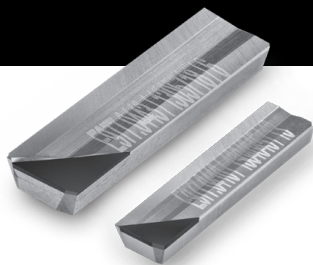


# FINE BORING TOOLS



**"ALWAYS ENGINEERING  
THE RIGHT SOLUTION."**

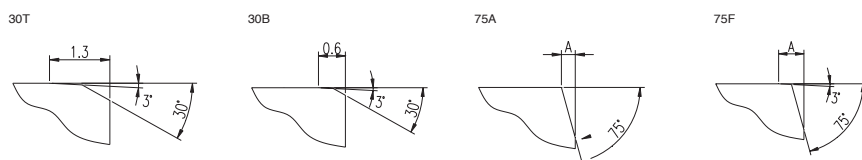


| Tool Diameter | Blade Size | Blade Geometry | Overstock recommended allowance (mm) | Feasible rugosity (Ra- µm) |   | Radial Rake  |
|---------------|------------|----------------|--------------------------------------|----------------------------|---|--|
| 8 to 12 mm    | 1          | 30T            | 0.1 to 0.2                           | 30T                        | 0.2 to 0.9<br>(0.1 possible for Aluminium)  | Radial rakes vary with the application being the standard 0°, 6°, 12° available from stock |
|               |            | 30B            | 0.1 to 0.2                           |                            |   |  |
|               |            | 75A            | 0.4 to 1.4                           |                            |   |  |
|               |            | 75F            | 0.4 to 1.4                           |                            |   |  |
| 12 to 30 mm   | 2          | 30T            | 0.15 to 0.35                         | 30B                        | 0.4 to 1.2<br>(0.1 possible for Aluminium)  |  |
|               |            | 30B            | 0.15 to 0.35                         |                            |   |  |
|               |            | 75A            | 0.5 to 2.4                           | 75A                        | 0.3 to 1.5<br>(0.15 possible for Aluminium) |  |
|               |            | 75F            | 0.5 to 2.4                           |                            |   |  |
| Over 30 mm    | 3          | 30T            | 0.15 to 0.4                          | 30B                        | 0.3 to 1<br>(0.15 possible for Aluminium)   |  |
|               |            | 30B            | 0.15 to 0.4                          |                            |   |  |
|               |            | 75A            | 0.5 to 2.6                           |                            |   |  |
|               |            | 75F            | 0.5 to 2.6                           |                            |   |  |

When a bore must have a superior surface finish along with tight size and roundness tolerances, fine-boring is the best option. Highly stable operation due to well positioned guide pads and very tight tolerances assure a continuously perfect position for the blade.

Depending on the surface finish required and if the hole is blind or through different lead angles can be used.

Lower entry angles on the lead will generate an even more stable cut and enable improved surface finishes. The only limitation is the amount of stock to be removed.



Radius and special profiles available under request.

## Flexibility and innovation. Enlarged portfolio. The best quality. The best cost effectiveness.



### BIG CHALLENGES, GREAT SOLUTIONS!