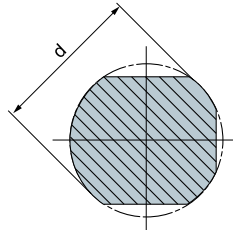


1 Type of Bar

- 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 |

Boring Bars

S
24
U
-
M
C

1

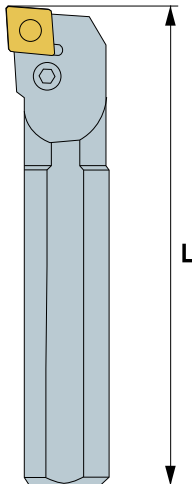
2

3

4

5

3 Type of Bar

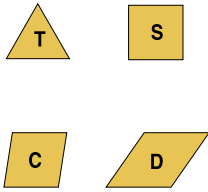


- F : 3
- G : 3.5
- H : 4
- J : 4.5
- K : 5.0
- L : 5.5
- M : 6
- N : 6.5
- P : 6.75
- Q : 7.0
- R : 8.0
- S : 10.3
- T : 12.0
- U : 14.0
- V : 16.0
- W : 18.0
- Y : 20.0
- X : Special length

4 Method of Mounting Insert

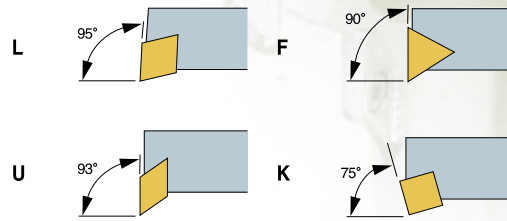
| | | | |
|--------------|---------------|-----------------------|----------|
| | | | |
| Top Clamping | Hole Clamping | Top and hole clamping | Screw on |
| C | P | M | S |

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

L
6

N
7

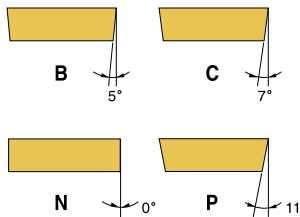
R
8

4
9

[]
10

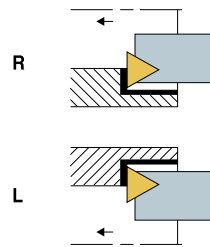
Boring Bars

7 Insert Clearance angle



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

8 Hand of Bar



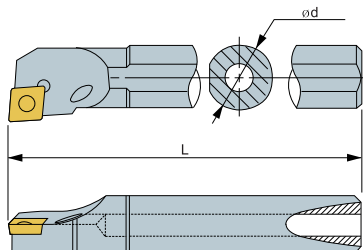
R : Right Hand
 L : Left Hand
 N : Neutral

9 Insert size IC

(Inscribed Circle)

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

Boring bar with coolant hole



10 Manufacturing Option