS, DOUBLE ENDED

.031" (0.78 mm) - .250" (6.35 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

INSERTS	WIDTH (INCH)	MAX GROOVE DEPTH	ANVIL	HOLDER NO.	HOLDER NO.	HOLDER NO.	
GAL01	0.031	.125"	BL01	M8-L1-35	M8-L1-55	M8-L1-67	1B
GAL02	0.062	.125"	BL02	M8-L1-35	M8-L1-55	M8-L1-67	
GAL03	0.093	.187"	BL03	M8-L1-35	M8-L1-55	M8-L1-67	
GAL04	0.125	.250"	BL04	M8-L1-35	M8-L1-55	M8-L1-67	
GAL05	0.156	.250"	BL05	M8-L2-35	M8-L2-55	M8-L2-67	2B
GAL06	0.187	.250"	BL06	M8-L2-35	M8-L2-55	M8-L2-67	
GAL07	0.218	.250"	BL07	M8-L3-35	M8-L3-55	M8-L3-67	3B
GAL08	0.250	.250"	BL08	M8-L3-35	M8-L3-55	M8-L3-67	

HOLDER OPTIONS FOR LH (Left Hand)



Holder No. (Width x Height x Length)

Holder No.	Holder No.	Holder No.
1B	M8-L1-35	.50" X .375" X 3.4" LONG
	M8-L1-55	.50" X .50" X 3.4" LONG
	M8-L1-67	.75" X .625" X 3.4" LONG
2B	M8-L2-35	.50" X .375" X 3.4" LONG
	M8-L2-55	.50" X .50" X 3.4" LONG
	M8-L2-67	.75" X .625" X 3.4" LONG
3B	M8-L3-35	.50" X .375" X 3.4" LONG
	M8-L3-55	.50" X .50" X 3.4" LONG
	M8-L3-67	.75" X .625" X 3.4" LONG

HOLDER BODIES INCLUDE CLAMP, CLAMP SCREW AND ANVIL SCREWS

SPARE PARTS: CLAMP (C1) - CLAMP SCREW (C1S) - ANVIL SCREW (AS2)

NEW – MICRO ADJUSTABLE SYSTEM

Face Grooving Applications



HOW TO ORDER

HOLDER: Cat 'V' 40 50 Other _____
 Straight Shank Diameter 1.000" 1.250" 1.500"
 (Straight Shank Option Valid Only Up To 3.5" O.D. Max)

PART: Type: 'A' 'B' 'C'

Major Diameter _____ ± _____ Minor Diameter _____ ± _____

Note: Should a family of parts be involved, please specify each diameter required.

INSERT: Width _____ ± _____ Groove Depth _____ ± _____

Corner Radii: Major Diameter _____ Minor Diameter _____

Chamfer Size _____ x 45°

Material to Machine _____

QUANTITY: Holders _____ Inserts _____

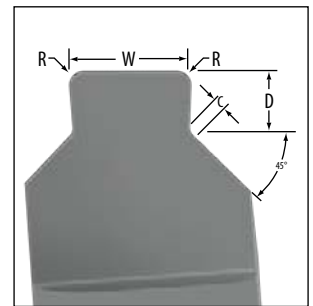
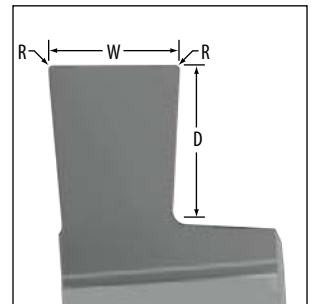


Figure 'A'
Flat

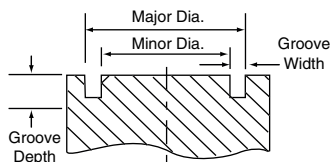


Figure 'B'
Counter Bore

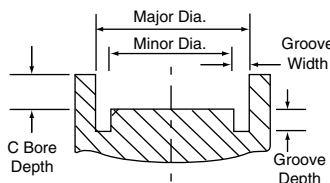
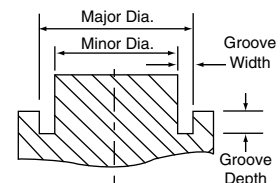


Figure 'C'
Hub



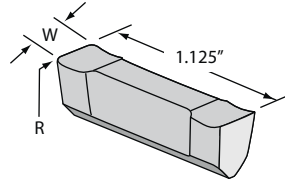
DB SERIES – OD (External) Grooving System for Deep Grooves

Depth of Cut: .50" (12.7 mm) and .75" (19.05 mm)

V-Base Insert provides maximum stability and rigidity in Standard and Deep Grooving Applications.

DB-OD: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
All standard inserts come with .008" (0.2 mm) RAD.



Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Depth of Cut: Up to .50" (12.7 mm)

INSERTS	WIDTH (INCH)	1" SQ HOLDERS		1.25" & 1.50" SQ HOLDERS	
		ANVILS	CLAMPS	ANVILS	CLAMPS
DBOB04	0.125	R1D04	CR1-1-D04	R2D04	CR1-1-D04
DBOB05	0.156	R1D05	CR1-1-D05	R2D05	CR1-1-D05
DBOB06	0.187	R1D06	CR1-1-D06	R2D06	CR1-1-D06
DBOB07	0.218	R1D07	CR1-1-D07	R2D07	CR1-1-D07
DBOB08	0.250				
DBOB09	0.281	R1D09	CR1-1-D09	R2D09	CR1-1-D09
DBOB10	0.312				
DBOB11	0.343	R1D11	CR1-1-D11	R2D11	CR1-1-D11
DBOB12	0.375				



Straight OD Holder Body Options for RH (Right Hand)

END CUTTING (Square Shank)	Holder Body	Length
	DB1-1-16R 1D	1.00" SQ x 6"
	DB1-1-20R 2D	1.25" SQ x 7"
	DB1-1-24R 2D	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

Depth of Cut: Up to .75" (19.05 mm)

INSERTS	WIDTH (INCH)	1" SQ HOLDERS		1.25" & 1.50" SQ HOLDERS	
		ANVILS	CLAMPS	ANVILS	CLAMPS
DBOB04	0.125	R1E04	CR1-1-E04	R2E04	CR1-1-E04
DBOB05	0.156	R1E05	CR1-1-E05	R2E05	CR1-1-E05
DBOB06	0.187	R1E06	CR1-1-E06	R2E06	CR1-1-E06
DBOB07	0.218	R1E07	CR1-1-E07	R2E07	CR1-1-E07
DBOB08	0.250				
DBOB09	0.281	R1E09	CR1-1-E09	R2E09	CR1-1-E09
DBOB10	0.312				
DBOB11	0.343	R1E11	CR1-1-E11	R2E11	CR1-1-E11
DBOB12	0.375				



Straight OD Holder Body Options for RH (Right Hand)

END CUTTING (Square Shank)	Holder Body	Length
	DB1-1-16R 1E	1.00" SQ x 6"
	DB1-1-20R 2E	1.25" SQ x 7"
	DB1-1-24R 2E	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

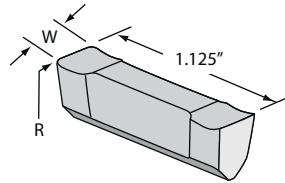
DB SERIES – OD (External) Grooving System for Deep Grooves

Depth of Cut: .50" (12.7 mm) and .75" (19.05 mm)

V-Base Insert provides maximum stability and rigidity in Standard and Deep Grooving Applications.

DB-OD: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
All standard inserts come with .008" (0.2 mm) RAD.



Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Depth of Cut: Up to .50" (12.7 mm)

INSERTS	WIDTH (INCH)	1" SQ HOLDERS		1.25" & 1.50" SQ HOLDERS	
		ANVILS	CLAMPS	ANVILS	CLAMPS
DBOB04	0.125	L1D04	CL1-1-D04	L2D04	CL1-1-D04
DBOB05	0.156	L1D05	CL1-1-D05	L2D05	CL1-1-D05
DBOB06	0.187	L1D06	CL1-1-D06	L2D06	CL1-1-D06
DBOB07	0.218	L1D07	CL1-1-D07	L2D07	CL1-1-D07
DBOB08	0.250				
DBOB09	0.281	L1D09	CL1-1-D09	L2D09	CL1-1-D09
DBOB10	0.312				
DBOB11	0.343	L1D11	CL1-1-D11	L2D11	CL1-1-D11
DBOB12	0.375				



Straight OD Holder Body Options for LH (Left Hand)

END CUTTING (Square Shank)	Holder Body	Shank Size
	DB1-1-16L 1D	1.00" SQ x 6"
	DB1-1-20L 2D	1.25" SQ x 7"
	DB1-1-24L 2D	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

Depth of Cut: Up to .75" (19.05 mm)

INSERTS	WIDTH (INCH)	1" SQ HOLDERS		1.25" & 1.50" SQ HOLDERS	
		ANVILS	CLAMPS	ANVILS	CLAMPS
DBOB04	0.125	L1E04	CL1-1-E04	L2E04	CL1-1-E04
DBOB05	0.156	L1E05	CL1-1-E05	L2E05	CL1-1-E05
DBOB06	0.187	L1E06	CL1-1-E06	L2E06	CL1-1-E06
DBOB07	0.218	L1E07	CL1-1-E07	L2E07	CL1-1-E07
DBOB08	0.250				
DBOB09	0.281	L1E09	CL1-1-E09	L2E09	CL1-1-E09
DBOB10	0.312				
DBOB11	0.343	L1E11	CL1-1-E11	L2E11	CL1-1-E11
DBOB12	0.375				



Straight OD Holder Body Options for LH (Left Hand)

END CUTTING (Square Shank)	Holder Body	Shank Size
	DB1-1-16L 1E	1.00" SQ x 6"
	DB1-1-20L 2E	1.25" SQ x 7"
	DB1-1-24L 2E	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

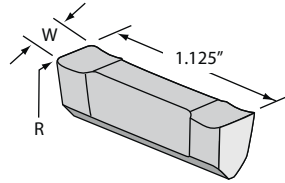
DB SERIES – OD (External) Grooving System for Deep Grooves

Depth of Cut: .50" (12.7 mm) and .75" (19.05 mm)

V-Base Insert provides maximum stability and rigidity in Standard and Deep Grooving Applications.

DB-OD: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
All standard inserts come with .008" (0.2 mm) RAD.



Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Depth of Cut: Up to .50" (12.7 mm)

INSERTS	WIDTH (INCH)	1" SQ HOLDERS		1.25" & 1.50" SQ HOLDERS	
		ANVILS	CLAMPS	ANVILS	CLAMPS
DBOB04	0.125	L1D04	CL1-1-D04	L2D04	CL1-1-D04
DBOB05	0.156	L1D05	CL1-1-D05	L2D05	CL1-1-D05
DBOB06	0.187	L1D06	CL1-1-D06	L2D06	CL1-1-D06
DBOB07	0.218	L1D07	CL1-1-D07	L2D07	CL1-1-D07
DBOB08	0.250				
DBOB09	0.281	L1D09	CL1-1-D09	L2D09	CL1-1-D09
DBOB10	0.312				
DBOB11	0.343	L1D11	CL1-1-D11	L2D11	CL1-1-D11
DBOB12	0.375				



Right Angle OD Holder Body Options for RH (Right Hand)

RIGHT ANGLE (Square Shank)	Holder Body	Width
	DB2-1-160 1D	1" x 1.25" x 7"
	DB2-1-200 2D	1.25" SQ x 7"
	DB2-1-240 2D	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

Depth of Cut: Up to .75" (19.05 mm)

INSERTS	WIDTH (INCH)	1" SQ HOLDERS		1.25" & 1.50" SQ HOLDERS	
		ANVILS	CLAMPS	ANVILS	CLAMPS
DBOB04	0.125	L1E04	CL1-1-E04	L2E04	CL1-1-E04
DBOB05	0.156	L1E05	CL1-1-E05	L2E05	CL1-1-E05
DBOB06	0.187	L1E06	CL1-1-E06	L2E06	CL1-1-E06
DBOB07	0.218	L1E07	CL1-1-E07	L2E07	CL1-1-E07
DBOB08	0.250				
DBOB09	0.281	L1E09	CL1-1-E09	L2E09	CL1-1-E09
DBOB10	0.312				
DBOB11	0.343	L1E11	CL1-1-E11	L2E11	CL1-1-E11
DBOB12	0.375				



Right Angle OD Holder Body Options for RH (Right Hand)

RIGHT ANGLE (Square Shank)	Holder Body	Width
	DB2-1-160 1E	1" x 1.25" x 7"
	DB2-1-200 2E	1.25" SQ x 7"
	DB2-1-240 2E	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

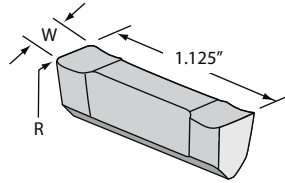
DB SERIES – OD (External) Grooving System for Deep Grooves

Depth of Cut: .50" (12.7 mm) and .75" (19.05 mm)

V-Base Insert provides maximum stability and rigidity in Standard and Deep Grooving Applications.

DB-OD: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
All standard inserts come with .008" (0.2 mm) RAD.



Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Depth of Cut: Up to .50" (12.7 mm)

INSERTS	WIDTH (INCH)	1" SQ HOLDERS		1.25" & 1.50" SQ HOLDERS	
		ANILIS	CLAMPS	ANVILS	CLAMPS
DBOB04	0.125	R1D04	CR1-1-D04	R2D04	CR1-1-D04
DBOB05	0.156	R1D05	CR1-1-D05	R2D05	CR1-1-D05
DBOB06	0.187	R1D06	CR1-1-D06	R2D06	CR1-1-D06
DBOB07	0.218	R1D07	CR1-1-D07	R2D07	CR1-1-D07
DBOB08	0.250				
DBOB09	0.281	R1D09	CR1-1-D09	R2D09	CR1-1-D09
DBOB10	0.312				
DBOB11	0.343	R1D11	CR1-1-D11	R2D11	CR1-1-D11
DBOB12	0.375				



Right Angle OD Holder Body Options for LH (Left Hand)

RIGHT ANGLE (Square Shank)	DB2-1-165 1D	1" x 1.25" x 7"
	DB2-1-205 2D	1.25" SQ x 7"
	DB2-1-245 2D	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

Depth of Cut: Up to .75" (19.05 mm)

INSERTS	WIDTH (INCH)	1" SQ HOLDERS		1.25" & 1.50" SQ HOLDERS	
		ANVILS	CLAMPS	ANVILS	CLAMPS
DBOB04	0.125	R1E04	CR1-1-E04	R2E04	CR1-1-E04
DBOB05	0.156	R1E05	CR1-1-E05	R2E05	CR1-1-E05
DBOB06	0.187	R1E06	CR1-1-E06	R2E06	CR1-1-E06
DBOB07	0.218	R1E07	CR1-1-E07	R2E07	CR1-1-E07
DBOB08	0.250				
DBOB09	0.281	R1E09	CR1-1-E09	R2E09	CR1-1-E09
DBOB10	0.312				
DBOB11	0.343	R1E11	CL1-1-E11	R2E11	CR1-1-E11
DBOB12	0.375				



Right Angle OD Holder Body Options for LH (Left Hand)

RIGHT ANGLE (Square Shank)	DB2-1-165 1E	1" x 1.25" x 7"
	DB2-1-205 2E	1.25" SQ x 7"
	DB2-1-245 2E	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

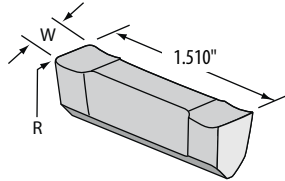
DB SERIES – OD (External) Grooving System for Deep Grooves

Depth of Cut: 1.25" (31.75 mm)

V-Base Insert provides maximum stability and rigidity in Standard and Deep Grooving Applications.

DB-OD: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
All standard inserts come with .008" (0.2 mm) RAD.



Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Depth of Cut: Up to 1.25" (31.75 mm)

INSERTS	WIDTH (INCH)	ANVILS	CLAMPS
DBOC04	0.125	R2H04	CR1-1-H04
DBOC05	0.156	R2H05	CR1-1-H06
DBOC06	0.187	R2H06	
DBOC07	0.218	R2H07	CR1-1-H07
DBOC08	0.250		
DBOC09	0.281	R2H09	CR1-1-H09
DBOC10	0.312		
DBOC11	0.343	R2H11	CR1-1-H11
DBOC12	0.375		



Straight OD Holder Body Options for RH (Right Hand)

END CUTTING (Square Shank)	DB1-1-20R 2H	1.25" SQ x 7"
	DB1-1-24R 2H	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

Depth of Cut: Up to 1.25" (31.75 mm)

INSERTS	WIDTH (INCH)	ANVILS	CLAMPS
DBOC04	0.125	L2H04	CL1-1-H04
DBOC05	0.156	L2H05	CL1-1-H06
DBOC06	0.187	L2H06	
DBOC07	0.218	L2H07	CL1-1-H07
DBOC08	0.250		
DBOC09	0.281	L2H09	CL1-1-H09
DBOC10	0.312		
DBOC11	0.343	L2H11	CL1-1-H11
DBOC12	0.375		



Straight OD Holder Body Options for LH (Left Hand)

END CUTTING (Square Shank)	DB1-1-20L 2H	1.25" SQ x 7"
	DB1-1-24L 2H	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

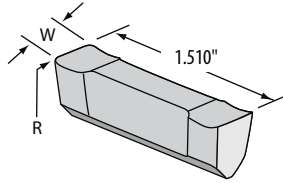
DB SERIES – OD (External) Grooving System for Deep Grooves

Depth of Cut: 1.25" (31.75 mm)

V-Base Insert provides maximum stability and rigidity in Standard and Deep Grooving Applications.

DB-OD: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
All standard inserts come with .008" (0.2 mm) RAD.



Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Depth of Cut: Up to 1.25" (31.75 mm)

INSERTS	WIDTH (INCH)	ANVILS	CLAMPS
DBOC04	0.125	L2H04	CL2-1-H04
DBOC05	0.156	L2H05	CL2-1-H06
DBOC06	0.187	L2H06	
DBOC07	0.218	L2H07	CL2-1-H07
DBOC08	0.250		
DBOC09	0.281	L2H09	CL2-1-H09
DBOC10	0.312		
DBOC11	0.343	L2H11	CL2-1-H11
DBOC12	0.375		



Right Angle OD Holder Body Options for RH (Right Hand)

END CUTTING (Square Shank)	DB2-1-200 2H	1.25" SQ x 7"
	DB2-1-240 2H	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

Depth of Cut: Up to 1.25" (31.75 mm)

INSERTS	WIDTH (INCH)	ANVILS	CLAMPS
DBOC04	0.125	R2H04	CR2-1-H04
DBOC05	0.156	R2H05	CR2-1-H06
DBOC06	0.187	R2H06	
DBOC07	0.218	R2H07	CR2-1-H07
DBOC08	0.250		
DBOC09	0.281	R2H09	CR2-1-H09
DBOC10	0.312		
DBOC11	0.343	R2H11	CR2-1-H11
DBOC12	0.375		



Right Angle OD Holder Body Options for LH (Left Hand)

END CUTTING (Square Shank)	DB2-1-205 2H	1.25" SQ x 7"
	DB2-1-245 2H	1.50" SQ x 7"

Holder Bodies include anvil and clamp screws.

D SYSTEM – ID GROOVING

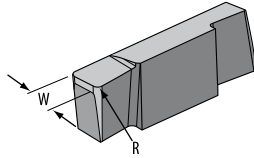
EXTENDED LENGTH SHANKS

D SYSTEM offers a superior side locking dove-tail pocket fit, an extremely rigid assembly without a support blade (anvil) For 1.00" Dia. Bores and Larger.

GI-ID-D - ATLOCK INSERTS, DOUBLE ENDED

.031" (0.78 mm) - .250" (6.35 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

Depth of cut: Up to .15" (3.81 mm)

INSERTS STYLE "DE"	WIDTH (INCH)	MAX DEPTH	HOLDER NO.	MIN BORE DIA
DEL01	0.031	.125"	D30-16-1	1.00"
DEL02	0.062	.15"		
DEL03	0.093			
DEL04	0.125			
DEL05	0.156	.15"	D30-16-2	1.00"
DEL06	0.187			

HOLDER OPTIONS FOR RH (Right Hand)

Round bars



Bars for 1.0" Min Bore Dia.

D30-16-1	SHANK DIA = 1.00" X 7" LONG; NECK .81"
D30-16-2	SHANK DIA = 1.00" X 7" LONG; NECK .81"

Note: RH Bars use LH inserts

SPARE PARTS: CLAMP (C-1) • SCREW (C1B)

Depth of cut: Up to .218" (5.53 mm)

INSERTS STYLE "DF"	WIDTH (INCH)	MAX DEPTH	HOLDER NO.	MIN BORE DIA	HOLDER NO.	MIN BORE DIA
DFL01	0.031	.125"	D20-16-1	1.25"	D20-20-1	1.50"
DFL02	0.062	.18"				
DFL03	0.093	.218"				
DFL04	0.125					
DFL05	0.156	.218"	D20-16-2	1.25"	D20-20-2	1.50"
DFL06	0.187					
DFL07	0.218	.218"	D20-16-3	1.25"	D20-20-3	1.50"
DFL08	0.250					

HOLDER OPTIONS FOR RH (Right Hand)

Round bars



Bars for 1.25" Min Bore Dia.

D20-16-1	SHANK DIA = 1.00" X 7"
D20-16-2	SHANK DIA = 1.00" X 7"
D20-16-3	SHANK DIA = 1.00" X 7"

Bars for 1.5" Min Bore Dia.

D20-20-1	SHANK DIA = 1.25" X 7"
D20-20-2	SHANK DIA = 1.25" X 7"
D20-20-3	SHANK DIA = 1.25" X 7"

Note: RH Bars use LH inserts

SPARE PARTS: CLAMP (C-1) • SCREW (C1B)

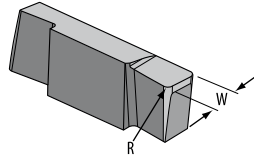
D SYSTEM – ID GROOVING

EXTENDED LENGTH SHANKS

D SYSTEM offers a superior side locking dove-tail pocket fit, an extremely rigid assembly without a support blade (anvil)
For 1.00" Dia. Bores and Larger.

GI-ID-D - ATLOCK INSERTS, DOUBLE ENDED

.031" (0.78 mm) - .250" (6.35 mm) WIDE
All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

Depth of cut: Up to .15" (3.81 mm)

INSERTS STYLE "DE"	WIDTH (INCH)	MAX DEPTH	HOLDER NO.	MIN BORE DIA
DER01	0.031	.125"	D35-16-1	1.00"
DER02	0.062	.15"		
DER03	0.093			
DER04	0.125			
DER05	0.156	.15"	D35-16-2	1.00"
DER06	0.187			

HOLDER OPTIONS FOR LH (Left Hand)

Round bars



Bars for 1.0" Min Bore Dia.

D35-16-1	SHANK DIA = 1.00" X 7" LONG; NECK .81"
D35-16-2	SHANK DIA = 1.00" X 7" LONG; NECK .81"

Note: LH Bars use RH inserts

SPARE PARTS: CLAMP (C-1) • SCREW (C1B)

Depth of cut: Up to .218" (5.53 mm)

INSERTS STYLE "DF"	WIDTH (INCH)	MAX DEPTH	HOLDER NO.	MIN BORE DIA	HOLDER NO.	MIN BORE DIA
DFR01	0.031	.125"	D25-16-1	1.25"	D25-20-1	1.50"
DFR02	0.062	.18"				
DFR03	0.093	.218"				
DFR04	0.125					
DFR05	0.156	.218"	D25-16-2	1.25"	D25-20-2	1.50"
DFR06	0.187					
DFR07	0.218	.218"	D25-16-3	1.25"	D25-20-3	1.50"
DFR08	0.250					

HOLDER OPTIONS FOR LH (Left Hand)

Round bars



Bars for 1.25" Min Bore Dia.

D25-16-1	SHANK DIA = 1.00" X 7"
D25-16-2	SHANK DIA = 1.00" X 7"
D25-16-3	SHANK DIA = 1.00" X 7"

Bars for 1.5" Min Bore Dia.

D25-20-1	SHANK DIA = 1.25" X 7"
D25-20-2	SHANK DIA = 1.25" X 7"
D25-20-3	SHANK DIA = 1.25" X 7"

Note: LH Bars use RH inserts

SPARE PARTS: CLAMP (C-1) • SCREW (C1B)

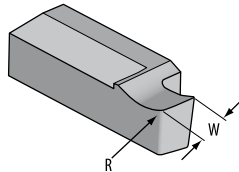
M12 SYSTEM – ID GROOVING

M12 SYSTEM offers a superior side locking dove-tail pocket fit, an extremely rigid assembly without a support blade (anvil) For .50" Dia. Bores and Larger.

GI-ID-M12 - ATLOCK INSERTS, SINGLE ENDED

.031" (0.78 mm) - .125" (3.18 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

Depth of cut: Up to .15" (3.81 mm)

INSERTS STYLE "D"	WIDTH (INCH)	HOLDER NO.	MIN BORE DIA
MLD01	0.031	M2-01-XXD	.50"
MLD02	0.062		
MLD03	0.093		
MLD04	0.125		

HOLDER OPTIONS FOR RH (Right Hand) STYLE "D" Bars for .50" Min Bore Dia.

M2 Round bars



M2-01-35D	DIA = .500" x 3.5 Long; Neck .312"
M2-01-36D	DIA = .625" x 3.5 Long; Neck .312"
M2-01-37D	DIA = .750" x 3.5 Long; Neck .312"

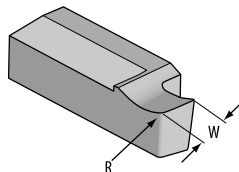
Note: RH Bars use LH inserts

SPARE PARTS: CLAMP (MCD) • SCREW (MSD)

GI-ID-M-12 - ATLOCK INSERTS, SINGLE ENDED

.031" (0.78 mm) - .187" (4.75 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

Depth of cut: Up to .15" (3.81 mm)

INSERTS STYLE "E"	WIDTH (INCH)	HOLDER NO.	SHANK DIA	MIN BORE DIA
MLE01	0.031	M1-01-05E	.500"	.688"
MLE02	0.062	M1-01-06E	.625"	.812"
MLE03	0.093	M1-01-56E	.625"	.688"
MLE04	0.125	M1-01-57E	.750"	.688"
		M1-01-67E	.750"	.812"
MLE05	0.156	M2-02-06E	.500"	.688"
		M2-02-06E	.625"	.812"
		M2-02-56E	.625"	.688"
MLE06	0.187	M2-02-57E	.750"	.688"
		M2-02-67E	.750"	.812"
		M2-02-67E	.750"	.812"

HOLDER OPTIONS FOR RH (Right Hand) STYLE "E" Bars for .688" Min Bore Dia.

M1 Round bars



M1-01-05E	DIA = .500" x 3.5 Long
M1-01-06E	DIA = .625" x 3.5 Long
M1-02-05E	DIA = .500" x 3.5 Long
M1-02-06E	DIA = .625" x 3.5 Long

M2 Round bars



M2-01-56E	DIA = .625" x 3.5 Long; Neck .500"
M2-01-57E	DIA = .750" x 3.5 Long; Neck .500"
M2-01-67E	DIA = .625" x 3.5 Long; Neck .625"
M2-02-56E	DIA = .625" x 3.5 Long; Neck .500"
M2-02-57E	DIA = .750" x 3.5 Long; Neck .500"
M2-02-67E	DIA = .750" x 3.5 Long; Neck .625"

Note: RH Bars use LH inserts

SPARE PARTS: CLAMP (MCE) • SCREW (MSE)

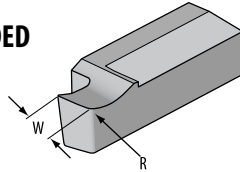
M12 SYSTEM – ID GROOVING

M12 SYSTEM offers a superior side locking dove-tail pocket fit, an extremely rigid assembly without a support blade (anvil) For .50" Dia. Bores and Larger.

GI-ID-M12 - ATLOCK INSERTS, SINGLE ENDED

.031" (0.78 mm) - .125" (3.18 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

Depth of cut: Up to .15" (3.81 mm)

INSERTS STYLE "D"	WIDTH (INCH)	HOLDER NO.	MIN BORE DIA
MRD01	0.031	M2-51-XXD	.50"
MRD02	0.062		
MRD03	0.093		
MRD04	0.125		

HOLDER OPTIONS FOR LH (Left Hand) STYLE "D" Bars for .50" Min Bore Dia.

M2 Round bars



M2-51-35D	DIA = .500" x 3.5 Long; Neck .312"
M2-51-36D	DIA = .625" x 3.5 Long; Neck .312"
M2-51-37D	DIA = .750" x 3.5 Long; Neck .312"

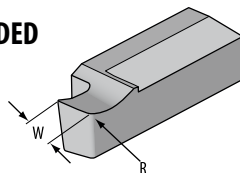
Note: LH Bars use RH inserts

SPARE PARTS: CLAMP (MCD) - SCREW (MSD)

GI-ID-M-12 - ATLOCK INSERTS, SINGLE ENDED

.031" (0.78 mm) - .187" (4.75 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

Depth of cut: Up to .15" (3.81 mm)

INSERTS STYLE "E"	WIDTH (INCH)	HOLDER NO.	SHANK DIA	MIN BORE DIA
MRE01	0.031	M1-51-05E	.500"	.688"
MRE02	0.062	M1-51-06E	.625"	.812"
MRE03	0.093	M1-51-56E	.625"	.688"
MRE04	0.125	M1-51-57E	.750"	.688"
		M1-51-67E	.750"	.812"
MRE05	0.156	M2-52-06E	.500"	.688"
		M2-52-06E	.625"	.812"
MRE06	0.187	M2-52-56E	.625"	.688"
		M2-52-57E	.750"	.688"
		M2-52-67E	.750"	.812"

HOLDER OPTIONS FOR LH (Left Hand) STYLE "E" Bars for .688" Min Bore Dia.

M1 Round bars



M1-51-05E	DIA = .500" x 3.5 Long
M1-51-06E	DIA = .625" x 3.5 Long
M1-52-05E	DIA = .500" x 3.5 Long
M1-52-06E	DIA = .625" x 3.5 Long

M2 Round bars



M2-51-56E	DIA = .625" x 3.5 Long; Neck .500"
M2-51-57E	DIA = .750" x 3.5 Long; Neck .500"
M2-51-67E	DIA = .625" x 3.5 Long; Neck .625"
M2-52-56E	DIA = .625" x 3.5 Long; Neck .500"
M2-52-57E	DIA = .750" x 3.5 Long; Neck .500"
M2-52-67E	DIA = .750" x 3.5 Long; Neck .625"

Note: LH Bars use RH inserts

SPARE PARTS: CLAMP (MCE) - SCREW (MSE)

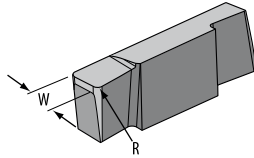
M12 SYSTEM – ID GROOVING

M12 SYSTEM offers a superior side locking dove-tail pocket fit, an extremely rigid assembly without a support blade (anvil) For 1.00" Dia. Bores and Larger.

GI-ID-M12 - ATLOCK INSERTS, DOUBLE ENDED

.031" (0.78 mm) - .250" (6.35 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

Depth of cut: Up to .218" (5.53 mm)

INSERTS STYLE "G"	WIDTH (INCH)	MAX DEPTH	HOLDER NO.	MIN BORE DIA
MLG01	0.031	.125"	M1-01-07G	1.00"
MLG02	0.062	.125"		
MLG03	0.093	.187"		
MLG04	0.125	.218"		
MLG05	0.156	.218"	M1-02-07G	
MLG06	0.187	.218"		
MLG07	0.218	.218"	M1-03-07G	
MLG08	0.250			

HOLDER OPTIONS FOR RH (Right Hand) STYLE "G" Bars for 1.00" Min Bore Dia.

M1 Round bars



M1-01-07G	DIA = .750" x 3.5 Long
M1-02-07G	DIA = .750" x 3.5 Long
M1-03-07G	DIA = .750" x 3.5 Long

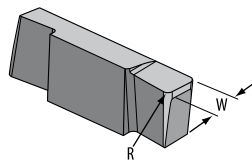
Note: RH Bars use LH inserts

SPARE PARTS: CLAMP (C-1) • SCREW (MSG)

GI-ID-M12 - ATLOCK INSERTS, DOUBLE ENDED

.031" (0.78 mm) - .250" (6.35 mm) WIDE

All standard inserts come with .008" (0.2 mm) RAD.



INSERT OPTIONS:

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. (For ordering designations see Page 4, or specify work material)

Depth of cut: Up to .218" (5.53 mm)

INSERTS STYLE "G"	WIDTH (INCH)	MAX DEPTH	HOLDER NO.	MIN BORE DIA
MRG01	0.031	.125"	M1-51-07G	1.00"
MRG02	0.062	.125"		
MRG03	0.093	.187"		
MRG04	0.125	.218"		
MRG05	0.156	.218"	M1-52-07G	
MRG06	0.187	.218"		
MRG07	0.218	.218"	M1-53-07G	
MRG08	0.250			

HOLDER OPTIONS FOR LH (Left Hand) STYLE "G" Bars for 1.00" Min Bore Dia.

M1 Round bars



M1-51-07G	DIA = .750" x 3.5 Long
M1-52-07G	DIA = .750" x 3.5 Long
M1-53-07G	DIA = .750" x 3.5 Long

Note: LH Bars use RH inserts

SPARE PARTS: CLAMP (C-1) • SCREW (MSG)

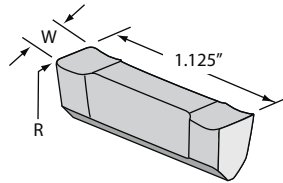
DB SERIES – ID One Piece Bar Grooving System for Deep Grooves

Depth of Cut: .21" (5.33 mm) or .31" (7.87 mm)

Uniquely Economical One-Piece Holders for 1.25" (31.7mm) Diameter Bores and Larger.

DB-ID: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
All standard inserts come with .008" (0.2 mm) RAD.



Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Depth of Cut: Up to .21" (5.33 mm)

INSERTS	WIDTH (INCH)	HOLDER NUMBER	CLAMP	HOLDER NUMBER	CLAMP	HOLDER NUMBER	CLAMPS
DB1B04	0.125	DB4-1600 B04	CLR02	DB4-2000 B04	CLR02	DB4-2400 B04	CL1-1-D04
DB1B05	0.156	DB4-1600 B05		DB4-2000 B05		DB4-2400 B05	CL1-1-D06
DB1B06	0.187	DB4-1600 B06		DB4-2000 B06		DB4-2400 B06	
DB1B07	0.218	DB4-1600 B07		DB4-2000 B07		DB4-2400 B07	CL1-1-D07
DB1B08	0.250						
DB1B09	0.281	DB4-1600 B09		DB4-2000 B09		DB4-2400 B09	CL1-1-D09
DB1B10	0.312						
DB1B11	0.343	DB4-1600 B11		DB4-2000 B11		DB4-2400 B11	CL1-1-D11
DB1B12	0.375						



Holder Body Options for RH (Right Hand) Round Bars

Min. Bore Dia. 1.25" (31.75 mm)	DB4-1600 BXX	1.00" Dia. x 7"
Min. Bore Dia. 1.50" (38.1 mm)	DB4-2000 BXX	1.25" Dia. x 10"
Min. Bore Dia. 1.75" (44.45 mm)	DB4-2400 BXX	1.50" Dia. x 10"

Holder Bodies include clamp and clamp screws.

Depth of Cut: Up to .31" (7.87 mm)

INSERTS	WIDTH (INCH)	HOLDER NUMBER	CLAMP	HOLDER NUMBER	CLAMP	HOLDER NUMBER	CLAMPS
DB1B04	0.125	DB4-1600 C04	CLR02	DB4-2000 C04	CLR02	DB4-2400 C04	CL1-1-D04
DB1B05	0.156	DB4-1600 C05		DB4-2000 C05		DB4-2400 C05	CL1-1-D06
DB1B06	0.187	DB4-1600 C06		DB4-2000 C06		DB4-2400 C06	
DB1B07	0.218	DB4-1600 C07		DB4-2000 C07		DB4-2400 C07	CL1-1-D07
DB1B08	0.250						
DB1B09	0.281	DB4-1600 C09		DB4-2000 C09		DB4-2400 C09	CL1-1-D09
DB1B10	0.312						
DB1B11	0.343	DB4-1600 C11		DB4-2000 C11		DB4-2400 C11	CL1-1-D11
DB1B12	0.375						



Holder Body Options for RH (Right Hand) Round Bars

Min. Bore Dia. 1.344" (34.14 mm)	DB4-1600 CXX	1.00" Dia. x 7"
Min. Bore Dia. 1.594" (40.49 mm)	DB4-2000 CXX	1.25" Dia. x 10"
Min. Bore Dia. 1.843" (46.81 mm)	DB4-2400 CXX	1.50" Dia. x 10"

Holder Bodies include clamp and clamp screws.

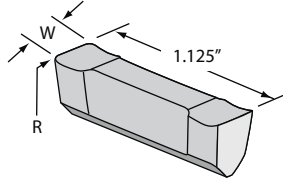
DB SERIES – ID One Piece Bar Grooving System for Deep Grooves

Depth of Cut: .21" (5.33 mm) or .31" (7.87 mm)

Uniquely Economical One-Piece Holders for 1.25" (31.7mm) Diameter Bores and Larger.

DB-ID: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
All standard inserts come with .008" (0.2 mm) RAD.



Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Depth of Cut: Up to .21" (5.33 mm)

INSERTS	WIDTH (INCH)	HOLDER NUMBER	CLAMP	HOLDER NUMBER	CLAMP	HOLDER NUMBER	CLAMPS
DB1B04	0.125	DB4-1650 B04	CLR02	DB4-2050 B04	CLR02	DB4-2450 B04	CL1-1-D04
DB1B05	0.156	DB4-1650 B05		DB4-2050 B05		DB4-2450 B05	CL1-1-D06
DB1B06	0.187	DB4-1650 B06		DB4-2050 B06		DB4-2450 B06	
DB1B07	0.218	DB4-1650 B07		DB4-2050 B07		DB4-2450 B07	CL1-1-D07
DB1B08	0.250			DB4-2050 B09		DB4-2450 B09	CL1-1-D09
DB1B09	0.281	DB4-1650 B09		DB4-2050 B11		DB4-2450 B11	CL1-1-D11
DB1B10	0.312						
DB1B11	0.343	DB4-1650 B11					
DB1B12	0.375						



Holder Body Options for LH (Left Hand) Round Bars

Min. Bore Dia. 1.344" (34.14 mm)	DB4-1650 BXX	1.00" Dia. x 7"
Min. Bore Dia. 1.594" (40.49 mm)	DB4-2050 BXX	1.25" Dia. x 10"
Min. Bore Dia. 1.843" (46.81 mm)	DB4-2450 BXX	1.50" Dia. x 10"

Holder Bodies include clamp and clamp screws.

Depth of Cut: Up to .31" (7.87 mm)

INSERTS	WIDTH (INCH)	HOLDER NUMBER	CLAMP	HOLDER NUMBER	CLAMP	HOLDER NUMBER	CLAMPS
DB1B04	0.125	DB4-1650 C04	CLR02	DB4-2050 C04	CLR02	DB4-2450 B04	CL1-1-D04
DB1B05	0.156	DB4-1650 C05		DB4-2050 C05		DB4-2450 B05	CL1-1-D06
DB1B06	0.187	DB4-1650 C06		DB4-2050 C06		DB4-2450 B06	
DB1B07	0.218	DB4-1650 C07		DB4-2050 C07		DB4-2450 B07	CL1-1-D07
DB1B08	0.250			DB4-2050 C09		DB4-2450 B09	CL1-1-D09
DB1B09	0.281	DB4-1650 C09		DB4-2050 C11		DB4-2450 B11	CL1-1-D11
DB1B10	0.312						
DB1B11	0.343	DB4-1650 C11					
DB1B12	0.375						



Holder Body Options for LH (Left Hand) Round Bars

Min. Bore Dia. 1.344" (34.14 mm)	DB4-1650 CXX	1.00" Dia. x 7"
Min. Bore Dia. 1.594" (40.49 mm)	DB4-2050 CXX	1.25" Dia. x 10"
Min. Bore Dia. 1.843" (46.81 mm)	DB4-2450 CXX	1.50" Dia. x 10"

Holder Bodies include clamp and clamp screws.

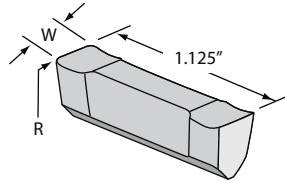
DB SERIES – ID DASH Holders for Deep Grooves

Depth of Cut: .31" (7.87 mm) or .50" (12.7 mm)

Tool Holders with Replaceable Support Blades (Anvils) For 2.095" (53.2 mm) Diameter Bores and Larger.

DB-ID: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
All standard inserts come with .008" (0.2 mm) RAD.



Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Depth of Cut: Up to .31" (7.87 mm)

INSERTS	WIDTH (INCH)	ANVILS	CLAMPS
DB1B04	0.125	L5C04	CL1-1-D04
DB1B05	0.156	L5C05	CL1-1-D06
DB1B06	0.187	L5C06	
DB1B07	0.218	L5C07	CL1-1-D07
DB1B08	0.250		
DB1B09	0.281	L5C09	CL1-1-D09
DB1B10	0.312		
DB1B11	0.343	L5C11	CL1-1-D11
DB1B12	0.375		



Holder Body Options for RH (Right Hand) Round Bars

Min. Bore Dia. 2.095" (53.2 mm)	DB4-1-2805	1.75" Dia. x 10"
Min. Bore Dia. 2.35" (59.7 mm)	DB4-1-3205	2.00" Dia. x 10"

Holder Bodies include anvil and clamp screws.

Depth of Cut: Up to .50" (12.7 mm)

INSERTS	WIDTH (INCH)	ANVILS	CLAMPS
DB1B04	0.125	L5D04	CL1-1-D04
DB1B05	0.156	L5D05	CL1-1-D06
DB1B06	0.187	L5D06	
DB1B07	0.218	L5D07	CL1-1-D07
DB1B08	0.250		
DB1B09	0.281	L5D09	CL1-1-D09
DB1B10	0.312		
DB1B11	0.343	L5D11	CL1-1-D11
DB1B12	0.375		



Holder Body Options for RH (Right Hand) Round Bars

Min. Bore Dia. 2.28" (57.9 mm)	DB4-1-2805	1.75" Dia. x 10"
Min. Bore Dia. 2.53" (64.3 mm)	DB4-1-3205	2.00" Dia. x 10"

Holder Bodies include anvil and clamp screws.

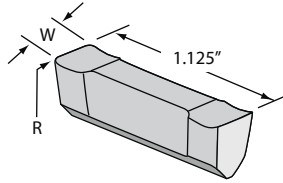
DB SERIES – ID DASH Holders for Deep Grooves

Depth of Cut: .31" (7.87 mm) or .50" (12.7 mm)

Tool Holders with Replaceable Support Blades (Anvils) For 2.095" (53.2 mm) Diameter Bores and Larger.

DB-ID: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
All standard inserts come with .008" (0.2 mm) RAD.



Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Depth of Cut: Up to .31" (7.87 mm)

INSERTS	WIDTH (INCH)	ANVILS	CLAMPS
DB1B04	0.125	R5C04	CR1-1-D04
DB1B05	0.156	R5C05	CR1-1-D06
DB1B06	0.187	R5C06	
DB1B07	0.218	R5C07	CR1-1-D07
DB1B08	0.250		
DB1B09	0.281	R5C09	CR1-1-D09
DB1B10	0.312		
DB1B11	0.343	R5C11	CR1-1-D11
DB1B12	0.375		



Holder Body Options for LH (Left Hand) Round Bars

Min. Bore Dia. 2.095" (53.2 mm)	DB4-1-2855	1.75" Dia. x 10"
Min. Bore Dia. 2.35" (59.7 mm)	DB4-1-3255	2.00" Dia. x 10"

Holder Bodies include anvil and clamp screws.

Depth of Cut: Up to .50" (12.7 mm)

INSERTS	WIDTH (INCH)	ANVILS	CLAMPS
DB1B04	0.125	R5D04	CR1-1-D04
DB1B05	0.156	R5D05	CR1-1-D06
DB1B06	0.187	R5D06	
DB1B07	0.218	R5D07	CR1-1-D07
DB1B08	0.250		
DB1B09	0.281	R5D09	CR1-1-D09
DB1B10	0.312		
DB1B11	0.343	R5D11	CR1-1-D11
DB1B12	0.375		



Holder Body Options for LH (Left Hand) Round Bars

Min. Bore Dia. 2.28" (57.9 mm)	DB4-1-2855	1.75" Dia. x 10"
Min. Bore Dia. 2.53" (64.3 mm)	DB4-1-3255	2.00" Dia. x 10"

Holder Bodies include anvil and clamp screws.

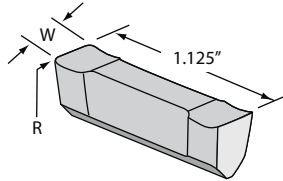
DB SERIES – ID DASH Holders for Deep Grooves

Depth of Cut: .75" (19.05 mm)

Tool Holders with Replaceable Support Blades (Anvils) For 2.53" (64.3 mm) Diameter Bores and Larger.

DB-ID: Dog Bone Style Inserts, Double Ended

.125" (3.175 mm) – .375" (9.525 mm) Wide
All standard inserts come with .008" (0.2 mm) RAD.



Insert Options

Carbide grades, chip breakers and coatings are stocked for applications based on work materials: Steels, Stainless Steels, Cast Irons, Aluminum, Composites. For ordering designations see page 4, or specify work material.

Depth of Cut: Up to .75" (19.05 mm)

INSERTS	WIDTH (INCH)	ANVILS	CLAMPS
DB1B04	0.125	L5E04	CL1-1-E04
DB1B05	0.156	L5E05	CL1-1-E06
DB1B06	0.187	L5E06	
DB1B07	0.218	L5E07	CL1-1-E07
DB1B08	0.250		
DB1B09	0.281	L5E09	CL1-1-E09
DB1B10	0.312		
DB1B11	0.343	L5E11	CL1-1-E11
DB1B12	0.375		



Holder Body Options for RH (Right Hand) Round Bars

Min. Bore Dia. 2.53" (64.3 mm)	DB4-1-2805	1.75" Dia. x 10"
Min. Bore Dia. 2.78" (70.6 mm)	DB4-1-3205	2.00" Dia. x 10"

Holder Bodies include anvil and clamp screws.

Depth of Cut: Up to .75" (19.05 mm)

INSERTS	WIDTH (INCH)	ANVILS	CLAMPS
DB1B04	0.125	R5E04	CR1-1-E04
DB1B05	0.156	R5E05	CR1-1-E06
DB1B06	0.187	R5E06	
DB1B07	0.218	R5E07	CR1-1-E07
DB1B08	0.250		
DB1B09	0.281	R5E09	CR1-1-E09
DB1B10	0.312		
DB1B11	0.343	R5E11	CR1-1-E11
DB1B12	0.375		



Holder Body Options for LH (Left Hand) Round Bars

Min. Bore Dia. 2.53" (64.3 mm)	DB4-1-2855	1.75" Dia. x 10"
Min. Bore Dia. 2.78" (70.6 mm)	DB4-1-3255	2.00" Dia. x 10"

Holder Bodies include anvil and clamp screws.

HOW TO ORDER

Grooving Applications

OD GROOVING

Holder

Type: Straight Right Angle
 R.H. L.H.

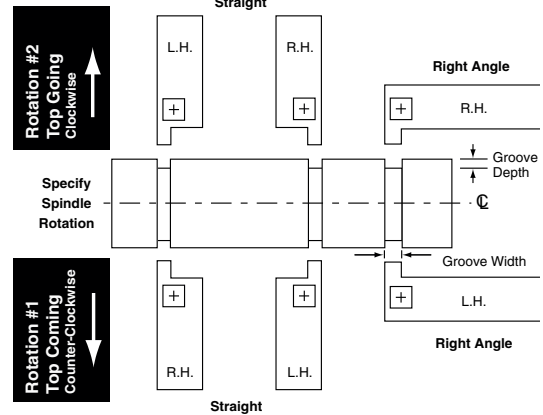
Series: HG GH M8 DB GTH
 Size: (H x W x L) _____ or (Dia. x L) _____

Insert:
 Width _____ Groove Depth _____ Radii _____

Material to Machine _____

Quantities:
 Holders _____ Spare Anvils _____
 Inserts _____

Top View Shown for all Holders



ID GROOVING

Holder

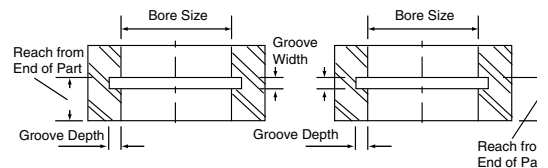
Type: Straight Right Angle
 R.H. L.H.

Series: D M12 DB One Piece DB Dash
 Size: (H x W x L) _____ or (Dia. x L) _____

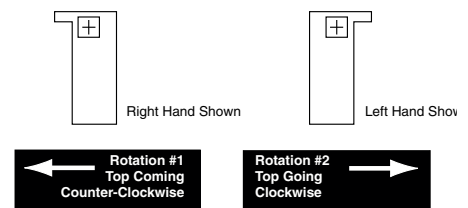
Insert:
 Width _____ Groove Depth _____ Radii _____

Material to Machine _____

Quantities:
 Holders _____ Spare Anvils _____
 Inserts _____



Top View Shown for all Holders



HOW TO ORDER

Face Grooving Applications

Holder

Rotation #1 Holder Detail _____ Rotation #2 Holder Detail _____

Series: HG M5 DB GTH MICRO ADJUSTABLE (see page 25)

Size (H x W x L) _____ Qualified: Yes No

Part Type: 'A' 'B' 'C'

Major Diameter _____ ± _____ Minor Diameter _____ ± _____

Insert:

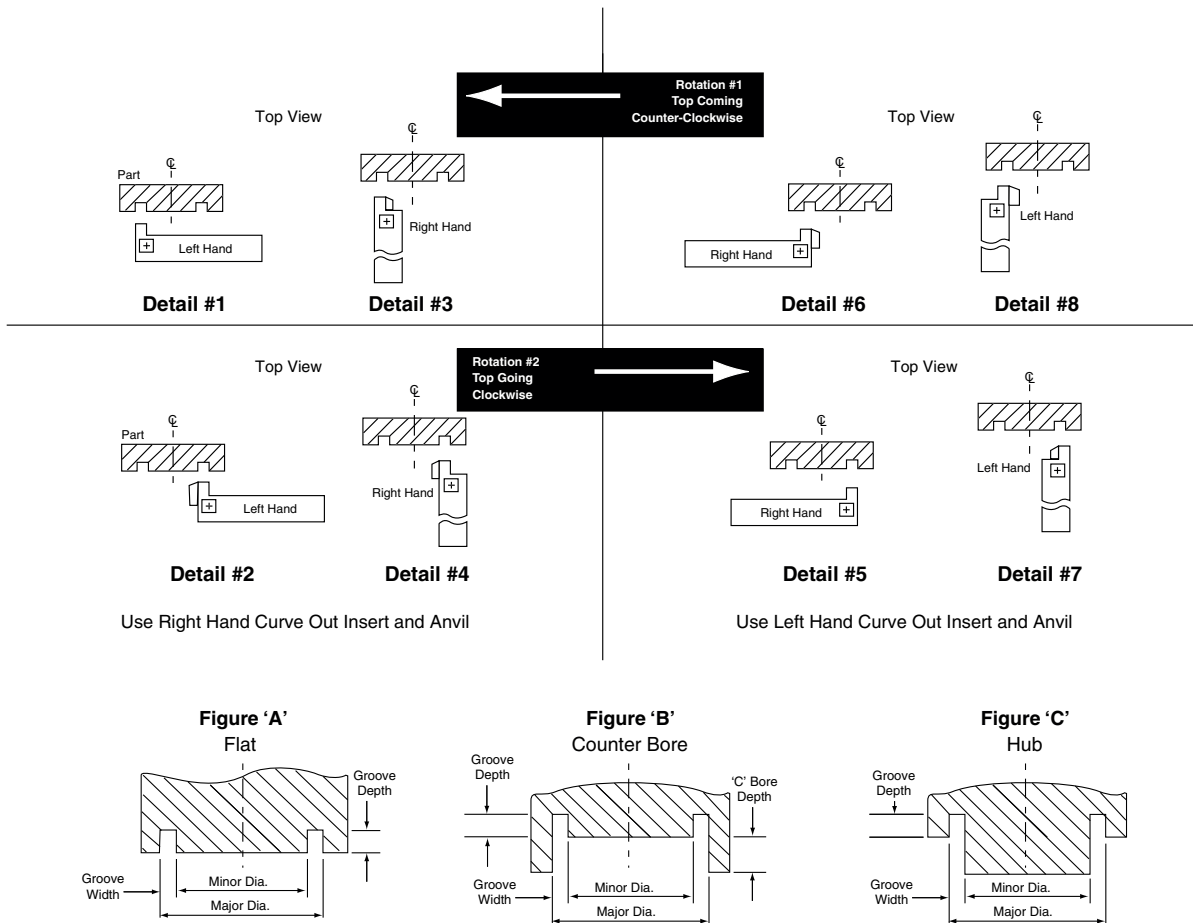
Width _____ Groove Depth _____ Radii _____

Material to Machine _____

Quantities:

Holders _____ Spare Anvils _____ Inserts _____

Submit Part Print or Operation Sketch (if available).



PRODUCTS

Samples of Standard and Special Tools

Samples B-24



Samples B-25



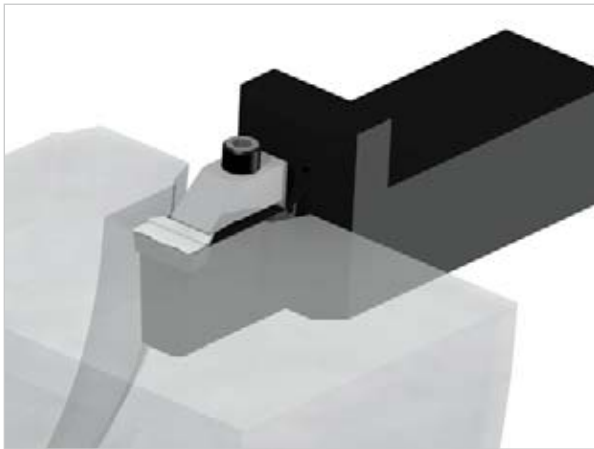
Samples B-26



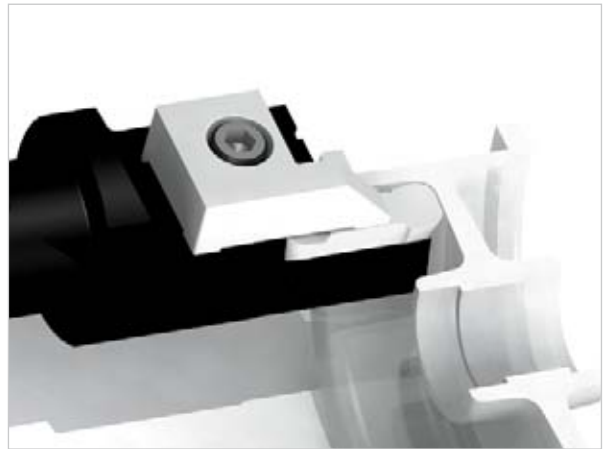
Samples B-27



Samples B-28



Samples B-29



PRODUCTS

Samples of Standard and Special Tools

Samples B-30



Samples B-31



Samples B-32



Samples B-33



Samples B-34



Samples B-35





Allied Tool Products
9334 North 107th Street
Milwaukee, Wisconsin 53224-1121 • USA

Phone: 800.558.5147
Local: 414.355.8280
Fax: 414.355.8297

www.atptools.com