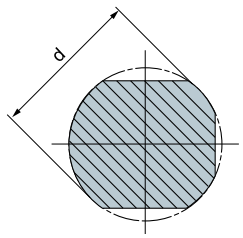
1 Type of Bar

A : Solid Steel with coolant hole
B : Solid Steel with anti-vibration
C : Carbide bar with fixed steel head
D : Solid steel bar with anti-vibration device and coolant hole
E : Carbide bar with fixed steel head and coolant hole
G : Carbide bar with fixed steel head and anti-vibration device and coolant hole
H : Solid heavy metal bar
J : Solid heavy metal with coolant
S : Solid steel bar
X : Special bar

2 Bar diameter

Two characters to describe bar diameter(Number of sixteenth's)

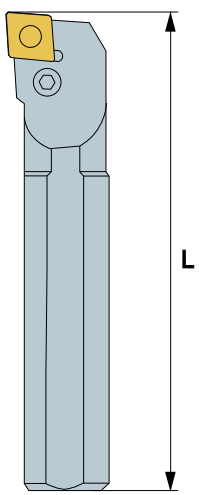


03 : 0.1875	16 : 1.0
04 : 0.250	20 : 1.250
05 : 0.3125	24 : 1.50
06 : 0.37	28 : 1.750
08 : 0.50	32 : 2.0
10 : 0.625	36 : 2.25
12 : 0.750	40 : 2.50

S 24 U - M C

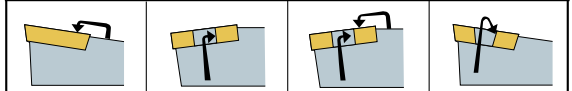
1 2 3 4 5

3 Type of Bar



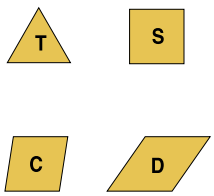
F : 3
G : 3.5
H : 4
J : 4.5
K : 5.0
L : 5.5
M : 6
N : 6.5
P : 6.75
Q : 7.0
R : 8.0
S : 10.3
T : 12.0
U : 14.0
V : 16.0
W : 18.0
Y : 20.0
X : Special length

4 Method of Mounting Insert



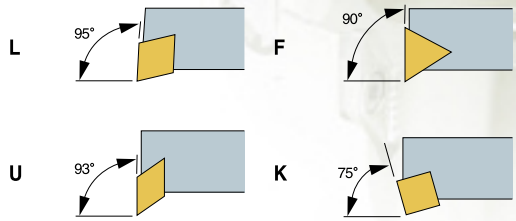
Top Clamping	Hole Clamping	Top and hole clamping	Screw on
C	P	M	S

5 Insert shape



C : 80°Rhombic
D : 80°Rhombic
R : 80°Rhombic
S : Square
T : Triangle
V : 35°Rhombic
W : 80°Trigon

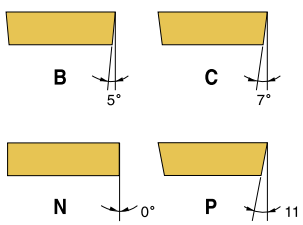
6 Bar Geometry



F : 90°
K : 75°
L : 95°
P : 117.5°
Q : 107.5°
U : 93°
S : 62.5°
Z : Negative 5° pull boring

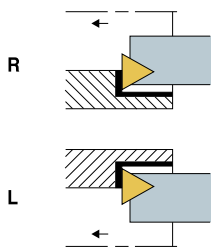
L	N	R	4	
6	7	8	9	10

7 Insert Clearance angle



B : 5°
C : 7°
D : 15°
E : 20°
F : 25°
G : 30°
N : 0°
P : 11°

8 Hand of Bar



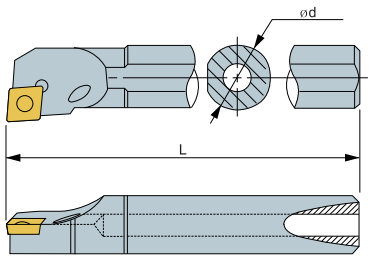
R : Right Hand
L : Left Hand
N : Neutral

9 Insert size IC

(Inscribed Circle)

1.2 : 0.156
1.5 : 0.188
1.8 : 0.219
2 : 0.25
2.5 : 0.3125
3 : 0.375
4 : 0.5
5 : 0.625
6 : 0.75
8 : 1.0
10 : 1.250

Boring bar with coolant hole



10 Manufacturing Option