



MAIN CATALOG

MODULAR BORING PROGRAM



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AND MAY BE SUBJECT TO CHANGE**

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## MODULAR BORING SYSTEM

Pinzbohr boring system features a wide range of rough and finish boring heads covering diameters from 6 mm. up to 500 mm.

There are three types of boring heads:

- 1) Rough boring heads (two inserts) with synchronized adjustment.
- 2) Finish boring heads (one insert) with graduated precision dial read out.
- 3) Micro adjustable boring heads (for small diameters) fitting indexable boring bars with also graduated precision dial read out.

All these boring heads are radially adjustable to machine different diameters.

Different arbor designs are available mating the most popular spindles. Extensions and reducers compliment the modular system to offer a complete flexibility across the range.

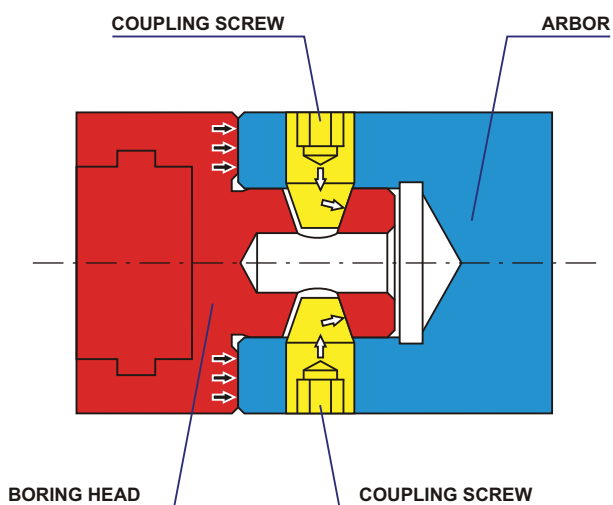
The system features a wide range of ISO standard insert pocket choices and indexable cartridges.

The taper screw design allows tools to be changed without removing from the spindle. Main components are manufactured from Nickel-Chrome alloy steel, heat treated to 58-60 HRC.

Precision ground slides ensure accuracy of adjustment throughout the heads working life.



## COUPLING SYSTEM



### HIGH RIGIDITY

By tightening the two coupling screws, high axial forces are developed in the tapered holes of the arbor. These axial forces preload the contact surface between the flange faces of the coupled components with high axial pressure for ample support against lateral loads. It can also dampen vibrations.

### POSITIVE TOOL ORIENTATION

The locating pin guarantees repeat positioning between components at all times.

**All arbors, extensions and reducers are shipped complete with coupling screws.**

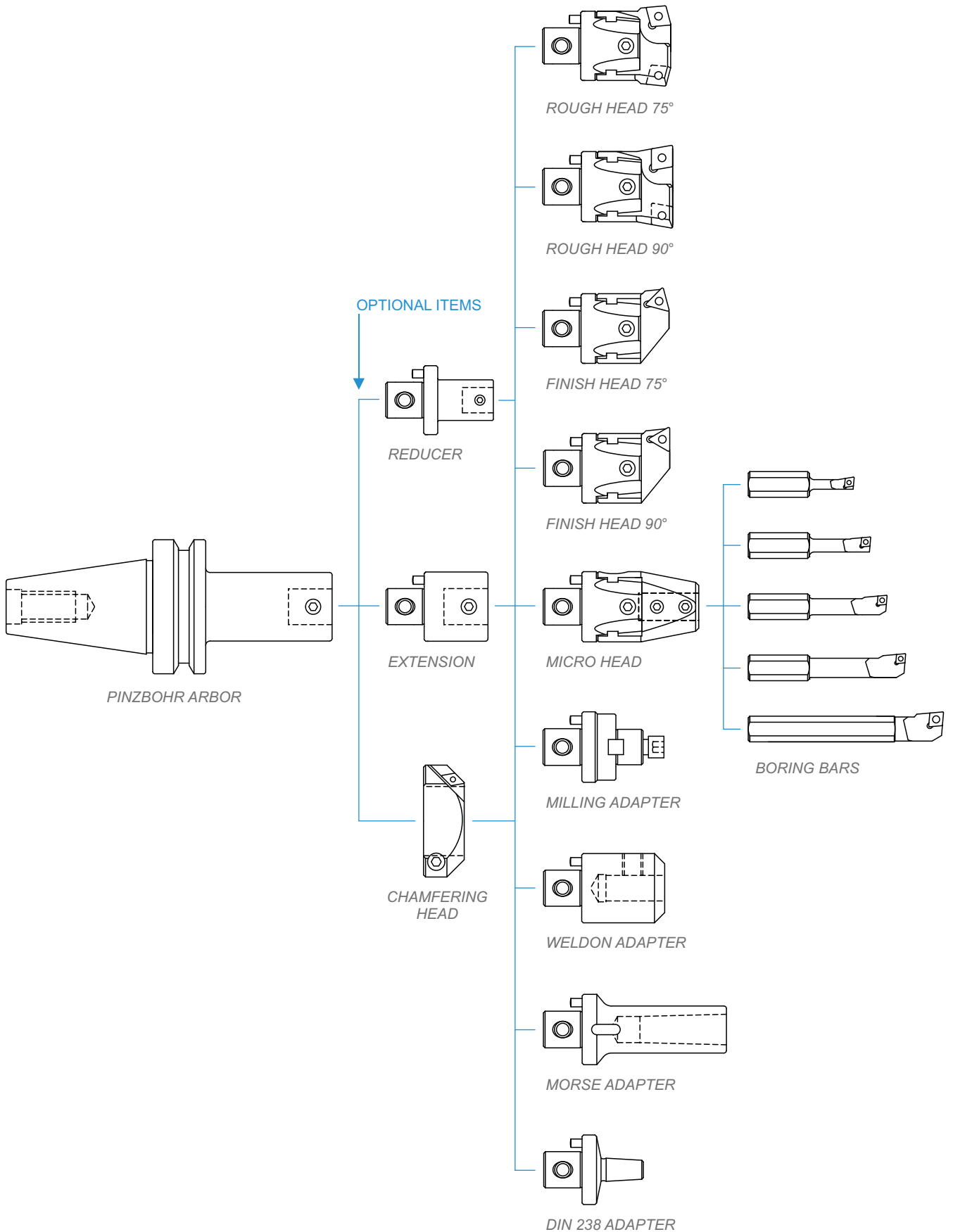
## ADVANTAGES

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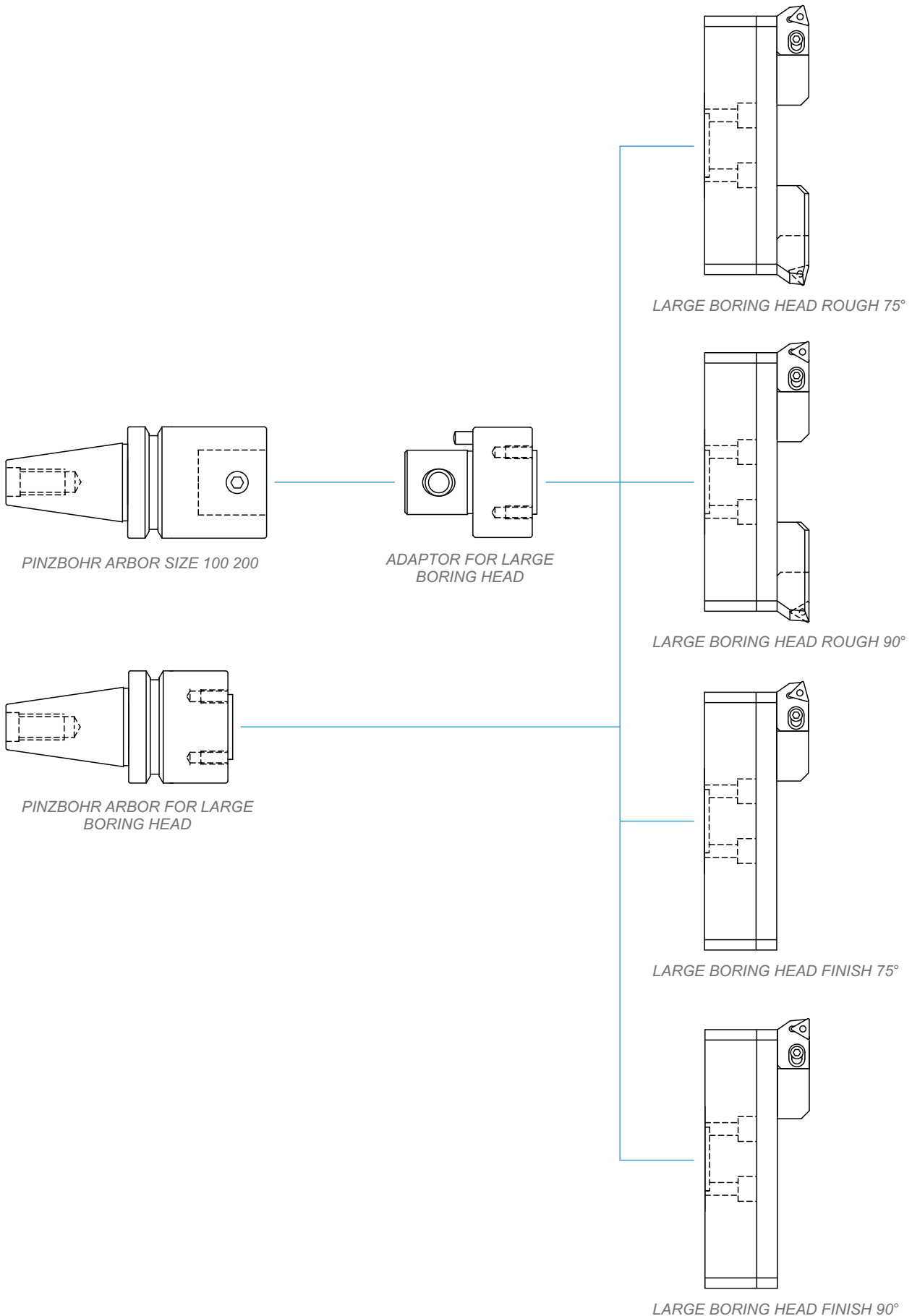
- Practical modular system: different types of boring heads with arbors, extensions, reducers allow price reduction when tooling up the machine.
- Wide range of diameters: 6 to 500 mm.
- High accuracy and rigidity: clamping with taper screws (coupling screws).
- Safety-set assembly: designed to prevent damaging the adjustment screw.
- Synchronized adjustment in rough boring heads (no need pre-setting slides with individual adjustment).
- Fine adjustment in finish boring heads: graduated dial and read out precision up to 0.002 mm. in diameter.
- Cutting tool selection among a wide variety of insert geometries.
- Main components Nickel-Chrome alloy steel heat treated to 58-60 HRC.
- Ground components to ensure accurate production.



# PRODUCT OVERVIEW



# PRODUCT OVERVIEW

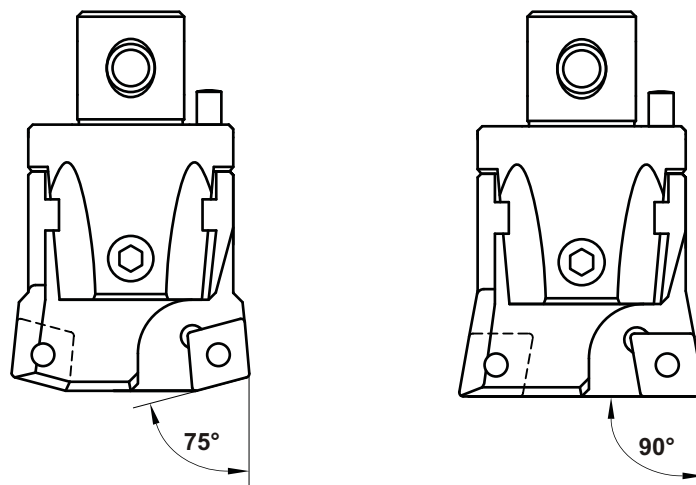


# MODULAR BORING SYSTEM DESCRIPTION

## ROUGH BORING HEADS

These boring heads with two cutting edges do have synchronized adjustment. This advantage means not to waste time in presetting the two cutting edges for a balanced cut (diameter adjustment can be set in the machine directly with a caliper).

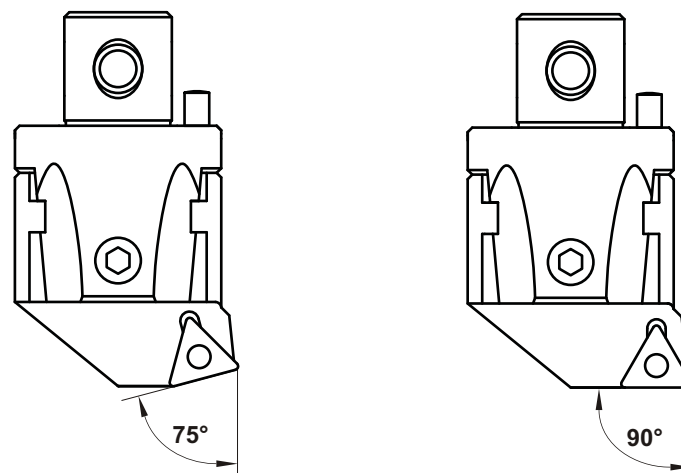
For diameters from 24 mm up to 220 mm, rough boring heads are available in two choices of angle approach: 75° & 90°. And feature various insert pocket geometries to choose.



## FINISH BORING HEADS

These adjustable boring heads do have a read out precision of 0.002 mm Ø.

For diameters from 24 mm up to 220 mm, finish boring heads are available in two choices of angle approach: 75° & 90°. And feature various insert pocket geometries to choose.



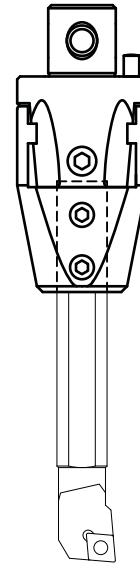


# MODULAR BORING SYSTEM DESCRIPTION

## MICRO BORING HEADS

MICRO boring heads are used in combination with indexable ISO boring bars; these units can produce bores down to 6 mm diameter and up to 38 mm diameter. MICRO boring heads fit the standard Pinzbohr arbors size 27, 32 and 42 (recommended in extra short execution).

Graduated dial and read out precision of 0.002 mm Ø.



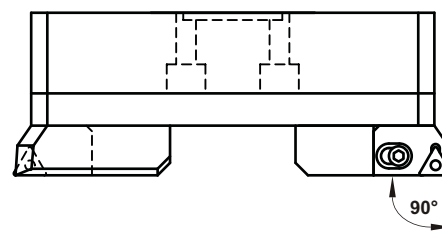
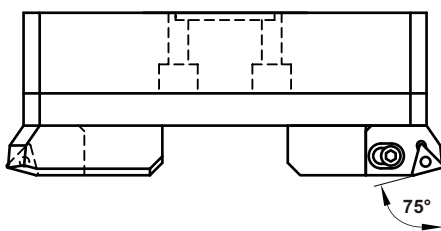
## LARGE DIAMETER BORING HEADS

These boring heads, either rough and finish do have graduated dial and read out precision of 0.002 mm Ø and a diameter range that goes from 220 mm up to 500 mm.

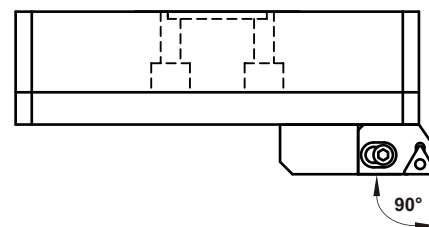
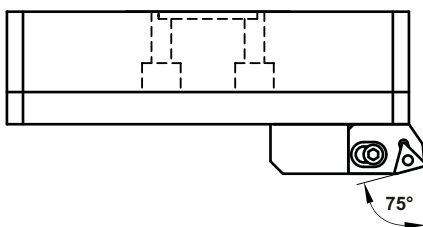
Four (4) facing coupling screws do the assembly of large diameter boring heads to its holder.

By using *ADT 100 050* adaptor it is possible to assemble large diameter boring heads to the standard size *100 200* Pinzbohr arbors to allow the use of longer arbors for deep boring applications.

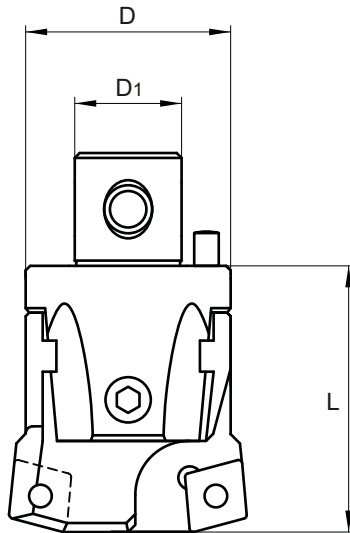
### ROUGH BORING HEADS



### FINISH BORING HEADS



# ROUGH HEADS 75° APPROACH



## INTEGRAL POCKET TYPE HEADS SYNCHRONIZED ADJUSTMENT

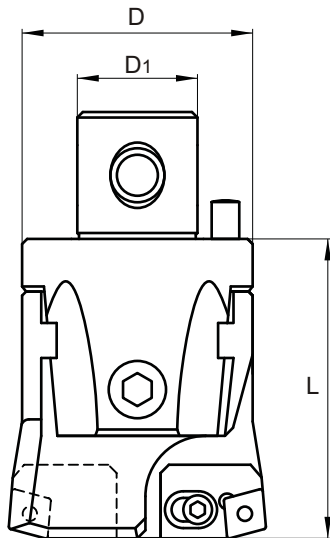


SIZE	Bore Range		Dimension			Product Number	Insert	Torx Screw	Kg.	Adjustment		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
22	24	30	22	12	34	<b>D 02275 400</b>	CC□□ 0602□□	TT 400	0.100	2	T8	3
27	29	40	27	15	42	<b>D 02775 401</b>	CC□□ 0803□□	TT 401	0.170	2	T10	4
	29	40	27	15	42	<b>D 02775 409</b>	CC□□ 09T3□□	TT 409	0.170	2	T15	4
32	39	50	32	20	45	<b>D 03275 401</b>	CC□□ 0803□□	TT 401	0.270	2.5	T10	4
	39	50	32	20	45	<b>D 03275 409</b>	CC□□ 09T3□□	TT 409	0.270	2.5	T15	4
42	49	65	42	24	56	<b>D 04275 300</b>	TC□□ 16T3□□	TT 300	0.550	3	T15	5
	49	65	42	24	56	<b>D 04275 402</b>	CC□□ 1204□□	TT 402	0.550	3	T20	5
	53	65	42	24	56	<b>D 04275 402 N</b>	CN□□ 1204□□ R	TT 402 N	0.550	3	2.5	5
54	63	82	54	28	66	<b>D 05475 300</b>	TC□□ 16T3□□	TT 300	1.080	3	T15	6
	63	82	54	28	66	<b>D 05475 402</b>	CC□□ 1204□□	TT 402	1.080	3	T20	6
	63	82	54	28	66	<b>D 05475 402 N</b>	CN□□ 1204□□ R	TT 402 N	1.080	3	2.5	6

☐ NOMENCLATURE FOR INSERT SELECTION IN PAGE 56

☐ TORX SCREW DETAILS IN PAGE 55

# ROUGH HEADS 75° APPROACH



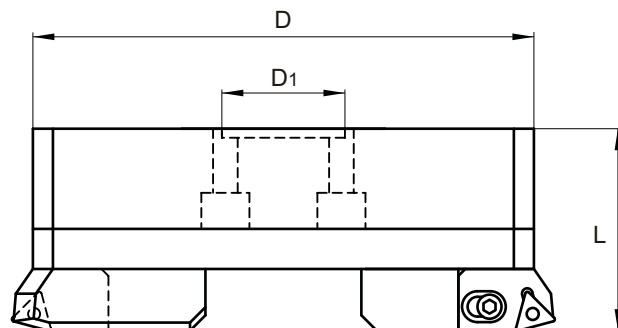
## CARTRIDGE TYPE HEADS SYNCHRONIZED ADJUSTMENT



SIZE	Bore Range		Dimension			Product Number	Cartridge	Torx Screw	Kg.	Adjustment		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
68	80	102	68	36	86	<b>D 06875 300</b>	2CT 75 300	TT 409	2.180	4	T15	8
	80	102	68	36	86	<b>D 06875 402</b>	2CT 75 402	TT 116	2.180	4	T20	8
	80	102	68	36	86	<b>D 06875 402 N</b>	2CT 75 402 N	TT 402 N	2.180	4	2.5	8
85	100	125	85	50	100	<b>D 08575 300</b>	3CT 75 300	TT 300	4.150	5	T15	8
	100	125	85	50	100	<b>D 08575 402</b>	3CT 75 402	TT 402	4.150	5	T20	8
	100	125	85	50	100	<b>D 08575 402 N</b>	3CT 75 402 N	TT 402 N	4.150	5	2.5	8
100	125	160	110	60	100	<b>D 10075 300</b>	3CT 75 300	TT 300	6.580	5	T15	8
	125	160	110	60	100	<b>D 10075 402</b>	3CT 75 402	TT 402	6.580	5	T20	8
	125	160	110	60	100	<b>D 10075 402 N</b>	3CT 75 402 N	TT 402 N	6.580	5	2.5	8
200	160	220	145	60	100	<b>D 20075 300</b>	3CT 75 300	TT 300	8.950	5	T15	8
	160	220	145	60	100	<b>D 20075 402</b>	3CT 75 402	TT 402	8.950	5	T20	8
	160	220	145	60	100	<b>D 20075 402 N</b>	3CT 75 402 N	TT 402 N	8.950	5	2.5	8

📄 FULL CARTRIDGE INFORMATION (INCLUDING INSERT SIZE) IN PAGE 25

# ROUGH HEADS 75° APPROACH



ADJUSTING ACCURACY 0.002 mm Ø



**LARGE DIAMETER CARTRIDGE TYPE HEADS** SYNCHRONIZED ADJUSTMENT



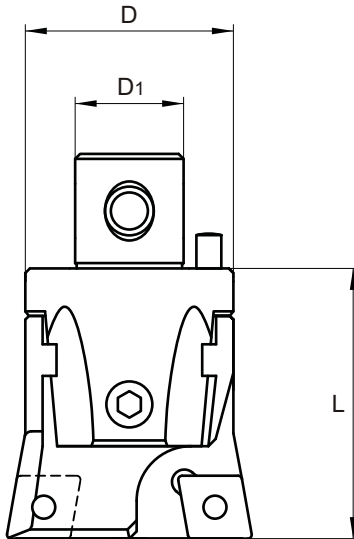
SIZE	Bore Range		Dimension			Product Number	Cartridge	Torx Screw	Kg.	Adjustment		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
300	220	320	202	60	90	<b>D 30075 300</b>	3CT 75 300	TT 300	9.370	5	T15	4
	220	320	202	60	90	<b>D 30075 402</b>	3CT 75 402	TT 402	9.370	5	T20	4
	220	320	202	60	90	<b>D 30075 402 N</b>	3CT 75 402 N	TT 402 N	9.370	5	2.5	4
400	290	400	272	60	90	<b>D 40075 300</b>	3CT 75 300	TT 300	12.980	5	T15	4
	290	400	272	60	90	<b>D 40075 402</b>	3CT 75 402	TT 402	12.980	5	T20	4
	290	400	272	60	90	<b>D 40075 402 N</b>	3CT 75 402 N	TT 402 N	12.980	5	2.5	4
500	370	500	352	60	90	<b>D 50075 300</b>	3CT 75 300	TT 300	16.740	5	T15	4
	370	500	352	60	90	<b>D 50075 402</b>	3CT 75 402	TT 402	16.740	5	T20	4
	370	500	352	60	90	<b>D 50075 402 N</b>	3CT 75 402 N	TT 402 N	16.740	5	2.5	4

FULL CARTRIDGE INFORMATION (INCLUDING INSERT SIZE) IN PAGE 25



**NOTE:** ARBOR ASSEMBLY SYSTEM FOR LARGE BORING HEADS IN PAGE 48

# ROUGH HEADS 90° APPROACH



## INTEGRAL POCKET TYPE HEADS SYNCHRONIZED ADJUSTMENT

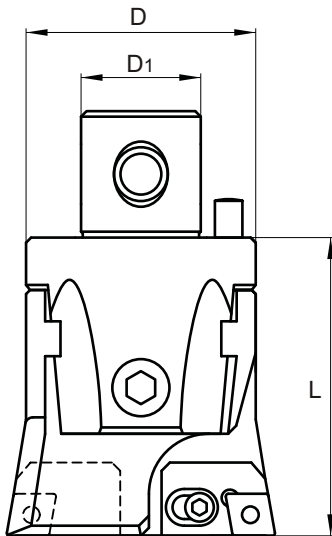


SIZE	Bore Range		Dimension			Product Number	Insert	Torx Screw	Kg.	Adjustment		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
22	24	30	22	12	34	<b>D 02290 400</b>	CC□□ 0602□□	TT 400	0.100	2	T8	3
27	29	40	27	15	42	<b>D 02790 401</b>	CC□□ 0803□□	TT 401	0.170	2	T10	4
	29	40	27	15	42	<b>D 02790 409</b>	CC□□ 09T3□□	TT 409	0.170	2	T15	4
32	39	50	32	20	45	<b>D 03290 401</b>	CC□□ 0803□□	TT 401	0.270	2.5	T10	4
	39	50	32	20	45	<b>D 03290 409</b>	CC□□ 09T3□□	TT 409	0.270	2.5	T15	4
42	49	65	42	24	56	<b>D 04290 300</b>	TC□□ 16T3□□	TT 300	0.550	3	T15	5
	49	65	42	24	56	<b>D 04290 402</b>	CC□□ 1204□□	TT 402	0.550	3	T20	5
	53	65	42	24	56	<b>D 04290 402 N</b>	CN□□ 1204□□ L	TT 402 N	0.550	3	2.5	5
54	63	82	54	28	66	<b>D 05490 300</b>	TC□□ 16T3□□	TT 300	1.080	3	T15	6
	63	82	54	28	66	<b>D 05490 402</b>	CC□□ 1204□□	TT 402	1.080	3	T20	6
	63	82	54	28	66	<b>D 05490 402 N</b>	CN□□ 1204□□ L	TT 402 N	1.080	3	2.5	6

☐ NOMENCLATURE FOR INSERT SELECTION IN PAGE 56

🔑 TORX SCREW DETAILS IN PAGE 55

# ROUGH HEADS 90° APPROACH



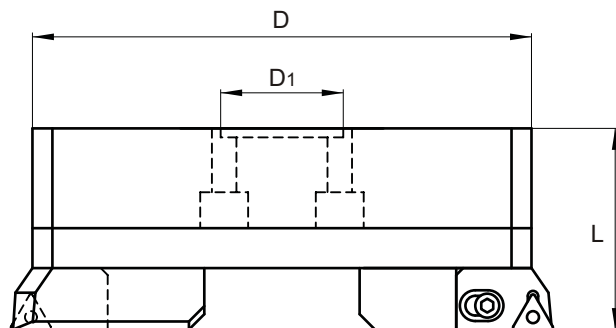
## CARTRIDGE TYPE HEADS SYNCHRONIZED ADJUSTMENT



SIZE	Bore Range		Dimension			Product Number	Cartridge	Torx Screw	Kg.	Adjustment		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
68	80	102	68	36	86	<b>D 06890 300</b>	2CT 90 300	TT 409	2.180	4	T15	8
	80	102	68	36	86	<b>D 06890 402</b>	2CT 90 402	TT 116	2.180	4	T20	8
	80	102	68	36	86	<b>D 06890 402 N</b>	2CT 90 402 N	TT 402 N	2.180	4	2.5	8
85	100	125	85	50	100	<b>D 08590 300</b>	3CT 90 300	TT 300	4.150	5	T15	8
	100	125	85	50	100	<b>D 08590 402</b>	3CT 90 402	TT 402	4.150	5	T20	8
	100	125	85	50	100	<b>D 08590 402 N</b>	3CT 90 402 N	TT 402 N	4.150	5	2.5	8
100	125	160	110	60	100	<b>D 10090 300</b>	3CT 90 300	TT 300	6.580	5	T15	8
	125	160	110	60	100	<b>D 10090 402</b>	3CT 90 402	TT 402	6.580	5	T20	8
	125	160	110	60	100	<b>D 10090 402 N</b>	3CT 90 402 N	TT 402 N	6.580	5	2.5	8
200	160	220	145	60	100	<b>D 20090 300</b>	3CT 90 300	TT 300	8.950	5	T15	8
	160	220	145	60	100	<b>D 20090 402</b>	3CT 90 402	TT 402	8.950	5	T20	8
	160	220	145	60	100	<b>D 20090 402 N</b>	3CT 90 402 N	TT 402 N	8.950	5	2.5	8

📄 FULL CARTRIDGE INFORMATION (INCLUDING INSERT SIZE) IN PAGE 25

# ROUGH HEADS 90° APPROACH



ADJUSTING ACCURACY 0.002 mm Ø



**LARGE DIAMETER CARTRIDGE TYPE HEADS** SYNCHRONIZED ADJUSTMENT



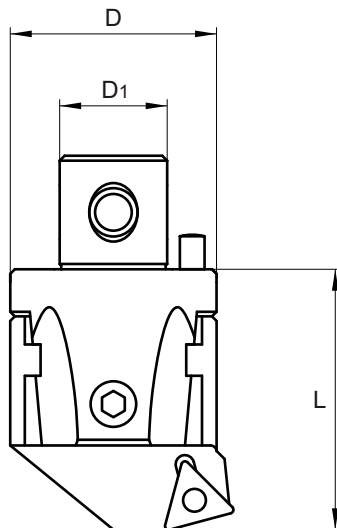
SIZE	Bore Range		Dimension			Product Number	Cartridge	Torx Screw	Kg.	Adjustment		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
300	220	320	202	60	90	<b>D 30090 300</b>	3CT 90 300	TT 300	9.370	5	T15	4
	220	320	202	60	90	<b>D 30090 402</b>	3CT 90 402	TT 402	9.370	5	T20	4
	220	320	202	60	90	<b>D 30090 402 N</b>	3CT 90 402 N	TT 402 N	9.370	5	2.5	4
400	290	400	272	60	90	<b>D 40090 300</b>	3CT 90 300	TT 300	12.980	5	T15	4
	290	400	272	60	90	<b>D 40090 402</b>	3CT 90 402	TT 402	12.980	5	T20	4
	290	400	272	60	90	<b>D 40090 402 N</b>	3CT 90 402 N	TT 402 N	12.980	5	2.5	4
500	370	500	352	60	90	<b>D 50090 300</b>	3CT 90 300	TT 300	16.740	5	T15	4
	370	500	352	60	90	<b>D 50090 402</b>	3CT 90 402	TT 402	16.740	5	T20	4
	370	500	352	60	90	<b>D 50090 402 N</b>	3CT 90 402 N	TT 402 N	16.740	5	2.5	4

FULL CARTRIDGE INFORMATION (INCLUDING INSERT SIZE) IN PAGE 25



**NOTE:** ARBOR ASSEMBLY SYSTEM FOR LARGE BORING HEADS IN PAGE 48

# FINISH HEADS 75° APPROACH



## INTEGRAL POCKET TYPE HEADS ADJUSTING ACCURACY 0.002 mm Ø

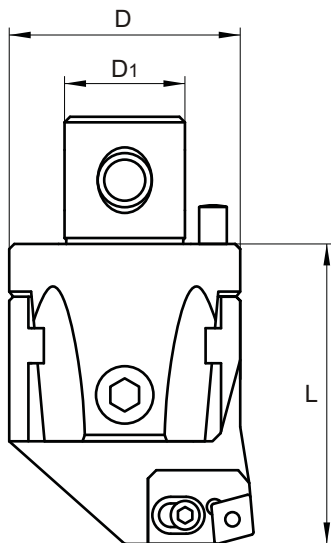
SIZE	Bore Range		Dimension			Product Number	Insert	Torx Screw	Kg.	Adjusting Accuracy		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
22	24	30	22	12	34	A 02275 310	TP □□ 0902□□	TT 400	0.100	2	T8	3
	24	30	22	12	34	A 02275 400	CC □□ 0602□□	TT 400	0.100	2	T8	3
27	29	40	27	15	42	A 02775 310	TP □□ 0902□□	TT 400	0.160	2	T8	4
	29	40	27	15	42	A 02775 401	CC □□ 0803□□	TT 401	0.160	2	T10	4
	29	40	27	15	42	A 02775 409	CC □□ 09T3□□	TT 409	0.160	2	T15	4
32	39	50	32	20	45	A 03275 310	TP □□ 0902□□	TT 400	0.250	2.5	T8	4
	39	50	32	20	45	A 03275 401	CC □□ 0803□□	TT 401	0.250	2.5	T10	4
	39	50	32	20	45	A 03275 409	CC □□ 09T3□□	TT 409	0.250	2.5	T15	4
42	49	65	42	24	56	A 04275 300	TC □□ 16T3□□	TT 300	0.510	3	T15	5
	49	65	42	24	56	A 04275 311	TP □□ 1103□□	TT 401	0.510	3	T10	5
54	63	82	54	28	66	A 05475 300	TC □□ 16T3□□	TT 300	1.020	3	T15	6
	63	82	54	28	66	A 05475 311	TP □□ 1103□□	TT 401	1.020	3	T10	6

NOMENCLATURE FOR INSERT SELECTION IN PAGE 56

TORX SCREW DETAILS IN PAGE 55



# FINISH HEADS 75° APPROACH



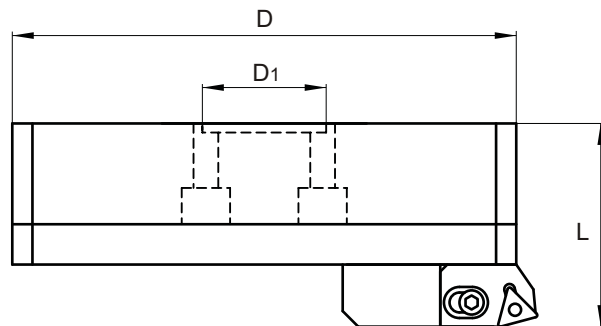
**CARTRIDGE TYPE HEADS** ADJUSTING ACCURACY 0.002 mm Ø



SIZE	Bore Range		Dimension			Product Number	Cartridge	Torx Screw	Kg.	Adjustment		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
68	80	102	68	36	86	<b>A 06875 300</b>	2CT 75 300	TT 409	2.050	5	T15	8
	80	102	68	36	86	<b>A 06875 311</b>	2CT 75 311	TT 401	2.050	5	T10	8
	80	102	68	36	86	<b>A 06875 402</b>	2CT 75 402	TT 116	2.050	5	T20	8
	80	102	68	36	86	<b>A 06875 402 N</b>	2CT 75 402 N	TT 402 N	2.050	5	2.5	8
85	100	125	85	50	100	<b>A 08575 300</b>	3CT 75 300	TT 300	3.930	6	T15	8
	100	125	85	50	100	<b>A 08575 311</b>	3CT 75 311	TT 401	3.930	6	T10	8
	100	125	85	50	100	<b>A 08575 402</b>	3CT 75 402	TT 402	3.930	6	T20	8
	100	125	85	50	100	<b>A 08575 402 N</b>	3CT 75 402 N	TT 402 N	3.930	6	2.5	8
100	125	160	110	60	100	<b>A 10075 300</b>	3CT 75 300	TT 300	6.250	6	T15	8
	125	160	110	60	100	<b>A 10075 311</b>	3CT 75 311	TT 401	6.250	6	T10	8
	125	160	110	60	100	<b>A 10075 402</b>	3CT 75 402	TT 402	6.250	6	T20	8
	125	160	110	60	100	<b>A 10075 402 N</b>	3CT 75 402 N	TT 402 N	6.250	6	2.5	8
200	160	220	145	60	100	<b>A 20075 300</b>	3CT 75 300	TT 300	8.330	6	T15	8
	160	220	145	60	100	<b>A 20075 311</b>	3CT 75 311	TT 401	8.330	6	T10	8
	160	220	145	60	100	<b>A 20075 402</b>	3CT 75 402	TT 402	8.330	6	T20	8
	160	220	145	60	100	<b>A 20075 402 N</b>	3CT 75 402 N	TT 402 N	8.330	6	2.5	8

📄 FULL CARTRIDGE INFORMATION (INCLUDING INSERT SIZE) IN PAGE 25

# FINISH HEADS 75° APPROACH



## LARGE DIAMETER CARTRIDGE TYPE HEADS ADJUSTING ACCURACY 0.002 mm Ø



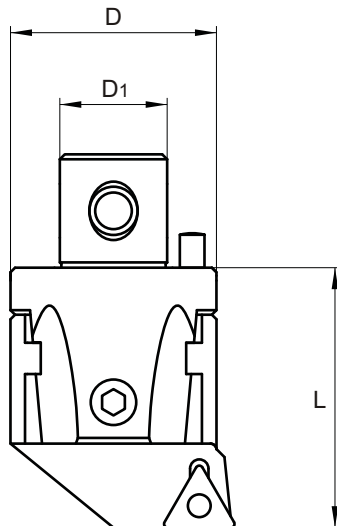
SIZE	Bore Range		Dimension			Product Number	Cartridge	Torx Screw	Kg.	Adjusting Accuracy		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
300	220	320	202	60	90	A 30075 300	3CT 75 300	TT 300	8.750	5	T15	4
	220	320	202	60	90	A 30075 311	3CT 75 311	TT 401	8.750	5	T10	4
	220	320	202	60	90	A 30075 402	3CT 75 402	TT 402	8.750	5	T20	4
	220	320	202	60	90	A 30075 402 N	3CT 75 402 N	TT 402 N	8.750	5	2.5	4
400	290	400	272	60	90	A 40075 300	3CT 75 300	TT 300	12.200	5	T15	4
	290	400	272	60	90	A 40075 311	3CT 75 311	TT 401	12.200	5	T10	4
	290	400	272	60	90	A 40075 402	3CT 75 402	TT 402	12.200	5	T20	4
	290	400	272	60	90	A 40075 402 N	3CT 75 402 N	TT 402 N	12.200	5	2.5	4
500	370	500	352	60	90	A 50075 300	3CT 75 300	TT 300	16.310	5	T15	4
	370	500	352	60	90	A 50075 311	3CT 75 311	TT 401	16.310	5	T10	4
	370	500	352	60	90	A 50075 402	3CT 75 402	TT 402	16.310	5	T20	4
	370	500	352	60	90	A 50075 402 N	3CT 75 402 N	TT 402 N	16.310	5	2.5	4

📄 FULL CARTRIDGE INFORMATION (INCLUDING INSERT SIZE) IN PAGE 25



**NOTE:** ARBOR ASSEMBLY SYSTEM FOR LARGE BORING HEADS IN PAGE 48

# FINISH HEADS 90° APPROACH



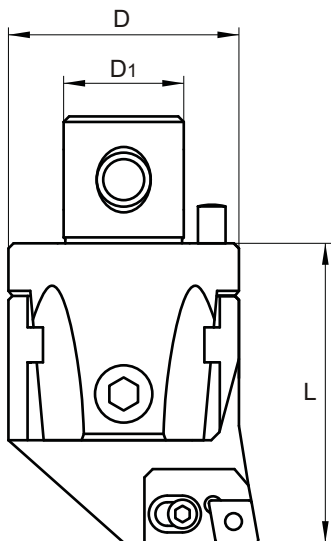
## INTEGRAL POCKET TYPE HEADS ADJUSTING ACCURACY 0.002 mm Ø

SIZE	Bore Range		Dimension			Product Number	Insert	Torx Screw	Kg.	Adjusting Accuracy		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
22	24	30	22	12	34	A 02290 310	TP□□ 0902□□	TT 400	0.100	2	T8	3
	24	30	22	12	34	A 02290 400	CC□□ 0602□□	TT 400	0.100	2	T8	3
27	29	40	27	15	42	A 02790 310	TP□□ 0902□□	TT 400	0.160	2	T8	4
	29	40	27	15	42	A 02790 401	CC□□ 0803□□	TT 401	0.160	2	T10	4
	29	40	27	15	42	A 02790 409	CC□□ 09T3□□	TT 409	0.160	2	T15	4
32	39	50	32	20	45	A 03290 300	TC□□ 16T3□□	TT 409	0.250	2.5	T15	4
	39	50	32	20	45	A 03290 310	TP□□ 0902□□	TT 400	0.250	2.5	T8	4
	39	50	32	20	45	A 03290 401	CC□□ 0803□□	TT 401	0.250	2.5	T10	4
	39	50	32	20	45	A 03290 409	CC□□ 09T3□□	TT 409	0.250	2.5	T15	4
42	49	65	42	24	56	A 04290 300	TC□□ 16T3□□	TT 300	0.510	3	T15	5
	49	65	42	24	56	A 04290 311	TP□□ 1103□□	TT 401	0.510	3	T10	5
	49	65	42	24	56	A 04290 402	CC□□ 1204□□	TT 402	0.510	3	T20	5
	53	65	42	24	56	A 04290 402 N	CN□□ 1204□□ L	TT 402 N	0.510	3	2.5	5
54	63	82	54	28	66	A 05490 300	TC□□ 16T3□□	TT 300	1.020	3	T15	6
	63	82	54	28	66	A 05490 311	TP□□ 1103□□	TT 401	1.020	3	T10	6
	63	82	54	28	66	A 05490 402	CC□□ 1204□□	TT 402	1.020	3	T20	6
	63	82	54	28	66	A 05490 402 N	CN□□ 1204□□ L	TT 402 N	1.020	3	2.5	6

NOMENCLATURE FOR INSERT SELECTION IN PAGE 56

TORX SCREW DETAILS IN PAGE 55

# FINISH HEADS 90° APPROACH



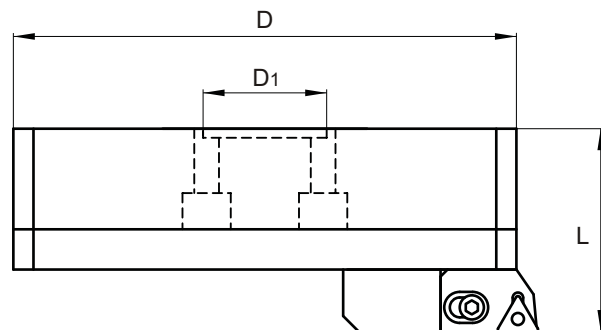
## CARTRIDGE TYPE HEADS ADJUSTING ACCURACY 0.002 mm Ø



SIZE	Bore Range		Dimension			Product Number	Cartridge	Torx Screw	Kg.	Adjusting Accuracy		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
68	80	102	68	36	86	A 06890 300	2CT 90 300	TT 409	2.050	5	T15	8
	80	102	68	36	86	A 06890 311	2CT 90 311	TT 401	2.050	5	T10	8
	80	102	68	36	86	A 06890 402	2CT 90 402	TT 116	2.050	5	T20	8
	80	102	68	36	86	A 06890 402 N	2CT 90 402 N	TT 402 N	2.050	5	2.5	8
85	100	125	85	50	100	A 08590 300	3CT 90 300	TT 300	3.930	6	T15	8
	100	125	85	50	100	A 08590 311	3CT 90 311	TT 401	3.930	6	T10	8
	100	125	85	50	100	A 08590 402	3CT 90 402	TT 402	3.930	6	T20	8
	100	125	85	50	100	A 08590 402 N	3CT 90 402 N	TT 402 N	3.930	6	2.5	8
100	125	160	110	60	100	A 10090 300	3CT 90 300	TT 300	6.250	6	T15	8
	125	160	110	60	100	A 10090 311	3CT 90 311	TT 401	6.250	6	T10	8
	125	160	110	60	100	A 10090 402	3CT 90 402	TT 402	6.250	6	T20	8
	125	160	110	60	100	A 10090 402 N	3CT 90 402 N	TT 402 N	6.250	6	2.5	8
200	160	220	145	60	100	A 20090 300	3CT 90 300	TT 300	8.330	6	T15	8
	160	220	145	60	100	A 20090 311	3CT 90 311	TT 401	8.330	6	T10	8
	160	220	145	60	100	A 20090 402	3CT 90 402	TT 402	8.330	6	T20	8
	160	220	145	60	100	A 20090 402 N	3CT 90 402 N	TT 402 N	8.330	6	2.5	8

📄 FULL CARTRIDGE INFORMATION (INCLUDING INSERT SIZE) IN PAGE 25

# FINISH HEADS 90° APPROACH



## LARGE DIAMETER CARTRIDGE TYPE HEADS ADJUSTING ACCURACY 0.002 mm Ø



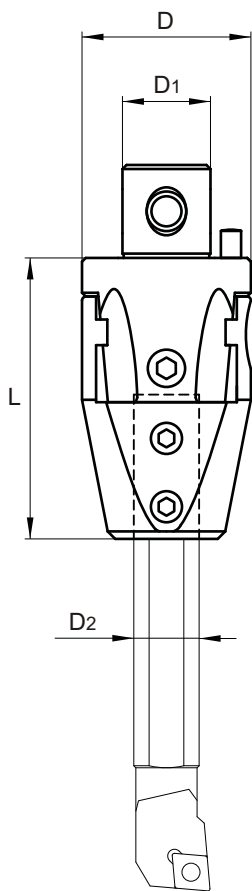
SIZE	Bore Range		Dimension			Product Number	Cartridge	Torx Screw	Kg.	Adjusting Accuracy		
	Min	Max	øD	øD1	L					Adj. Key	Torx Key	Locking Key
300	220	320	202	60	90	A 30090 300	3CT 90 300	TT 300	8.750	5	T15	4
	220	320	202	60	90	A 30090 311	3CT 90 311	TT 401	8.750	5	T10	4
	220	320	202	60	90	A 30090 402	3CT 90 402	TT 402	8.750	5	T20	4
	220	320	202	60	90	A 30090 402 N	3CT 90 402 N	TT 402 N	8.750	5	2.5	4
400	290	400	272	60	90	A 40090 300	3CT 90 300	TT 300	12.200	5	T15	4
	290	400	272	60	90	A 40090 311	3CT 90 311	TT 401	12.200	5	T10	4
	290	400	272	60	90	A 40090 402	3CT 90 402	TT 402	12.200	5	T20	4
	290	400	272	60	90	A 40090 402 N	3CT 90 402 N	TT 402 N	12.200	5	2.5	4
500	370	500	352	60	90	A 50090 300	3CT 90 300	TT 300	16.310	5	T15	4
	370	500	352	60	90	A 50090 311	3CT 90 311	TT 401	16.310	5	T10	4
	370	500	352	60	90	A 50090 402	3CT 90 402	TT 402	16.310	5	T20	4
	370	500	352	60	90	A 50090 402 N	3CT 90 402 N	TT 402 N	16.310	5	2.5	4

📄 FULL CARTRIDGE INFORMATION (INCLUDING INSERT SIZE) IN PAGE 25



**NOTE:** ARBOR ASSEMBLY SYSTEM FOR LARGE BORING HEADS IN PAGE 48

# MICRO BORING HEADS

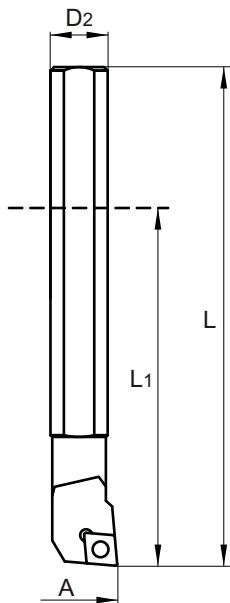


## HEADS FOR ISO BORING BARS ADJUSTING ACCURACY 0.002 mm Ø



SIZE	Bore Range		Dimension				Product Number	Kg.	Adjustment	
	Min	Max	øD	øD1	øD2	L			Adj. Key	Locking Key
27	8	20	27	15	6	50	A 027 006	0.210	2	4
27	10	21	27	15	8	50	A 027 008	0.200	2	4
32	10	21	32	20	8	58	A 032 008	0.330	2.5	4
32	13	25	32	20	10	58	A 032 010	0.330	2.5	4
42	13	29	42	24	10	70	A 042 010	0.660	3	5
42	16	34	42	24	12	70	A 042 012	0.660	3	5
42	20	38	42	24	16	70	A 042 016	0.630	3	5

# ISO BORING BARS



## STEEL SHANK BORING BARS

Dimension				ISO Boring bar	Insert	Torx Screw	Torx Key
øD2	øA	L	L1				
6	8	70	46	<b>S06E SELPR 04</b>	EP□□ 0401□□ L	TT 102	T6
6	8	70	46	<b>S06E SELPR 05</b>	EP□□ 0502□□	TT 106	T7
8	10	80	50	<b>S08F SCLCR 06</b>	CC□□ 0602□□	TT 110	T8
10	13	90	54	<b>S10G SCLCR 06</b>	CC□□ 0602□□	TT 400	T8
12	16	100	64	<b>S12H SCLCR 06</b>	CC□□ 0602□□	TT 400	T8
16	20	110	74	<b>S16J SCLCR 09</b>	CC□□ 09T3□□	TT 409	T15
16	20	110	74	<b>S16J STF CR 09</b>	TC□□ 0902□□	TT 108	T7
16	20	110	74	<b>S16J STF CR 16</b>	TC□□ 16T3□□	TT 409	T15

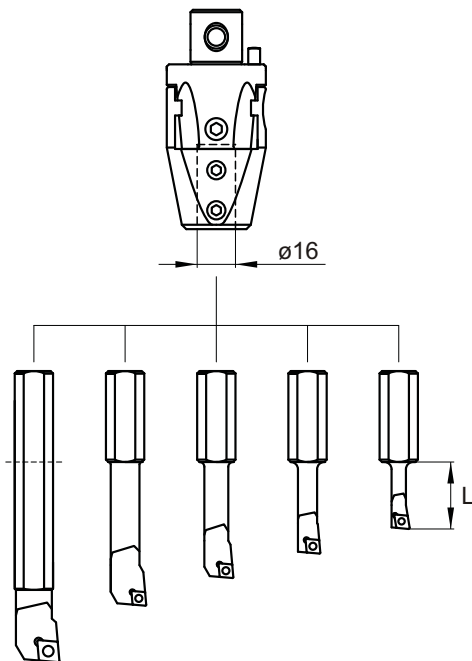
## CARBIDE SHANK BORING BARS

Dimension				ISO Boring bar	Insert	Torx Screw	Torx Key
øD2	øA	L	L1				
6	8	80	56	<b>C06F SELPR 04</b>	EP□□ 0401□□ L	TT 102	T6
8	10	90	60	<b>C08G SCLCR 06</b>	CC□□ 0602□□	TT 110	T8
10	13	110	74	<b>C10J SCLCR 06</b>	CC□□ 0602□□	TT 400	T8
12	16	125	89	<b>C12K SCLCR 06</b>	CC□□ 0602□□	TT 400	T8
16	20	140	104	<b>C16L SCLCR 09</b>	CC□□ 09T3□□	TT 409	T15

☐ NOMENCLATURE FOR INSERT SELECTION IN PAGE 56

☐ TORX SCREW DETAILS IN PAGE 55

# INDEXABLE BORING BARS FOR A 042 016



## RHOMBIC INSERT

Bore Range		L	Product Number	Insert	Torx Screw	Torx Key
Min	Max					
6	24	20	<b>S05/16 SELPR 04</b>	EP□□ 0401□□ L	TT 100	T6
8	26	25	<b>S06/16 SELPR 04</b>	EP□□ 0401□□ L	TT 102	T6
8	26	25	<b>S06/16 SELPR 05</b>	EP□□ 0502□□	TT 106	T7
10	28	35	<b>S08/16 SCLCR 06</b>	CC□□ 0602□□	TT 110	T8
13	31	45	<b>S10/16 SCLCR 06</b>	CC□□ 0602□□	TT 400	T8
16	34	57	<b>S12/16 SCLCR 06</b>	CC□□ 0602□□	TT 400	T8
20	38	73	<b>S16/16 SCLCR 09</b>	CC□□ 09T3□□	TT 409	T15

## TRIANGULAR INSERT

Bore Range		L	Product Number	Insert	Torx Screw	Torx Key
Min	Max					
8	26	25	<b>S06/16 STF CR 06</b>	TC□□ 06T1□□	TT 104	T6
10	28	35	<b>S08/16 STF CR 06</b>	TC□□ 06T1□□	TT 104	T6
13	31	45	<b>S10/16 STF CR 09</b>	TC□□ 0902□□	TT 108	T7
16	34	57	<b>S12/16 STF CR 09</b>	TC□□ 0902□□	TT 108	T7
20	38	73	<b>S16/16 STF CR 09</b>	TC□□ 0902□□	TT 108	T7
20	38	73	<b>S16/16 STF CR 16</b>	TC□□ 16T3□□	TT 409	T15

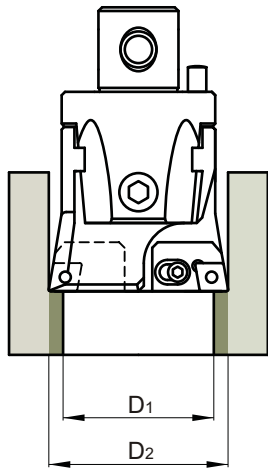
☐ NOMENCLATURE FOR INSERT SELECTION IN PAGE 56

☐ TORX SCREW DETAILS IN PAGE 55

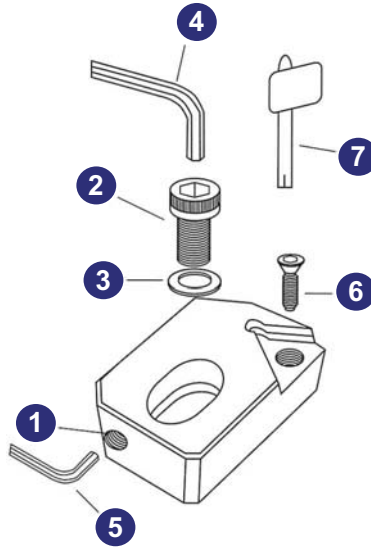


# INDEXABLE STANDARD CARTRIDGES

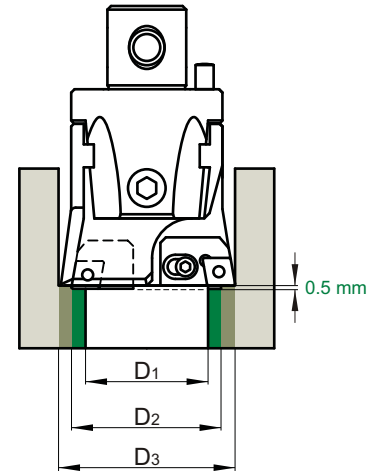
## SYMETRICAL BORING



2CT □□ □□ + 2CT □□ □□  
or 3CT □□ □□ + 3CT □□ □□



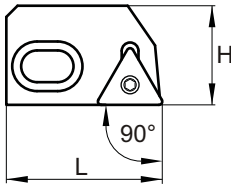
## STAGGERED BORING



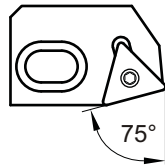
2CT □□ □□ S + 2CT □□ □□  
or 3CT □□ □□ S + 3CT □□ □□

STAGGERED CARTRIDGES IN NEXT PAGE

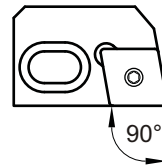
TYPE 90 300



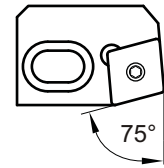
TYPE 75 300



TYPE 90 402



TYPE 75 402



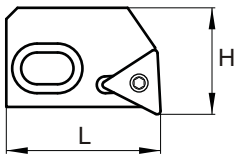
Product Number	Dimension		Kg.	Insert	1	2	3	4	5	6	7
	H	L									
2CT 75 300	22.5	35	0.050	TC□□ 16T3□□	D 068 29	A 068 26	D 068 28	5	2	TT 409	T15
2CT 75 311	22.5	35	0.050	TP□□ 1103□□	D 068 29	A 068 26	D 068 28	5	2	TT 401	T10
2CT 75 402	22.5	35	0.050	CC□□ 1204□□	D 068 29	A 068 26	D 068 28	5	2	TT 116	T20
2CT 75 402 N	22.5	35	0.070	CN□□ 1204□□ R	D 068 29	A 068 26	D 068 28	5	2	TT 402 N	2.5
2CT 90 300	22.5	35	0.050	TC□□ 16T3□□	D 068 29	A 068 26	D 068 28	5	2	TT 409	T15
2CT 90 311	22.5	35	0.050	TP□□ 1103□□	D 068 29	A 068 26	D 068 28	5	2	TT 401	T10
2CT 90 402	22.5	35	0.050	CC□□ 1204□□	D 068 29	A 068 26	D 068 28	5	2	TT 116	T20
2CT 90 402 N	22.5	35	0.070	CN□□ 1204□□ L	D 068 29	A 068 26	D 068 28	5	2	TT 402 N	2.5
3CT 75 300	28	39	0.100	TC□□ 16T3□□	D 085 29	D 085 27	D 068 28	5	3	TT 300	T15
3CT 75 311	28	39	0.100	TP□□ 1103□□	D 085 29	D 085 27	D 068 28	5	3	TT 401	T10
3CT 75 402	28	39	0.100	CC□□ 1204□□	D 085 29	D 085 27	D 068 28	5	3	TT 402	T20
3CT 75 402 N	28	39	0.120	CN□□ 1204□□ R	D 085 29	D 085 27	D 068 28	5	3	TT 402 N	2.5
3CT 90 300	28	39	0.100	TC□□ 16T3□□	D 085 29	D 085 27	D 068 28	5	3	TT 300	T15
3CT 90 311	28	39	0.100	TP□□ 1103□□	D 085 29	D 085 27	D 068 28	5	3	TT 401	T10
3CT 90 402	28	39	0.100	CC□□ 1204□□	D 085 29	D 085 27	D 068 28	5	3	TT 402	T20
3CT 90 402 N	28	39	0.120	CN□□ 1204□□ L	D 085 29	D 085 27	D 068 28	5	3	TT 402 N	2.5

☐ NOMENCLATURE FOR INSERT SELECTION IN PAGE 56

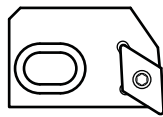
🔩 TORX SCREW DETAILS IN PAGE 55

# INDEXABLE SPECIAL CARTRIDGES

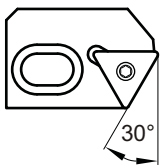
TYPE GR 300



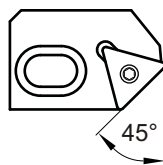
TYPE GR 411



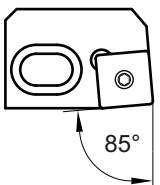
TYPE 30 300



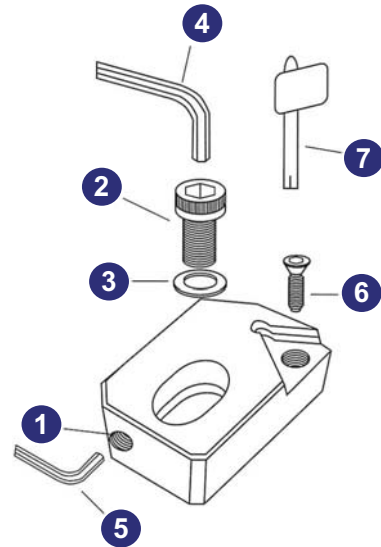
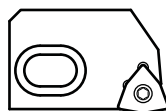
TYPE 45 300



TYPE 85 502



TYPE W06 / W08



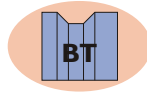
Product Number	Dimension		Kg.	Insert	1	2	3	4	5	6	7
	H	L									
2CT GR 300	25	36	0.050	TC □□ 16T3□□	D 068 29	A 068 26	D 068 28	5	2	TT 409	T15
2CT GR 411	25	36	0.050	DC □□ 11T3□□	D 068 29	A 068 26	D 068 28	5	2	TT 409	T15
2CT 30 300	22.5	35	0.050	TC □□ 16T3□□	D 068 29	A 068 26	D 068 28	5	2	TT 409	T15
2CT 45 300	22.5	35	0.050	TC □□ 16T3□□	D 068 29	A 068 26	D 068 28	5	2	TT 409	T15
2CT 85 502	22.5	35	0.050	SC □□ 1204□□	D 068 29	A 068 26	D 068 28	5	2	TT 116	T20
2CT 90 W06	23.5	35	0.050	WC □□ 06T3□□	D 068 29	A 068 26	D 068 28	5	2	TT 112	T9
2CT 90 W06 S	24	33	0.050	WC □□ 06T3□□	D 068 29	A 068 26	D 068 28	5	2	TT 112	T9
2CT 90 300 S	23	33	0.050	TC □□ 16T3□□	D 068 29	A 068 26	D 068 28	5	2	TT 409	T15
2CT 90 402 S	23	33	0.050	CC □□ 1204□□	D 068 29	A 068 26	D 068 28	5	2	TT 116	T20
2CT 90 402 N S	23	33	0.070	CN □□ 1204□□ L	D 068 29	A 068 26	D 068 28	5	2	TT 402 N	2.5
3CT GR 300	30	40	0.100	TC □□ 16T3□□	D 085 29	D 085 27	D 068 28	5	3	TT 300	T15
3CT GR 411	30	40	0.100	DC □□ 11T3□□	D 085 29	D 085 27	D 068 28	5	3	TT 300	T15
3CT 30 300	28	39	0.100	TC □□ 16T3□□	D 085 29	D 085 27	D 068 28	5	3	TT 300	T15
3CT 45 300	28	39	0.100	TC □□ 16T3□□	D 085 29	D 085 27	D 068 28	5	3	TT 300	T15
3CT 85 502	28	39	0.100	SC □□ 1204□□	D 085 29	D 085 27	D 068 28	5	3	TT 402	T20
3CT 90 W08	29	39	0.100	WC □□ 0804□□	D 085 29	D 085 27	D 068 28	5	3	TT 114	T15
3CT 90 W08 S	29.5	37	0.100	WC □□ 0804□□	D 085 29	D 085 27	D 068 28	5	3	TT 114	T15
3CT 90 300 S	28.5	37	0.100	TC □□ 16T3□□	D 085 29	D 085 27	D 068 28	5	3	TT 300	T15
3CT 90 402 S	28.5	37	0.100	CC □□ 1204□□	D 085 29	D 085 27	D 068 28	5	3	TT 402	T20
3CT 90 402 N S	28.5	37	0.120	CN □□ 1204□□ L	D 085 29	D 085 27	D 068 28	5	3	TT 402 N	2.5

☐ NOMENCLATURE FOR INSERT SELECTION IN PAGE 56

🔩 TORX SCREW DETAILS IN PAGE 55

# ARBORS FOR BORING HEADS

## MAS BT 403

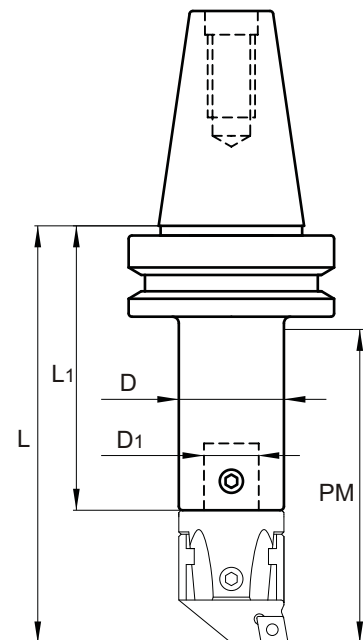


### ISO 30

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	125	91	100	<b>BT 330 022 100</b>	0.650	22-68
27	27	15	77	35	55	<b>BT 330 027 055</b>	0.480	27-610
	27	15	125	83	100	<b>BT 330 027 100</b>	0.700	27-610
32	32	20	83	38	60	<b>BT 330 032 060</b>	0.490	32-810
	32	20	125	80	100	<b>BT 330 032 100</b>	0.760	32-810
42	42	24	100	44	75	<b>BT 330 042 075</b>	0.590	42-1014

### ISO 40

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	80	46	50	<b>BT 340 022 050</b>	1.100	22-68
	22	12	110	76	80	<b>BT 340 022 080</b>	1.200	22-68
	22	12	130	96	100	<b>BT 340 022 100</b>	1.250	22-68
27	27	15	82	40	55	<b>BT 340 027 055</b>	1.100	27-610
	27	15	130	88	100	<b>BT 340 027 100</b>	1.310	27-610
	27	15	160	118	130	<b>BT 340 027 130</b>	1.450	27-610
32	32	20	88	43	60	<b>BT 340 032 060</b>	1.140	32-810
	32	20	130	85	100	<b>BT 340 032 100</b>	1.390	32-810
	32	20	160	115	130	<b>BT 340 032 130</b>	1.580	32-810
42	42	24	104	48	75	<b>BT 340 042 075</b>	1.180	42-1014
	42	24	190	134	160	<b>BT 340 042 160</b>	2.120	42-1014
	42	24	230	174	200	<b>BT 340 042 200</b>	2.600	42-1014
54	54	28	120	54	90	<b>BT 340 054 090</b>	1.350	54-1220
	54	28	190	124	160	<b>BT 340 054 160</b>	2.610	54-1220
	54	28	230	164	200	<b>BT 340 054 200</b>	3.370	54-1220
68	68	36	181	95	160	<b>BT 340 068 160</b>	2.600	68-1624
	68	36	221	135	200	<b>BT 340 068 200</b>	3.760	68-1624
85	85	50	220	120	200	<b>BT 340 085 200</b>	4.210	85-1630
100 200	100	60	220	120	200	<b>BT 340 100 200</b>	4.910	100-2035



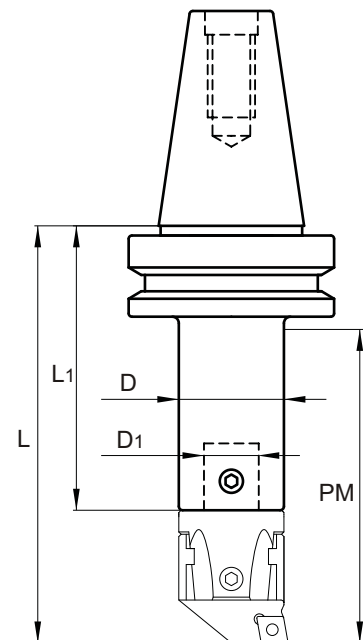
# ARBORS FOR BORING HEADS

## MAS BT 403



ISO 45 (UPON REQUEST)

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	116	82	80	<b>BT 345 022 080</b>	2.550	22-68
	22	12	136	102	100	<b>BT 345 022 100</b>	2.610	22-68
27	27	15	88	46	55	<b>BT 345 027 055</b>	2.550	27-610
	27	15	136	94	100	<b>BT 345 027 100</b>	2.750	27-610
	27	15	166	124	130	<b>BT 345 027 130</b>	2.800	27-610
32	32	20	94	49	60	<b>BT 345 032 060</b>	2.550	32-810
	32	20	166	121	130	<b>BT 345 032 130</b>	2.950	32-810
	32	20	196	151	160	<b>BT 345 032 160</b>	3.200	32-810
42	42	24	110	54	75	<b>BT 345 042 075</b>	2.650	42-1014
	42	24	196	140	160	<b>BT 345 042 160</b>	3.500	42-1014
	42	24	236	180	200	<b>BT 345 042 200</b>	4.000	42-1014
54	54	28	123	57	90	<b>BT 345 054 090</b>	2.850	54-1220
	54	28	196	130	160	<b>BT 345 054 160</b>	4.100	54-1220
	54	28	236	170	200	<b>BT 345 054 200</b>	4.800	54-1220
68	68	36	237	151	200	<b>BT 345 068 200</b>	5.550	68-1624
	68	36	297	211	260	<b>BT 345 068 260</b>	7.250	68-1624
85	85	50	236	136	200	<b>BT 345 085 200</b>	6.100	85-1630
	85	50	296	196	260	<b>BT 345 085 260</b>	8.850	85-1630
	85	50	356	256	320	<b>BT 345 085 320</b>	11.650	85-1630



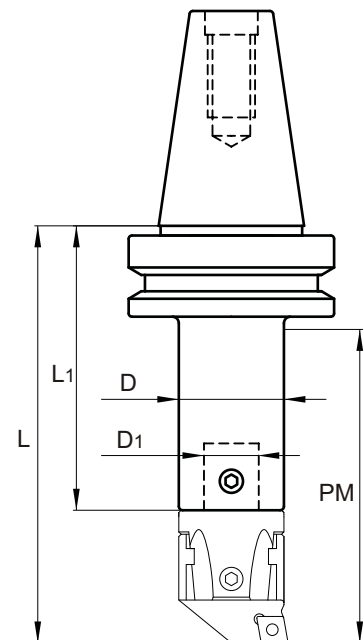
# ARBORS FOR BORING HEADS

## MAS BT 403



### ISO 50

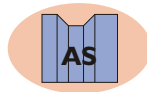
SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	121	87	80	<b>BT 350 022 080</b>	3.980	22-68
	22	12	141	107	100	<b>BT 350 022 100</b>	4.050	22-68
27	27	15	93	51	55	<b>BT 350 027 055</b>	3.870	27-610
	27	15	141	99	100	<b>BT 350 027 100</b>	4.080	27-610
	27	15	171	129	130	<b>BT 350 027 130</b>	4.220	27-610
32	32	20	99	54	60	<b>BT 350 032 060</b>	3.870	32-810
	32	20	171	126	130	<b>BT 350 032 130</b>	4.340	32-810
	32	20	201	156	160	<b>BT 350 032 160</b>	4.520	32-810
42	42	24	115	59	75	<b>BT 350 042 075</b>	3.930	42-1014
	42	24	201	145	160	<b>BT 350 042 160</b>	4.900	42-1014
	42	24	241	185	200	<b>BT 350 042 200</b>	5.400	42-1014
54	54	28	131	65	90	<b>BT 350 054 090</b>	4.110	54-1220
	54	28	201	135	160	<b>BT 350 054 160</b>	5.400	54-1220
	54	28	241	175	200	<b>BT 350 054 200</b>	6.100	54-1220
68	68	36	154	68	115	<b>BT 350 068 115</b>	4.280	68-1624
	68	36	242	156	200	<b>BT 350 068 200</b>	6.820	68-1624
	68	36	302	216	260	<b>BT 350 068 260</b>	8.600	68-1624
85	85	50	242	142	200	<b>BT 350 085 200</b>	7.520	85-1630
	85	50	302	202	260	<b>BT 350 085 260</b>	10.270	85-1630
	85	50	362	262	320	<b>BT 350 085 320</b>	13.080	85-1630
100 200	100	60	195	95	170	<b>BT 350 100 170</b>	5.780	100-2035
	100	60	302	202	260	<b>BT 350 100 260</b>	12.460	100-2035
	100	60	362	262	320	<b>BT 350 100 320</b>	16.080	100-2035
300 400 500	100	60	160	70	125	<b>*BT 550 160</b>	6.010	TF 100



\* SEE PAGE 48: THE ASSEMBLY SYSTEM FOR LARGE BORING HEADS

# ARBORS FOR BORING HEADS

DIN 69871

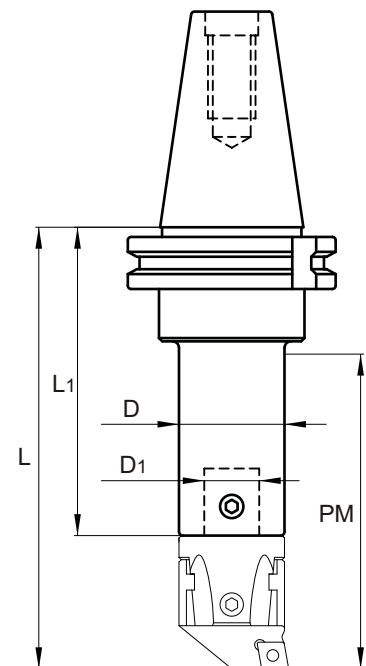


## ISO 30

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	138	104	100	AS 330 022 100	0.700	22-68
27	27	15	90	48	55	AS 330 027 055	0.560	27-610
	27	15	138	96	100	AS 330 027 100	0.740	27-610
32	32	20	96	51	60	AS 330 032 060	0.580	32-810
	32	20	138	93	100	AS 330 032 100	0.800	32-810

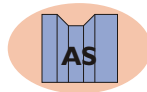
## ISO 40

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	118	84	80	AS 340 022 080	1.230	22-68
	22	12	138	104	100	AS 340 022 100	1.300	22-68
27	27	15	90	48	55	AS 340 027 055	1.130	27-610
	27	15	138	96	100	AS 340 027 100	1.350	27-610
	27	15	168	126	130	AS 340 027 130	1.490	27-610
32	32	20	96	51	60	AS 340 032 060	1.140	32-810
	32	20	138	93	100	AS 340 032 100	1.400	32-810
	32	20	168	123	130	AS 340 032 130	1.590	32-810
42	42	24	112	56	75	AS 340 042 075	1.200	42-1014
	42	24	182	126	160	AS 340 042 160	1.980	42-1014
	42	24	222	166	200	AS 340 042 200	2.460	42-1014
54	54	28	142	76	120	AS 340 054 120	1.630	54-1220
	54	28	182	116	160	AS 340 054 160	2.360	54-1220
	54	28	222	156	200	AS 340 054 200	3.110	54-1220
68	68	36	183	97	160	AS 340 068 160	2.480	68-1624
	68	36	223	137	200	AS 340 068 200	3.630	68-1624
85	85	50	224	124	200	AS 340 085 200	4.240	85-1630
100 200	100	60	224	124	200	AS 340 100 200	5.160	100-2035



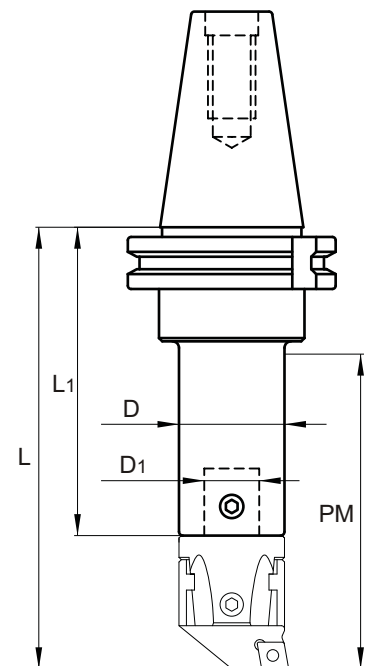
# ARBORS FOR BORING HEADS

**DIN 69871**



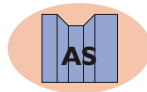
**ISO 45** (UPON REQUEST)

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	118	84	80	<b>AS 345 022 080</b>	2.250	22-68
	22	12	138	104	100	<b>AS 345 022 100</b>	2.350	22-68
27	27	15	90	48	55	<b>AS 345 027 055</b>	2.010	27-610
	27	15	138	96	100	<b>AS 345 027 100</b>	2.400	27-610
	27	15	168	126	130	<b>AS 345 027 130</b>	2.600	27-610
32	32	20	96	51	60	<b>AS 345 032 060</b>	1.800	32-810
	32	20	168	123	130	<b>AS 345 032 130</b>	2.850	32-810
	32	20	198	153	160	<b>AS 345 032 160</b>	3.100	32-810
42	42	24	112	56	75	<b>AS 345 042 075</b>	2.100	42-1014
	42	24	198	142	160	<b>AS 345 042 160</b>	3.000	42-1014
	42	24	238	182	200	<b>AS 345 042 200</b>	3.300	42-1014
54	54	28	125	59	90	<b>AS 345 054 090</b>	2.400	54-1220
	54	28	182	116	160	<b>AS 345 054 160</b>	3.900	54-1220
	54	28	222	156	200	<b>AS 345 054 200</b>	4.650	54-1220
68	68	36	223	137	200	<b>AS 345 068 200</b>	4.800	68-1624
	68	36	283	197	260	<b>AS 345 068 260</b>	6.650	68-1624
85	85	50	224	124	200	<b>AS 345 085 200</b>	5.400	85-1630
	85	50	284	184	260	<b>AS 345 085 260</b>	8.150	85-1630
	85	50	344	244	320	<b>AS 345 085 320</b>	8.900	85-1630



# ARBORS FOR BORING HEADS

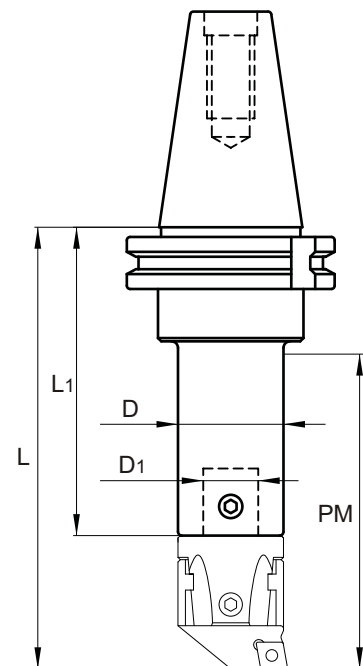
DIN 69871



ISO 50

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	118	84	80	<b>AS 350 022 080</b>	3.450	22-68
	22	12	138	104	100	<b>AS 350 022 100</b>	3.500	22-68
27	27	15	90	48	55	<b>AS 350 027 055</b>	3.300	27-610
	27	15	138	96	100	<b>AS 350 027 100</b>	3.550	27-610
	27	15	168	126	130	<b>AS 350 027 130</b>	3.680	27-610
32	32	20	96	51	60	<b>AS 350 032 060</b>	3.310	32-810
	32	20	168	123	130	<b>AS 350 032 130</b>	3.790	32-810
	32	20	198	153	160	<b>AS 350 032 160</b>	3.980	32-810
42	42	24	112	56	75	<b>AS 350 042 075</b>	3.390	42-1014
	42	24	198	142	160	<b>AS 350 042 160</b>	4.360	42-1014
	42	24	238	182	200	<b>AS 350 042 200</b>	4.860	42-1014
54	54	28	128	62	90	<b>AS 350 054 090</b>	3.570	54-1220
	54	28	198	132	160	<b>AS 350 054 160</b>	4.850	54-1220
	54	28	238	172	200	<b>AS 350 054 200</b>	5.570	54-1220
68	68	36	151	65	115	<b>AS 350 068 115</b>	3.740	68-1624
	68	36	223	137	200	<b>AS 350 068 200</b>	5.800	68-1624
	68	36	283	197	260	<b>AS 350 068 260</b>	7.600	68-1624
85	85	50	224	124	200	<b>AS 350 085 200</b>	6.300	85-1630
	85	50	284	184	260	<b>AS 350 085 260</b>	9.040	85-1630
	85	50	344	244	320	<b>AS 350 085 320</b>	11.700	85-1630
100 200	100	60	214	114	190	<b>AS 350 100 190</b>	6.600	100-2035
	100	60	284	184	260	<b>AS 350 100 260</b>	11.000	100-2035
	100	60	344	244	320	<b>AS 350 100 320</b>	14.660	100-2035
300 400 500	100	60	160	70	125	<b>* AS 550 160</b>	5.650	TF 100

\* SEE PAGE 48: THE ASSEMBLY SYSTEM FOR LARGE BORING HEADS





# ARBORS FOR BORING HEADS

DIN 2080

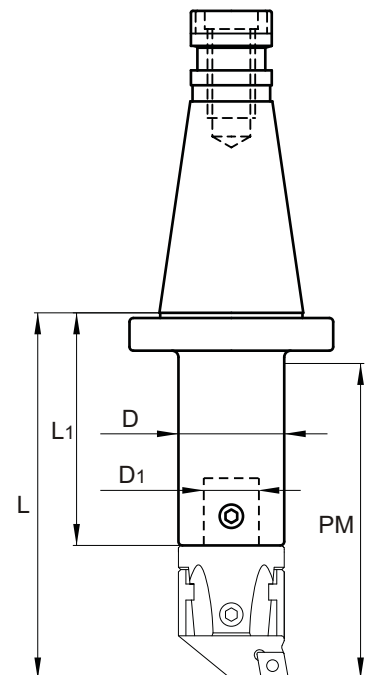
OTT

## ISO 30

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	113	79	100	<b>OTT 330 022 100</b>	0.570	22-68
27	27	15	65	23	55	<b>OTT 330 027 055</b>	0.490	27-610
	27	15	113	71	100	<b>OTT 330 027 100</b>	0.630	27-610
32	32	20	71	26	60	<b>OTT 330 032 060</b>	0.420	32-810
	32	20	113	68	100	<b>OTT 330 032 100</b>	0.680	32-810
42	42	24	87	31	75	<b>OTT 330 042 075</b>	0.510	42-1014

## ISO 40

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	95	61	80	<b>OTT 340 022 080</b>	0.980	22-68
	22	12	115	81	100	<b>OTT 340 022 100</b>	1.050	22-68
27	27	15	67	25	55	<b>OTT 340 027 055</b>	0.900	27-610
	27	15	115	73	100	<b>OTT 340 027 100</b>	1.110	27-610
	27	15	145	103	130	<b>OTT 340 027 130</b>	1.250	27-610
32	32	20	73	28	60	<b>OTT 340 032 060</b>	0.900	32-810
	32	20	115	70	100	<b>OTT 340 032 100</b>	1.160	32-810
	32	20	145	100	130	<b>OTT 340 032 130</b>	1.360	32-810
42	42	24	89	33	75	<b>OTT 340 042 075</b>	0.970	42-1014
	42	24	175	119	160	<b>OTT 340 042 160</b>	1.910	42-1014
	42	24	215	159	200	<b>OTT 340 042 200</b>	2.390	42-1014
54	54	28	105	39	90	<b>OTT 340 054 090</b>	1.100	54-1220
	54	28	175	109	160	<b>OTT 340 054 160</b>	2.370	54-1220
	54	28	215	149	200	<b>OTT 340 054 200</b>	3.140	54-1220
68	68	36	176	90	160	<b>OTT 340 068 160</b>	2.570	68-1624
	68	36	216	130	200	<b>OTT 340 068 200</b>	3.730	68-1624
85	85	50	211	111	200	<b>OTT 340 085 200</b>	4.110	85-1630
100 200	100	60	211	111	200	<b>OTT 340 100 200</b>	5.010	100-2035



# ARBORS FOR BORING HEADS

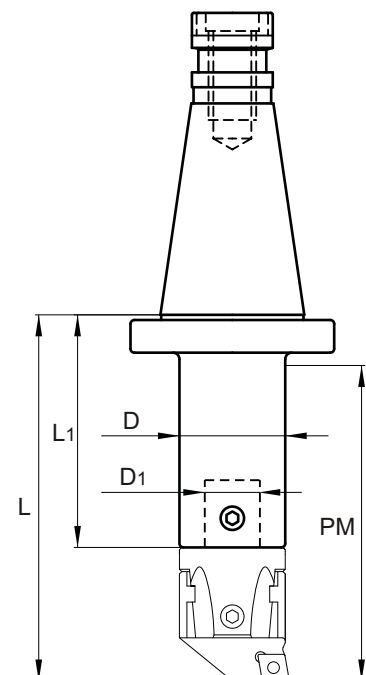
DIN 2080

OTT

ISO 50

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	99	65	80	OTT 350 022 080	2.980	22-68
	22	12	119	85	100	OTT 350 022 100	3.010	22-68
27	27	15	71	29	55	OTT 350 027 055	2.930	27-610
	27	15	119	77	100	OTT 350 027 100	3.090	27-610
	27	15	149	107	130	OTT 350 027 130	3.200	27-610
32	32	20	77	32	60	OTT 350 032 060	2.840	32-810
	32	20	149	104	130	OTT 350 032 130	3.320	32-810
	32	20	179	134	160	OTT 350 032 160	3.510	32-810
42	42	24	93	37	75	OTT 350 042 075	2.920	42-1014
	42	24	179	123	160	OTT 350 042 160	3.870	42-1014
	42	24	219	163	200	OTT 350 042 200	4.380	42-1014
54	54	28	109	43	90	OTT 350 054 090	3.100	54-1220
	54	28	179	113	160	OTT 350 054 160	4.380	54-1220
	54	28	219	153	200	OTT 350 054 200	5.100	54-1220
68	68	36	132	46	115	OTT 350 068 115	3.290	68-1624
	68	36	220	134	200	OTT 350 068 200	5.820	68-1624
	68	36	280	194	260	OTT 350 068 260	7.590	68-1624
85	85	50	221	121	200	OTT 350 085 200	6.500	85-1630
	85	50	281	181	260	OTT 350 085 260	9.560	85-1630
	85	50	341	241	320	OTT 350 085 320	11.840	85-1630
100 200	100	60	193	93	170	OTT 350 100 170	5.680	100-2035
	100	60	281	181	260	OTT 350 100 260	11.250	100-2035
	100	60	341	241	320	OTT 350 100 320	15.100	100-2035
300 400 500	100	60	160	70	125	*OTT 550 160	5.910	TF 100

\* SEE PAGE 48: THE ASSEMBLY SYSTEM FOR LARGE BORING HEADS



# ARBORS FOR BORING HEADS

**DIN 69893**



## HSK 50

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	81	47	55	<b>HSK 050A 022 055</b>	0.490	22-68
27	27	15	91	49	65	<b>HSK 050A 027 065</b>	0.570	27-610
32	32	20	101	56	75	<b>HSK 050A 032 075</b>	0.660	32-810
42	42	24	116	60	90	<b>HSK 050A 042 090</b>	0.730	42-1014

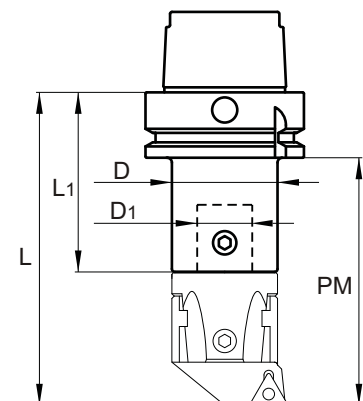


## HSK 63

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	81	47	55	<b>HSK 063A 022 055</b>	0.750	22-68
27	27	15	91	49	65	<b>HSK 063A 027 065</b>	0.780	27-610
32	32	20	101	56	75	<b>HSK 063A 032 075</b>	0.840	32-810
42	42	24	116	60	90	<b>HSK 063A 042 090</b>	0.980	42-1014
54	54	28	136	70	110	<b>HSK 063A 054 110</b>	1.300	54-1220
68	68	36	171	85	145	<b>HSK 063A 068 145</b>	1.850	68-1624

## HSK 100

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	89	55	55	<b>HSK 100A 022 055</b>	2.280	22-68
27	27	15	99	57	65	<b>HSK 100A 027 065</b>	2.350	27-610
32	32	20	104	59	75	<b>HSK 100A 032 075</b>	2.330	32-810
42	42	24	119	63	90	<b>HSK 100A 042 090</b>	2.470	42-1014
54	54	28	139	73	110	<b>HSK 100A 054 110</b>	2.800	54-1220
68	68	36	174	88	145	<b>HSK 100A 068 145</b>	3.510	68-1624
85	85	50	194	94	165	<b>HSK 100A 085 165</b>	4.150	85-1630
100	100	60	214	114	185	<b>HSK 100A 100 185</b>	5.670	100-2035
300	100	60	170	80	140	<b>* HSK 550 160</b>	5.240	TF 100



\* SEE PAGE 48: THE ASSEMBLY SYSTEM FOR LARGE BORING HEADS

# ARBORS FOR BORING HEADS

## DIN 228

### MORSE 2,3,4

#### MORSE 2

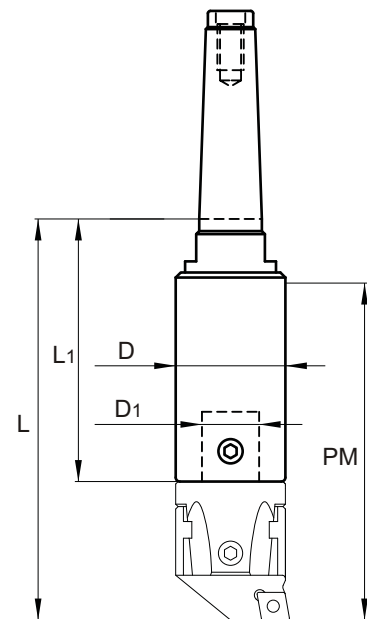
SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	105	71	80	<b>302 022 080</b>	0.370	22-68
27	27	15	73	31	55	<b>302 027 055</b>	0.200	27-610
	27	15	128	83	100	<b>302 027 100</b>	0.480	27-610

#### MORSE 3

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	110	76	80	<b>303 022 080</b>	0.630	22-68
27	27	15	78	36	55	<b>303 027 055</b>	0.410	27-610
	27	15	130	88	100	<b>303 027 100</b>	0.680	27-610
32	32	20	84	39	60	<b>303 032 060</b>	0.420	32-810
	32	20	160	115	130	<b>303 032 130</b>	1.020	32-810
42	42	24	114	58	90	<b>303 042 090</b>	0.700	42-1014
	42	24	160	104	130	<b>303 042 130</b>	1.250	42-1014

#### MORSE 4

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	136	102	100	<b>304 022 100</b>	1.080	22-68
	22	12	166	132	130	<b>304 022 130</b>	1.170	22-68
27	27	15	82	40	55	<b>304 027 055</b>	0.800	27-610
	27	15	137	95	100	<b>304 027 100</b>	1.080	27-610
	27	15	167	125	130	<b>304 027 130</b>	1.240	27-610
32	32	20	88	43	60	<b>304 032 060</b>	0.810	32-810
	32	20	166	121	130	<b>304 032 130</b>	1.380	32-810
	32	20	196	151	160	<b>304 032 160</b>	1.570	32-810
42	42	24	104	48	75	<b>304 042 075</b>	0.870	42-1014
	42	24	166	110	130	<b>304 042 130</b>	1.570	42-1014
	42	24	196	140	160	<b>304 042 160</b>	1.970	42-1014
54	54	28	120	54	90	<b>304 054 090</b>	1.030	54-1220
	54	28	196	130	160	<b>304 054 160</b>	2.450	54-1220
	54	28	236	170	200	<b>304 054 200</b>	3.180	54-1220
68	68	36	235	149	200	<b>304 068 200</b>	3.870	68-1624
	68	36	295	209	260	<b>304 068 260</b>	5.890	68-1624



# ARBORS FOR BORING HEADS

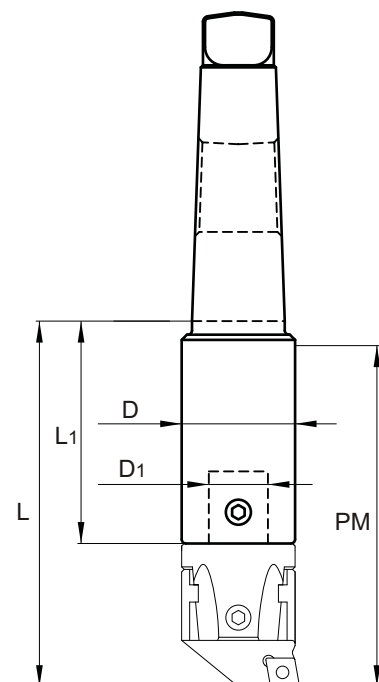
**DIN 1806**

**MORSE 5**

## MORSE 5

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	112	78	100	<b>305 022 100</b>	1.680	22-68
	22	12	142	108	130	<b>305 022 130</b>	1.760	22-68
27	27	15	65	23	55	<b>305 027 055</b>	1.580	27-610
	27	15	113	71	100	<b>305 027 100</b>	1.720	27-610
	27	15	143	101	130	<b>305 027 130</b>	1.860	27-610
32	32	20	70	25	60	<b>305 032 060</b>	1.560	32-810
	32	20	143	98	130	<b>305 032 130</b>	1.970	32-810
	32	20	173	128	160	<b>305 032 160</b>	2.160	32-810
42	42	24	83	27	75	<b>305 042 075</b>	1.520	42-1014
	42	24	188	86	130	<b>305 042 130</b>	2.220	42-1014
	42	24	218	116	160	<b>305 042 160</b>	2.520	42-1014
54	54	28	172	106	160	<b>305 054 160</b>	3.040	54-1220
	54	28	212	146	200	<b>305 054 200</b>	3.770	54-1220
68	68	36	146	60	140	<b>305 068 140</b>	2.560	68-1624
	68	36	212	126	200	<b>305 068 200</b>	4.470	68-1624
	68	36	272	186	260	<b>305 068 260</b>	6.560	68-1624
85	85	50	216	116	200	<b>305 085 200</b>	5.400	85-1630
	85	50	276	176	260	<b>305 085 260</b>	8.450	85-1630
	85	50	336	236	320	<b>305 085 320</b>	10.810	85-1630
100 200	100	60	276	176	260	<b>305 100 260</b>	8.440	100-2035
	100	60	336	236	320	<b>305 100 320</b>	11.430	100-2035
300 400 500	100	60	146	56	140	<b>* 505 160</b>	4.700	TF 100

\* SEE PAGE 48: THE ASSEMBLY SYSTEM FOR LARGE BORING HEADS



**NOTE:** MORSE 6 ARBORS CAN BE MANUFACTURED AS "SPECIAL" UPON REQUEST

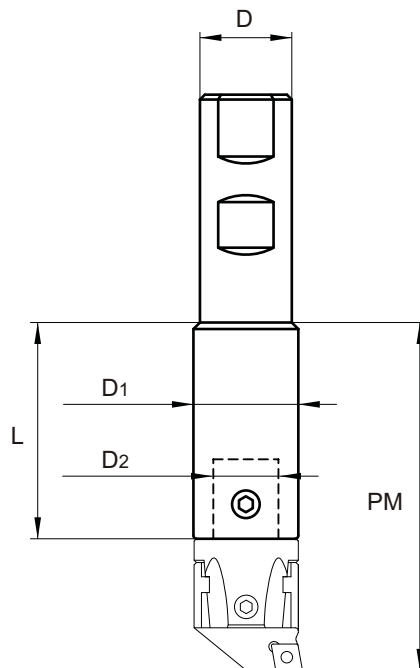
# ARBORS FOR BORING HEADS

**DIN 1835**

**WELDON**

**WELDON Ø20, Ø25, Ø32, Ø40**

SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	øD2	L	PM			
22	20	22	12	16	50	<b>B 020 022 050</b>	0.170	22-68
	20	22	12	70	100	<b>B 020 022 100</b>	0.350	22-68
27	25	27	15	14	55	<b>B 025 027 055</b>	0.260	27-610
	25	27	15	58	100	<b>B 025 027 100</b>	0.470	27-610
32	32	32	20	18	60	<b>B 032 032 060</b>	0.440	32-810
	32	32	20	58	100	<b>B 032 032 100</b>	0.700	32-810
	32	32	20	118	160	<b>B 032 032 160</b>	1.150	32-810
42	32	42	24	40	90	<b>B 032 042 090</b>	0.730	42-1014
42	40	42	24	36	90	<b>B 040 042 090</b>	1.000	42-1014
	40	42	24	106	160	<b>B 040 042 160</b>	1.820	42-1014

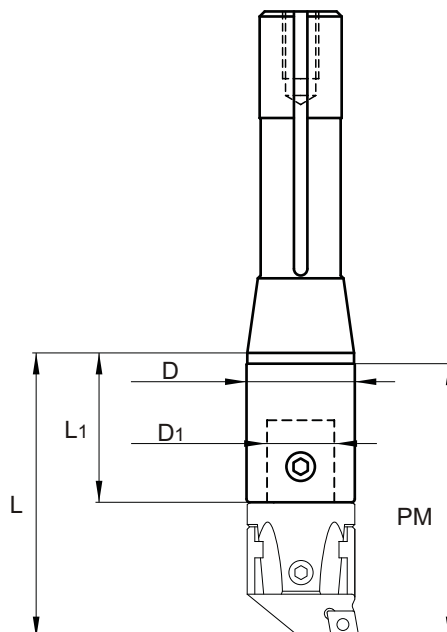


# ARBORS FOR BORING HEADS

## BRIDGEPORT

### R8 HOLDERS

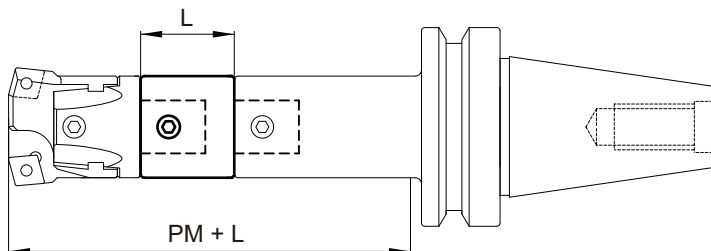
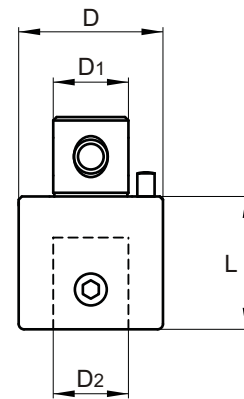
SIZE	Dimension					Product Number	Kg.	Coupling Screw
	øD	øD1	L	L1	PM			
22	22	12	54	20	50	<b>R8 022 050</b>	0.490	22-68
27	27	15	64	22	60	<b>R8 027 060</b>	0.510	27-610
32	32	20	79	34	75	<b>R8 032 075</b>	0.590	32-810
42	42	24	95	39	90	<b>R8 042 090</b>	0.720	42-1014
54	54	28	114	48	110	<b>R8 054 110</b>	1.070	54-1220



# ACCESSORIES

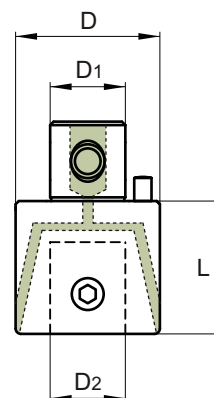
## EXTENSION PIECES

SIZE	Dimension				Product Number	Kg.	Coupling Screw
	øD	øD1	øD2	L			
22	22	12	12	20	<b>P 022 020</b>	0.060	22-68
	22	12	12	30	<b>P 022 030</b>	0.090	22-68
27	27	15	15	30	<b>P 027 030</b>	0.140	27-610
	27	15	15	45	<b>P 027 045</b>	0.200	27-610
32	32	20	20	35	<b>P 032 035</b>	0.210	32-810
	32	20	20	52	<b>P 032 052</b>	0.300	32-810
42	42	24	24	40	<b>P 042 040</b>	0.410	42-1014
	42	24	24	60	<b>P 042 060</b>	0.620	42-1014
54	54	28	28	50	<b>P 054 050</b>	0.880	54-1220
	54	28	28	75	<b>P 054 075</b>	1.320	54-1220
68	68	36	36	60	<b>P 068 060</b>	1.660	68-1624
	68	36	36	90	<b>P 068 090</b>	2.480	68-1624
85	85	50	50	70	<b>P 085 070</b>	2.940	85-1630
	85	50	50	105	<b>P 085 105</b>	4.420	85-1630
100 200	100	60	60	80	<b>P 100 080</b>	4.580	100-2035
	100	60	60	120	<b>P 100 120</b>	7.060	100-2035



## COOLANT-FEEDING EXTENSIONS (PROVIDES FLOOD COOLANT)

SIZE	Dimension				Product Number	Kg.	Coupling Screw
	øD	øD1	øD2	L			
22	22	12	12	30	<b>P 022 030 R</b>	0.090	22-68
27	27	15	15	30	<b>P 027 030 R</b>	0.140	27-610
32	32	20	20	35	<b>P 032 035 R</b>	0.210	32-810
42	42	24	24	40	<b>P 042 040 R</b>	0.410	42-1014
54	54	28	28	50	<b>P 054 050 R</b>	0.880	54-1220
68	68	36	36	60	<b>P 068 060 R</b>	1.660	68-1624
85	85	50	50	70	<b>P 085 070 R</b>	2.940	85-1630
100 200	100	60	60	80	<b>P 100 080 R</b>	4.580	100-2035



**NOTE:** Arbors to match with coolant-feeding extensions must be ordered by adding "R" at the end of the product number.

*Standard Execution:*

BT 340 022 050

*Coolant Execution:*

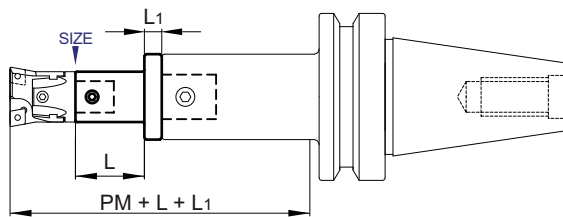
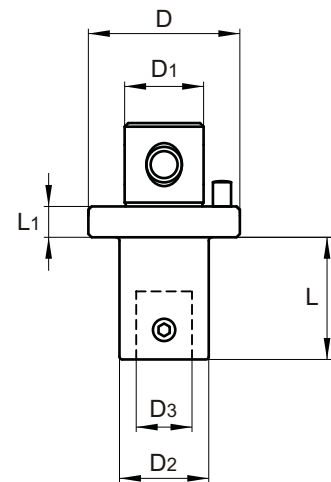
BT 340 022 050 R



# ACCESSORIES

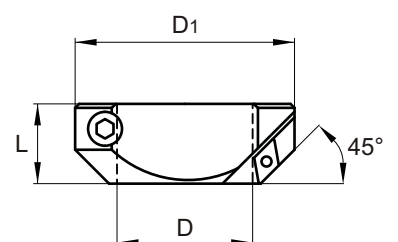
## REDUCERS

SIZE	Dimension						Product Number	Kg.	Coupling Screw
	øD	øD1	øD2	øD3	L	L1			
22	27	15	22	12	26	10	R 027 022 036	0.130	22-68
	32	20	22	12	30	10	R 032 022 040	0.180	22-68
	42	24	22	12	48	10	R 042 022 058	0.320	22-68
	54	28	22	12	76	10	R 054 022 086	0.510	22-68
	68	36	22	12	90	12	R 068 022 102	0.900	22-68
27	32	20	27	15	24	10	R 032 027 034	0.190	27-610
	42	24	27	15	40	10	R 042 027 050	0.340	27-610
	54	28	27	15	70	10	R 054 027 080	0.640	27-610
	68	36	27	15	83	12	R 068 027 095	0.980	27-610
32	42	24	32	20	36	10	R 042 032 046	0.360	32-810
	54	28	32	20	66	10	R 054 032 076	0.700	32-810
	68	36	32	20	78	12	R 068 032 090	1.090	32-810
42	54	28	42	24	60	10	R 054 042 070	0.880	42-1014
	68	36	42	24	70	12	R 068 042 082	1.310	42-1014
	85	50	42	24	83	12	R 085 042 095	2.080	42-1014
54	68	36	54	28	60	12	R 068 054 072	1.520	54-1220
	85	50	54	28	78	12	R 085 054 090	2.460	54-1220
68	85	50	68	36	88	12	R 085 068 100	3.320	68-1624
85	100	60	85	50	88	12	R 100 085 100	5.040	85-1630



## 45° CHAMFERING HEADS

SIZE	Dimension			Product Number	Insert	Torx Screw	Kg.	Torx Key / Locking Key	
	øD	øD1	L					Torx Key	Locking Key
22	22	43	24	CH 022	DC□□ 11T3□□	TT 409	0.140	T15	4
27	27	48	24	CH 027	DC□□ 11T3□□	TT 409	0.160	T15	4
32	32	62	30	CH 032	DC□□ 11T3□□	TT 409	0.300	T15	5
42	42	72	30	CH 042	DC□□ 11T3□□	TT 409	0.400	T15	5
54	54	94	40	CH 054	DC□□ 1504□□	TT 402	0.910	T20	6
68	68	110	40	CH 068	DC□□ 1504□□	TT 402	1.230	T20	8
85	85	145	55	CH 085	DC□□ 1504□□	TT 402	2.700	T20	10
100	100	170	60	CH 100	DC□□ 1504□□	TT 402	4.140	T20	14
200	100	200	60	CH 200	DC□□ 1504□□	TT 402	5.800	T20	14

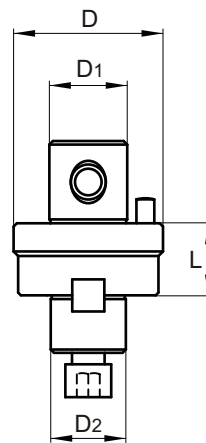


# ACCESSORIES

## ADAPTORS

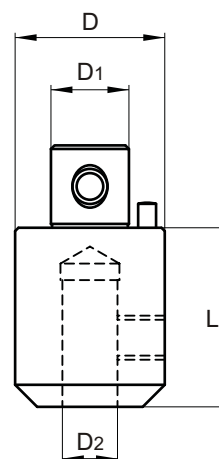
### MILLING CUTTER HOLDER

SIZE	Dimension				Product Number	Kg.
	øD	øD1	øD2	L		
42	42	24	16	14	<b>ADM 042 016</b>	0.230
	42	24	22	12	<b>ADM 042 022</b>	0.280
54	54	28	16	30	<b>ADM 054 016</b>	0.600
	54	28	22	28	<b>ADM 054 022</b>	0.660
	54	28	27	18	<b>ADM 054 027</b>	0.720
68	68	36	16	25	<b>ADM 068 016</b>	0.930
	68	36	22	23	<b>ADM 068 022</b>	0.870
	68	36	27	21	<b>ADM 068 027</b>	0.900
	68	36	32	26	<b>ADM 068 032</b>	0.950
85	85	50	32	25	<b>ADM 085 032</b>	1.850
	85	50	40	30	<b>ADM 085 040</b>	2.250



### WELDON

SIZE	Dimension				Product Number	Kg.
	øD	øD1	øD2	L		
42	42	24	6	35	<b>ADM 042 W06</b>	0.250
	42	24	8	35	<b>ADM 042 W08</b>	0.270
	42	24	10	38	<b>ADM 042 W10</b>	0.360
	42	24	12	55	<b>ADM 042 W12</b>	0.620
	48	24	16	60	<b>ADM 042 W16</b>	0.830
54	52	24	20	65	<b>ADM 042 W20</b>	0.990
	54	28	16	60	<b>ADM 054 W16</b>	0.950
	54	28	20	65	<b>ADM 054 W20</b>	1.160
	54	28	25	70	<b>ADM 054 W25</b>	1.650

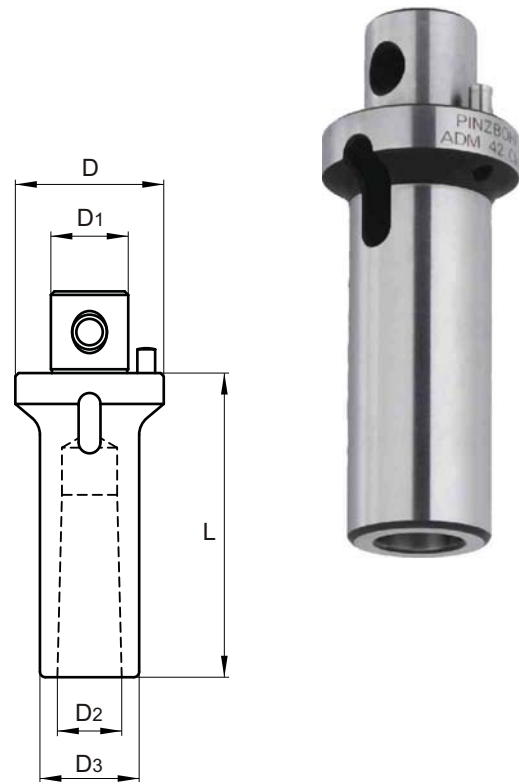


# ACCESSORIES

## ADAPTORS

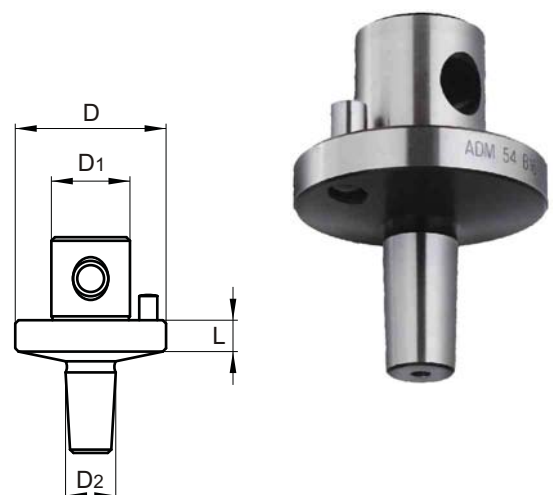
### MORSE

SIZE	Dimension					Product Number	Kg.
	øD	øD1	øD2	øD3	L		
42	42	24	17.780	30	90	<b>ADM 042 CM2</b>	0.650
	42	24	23.825	36	110	<b>ADM 042 CM3</b>	0.810
54	54	28	17.780	30	90	<b>ADM 054 CM2</b>	0.730
	54	28	23.825	36	110	<b>ADM 054 CM3</b>	0.920



### DIN 238 (FOR DRILL CHUCKS)

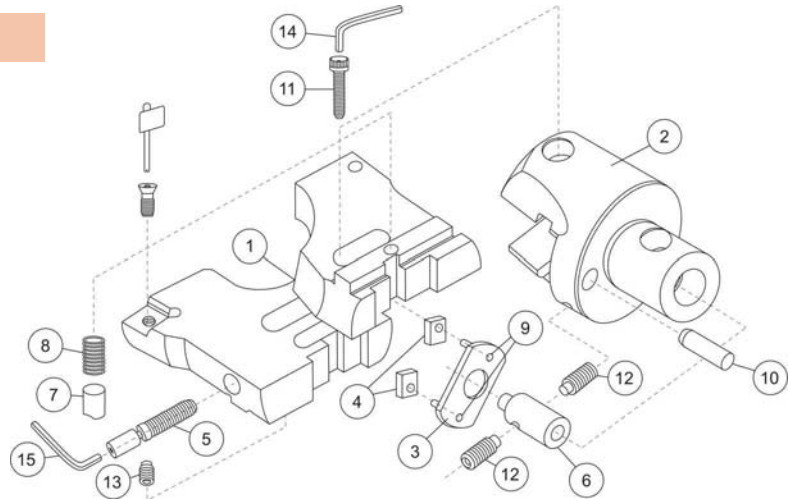
SIZE	Dimension				Product Number	Kg.
	øD	øD1	øD2	L		
42	42	24	12.065	8	<b>ADM 042 B12</b>	0.220
54	54	28	12.065	10	<b>ADM 054 B12</b>	0.440
	54	28	15.733	10	<b>ADM 054 B16</b>	0.400
68	68	36	15.733	12	<b>ADM 068 B16</b>	0.770



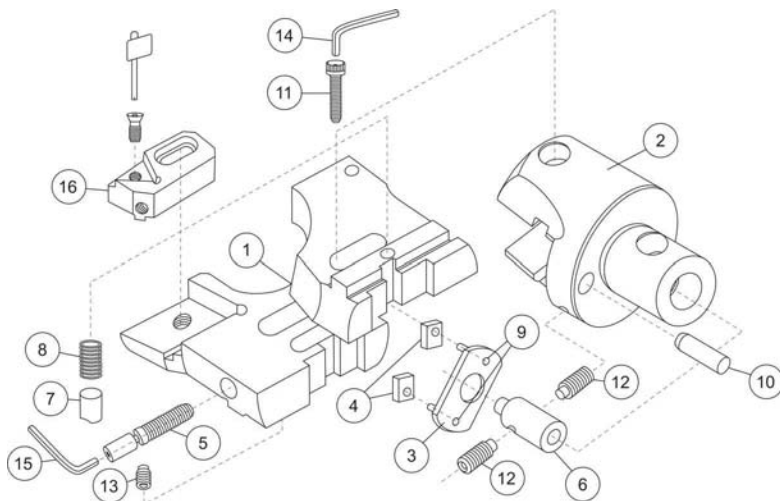
# SPARE PARTS

## ROUGH BORING HEADS

### INTEGRAL POCKET TYPE



SIZE	Boring Head	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
22	D 02275 □□□□	D 02275 01 □□□□	D 022 03	D 022 04	-	D 022 06	D 022 07	D 022 08	D 022 09	D 022 19	D 022 20	D 022 21	D 022 22	D 022 23	HK 030	HK 020
	D 02290 □□□□	D 02290 01 □□□□														
27	D 02775 □□□□	D 02775 01 □□□□	D 027 03	D 027 04	-	D 027 06	D 027 07	D 027 08	D 027 09	D 027 20	D 027 21	D 027 22	D 027 23	HK 040	HK 025	HK 030
	D 02790 □□□□	D 02790 01 □□□□														
32	D 03275 □□□□	D 03275 01 □□□□	D 032 03	D 032 04	-	D 032 06	D 032 07	D 032 08	D 032 09	D 032 19	D 032 20	D 032 21	D 032 22	D 032 23	HK 050	HK 030
	D 03290 □□□□	D 03290 01 □□□□														
42	D 04275 □□□□	D 04275 01 □□□□	D 042 03	D 042 04	D 042 05	D 042 06	D 042 07	D 042 08	D 042 09	D 022 20	D 042 20	D 042 21	D 042 22	D 042 23	HK 060	HK 030
	D 04290 □□□□	D 04290 01 □□□□														
54	D 05475 □□□□	D 05475 01 □□□□	D 054 03	D 054 04	D 054 05	D 054 06	D 054 07	D 054 08	D 054 09	D 054 19	D 054 20	D 054 21	D 054 22	D 054 23	HK 060	HK 030
	D 05490 □□□□	D 05490 01 □□□□														



### CARTRIDGE TYPE

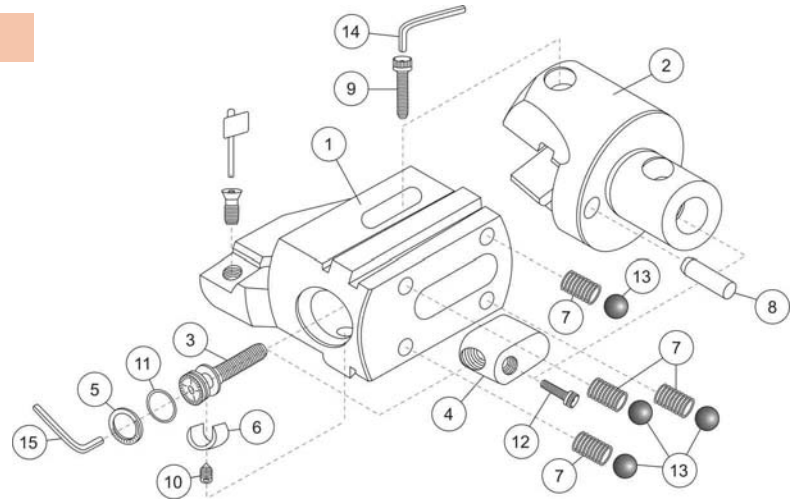
SIZE	Boring Head	16
68	D 068□□□□□	2CT □□□□□
85	D 085□□□□□	3CT □□□□□
100	D 100□□□□□	3CT □□□□□
200	D 200□□□□□	3CT □□□□□

SIZE	Boring Head	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
68	D 068□□□□□	D 06800 01 2CT	D 068 03	D 068 04	D 068 05	D 068 06	D 068 07	D 068 08	D 068 09	D 068 19	D 068 20	D 068 21	D 068 22	D 068 23	HK 080	HK 040
85	D 085□□□□□	D 08500 01 3CT	D 085 03	D 085 04	D 085 05	D 085 06	D 085 07	D 085 08	D 085 09	D 085 19	D 085 20	D 085 21	D 085 22	D 085 23		HK 050
100	D 100□□□□□	D 10000 01 3CT	D 100 03	D 100 04		D 100 06	D 100 07	D 100 08			D 100 20	D 100 21				
200	D 200□□□□□	D 20000 01 3CT	D 200 03	D 200 04		D 200 06	D 200 07	D 200 08			D 200 20	D 200 21				

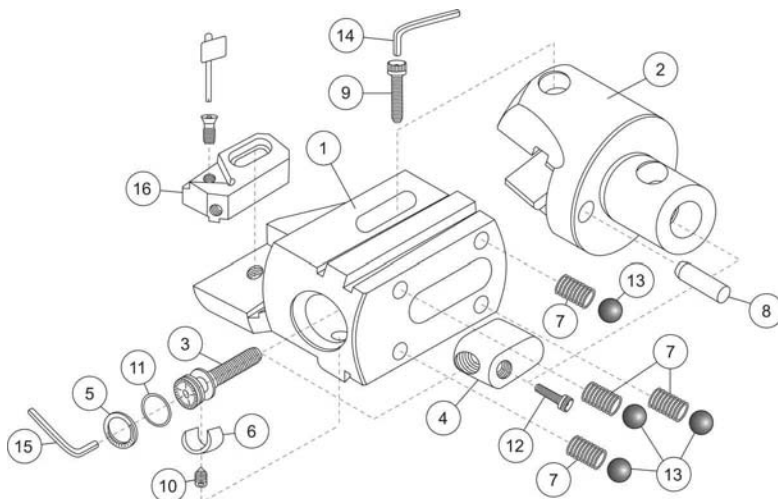
# SPARE PARTS

## FINISH BORING HEADS

### INTEGRAL POCKET TYPE



SIZE	Boring Head	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
22	A 02275 □□□□	A 02275 02 □□□□	A 022 03	A 022 13	A 022 14	A 022 15	A 022 16	A 022 17	D 022 20	D 022 21	D 022 23	A 022 25	A 022 26	A 022 30	HK 030	HK 020
	A 02290 □□□□	A 02290 02 □□□□														
27	A 02775 □□□□	A 02775 02 □□□□	A 027 03	A 027 13	A 027 14	A 027 15	A 027 16	A 027 17	D 027 20	D 027 21	D 027 23	A 027 25	A 027 26	A 027 30	HK 040	HK 025
	A 02790 □□□□	A 02790 02 □□□□														
32	A 03275 □□□□	A 03275 02 □□□□	A 032 03	A 032 13	A 032 14	A 032 15	A 032 16	A 032 17	D 032 20	D 032 21	D 032 23	A 032 25	A 032 26	A 032 30	HK 050	HK 030
	A 03290 □□□□	A 03290 02 □□□□														
42	A 04275 □□□□	A 04275 02 □□□□	A 042 03	A 042 13	A 042 14	A 042 15	A 042 16	A 042 17	D 042 20	D 042 21	D 042 23	A 042 25	A 042 26	A 042 30	HK 060	HK 020
	A 04290 □□□□	A 04290 02 □□□□														
54	A 05475 □□□□	A 05475 02 □□□□	A 054 03	A 054 13	A 054 14	A 054 15	A 054 16	D 042 09	D 054 20	D 054 21	D 042 23	A 042 25	A 042 26	A 054 30	HK 060	HK 020
	A 05490 □□□□	A 05490 02 □□□□														



### CARTRIDGE TYPE

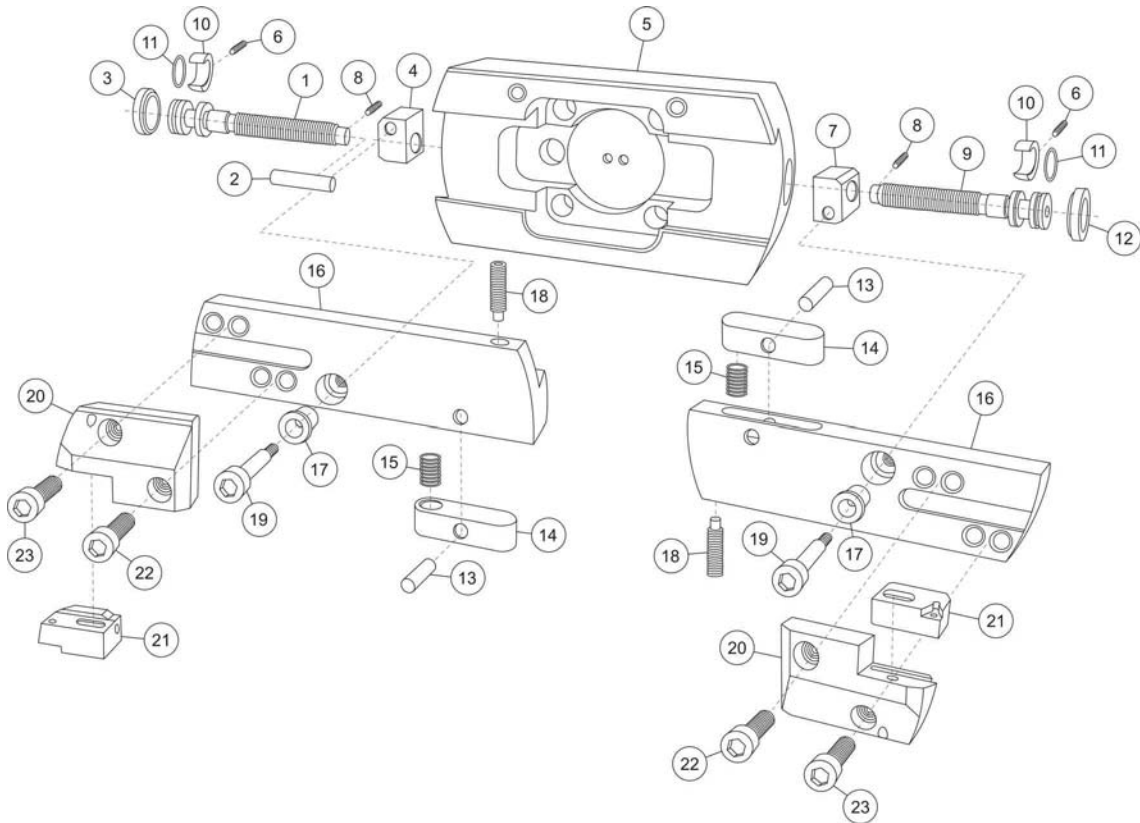
SIZE	Boring Head	16
68	A 068□□□□□	2CT □□□□□
85	A 085□□□□□	3CT □□□□□
100	A 100□□□□□	3CT □□□□□
200	A 200□□□□□	3CT □□□□□

SIZE	Boring Head	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
68	A 068□□□□□	A 06800 02 2CT	A 068 03	A 068 13	A 068 14	A 068 15	A 068 16	A 068 17	D 068 20	D 068 21	D 068 23	A 068 25	A 068 26	A 068 30	HK 080	HK 050
85	A 085□□□□□	A 08500 02 3CT	A 085 03	A 085 13	A 085 14	A 085 15	A 085 16	D 085 09	D 085 20	D 085 21	D 085 23	A 085 25	A 085 26	A 085 30		HK 060
100	A 100□□□□□	A 10000 02 3CT	A 100 03													
200	A 200□□□□□	A 20000 02 3CT	A 200 03	A 200 13												

# SPARE PARTS

## LARGE BORING HEADS

### ROUGHING



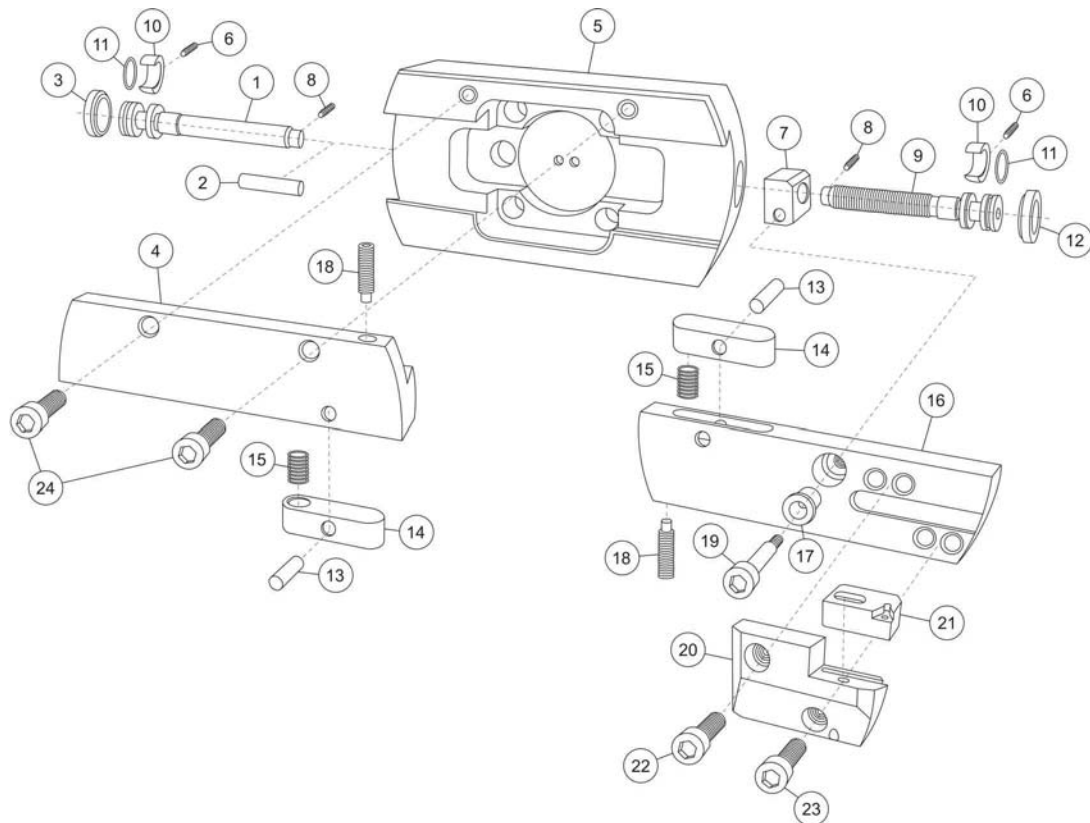
SIZE	Boring Head	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23
300	D 300□□ □□	D 300 51	D 300 66	A 068 15	D 300 55	D 300 03	D 068 23	D 300 54	D 300 65	D 300 50	A 068 16	A 068 25	D 300 15	D 300 60	D 300 56	D 300 59	D 300 01	D 300 62	D 300 58	D 300 57	D 300 49	3CT □□ □□	D 300 61	D 300 67
400	D 400□□ □□	D 400 51	D 300 66	A 068 15	D 300 55	D 400 03	D 068 23	D 300 54	D 300 65	D 400 50	A 068 16	A 068 25	D 300 15	D 300 60	D 300 56	D 300 59	D 400 01	D 300 62	D 300 58	D 300 57	D 300 49	3CT □□ □□	D 300 61	D 300 67
500	D 500□□ □□	D 500 51	D 300 66	A 068 15	D 300 55	D 500 03	D 068 23	D 300 54	D 300 65	D 500 50	A 068 16	A 068 25	D 300 15	D 300 60	D 300 56	D 300 59	D 500 01	D 300 62	D 300 58	D 300 57	D 300 49	3CT □□ □□	D 300 61	D 300 67



# SPARE PARTS

## LARGE BORING HEADS

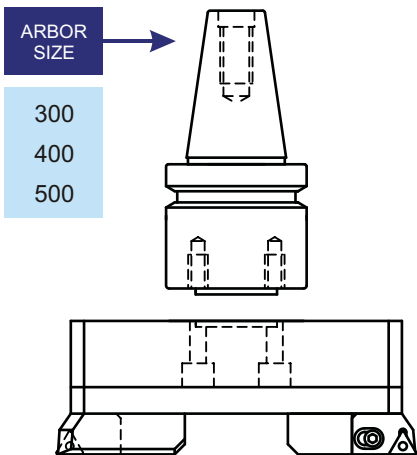
### FINISHING



SIZE	Boring Head	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24
300	A 300□□ □□□	A 300 52	D 300 66	A 068 15	A 300 02	D 300 03	D 068 23	D 300 54	D 300 65	D 300 50	A 068 16	A 068 25	D 300 15	D 300 60	D 300 56	D 300 59	D 300 01	D 300 62	D 300 58	D 300 57	D 300 49	3CT □□ □□□	D 300 61	D 300 67	A 300 63
400	A 400□□ □□□	A 400 52	D 300 66	A 068 15	A 400 02	D 400 03	D 068 23	D 300 54	D 300 65	D 400 50	A 068 16	A 068 25	D 300 15	D 300 60	D 300 56	D 300 59	D 400 01	D 300 62	D 300 58	D 300 57	D 300 49	3CT □□ □□□	D 300 61	D 300 67	A 300 63
500	A 500□□ □□□	A 500 52	D 300 66	A 068 15	A 500 02	D 500 03	D 068 23	D 300 54	D 300 65	D 500 50	A 068 16	A 068 25	D 300 15	D 300 60	D 300 56	D 300 59	D 500 01	D 300 62	D 300 58	D 300 57	D 300 49	3CT □□ □□□	D 300 61	D 300 67	A 300 63

# ASSEMBLY SYSTEM FOR LARGE BORING HEADS

## ARBORS FOR LARGE BORING HEADS

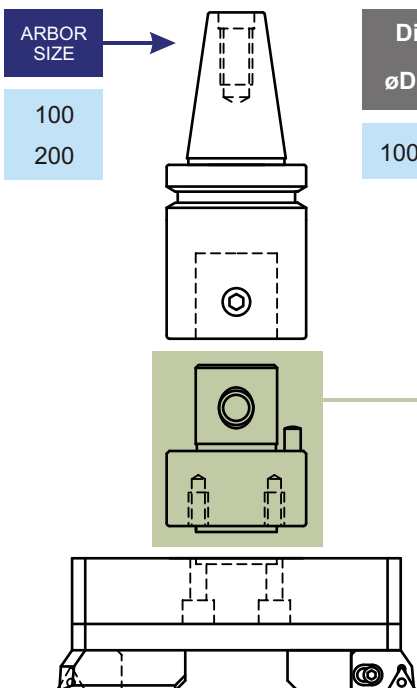


Product Number	Coupling Screws
BT 550 160	TF 100
AS 550 160	
OTT 550 160	
HSK 550 160	
505 160	

**DIRECT MOUNT**

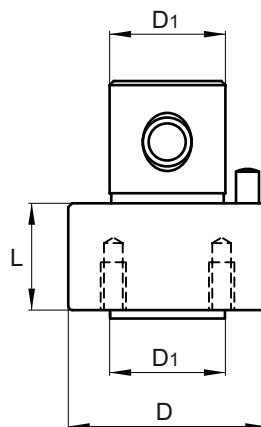


## ADAPTOR FOR SIZE 100 200 STANDARD PINZBOHR ARBORS



Dimension			Product Number	Kg.	Coupling Screws
$\varnothing D$	$\varnothing D_1$	L			
100	60	50	<b>ADT 100 050</b>	4.360	TF 100

**ADAPTOR MOUNT**





# ASSEMBLY SYSTEM FOR LARGE BORING HEADS

## HOW TO FIT THE LARGE DIAMETER BORING HEAD ON THE TAPER

Remove the position screws (D 300 57) and push along the slides until the four coupling screw sockets appear. Put together the taper face with the four screw sockets over the head's back end, then fit and tight the 4 coupling screws.

## MOUNTING THE SLIDES ON THE HEAD

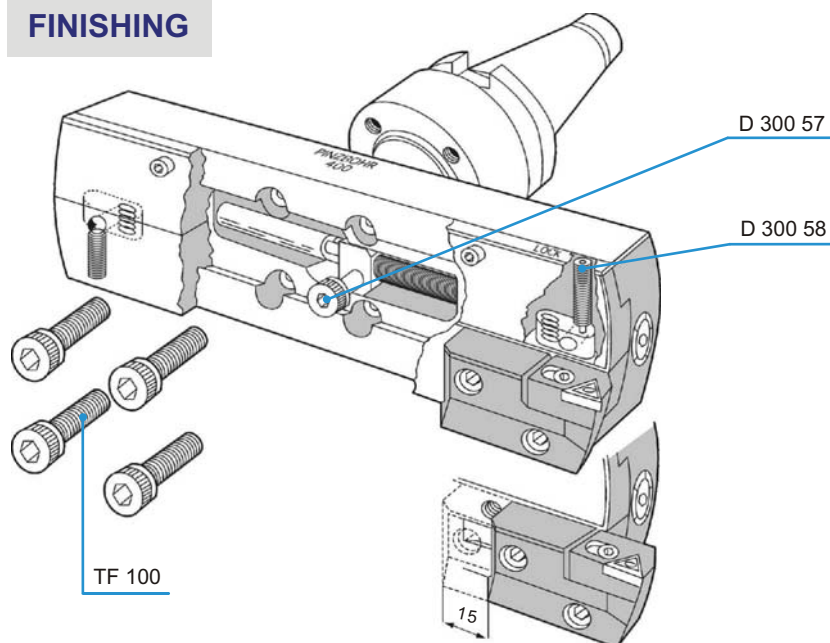
Insert both slides into the V guides, push them along until they face the nut thread holes. Fit the screws (D 300 57) and tight them lightly.

The function of these screws is dual, fixing the slide into the V guides and linking both the slide with the bronze lead nut.

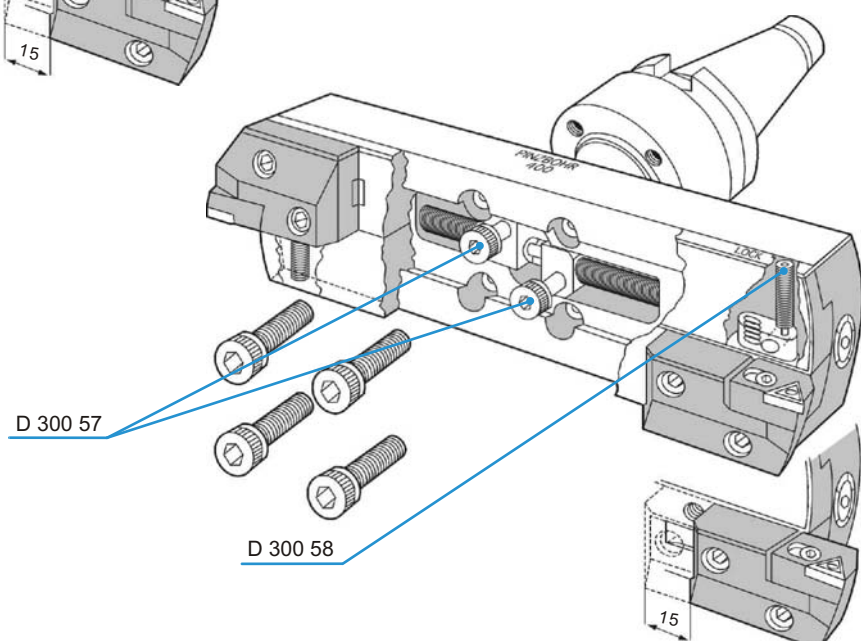
Finally check that the slide (slides in roughing) glide softly.

**Attention:** During the entire mounting process the brake screw (D 300 58) must be released.

### FINISHING



### ROUGHING



## BORING KITS

# Bohrstar 54

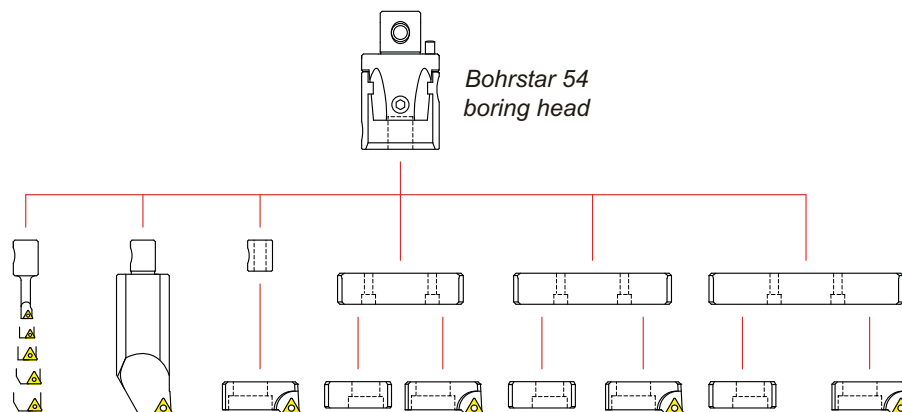


**BORING KITS** from  $\varnothing 6$  mm up to 210 mm



FOR PRECISE INFORMATION SEE OUR **BOHRSTAR 54** CATALOG

# BORING KITS

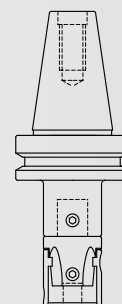


From	Ø 6 / 8	Ø 38	Ø 56	Ø 85	Ø 125	Ø 165
To	Ø 43	Ø 59	Ø 100	Ø 130	Ø 170	Ø 210

Range		Components	Ordering Number
Ø 8 ~ Ø 210			BS 54 KIT T 8-210 BS 54 KIT R 8-210
Ø 8 ~ Ø 170			BS 54 KIT T 8-170 BS 54 KIT R 8-170
Ø 8 ~ Ø 100			BS 54 KIT T 8-100 BS 54 KIT R 8-100
Ø 8 ~ Ø 43			BS 54 KIT T 8-043 BS 54 KIT R 8-043
Ø 6 ~ Ø 210			BS 54 KIT R 6-210
Ø 6 ~ Ø 170			BS 54 KIT R 6-170
Ø 6 ~ Ø 100			BS 54 KIT R 6-100
Ø 6 ~ Ø 43			BS 54 KIT R 6-043

## Features

- Several hole solutions with only one boring head.
- Rhombic or triangular kit insert choice.
- Bohrstar 54 boring head read out precision of 0.002 mm Ø.
- Bohrstar 54 boring head matches with all arbors and accessories size 54 shown on this main catalog.



FOR PRECISE INFORMATION SEE OUR **BOHRSTAR 54** CATALOG

# TOOL PRE-SETTERS

DIGITAL DISPLAY  
INTEGRATED OPTICAL SYSTEM

**ADI**

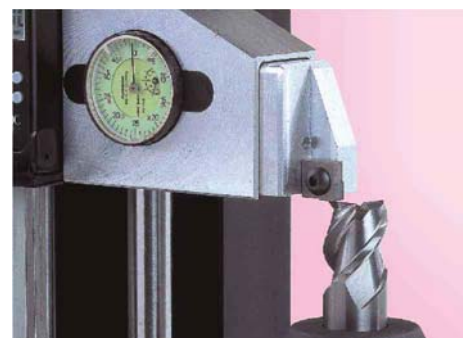
	ADI 1	ADI 2
Taper Style	ISO 40	ISO 50
Maximum Diameter	230	300
Maximum Height	300	400



**BWT**

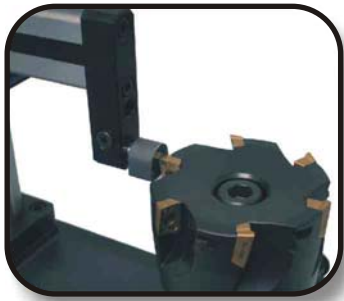
DIGITAL DISPLAY  
PRECISION DIAL INDICATOR

	BWT A	BWT B
Taper Style	ISO 40	ISO 50
Maximum Diameter	230	300
Maximum Height	300	400



FOR ADDITIONAL INFORMATION THERE IS A SPECIFIC CATALOG

## TOOL PRE-SETTERS



### TWO DIGITAL DISPLAYS

TPR	302	402
Taper Style	ISO 40	ISO 50
Maximum Diameter	200	300
Maximum Height	300	400

FOR ADDITIONAL INFORMATION THERE IS A SPECIFIC CATALOG

## TOOL LOCKING FIXTURE

### TLF 40

Taper Style	ISO 40
Dimensions	120 x 150 x 120
Kg.	0,550



Mounted on a work table a strong gripping power on the taper enables assembling and disassembling cutting tools and pull studs.

- Horizontal and vertical taper position.
- Hard polyamide, fiber reinforced, prevents tool damages.
- 4 positioning magnets enable the right adhesion in horizontal position.





# ADJUSTABLE TORQUE SCREWDRIVERS

## ADJUSTABLE TORQUE SCREWDRIVERS WITH RAPIDAPTOR® QUICK-RELEASE CHUCK

**Construction:** With quick-release bitholder Rapidaptor® for insert and power bits

**Accuracy:** ± 6% (EN ISO 6789)

**Application:** For 1/4" bits DIN 3126-C 6,3 and E 6,3

**Handle:** Kraffform® with anti-roll protection, multi-component



Code	Art.No.				
Code	Art.No.		Nm	Nm	mm
05074700001	7440	1/4"	0,3-1,2	0,05	155
05074701001	7441	1/4"	1,2-3,0	0,10	155

## PISTOL HANDLE, ADJUSTABLE TORQUE SCREWDRIVERS WITH RAPIDAPTOR®

**Construction:** With quick-release bitholder Rapidaptor® for insert and power bits

**Accuracy:** ± 6% (EN ISO 6789)

**Application:** For 1/4" bits DIN 3126-C 6,3 and E 6,3

**Handle:** Kraffform®, pistol handle, multi-component



Code	Art.No.					
Code	Art.No.		Nm	Nm	mm	mm
05074702001	7442	1/4"	3,0-6,0	0,25	150	100

## TORQUE SCREWDRIVER SET 0,3 - 6 Nm



Code		
05074739001	7400	1 x 7440; 1 x 7441
	7400 Pistole	1 x 7442
	840/1 Z Hex-Plus	1 x 2,0x25; 1 x 2,5x25; 1 x 3,0x25; 1 x 4,0x25; 1 x 5,0x25; 1 x 6,0x25
	867/1 TZ TORX®	1 x TX 6x25; 1 x TX 7x25; 1 x TX 8x25; 1 x TX 9x25; 1 x TX 10x25; 1 x TX 15x25; 1 x TX 20x25; 1 x TX 25x25; 1 x TX 30x25
	867/1 Z IP TORX PLUS®	1 x 6 IPx25; 1 x 7 IPx25; 1 x 8 IPx25; 1 x 9 IPx25; 1 x 10 IPx25; 1 x 15 IPx25; 1 x 20 IPx25; 1 x 25 IPx25; 1 x 30 IPx25

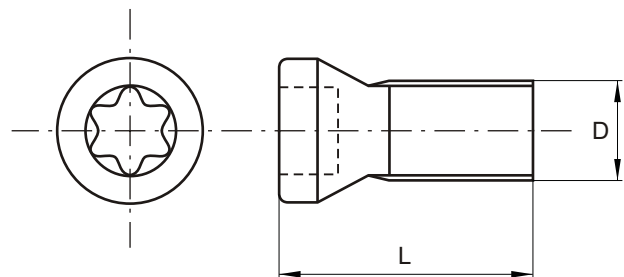
# INSERTS

Shape	Pinzbohr code	ISO code
	<b>300</b> <b>306</b> <b>309</b>	TC□□ 16T3□□ TC□□ 06T1□□ TC□□ 0902□□
	<b>310</b> <b>311</b>	TP□□ 0902□□ TP□□ 1103□□
	<b>400</b> <b>401</b> <b>402</b> <b>409</b>	CC□□ 0602□□ CC□□ 0803□□ CC□□ 1204□□ CC□□ 09T3□□
	<b>402 N</b>	CN□□ 1204□□

Shape	Pinzbohr code	ISO code
	<b>404</b> <b>405</b>	EP□□ 0401□□ L EP□□ 0502□□
	<b>411</b> <b>415</b>	DC□□ 11T3□□ DC□□ 1504□□
	<b>502</b> <b>509</b>	SC□□ 1204□□ SC□□ 09T3□□
	<b>W06</b> <b>W08</b>	WC□□ 06T3□□ WC□□ 0804□□

# INSERT SCREWS

Torx Screw	Dimension D x L	Torx Key
<b>TT 100</b>	M2X3.3	TK 06
<b>TT 102</b>	M2X4	TK 06
<b>TT 104</b>	M2X4.9	TK 06
<b>TT 106</b>	M2.2X5.6	TK 07
<b>TT 108</b>	M2.2X6.4	TK 07
<b>TT 110</b>	M2.5X4.8	TK 08
<b>TT 112</b>	M3.5X8.5	TK 09
<b>TT 114</b>	M4X8.8	TK 15
<b>TT 116</b>	M5X9.5	TK 20
<b>TT 300</b>	M4X15	TK 15
<b>TT 400</b>	M2.5X6	TK 08
<b>TT 401</b>	M3X7.6	TK 10
<b>TT 402</b>	M5X13	TK 20
<b>TT 402 N</b>	M6.3X13.2	HK 025
<b>TT 409</b>	M4X8.5	TK 15



HEXAGONAL KEY

# NOMENCLATURE FOR INSERTS

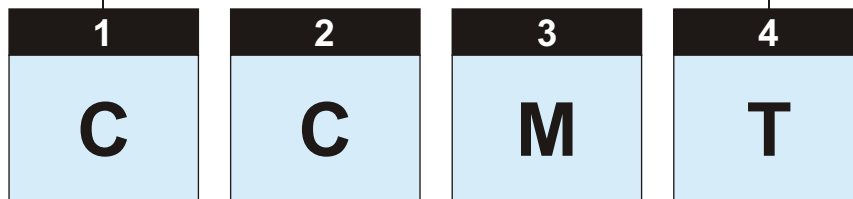
## 1 Shape

<b>C</b> 	<b>D</b> 	<b>E</b> 	<b>K</b> 	<b>L</b> 
<b>R</b> 	<b>S</b> 	<b>T</b> 	<b>V</b> 	<b>W</b> 

## 4 Chipbreaker and hole

<b>A</b> 	<b>F</b> 	<b>G</b> 	<b>H</b> 	<b>M</b> 
<b>N</b> 	<b>P</b> 	<b>Q</b> 	<b>R</b> 	<b>T</b> 
<b>U</b> 	<b>W</b> 	<b>X</b> Others (particular design)		

Example:



## 2 Relief angle

<b>A</b>	3°
<b>B</b>	5°
<b>C</b>	7°
<b>D</b>	15°
<b>E</b>	20°
<b>F</b>	25°
<b>G</b>	30°
<b>N</b>	0°
<b>P</b>	11°
<b>O</b>	Others



## 3 Tolerance (mm)

Symbol	Corner height m	Thickness s	Inscribed circle ød	
<b>A</b>	± 0.005	± 0.025	± 0.025	
<b>F</b>			± 0.013	
<b>C</b>	± 0.013	± 0.025	± 0.025	
<b>H</b>			± 0.013	
<b>E</b>	± 0.025	± 0.13	± 0.025	
<b>G</b>			± 0.025	
<b>J</b>	± 0.005	± 0.025	± 0.05 - ± 0.15	
<b>K</b>	± 0.013			
<b>L</b>	± 0.025	± 0.13	± 0.08 - ± 0.25	
<b>M</b>	± 0.08 ~ ± 0.18			
<b>N</b>	± 0.08 ~ ± 0.18	± 0.025		
<b>U</b>	± 0.13 ~ ± 0.38	± 0.13	± 0.08 - ± 0.25	




# NOMENCLATURE FOR INSERTS

## 6 Thickness

Positive insert   
 Negative insert 

Symbol	s (mm)
01	1.59
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76
05	5.56
06	6.35
07	7.94
09	9.52


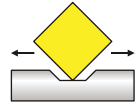
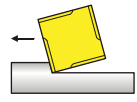
## 7 Corner radius



Symbol	r (mm)
01	0 ~ 0.1
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
28	2.8
32	3.2

## 9 Hand of insert

*Optional*

R	
N	
L	

## 10 Chipbreaker

*Optional*

Supplementary symbol specific to the manufacturer.  
 Identification of chipbreaker.

5  
12

6  
04








7  
08

8  
-

9  
-





10  
PS

## 5 Cutting edge length / Inscribed circle

Cutting edge length Symbol							Inscribed circle Ø (mm)
							
03	04		03	06			3.97
04	05		04	08	08		4.76
		05					5
05	06		05	09		03	5.56
		06					6
06	07		06	11	11	04	6.35
08	09		07	13		05	7.94
		08					8
09	11	09	09	16	16	06	9.525
	12	10					10
		12					12
12	15	12	12	22	22	08	12.7
16	19	15	15	27	27	10	15.875
		16					16
19	23	19	19	33	33	13	19.05
		20					20
22	27	25	22	38			22.225
		25					25
25	31	25	25	44	44	17	25.4
32	38	31	31	54	54	21	31.75
		32					32

## 8 Cutting edge

*Optional*

F	
E	
T	
S	

# APPLICATION HINTS

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## SPEEDS AND FEEDS

Ultimate or optimum speeds and feeds will depend upon material, machine and setup conditions, as well as tool overhang.

## BORING DEPTH - TOOL OVERHANG FOR ROUGHING AND FINISHING

Under conditions suited for carbide tooling depths of 5x Ø for rough boring and 3x Ø for finish boring are achievable. With the increasing overhang, the mechanical stability of the tool body decreases. Overlength tools will have a tendency for deflections as well as harmonic (high pitch) chatter. Harmonic chatter can cause movement of adjusting components inside the boring head leading to off-size or tapered holes.

In many cases the high pitch harmonic chatter can be dampened by increasing the feed and (or) lowering the cutting speed.

Please note that the cutting behavior will also change with the amount of slide block (insert holder) extension from the boring head requiring adjustments regarding speeds and feeds.

## BORING DEPTH - TOOL OVERHANG FOR MICRO BORING HEADS

The maximum boring depth with steel boring bars should not exceed 5x bar diameter and 7x bar diameter with solid carbide bars. We recommend to shorten the bars to the shortest overhang necessary according to the required boring depth.

## ROUGH BORING HEAD 75° vs. 90°

The 75° rough boring head should be used whenever a lot of stock is being removed and no square shoulder is required inside of blind or stepped hole. The 75° lead has a tendency to self-center to the pre-existing hole and therefore cut very stable. If this pre-existing hole, is off-center, shifted or off-angle then it is recommended to use the 90° boring head since the 90° lead angle will have less tendency to follow the pre-existing hole.

## AMOUNT OF STOCK REMOVAL

The maximum stock removal for rough boring may have to be decreased on very tough materials, extended overhangs as well as for extended slide blocks.

## INSERT CORNER RADIUS

For heavy duty roughing applications the largest available corner radius should be selected unless otherwise specified. For finish boring with very little stock removal the smallest available corner radius is most advantageous to minimize lateral tool deflection. This can be especially important on applications involving long overhangs.

## 4 CUTTING EDGES PER INSERT

The 80° diamond shaped insert provides normally for two cutting edges. However, all four cutting edges can be used if a 75° and a 90° rough boring head within the same size range is utilized. The same is possible between a 75° rough boring head and a 90° finish boring head.

# CUTTING DATA

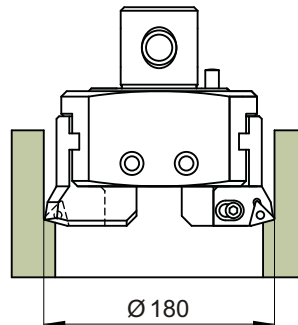
Material	Finish boring (with single insert)				Rough boring (with double inserts)			
	Diameter	Cutting speed $v_c$	Feed $f_z$	Cutting depth $a_p$	Diameter	Cutting speed $v_c$	Feed $f_z$	Max. Cutting depth $a_p$ max.
CARBON STEEL	24 - 30	110 - 140	0.05 - 0.15	0.05 - 0.30	24 - 30	110 - 140	0.15 - 0.25	4.2
	29 - 40	115 - 150			0.06 - 0.35	29 - 40	105 - 140	0.15 - 0.30
	39 - 50		0.10 - 0.20	0.07 - 0.50		39 - 50	105 - 150	0.20 - 0.30
	49 - 102				49 - 102	0.25 - 0.35		
	100 - 220		100 - 220	0.30 - 0.40				
	220 - 500		220 - 500					
STEEL ALLOYS	24 - 30	100 - 130	0.05 - 0.15	0.05 - 0.30	24 - 30	90 - 120		0.15 - 0.25
	29 - 40	110 - 140			0.06 - 0.35	29 - 40	100 - 130	0.15 - 0.30
	39 - 50	110 - 150	0.10 - 0.20	0.07 - 0.50		39 - 50		0.20 - 0.30
	49 - 102				49 - 102	0.25 - 0.35		
	100 - 220		100 - 220	0.30 - 0.40				
	220 - 500		220 - 500					
STAINLESS STEEL	24 - 30		70 - 110	0.07 - 0.15	0.12 - 0.35	24 - 30	69 - 90	0.12 - 0.20
	29 - 40	80 - 110	0.20 - 0.50			29 - 40	70 - 100	0.15 - 0.25
	39 - 50			0.10 - 0.20	0.25 - 0.75	39 - 50		0.20 - 0.30
	49 - 102		49 - 102			0.25 - 0.35		
	100 - 220		100 - 220					
	220 - 500		220 - 500					
CAST IRON	24 - 30	70 - 110	0.07 - 0.15	0.12 - 0.35	24 - 30	60 - 110	0.20 - 0.30	4.2
	29 - 40	80 - 115			0.20 - 0.50		29 - 40	0.25 - 0.35
	39 - 50		0.12 - 0.20	0.25 - 0.75			39 - 50	0.30 - 0.40
	49 - 102				49 - 102		0.30 - 0.45	
	100 - 220		100 - 220					
	220 - 500		220 - 500					
ALUMINIUM, ALUMINIUM ALLOYS	24 - 30	150 - 300	0.05 - 0.15	0.12 - 0.35	24 - 30	120 - 300	0.20 - 0.30	4.2
	29 - 40	150 - 360	0.10 - 0.20	0.20 - 0.50	29 - 40	150 - 370	0.25 - 0.35	5.7
	39 - 50				0.10 - 0.25		0.25 - 0.75	39 - 50
	49 - 102		49 - 102	0.30 - 0.45				
	100 - 220		100 - 220	0.30 - 0.40				
	220 - 500		220 - 500					
TITANIUM	24 - 30	30 - 40	0.07 - 0.15	0.12 - 0.35	24 - 30	25 - 35	0.12 - 0.20	4.2
	29 - 40	30 - 45			0.20 - 0.50	29 - 40	30 - 40	0.15 - 0.25
	39 - 50		0.10 - 0.20	0.25 - 0.75		39 - 50		0.20 - 0.30
	49 - 102				49 - 102	0.20 - 0.35		
	100 - 220		100 - 220					
	220 - 500		220 - 500					
HARDENED ALLOYS	24 - 30	30 - 40	0.07 - 0.15	0.12 - 0.35	24 - 30	25 - 35	0.12 - 0.20	4.2
	29 - 40	30 - 45			0.20 - 0.50	29 - 40	30 - 40	0.15 - 0.25
	39 - 50		0.10 - 0.20	0.25 - 0.75		39 - 50		0.20 - 0.30
	49 - 102				49 - 102	0.20 - 0.35		
	100 - 220		100 - 220					
	220 - 500		220 - 500					

# EXAMPLES OF MACHINING

## ROUGH BORING

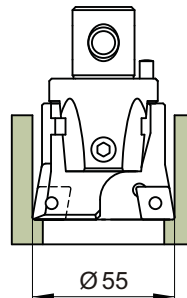
### THROUGH HOLE

Material: 42 Cr Mo 4  
 Boring head: D 20075 300  
 Arbor: BT 350 100 260  
 Insert: TCMT 16T308  
 Cutting speed: 120 m/min  
 Cutting depth: 5 mm  
 Feed: 0.25 mm/rev  
 Boring depth: 200 mm  
 Coolant



### BLIND HOLE

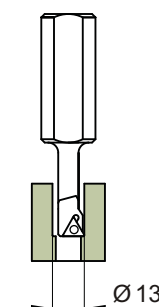
Material: Ck 45  
 Boring head: D 04290 402 N  
 Arbor: BT 350 042 160  
 Insert: CNMG 120408  
 Cutting speed: 110 m/min  
 Cutting depth: 3 mm  
 Feed: 0.3 mm/rev  
 Boring depth: 120 mm  
 Coolant



## FINISH BORING

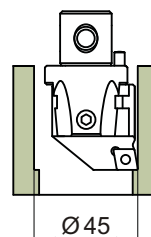
### FINISH BORING SMALL DIAMETER

Material: Al Si 8 Cu 3  
 Boring head: A 042 016 + S10/16 STFCR 09  
 Arbor: BT 350 042 075  
 Insert: TCMT 090202  
 Cutting speed: 120 m/min  
 Cutting depth: 0.2 mm  
 Feed: 0.08 mm/rev  
 Boring depth: 14 mm  
 Coolant



### FINISH BORING

Material: St 37.3  
 Boring head: A 03290 409  
 Arbor: BT 350 032 130  
 Insert: CCGT 09T304  
 Cutting speed: 140 m/min  
 Cutting depth: 0.2 mm  
 Feed: 0.1 mm/rev  
 Boring depth: 70 mm  
 Coolant





# NOTES

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