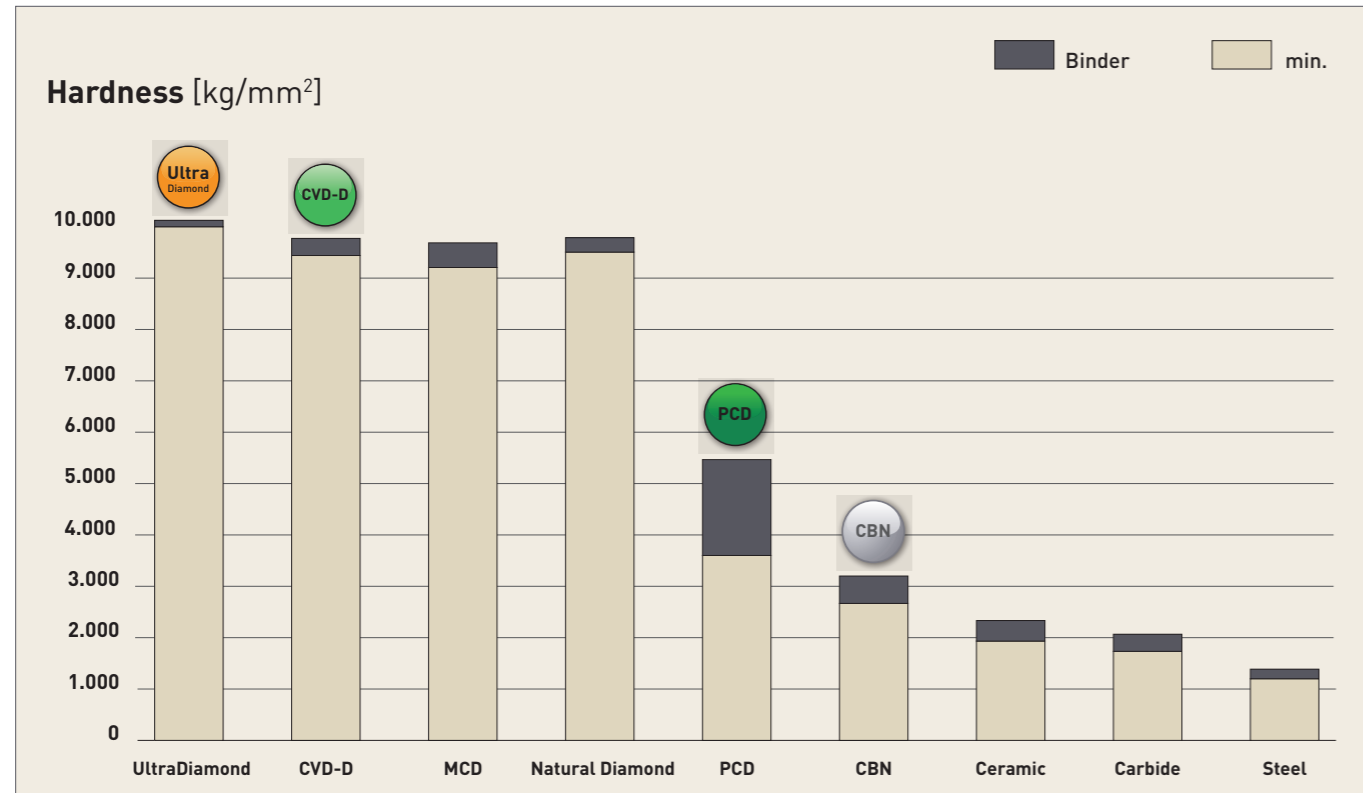


PASSION FOR DIAMOND...

ultrahard cutting materials at a glance



... is not just a slogan for us - we live this passion in our daily dealings with our customers and we are your partner when it comes to diamond or CBN tools.



Polycrystalline diamond (PCD)

The well-known Standard Diamond

PCD is a synthetically produced, extremely tough, intergrown mass of diamond particles with a random orientation in a metal matrix. It is produced by sintering selected diamond particles under high pressure and high temperatures.

Graphite serves as a catalyst allowing the PDC crystals to intergrow. PCD has a high thermal conductivity and good heat dissipation away from the cutting edge. In addition, PCD has the highest bending fracture strength of all cutting materials.

PCD is very well suited for machining aluminum with a Si content of up to 12% and/or other abrasive fillers. The thermal hardness is about 750°C. The areas of application are like those of CVD thick-film diamond, but CVD thick film has a higher cost effectiveness with hard-brittle materials or aluminum from a Si content of 12%.

CVD-Thickfilm Diamond (CVD-D)

The Star among Diamond Cutting Materials

For the machining of hard-brittle materials such as Ceramics, glass, glass-Ceramics, tungsten Carbide, MMC and fiber-reinforced composites such as CFRP and GFRP. Due to the lack of a bonding matrix, the diamond content is much higher than with PCD. In the group of ultra-hard cutting materials, binderless CVD-D is one of the hardest man-made diamond cutting materials.

CVD-D is characterized by high hardness as well as high wear resistance. These properties make CVD-D the perfect cutting material for machining abrasive materials. Compared to PCD, which is damaged by the abrasive particles due to its soft metallic binder phase, the CVD-D cutting edge remains stable due to its binderless anchoring in the diamond matrix.

With the correct use of CVD-D, the tool life can be increased by up to 10 times (and even more) compared to PCD!

Binderless Diamond (UltraDiamond)

The hardest Mono Crystal

Single-crystal elements are laser-cut from diamond blanks in a defined orientation using laser segmentation technology. This new technology makes it possible, in addition to polycrystalline cutting materials such as PCD and CVD-D, to also braze a monocrystal (UltraDiamond) under high vacuum on any tool carrier. Compared to PCD, the tool life can be increased by approx. 15 to 25 times and compared to CVD-D by approx. 2 to 5 times.

The areas of application are similar to PCD and CVD-D, but this monocrystalline cutting material offers a further significant increase in tool life in all applications where PCD and CVD-D reach the limits of economic viability. The UltraDiamond cutting material makes economical machining of very hard, highly brittle materials such as Ceramics, glass, glass-Ceramics and hard metals with low cobalt binder and nickel binder (<10%) possible.

Polycrystalline Cubic Boron Nitride (CBN)

Chemically resistant and stable at high temperatures

of up to 1,400°C. Boron nitride powder is the starting point for the production of CBN, which has been available since the end of the 1960s. It is produced under high pressure and at temperatures of over 1,500°C and the many different substrates are specifically adapted to the final application.

CBN is now considered the second hardest material after diamond cutting materials!

The applications of CBN take place in the automotive industry, aerospace, tool and die and mold making as well as in mechanical engineering. The wide range as cutting and abrasive material includes hardened steels, cast irons, chilled cast iron, sintered materials, stellites, nickel- and cobalt-based superalloys. In many applications, cubic boron nitride is preferred to diamond cutting materials because it is absolutely stable in air at temperatures up to 1,400°C. Diamond, on the other hand, begins to decompose at a temperature of approx. 750°C.

Compared to PCD, CBN is also characterized by its chemical resistance to ferrous materials.

Boring Bars

for internal machining from Dmin 4,00 mm

Type BS

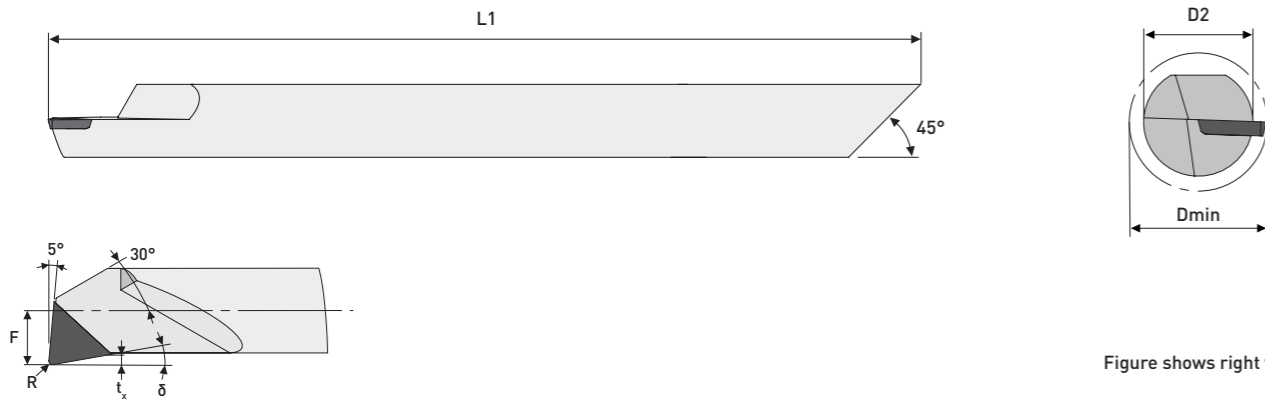


Figure shows right version

Dmin	F	L2	L1	R	D2	tx	δ	Version	Material		
									Item No.	Item No.	Item No.
4,00	2,00	10,00	78,00	0,10	4h6	0,30	10°	right		BS2050-1132	BS3550-1132
								left		BS2050-1133	BS3550-1133
	2,00	10,00	78,00	0,20	4h6	0,30	10°	right		BS2050-2132	BS3550-2132
								left		BS2050-2133	BS3550-2133
	2,00	15,00	80,00	0,10	4h6	0,30	10°	right	BS1050-1140	BS2050-1140	BS3550-1140
								left	BS1050-1141	BS2050-1141	BS3550-1141
	2,00	15,00	83,00	0,20	4h6	0,30	10°	right	BS1050-2130	BS2050-2130	BS3550-2130
								left	BS1050-2131	BS2050-2131	BS3550-2131
	2,00	21,00	89,00	0,10	4h6	0,30	10°	right	BS1050-1134	BS2050-1134	BS3550-1038
								left	BS1050-1135	BS2050-1135	BS3550-1039
	2,00	21,00	89,00	0,20	4h6	0,30	10°	right	BS1050-2134	BS2050-2134	BS3550-2038
								left	BS1050-2135	BS2050-2135	BS3550-2039
4,50	2,25	-	78,00	0,10	4h6	0,25	10°	right		BS2050-1230	BS3550-1240
								left		BS2050-1231	BS3550-1241
	2,25	-	78,00	0,20	4h6	0,25	10°	right		BS2050-2230	BS3550-2240
								left		BS2050-2231	BS3550-2241
	2,25	-	83,00	0,10	4h6	0,25	10°	right	BS1050-1232	BS2050-1232	BS3550-1242
								left	BS1050-1233	BS2050-1233	BS3550-1243
	2,25	-	83,00	0,20	4h6	0,25	10°	right	BS1050-2232	BS2050-2232	BS3550-2242
								left	BS1050-2233	BS2050-2233	BS3550-2243
	2,25	-	89,00	0,10	4h6	0,25	10°	right		BS2050-1234	BS3550-1244
								left		BS2050-1235	BS3550-1245
	2,25	-	89,00	0,20	4h6	0,25	10°	right		BS2050-2234	BS3550-2244
								left		BS2050-2235	BS3550-2245

Dmin	F	L2	L1	R	D2	tx	δ	Version	Material		
									Item No.	Item No.	Item No.
5,00	2,50	-	80,00	0,10	4h6	0,50	10°	right		BS2050-1240	BS3550-1040
								left		BS2050-1241	BS3550-1041
	2,50	-	80,00	0,20	4h6	0,50	10°	right	BS1050-2040	BS2050-2040	BS3550-2040
								left	BS1050-2041	BS2050-2041	BS3550-2041
	2,50	-	80,00	0,40	4h6	0,50	10°	right	BS1050-4040	BS2050-4040	BS3550-4040
								left	BS1050-4041	BS2050-4041	BS3550-4041
6,00	3,00	-	100,00	0,10	5h6	0,50	10°	right		BS2050-1050	BS3550-1050
								left		BS2050-1051	BS3550-1051
	3,00	-	100,00	0,20	5h6	0,50	10°	right	BS1050-2050	BS2050-2050	BS3550-2050
								left	BS1050-2051	BS2050-2051	BS3550-2051
	3,00	-	100,00	0,40	5h6	0,50	10°	right	BS1050-4050	BS2050-4050	BS3550-4050
								left	BS1050-4051	BS2050-4051	BS3550-4051
7,00	3,50	-	100,00	0,20	6h6	0,50	10°	right	BS1050-2060	BS2050-2060	BS3550-2060
								left	BS1050-2061	BS2050-2061	BS3550-2061
	3,50	-	100,00	0,40	6h6	0,50	10°	right	BS1050-4060	BS2050-4060	BS3550-4060
								left	BS1050-4061	BS2050-4061	BS3550-4061
9,00	4,50	-	100,00	0,20	8h6	0,50	10°	right	BS1050-2080	BS2050-2080	BS3550-2080
								left	BS1050-2081	BS2050-2081	BS3550-2081
	4,50	-	100,00	0,40	8h6	0,50	10°	right	BS1050-4080	BS2050-4080	BS3550-4080
								left	BS1050-4081	BS2050-4081	BS3550-4081

Application range:

- PCD** Aluminum <10% Si, Brass, Brass lead-free, Graphite, Titanium (Roughing) ...
- CVD-D** Acrylic, Aluminum >10% Si, Carbide, Ceramics, Composites (CFRP, GFRP, MMC), Copper, Plastics, PEEK, Titanium (Finishing) ...
- CBN** Steel hardened up to 72 HRC, Tool Steel up to 72 HRC, powder metallurgical Steel ...



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Visit us at ranitool.com

Boring Bars

for internal machining from Dmin 3,60 mm

Type BE

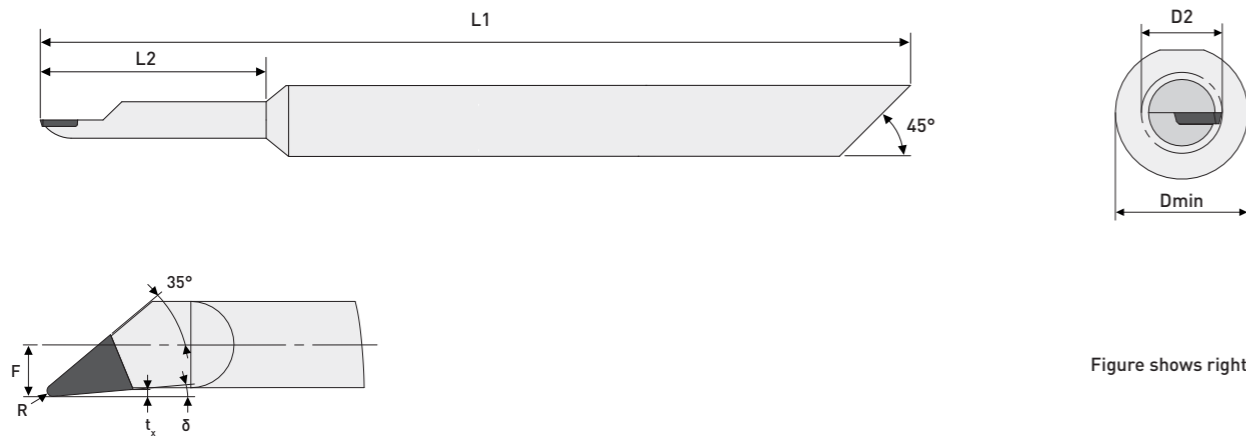


Figure shows right version

Dmin	F	L2	L1	R	D2	t _x	δ	Version	PCD	CVD-D	CBN
									Item No.	Item No.	Item No.
3,60	1,80	10,00	100,00	0,20	6h6	0,30	5°	right	BE2050-2130	BE3550-2130	
								left	BE2050-2131	BE3550-2131	
	1,80	18,00	100,00	0,20	6h6	0,30	5°	right	BE2050-2030	BE3550-2030	
								left	BE2050-2031	BE3550-2031	
7,00	3,50	-	100,00	0,20	6h6	0,50	5°	right	BE2050-2060	BE3550-2060	
								left	BE2050-2061	BE3550-2061	
	3,50	-	100,00	0,40	6h6	0,50	5°	right	BE2050-4060	BE3550-4060	
								left	BE2050-4061	BE3550-4061	

Your Notes

Application range:


- PCD Aluminum <10% Si, Brass, Brass lead-free, Graphite, Titanium (Roughing) ...
- CVD-D Acrylic, Aluminum >10% Si, Carbide, Ceramics, Composites (CFRP, GFRP, MMC), Copper, Plastics, PEEK, Titanium (Finishing) ...
- CBN Steel hardened up to 72 HRC, Tool Steel up to 72 HRC, powder metallurgical Steel ...

ISO Code


Shank specification E 08 X S C L C R 06

A Steel shank with internal cooling	C Carbide shank	E Carbide shank with internal cooling	S Steel shank
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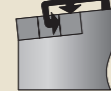



Shank diameter [mm] E 08 X S C L C R 06

	08 = 8 mm	12 = 12 mm	20 = 20 mm	32 = 32 mm	50 = 50 mm
	10 = 10 mm	16 = 16 mm	25 = 25 mm	40 = 40 mm	60 = 60 mm









Tool length L1 [mm] E 08 X S C L C R 06

	F = 80 mm	L = 140 mm	P = 170 mm	S = 250 mm	V = 400 mm	X = Special
	H = 100 mm	M = 150 mm	Q = 180 mm	T = 300 mm	W = 450 mm	
	K = 125 mm	N = 160 mm	R = 200 mm	U = 350 mm	Y = 500 mm	

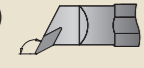

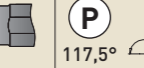
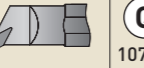
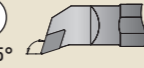

Clamping system E 08 X S C L C R 06

C 	D 	M 	P 	S 
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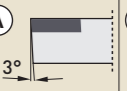
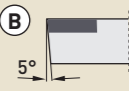
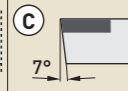
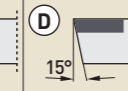
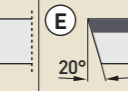
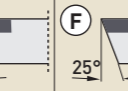
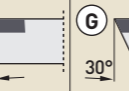
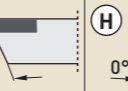

Insert shape E 08 X S C L C R 06

C 	D 	K 	R 	S 	T 	V 	W 
--	--	--	--	--	---	--	--

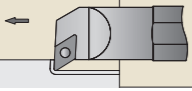

Approach angle E 08 X S C L C R 06

F 	L 	P 	Q 	U 	W 
--	--	--	--	--	---

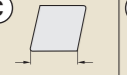


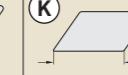


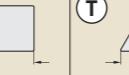

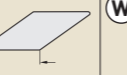
Insert clearance angle E 08 X S C L C R 06

A 	B 	C 	D 	E 	F 	G 	H 	I 
--	--	--	--	--	--	--	---	--

Hand of tool E 08 X S C L C R 06

R 	L 
--	--

Cutting edge length [mm] E 08 X S C L C R 06

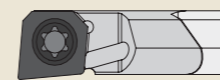
C 	E 	D 	K 	R 	S 	T 	V 	W 
--	--	--	--	--	--	--	---	--

MiniTools

equipped with multi-edged Diamond or CBN inserts

Boring Tools with Carbide Tool Holders for Mini Inserts :

- ✓ Highly economical due to multi-edged inserts
- ✓ Starting from bore Ø 3,5mm
- ✓ Low vibration carbide design
- ✓ With inner cooling
- ✓ For internal turning on lathes
- ✓ For spindle turning on milling machines



E-SCLDR/L



E-SCLDR/L



E-SDQCR/L



E-SELPR/L



E-SRLCR/L



E-SVLXR/L



E... STXPR/L



E-SWUCR/L

Large selection of multi-edged indexable inserts!

Application range of our diamond indexable inserts:

- ✓ All abrasive non-ferrous materials
- ✓ Aluminum
- ✓ Carbide G-Grade
- ✓ Carbide K-Grade
- ✓ Carbide with Ni Binder
- ✓ Ceramic Materials
- ✓ Composite such as CFRP / GFRP
- ✓ Copper Alloys
- ✓ Glass and Glass Ceramic
- ✓ MMC
- ✓ Other brittle non-ferrous materials
- ✓ Titanium (Finishing)

Application range of our CBN indexable inserts:

- ✓ Cast Iron
- ✓ Special Alloys such as ASP, CPM, Hardox
- ✓ Steel hardened up to 72 HRC
- ✓ Stellite
- ✓ Tool Steel up to 72 HRC

CDGW 03 ...
FullFace (Z1)



from Dmin 3,50

CDGW 04 ...
Z2



from Dmin 4,80

DCGW 05 ...
Z2



from Dmin 5,20

EPGW 05 ...
Z2



from Dmin 8,00

TPGW 06 ...
Z1



from Dmin 8,00

VCGW 05 ...
Z2



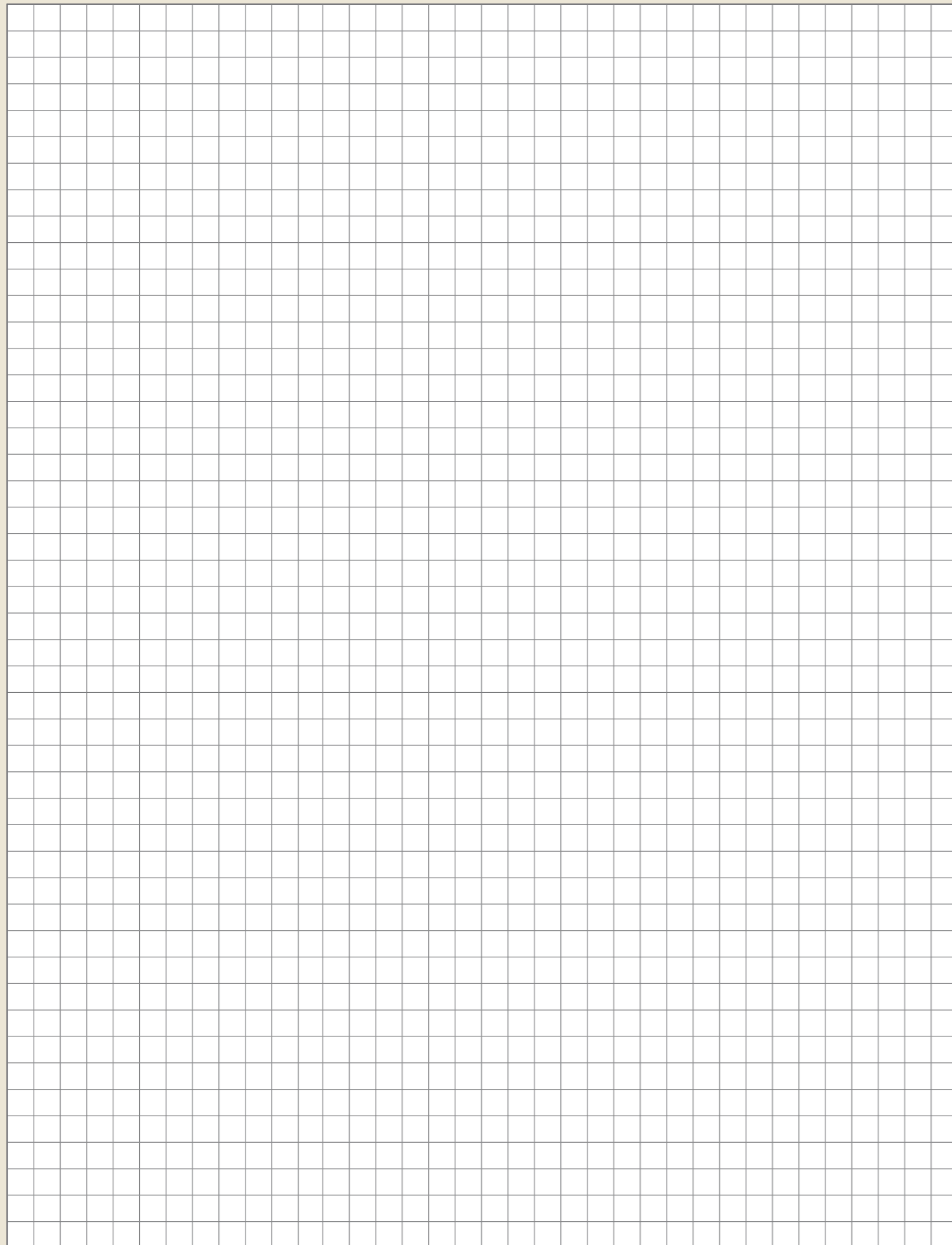
from Dmin 8,00

WCGW 02 ...
Z3



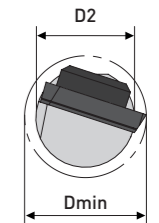
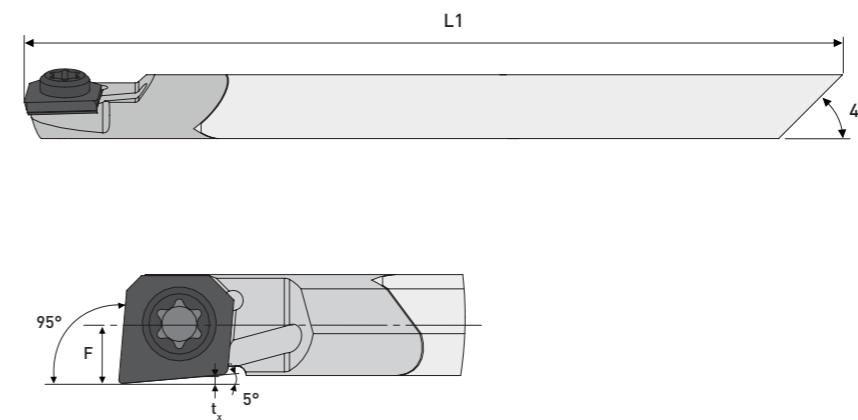
from Dmin 5,80

Inserts available with radii from 0.10 mm to 0.40 mm.



E... SCLDR/L 95°/5°

for inserts CDGW 03...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	t _x	Version	ISO Code ^{New}	Item No.
3,50	1,75	-	80,00	3,00	0,20	right	E03X SCLDR 03	BW6060-0234
						left	E03X SCLDL 03	BW6060-0235

Matching clamping screw: 01-KL9060-0016

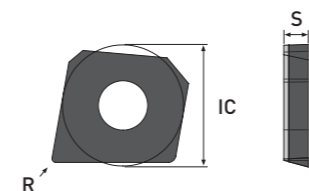


Figure shows right version FullFace

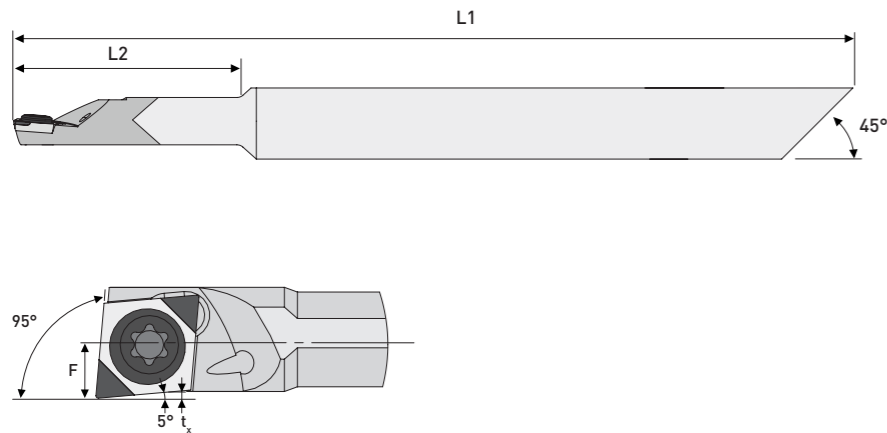
ISO Code	IC	S	R	CVD-D ^{New}	Ultra Diamond	CBN-H ^{New}	CBN-X ^{New}	CBN-K ^{New}
				Item No.	Item No.	Item No.	Item No.	Item No.
CDGW 03X101-Right	3,20	0,63	0,10	DP2030-0500	-	TI5030-0500	TI5930-0500	TI5530-0500
CDGW 03X102-Right	3,20	0,63	0,20	DP2030-0502	-	TI5030-0502	TI5930-0502	TI5530-0502
CDGW 03X101-Left	3,20	0,63	0,10	DP2030-0501	-	TI5030-0501	TI5930-0501	TI5530-0501
CDGW 03X102-Left	3,20	0,63	0,20	DP2030-0503	-	TI5030-0503	TI5930-0503	TI5530-0503

Application range:

- CVD-D Aluminum, Brass, Brass lead-free, Composites (CFRP, GFRP, MMC), Graphite, Titanium ...
- U-Diamond Acrylic, Carbide < 10% Binder, Ceramics, Zirconium ...
- CBN-H Steel hardened up to 72 HRC
- CBN-X Tool Steel hardened up to 72 HRC, Tool Steel low alloy, Stellite, powder metallurgical Steel ...
- CBN-K Grey Cast Iron (GCI), Ductile Cast Iron (DCI) ...

E... SCLDR/L 95°/5°

for inserts CDGW 0401...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	tx	Version	ISO Code	Item No.
4,80	2,50	24,00	80,00	8,00	0,30	right	E0408X SCLDR 04	BW6060-0130
						left	E0408X SCLDL 04	BW6060-0131
5,80	2,90	21,50	100,00	8,00	0,40	right	E0508X SCLDR 04	BW6060-0132
						left	E0508X SCLDL 04	BW6060-0133
6,80	3,40	22,00	100,00	8,00	0,40	right	E0608X SCLDR 04	BW6060-0134
						left	E0608X SCLDL 04	BW6060-0135

Matching clamping screw: 01-BW9060-0011

CL 2,00 mm
2-edge tipped

ISO Code	IC	S	R	CVD-D Item No.	Ultra Diamond Item No.	CBN-H Item No.	CBN-X Item No.	CBN-K Item No.
CDGW 040101	3,97	1,00	0,10	DP2010-0511	DP1110-1480	TI5010-1511	TI5910-2510	TI5510-2510
CDGW 040102	3,97	1,00	0,20	DP2010-0512	DP1110-1482	TI5010-1512	TI5910-2512	TI5510-2512
CDGW 040104	3,97	1,00	0,40	DP2010-0513	DP1110-1484	TI5010-1513	TI5910-2514	TI5510-2514

Application range:

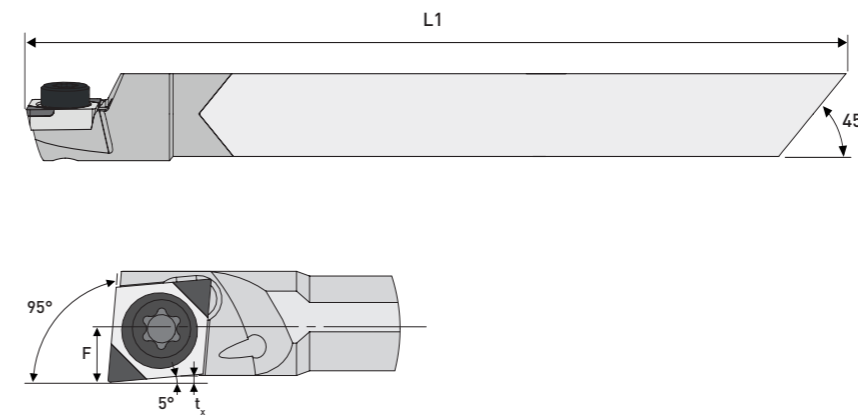
- CVD-D** Aluminum, Brass, Brass lead-free, Composites (CFRP, GFRP, MMC), Graphite, Titanium ...
- U-Diamond** Acrylic, Carbide < 10% Binder, Ceramics, Zirconium ...
- CBN-H** Steel hardened up to 72 HRC
- CBN-X** Tool Steel hardened up to 72 HRC, Tool Steel low alloy, Stellite, powder metallurgical Steel ...
- CBN-K** Grey Cast Iron (GCI), Ductile Cast Iron (DCI) ...

Suitable clamping adapters can be found from page 36 onwards.

You will find further application ranges in the detailed overview from page 8.

E... SCLDR/L 95°/5°

for inserts CDGW 0401...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	tx	Version	ISO Code	Item No.
4,80	2,50	-	80,00	4,00	0,30	right	E04X SCLDR 04	BW6060-0120
						left	E04X SCLDL 04	BW6060-0121
5,80	2,90	-	100,00	5,00	0,40	right	E05X SCLDR 04	BW6060-0122
						left	E05X SCLDL 04	BW6060-0123
6,80	3,40	-	100,00	6,00	0,40	right	E06X SCLDR 04	BW6060-0124
						left	E06X SCLDL 04	BW6060-0125

Matching clamping screw: 01-BW9060-0011

CL 2,00 mm
2-edge tipped

ISO Code	IC	S	R	CVD-D Item No.	Ultra Diamond Item No.	CBN-H Item No.	CBN-X Item No.	CBN-K Item No.
CDGW 040101	3,97	1,00	0,10	DP2010-0511	DP1110-1480	TI5010-1511	TI5910-2510	TI5510-2510
CDGW 040102	3,97	1,00	0,20	DP2010-0512	DP1110-1482	TI5010-1512	TI5910-2512	TI5510-2512
CDGW 040104	3,97	1,00	0,40	DP2010-0513	DP1110-1484	TI5010-1513	TI5910-2514	TI5510-2514



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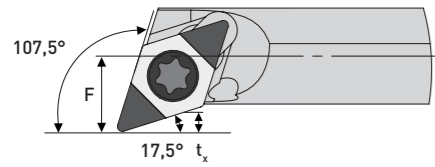
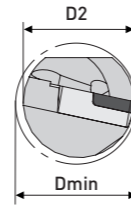
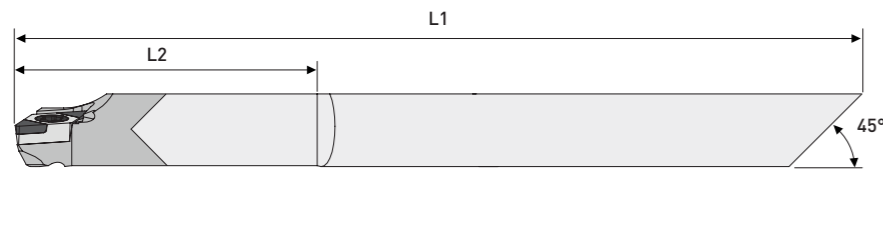
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Subject to technical changes.

E... SDQCR/L 107,5°/17,5°

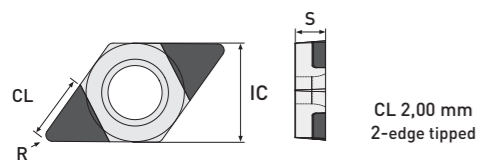
for inserts DCGW 04T0...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	tx	Version	ISO Code	Item No.
5,20	3,00	25,00	100,00	5,00	1,10	right	E0405X SDQCR 04	BW6060-0166
						left	E0405X SDQCL 04	BW6060-0167

Matching clamping screw: 01-BW9060-0010



CL 2,00 mm
2-edge tipped



ISO Code	IC	S	R	Item No.	Item No. <small>New</small>	Item No.	Item No. <small>New</small>	Item No. <small>New</small>
DCGW 04T001	3,10	1,20	0,10	DP2010-0521	DP1110-1492	TI5010-1521	TI5910-2522	TI5510-2522
DCGW 04T002	3,10	1,20	0,20	DP2010-0522	DP1110-1494	TI5010-1522	TI5910-2524	TI5510-2524
DCGW 04T004	3,10	1,20	0,40	DP2010-0523	DP1110-1496	TI5010-1523	TI5910-2526	TI5510-2526

Application range:

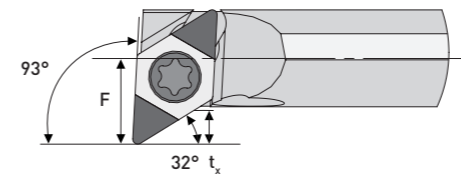
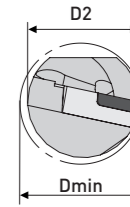
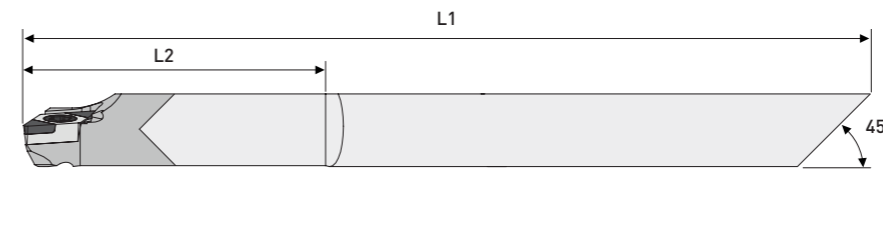
- CVD-D Aluminum, Brass, Brass lead-free, Composites (CFRP, GFRP, MMC), Graphite, Titanium ...
- U-Diamond Acrylic, Carbide < 10% Binder, Ceramics, Zirconium ...
- CBN-H Steel hardened up to 72 HRC
- CBN-X Tool Steel hardened up to 72 HRC, Tool Steel low alloy, Stellite, powder metallurgical Steel ...
- CBN-K Grey Cast Iron (GCI), Ductile Cast Iron (DCI) ...

Suitable clamping adapters can be found from page 36 onwards.

You will find further application ranges in the detailed overview from page 8.

E... SDUCR/L 93°/32°

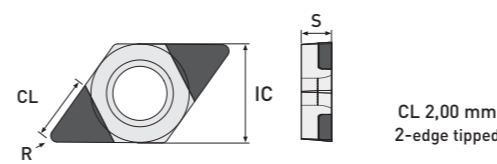
for inserts DCGW 04T0...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	tx	Version	ISO Code	Item No.
5,60	3,00	25,00	100,00	5,00	1,50	right	E0405X SDUCR 04	BW6060-0160
						left	E0405X SDUCL 04	BW6060-0161

Matching clamping screw: 01-BW9060-0010



CL 2,00 mm
2-edge tipped



ISO Code	IC	S	R	Item No.	Item No. <small>New</small>	Item No.	Item No. <small>New</small>	Item No. <small>New</small>
DCGW 04T001	3,10	1,20	0,10	DP2010-0521	DP1110-1492	TI5010-1521	TI5910-2522	TI5510-2522
DCGW 04T002	3,10	1,20	0,20	DP2010-0522	DP1110-1494	TI5010-1522	TI5910-2524	TI5510-2524
DCGW 04T004	3,10	1,20	0,40	DP2010-0523	DP1110-1496	TI5010-1523	TI5910-2526	TI5510-2526



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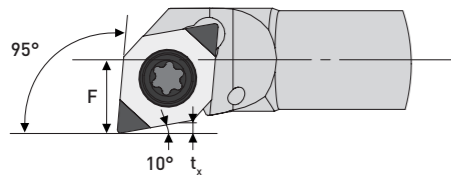
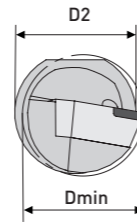
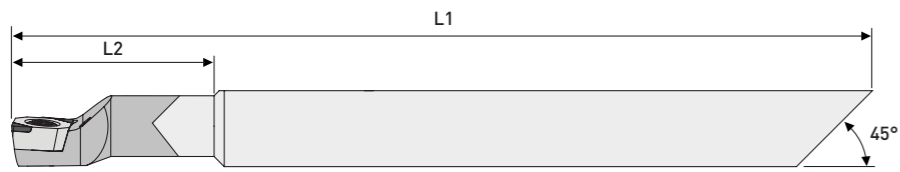
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Subject to technical changes.

E... SELPR/L 95°/10°

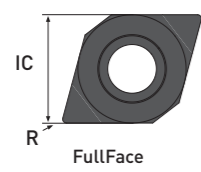
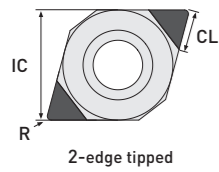
for inserts EPGW 0502...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	tx	Version	ISO Code	Item No.
8,00	4,50	20,00	100,00	8,00	0,80	right	E0608X SELPR 05	BW6060-0150
						left	E0608X SELPL 05	BW6060-0151
11,00	6,00	33,00	100,00	10,00	0,80	right	E0810X SELPR 05	BW6060-0152
						left	E0810X SELPL 05	BW6060-0153

Matching clamping screw: 01-BW9060-0005



ISO Code	IC	S	R	CVD-D	Ultra Diamond	CBN-H	CBN-X	CBN-K
				Item No.	Item No. <small>New</small>	Item No.	Item No. <small>New</small>	Item No. <small>New</small>
EPGW 050201	5,56	2,38	0,10	DP2010-0531	DP1110-1400	TI5010-1531	TI5910-2550	TI5510-2550
EPGW 050202	5,56	2,38	0,20	DP2010-0532	DP1110-1402	TI5010-1532	TI5910-2552	TI5510-2552
EPGW 050204	5,56	2,38	0,40	DP2010-0533	DP1110-1404	TI5010-1533	TI5910-2554	TI5510-2554
EPGW 050201 FF	5,56	2,38	0,10			TI5030-0081	TI5930-0081	TI5530-0081
EPGW 050202 FF	5,56	2,38	0,20			TI5030-0082	TI5930-0082	TI5530-0082
EPGW 050204 FF	5,56	2,38	0,40			TI5030-0083	TI5930-0083	TI5530-0083

Application range:

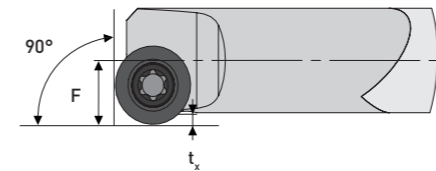
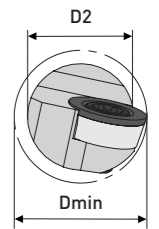
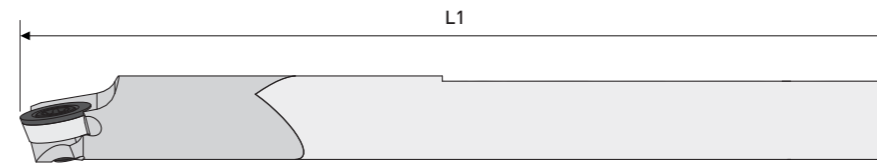
- CVD-D Aluminum, Brass, Brass lead-free, Composites (CFRP, GFRP, MMC), Graphite, Titanium ...
- U-Diamond Acrylic, Carbide < 10% Binder, Ceramics, Zirconium ...
- CBN-H Steel hardened up to 72 HRC
- CBN-X Tool Steel hardened up to 72 HRC, Tool Steel low alloy, Stellite, powder metallurgical Steel ...
- CBN-K Grey Cast Iron (GCI), Ductile Cast Iron (DCI) ...

Suitable clamping adapters can be found from page 36 onwards.

You will find further application ranges in the detailed overview from page 8.

E... SRLCR/L 95°/10°

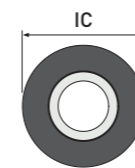
for inserts RCGW 0602...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	tx	Version	ISO Code	Item No.
10,00	5,00	-	125,00	8,00	1,00	right	E08X SRLCR 06	BW6060-1024
						left	E08X SRLCL 06	BW6060-1025

Matching clamping screw: 01-BW9060-0005



FullFace

ISO Code	IC	S	R	CVD-D	Ultra Diamond	CBN-H	CBN-X	CBN-K
				Item No.	Item No.	Item No.	Item No.	Item No.
RCGW 0602M0 FF	6,00	2,38	-	DP1030-0001	DP2030-0001	TI5030-0100	TI5930-0102	TI5530-0102



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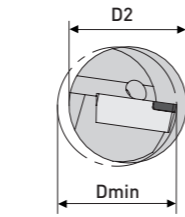
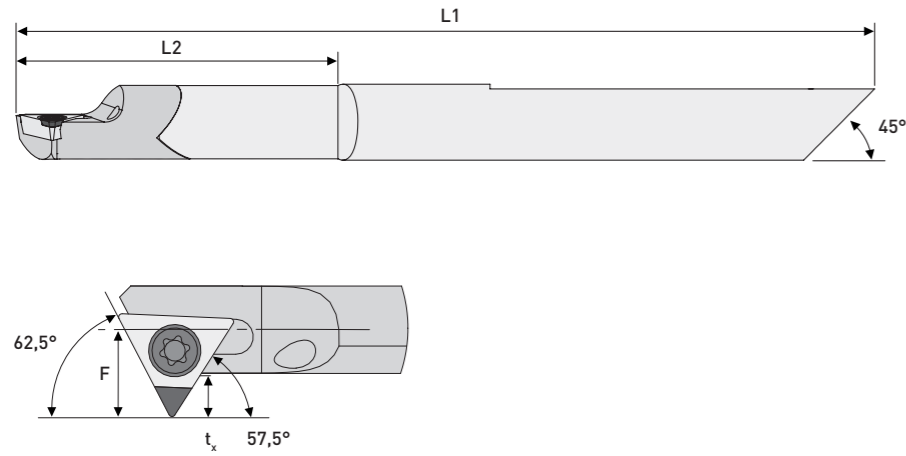
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Subject to technical changes.

E... STXPR/L 62,5°/57,5°

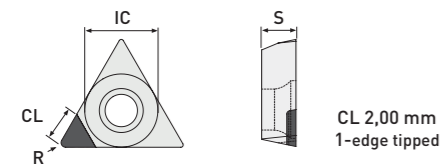
for inserts TPGW 06T1...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	tx	Version	ISO Code	Item No.
8,00	4,50	40,00	100,00	6,00	2,50	right	E06X STXPR 06	BW6060-0126
						left	E06X STXPL 06	BW6060-0127

Matching clamping screw: 01-BW9060-0126

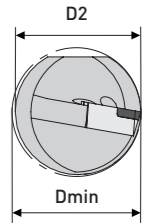
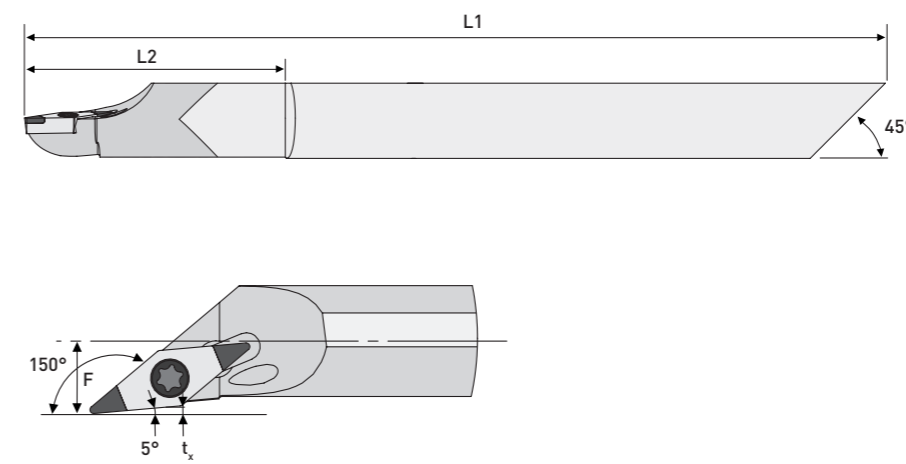


ISO Code	IC	S	R	CVD-D Item No.	Ultra Diamond Item No. <small>New</small>	CBN-H Item No.	CBN-X Item No. <small>New</small>	CBN-K Item No. <small>New</small>
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TPGW 06T101	3,97	1,98	0,10	DP2010-0671	DP1110-1410	TI5010-0786	TI5910-0786	TI5510-0786
TPGW 06T102	3,97	1,98	0,20	DP2010-0672	DP1110-1412	TI5010-0787	TI5910-0787	TI5510-0787
TPGW 06T104	3,97	1,98	0,40	DP2010-0673	DP1110-1414	TI5010-0788	TI5910-0788	TI5510-0788

E... SVXCR/L 5°/150°

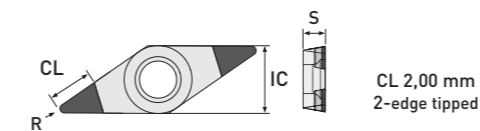
for inserts VCGW 0501...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	tx	Version	ISO Code	Item No.
8,00	3,00	26,00	80,00	8,00	0,40	right	E08X SVXCR 05 5°	BW6060-0180
						left	E08X SVXCL 05 5°	BW6060-0181

Matching clamping screw: 01-BW9060-0002



ISO Code	IC	S	R	CVD-D Item No.	Ultra Diamond Item No. <small>New</small>	CBN-H Item No.	CBN-X Item No. <small>New</small>	CBN-K Item No. <small>New</small>
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VCGW 050101	3,10	1,59	0,10	DP2010-0561	DP1110-1498	TI5010-1561	TI5910-2528	TI5510-2528
VCGW 050102	3,10	1,59	0,20	DP2010-0562	DP1110-1500	TI5010-1562	TI5910-2530	TI5510-2530
VCGW 050104	3,10	1,59	0,40	DP2010-0563	DP1110-1502	TI5010-1563	TI5910-2532	TI5510-2532


Application range:

- CVD-D Aluminum, Brass, Brass lead-free, Composites (CFRP, GFRP, MMC), Graphite, Titanium ...
- U-Diamond Acrylic, Carbide < 10% Binder, Ceramics, Zirconium ...
- CBN-H Steel hardened up to 72 HRC
- CBN-X Tool Steel hardened up to 72 HRC, Tool Steel low alloy, Stellite, powder metallurgical Steel ...
- CBN-K Grey Cast Iron (GCI), Ductile Cast Iron (DCI) ...

Suitable clamping adapters can be found from page 36 onwards.

You will find further application ranges in the detailed overview from page 8.

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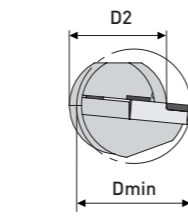
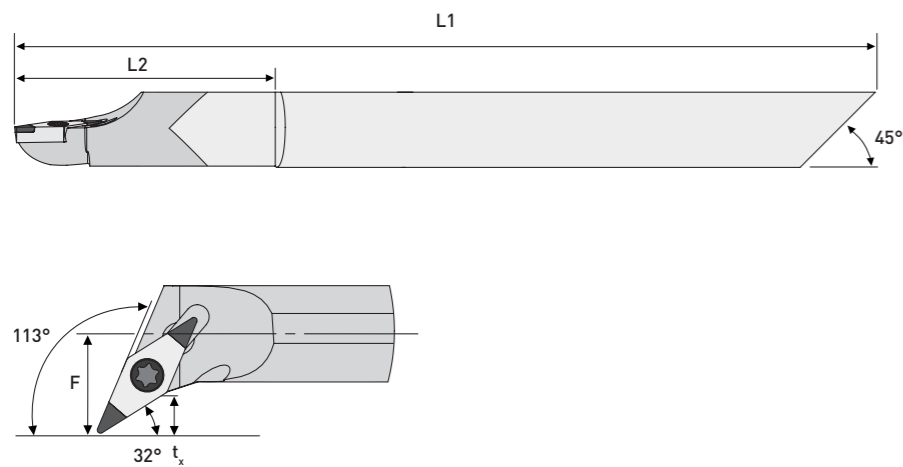
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Subject to technical changes.

E... SVXCR/L 113°/32°

for inserts VCGW 0501...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	t _x	Version	ISO Code	Item No.
9,20	5,00	26,00	80,00	8,00	2,50	right	E08X SVXCR 05 113°	BW6060-0186
						left	E08X SVXCL 05 113°	BW6060-0187

Matching clamping screw: 01-BW9060-0002

CL 2,00 mm
2-edge tipped

ISO Code	IC	S	R	CVD-D Item No.	Ultra Diamond Item No. <small>New</small>	CBN-H Item No.	CBN-X Item No. <small>New</small>	CBN-K Item No. <small>New</small>
VCGW 050101	3,10	1,59	0,10	DP2010-0561	DP1110-1498	TI5010-1561	TI5910-2528	TI5510-2528
VCGW 050102	3,10	1,59	0,20	DP2010-0562	DP1110-1500	TI5010-1562	TI5910-2530	TI5510-2530
VCGW 050104	3,10	1,59	0,40	DP2010-0563	DP1110-1502	TI5010-1563	TI5910-2532	TI5510-2532

Application range:

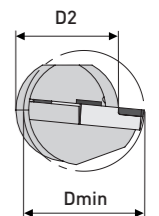
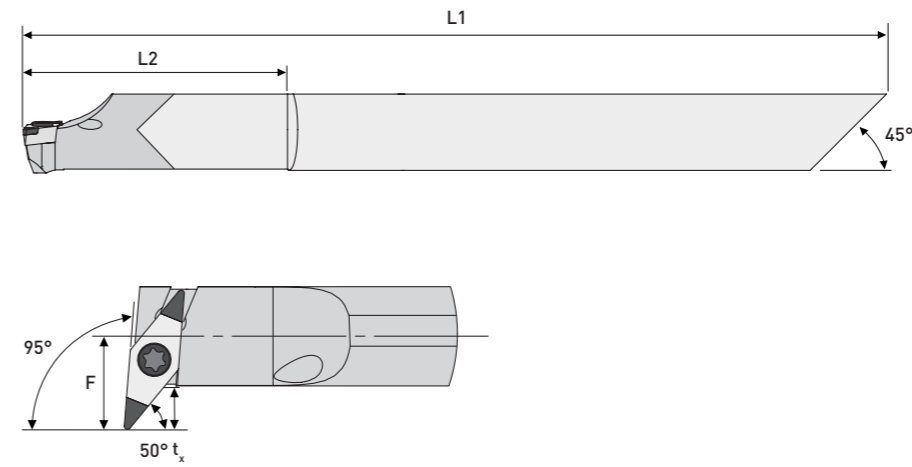
- CVD-D Aluminum, Brass, Brass lead-free, Composites (CFRP, GFRP, MMC), Graphite, Titanium ...
- U-Diamond Acrylic, Carbide < 10% Binder, Ceramics, Zirconium ...
- CBN-H Steel hardened up to 72 HRC
- CBN-X Tool Steel hardened up to 72 HRC, Tool Steel low alloy, Stellite, powder metallurgical Steel ...
- CBN-K Grey Cast Iron (GCI), Ductile Cast Iron (DCI) ...

Suitable clamping adapters can be found from page 36 onwards.

You will find further application ranges in the detailed overview from page 8.

E... SVLCR/L 95°/50°

for inserts VCGW 0501...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	t _x	Version	ISO Code	Item No.
9,20	5,00	26,00	80,00	8,00	3,00	right	E08X SVLCR 05	BW6060-0190
						left	E08X SVLCL 05	BW6060-0191

Matching clamping screw: 01-BW9060-0002

CL 2,00 mm
2-edge tipped

ISO Code	IC	S	R	CVD-D Item No.	Ultra Diamond Item No. <small>New</small>	CBN-H Item No.	CBN-X Item No. <small>New</small>	CBN-K Item No. <small>New</small>
VCGW 050101	3,10	1,59	0,10	DP2010-0561	DP1110-1498	TI5010-1561	TI5910-2528	TI5510-2528
VCGW 050102	3,10	1,59	0,20	DP2010-0562	DP1110-1500	TI5010-1562	TI5910-2530	TI5510-2530
VCGW 050104	3,10	1,59	0,40	DP2010-0563	DP1110-1502	TI5010-1563	TI5910-2532	TI5510-2532



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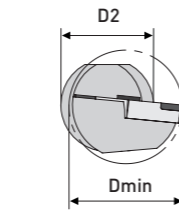
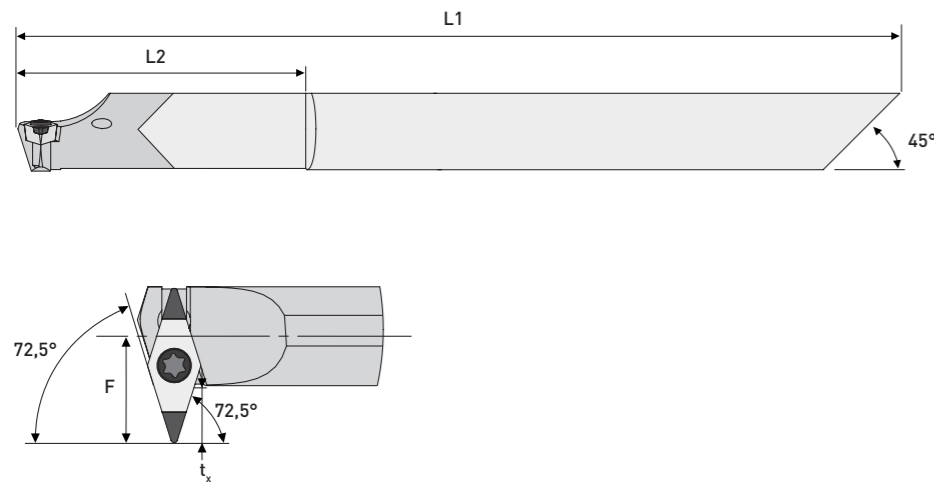
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Subject to technical changes.

E... SVVCR 72,5°/72,5°

for inserts VCGW 0501...



Carbide Tool Holder
Figure shows right version

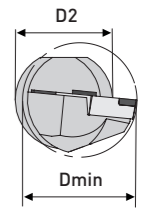
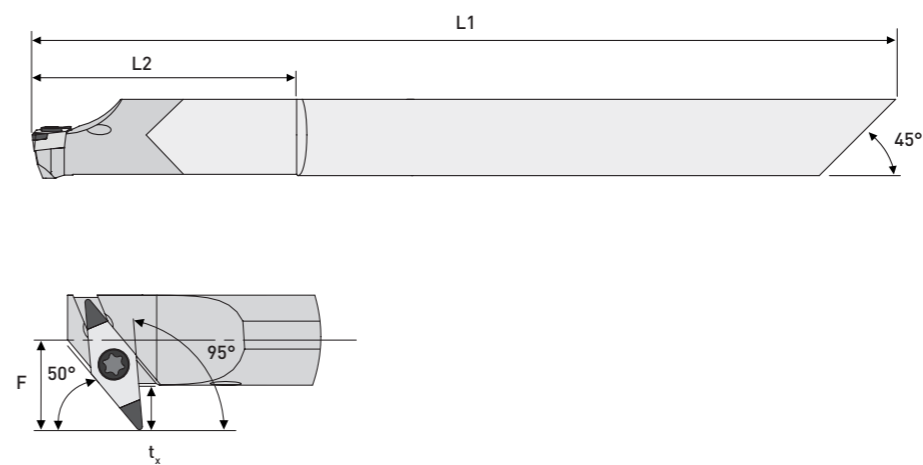
Dmin	F	L2	L1	D2	t _x	Version	ISO Code	Item No.
10,00	5,50	26,00	80,00	8,00	3,50	right	E08X SVVCR 05	BW6060-0196

Matching clamping screw: 01-BW9060-0002

ISO Code	IC	S	R	CVD-D	Ultra Diamond	CBN-H	CBN-X	CBN-K
				Item No.	Item No. <small>New</small>	Item No.	Item No. <small>New</small>	Item No. <small>New</small>
VCGW 050101	3,10	1,59	0,10	DP2010-0561	DP1110-1498	TI5010-1561	TI5910-2528	TI5510-2528
VCGW 050102	3,10	1,59	0,20	DP2010-0562	DP1110-1500	TI5010-1562	TI5910-2530	TI5510-2530
VCGW 050104	3,10	1,59	0,40	DP2010-0563	DP1110-1502	TI5010-1563	TI5910-2532	TI5510-2532

E... SVLXR/L 50°/95° EX

for inserts VCGW 0501...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	t _x	Version	ISO Code	Item No.
9,20	5,00	26,00	80,00	8,00	3,00	right	E08X SVLXR 05	BW6060-0200
						left	E08X SVLXL 05	BW6060-0201

Matching clamping screw: 01-BW9060-0002

ISO Code	IC	S	R	CVD-D	Ultra Diamond	CBN-H	CBN-X	CBN-K
				Item No.	Item No. <small>New</small>	Item No.	Item No. <small>New</small>	Item No. <small>New</small>
VCGW 050101	3,10	1,59	0,10	DP2010-0561	DP1110-1498	TI5010-1561	TI5910-2528	TI5510-2528
VCGW 050102	3,10	1,59	0,20	DP2010-0562	DP1110-1500	TI5010-1562	TI5910-2530	TI5510-2530
VCGW 050104	3,10	1,59	0,40	DP2010-0563	DP1110-1502	TI5010-1563	TI5910-2532	TI5510-2532

Application range:

- CVD-D Aluminum, Brass, Brass lead-free, Composites (CFRP, GFRP, MMC), Graphite, Titanium ...
- U-Diamond Acrylic, Carbide < 10% Binder, Ceramics, Zirconium ...
- CBN-H Steel hardened up to 72 HRC
- CBN-X Tool Steel hardened up to 72 HRC, Tool Steel low alloy, Stellite, powder metallurgical Steel ...
- CBN-K Grey Cast Iron (GCI), Ductile Cast Iron (DCI) ...

Suitable clamping adapters can be found from page 36 onwards.

You will find further application ranges in the detailed overview from page 8.



Special tools on request for you!
Please send inquiries to sales@ranitool.com



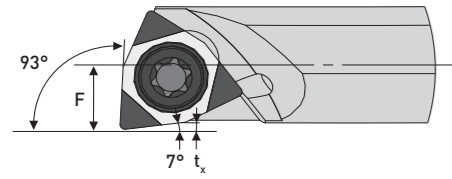
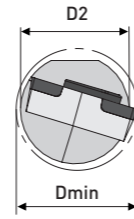
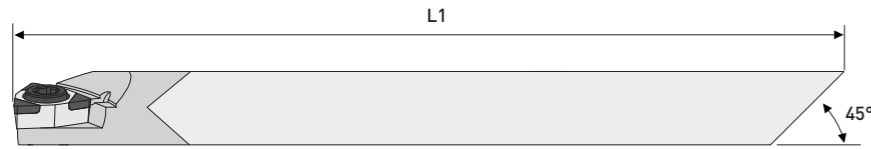
All our products are also available in the online shop.
Visit us at ranitool.com

You can find our complete holder program in our tool holder catalog or in our online shop.

Subject to technical changes.

E... SWUCR/L 93°/7°

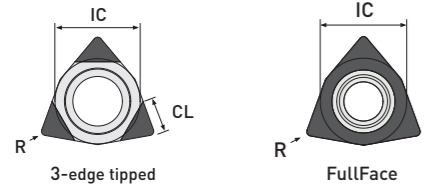
for inserts WCGW 0201...



Carbide Tool Holder
Figure shows right version

Dmin	F	L2	L1	D2	tx	Version	ISO Code	Item No.
5,80	2,90	-	100,00	5,00	0,25	right	E05X SWUCR 02	BW6060-0090
						left	E05X SWUCL 02	BW6060-0091
7,80	3,90	-	100,00	6,00	0,25	right	E06X SWUCR 02	BW6060-0094
						left	E06X SWUCL 02	BW6060-0095

Matching clamping screw: 01-BW9060-0012

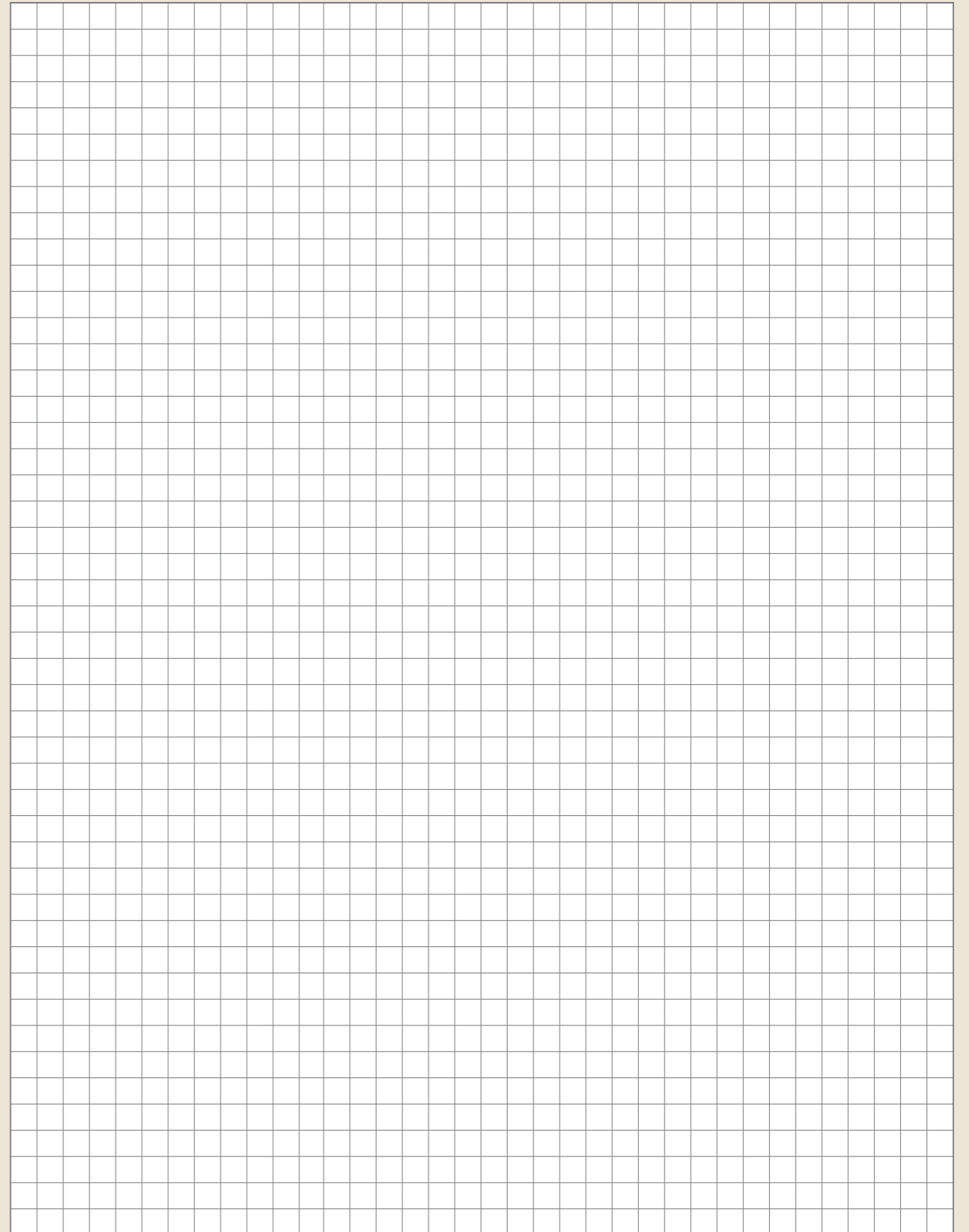


ISO Code	IC	S	R	CVD-D	Ultra Diamond	CBN-H	CBN-X	CBN-K
				Item No.	Item No. <small>New</small>	Item No.	Item No. <small>New</small>	Item No. <small>New</small>
WCGW 020101	3,97	1,59	0,10	DP2010-0571	DP1110-1504	TI5010-1571	TI5910-2534	TI5510-2534
WCGW 020102	3,97	1,59	0,20	DP2010-0572	DP1110-1506	TI5010-1572	TI5910-2536	TI5510-2536
WCGW 020104	3,97	1,59	0,40	DP2010-0573	DP1110-1508	TI5010-1573	TI5910-2538	TI5510-2538
WCGW 020101 FF	3,97	1,59	0,10	DP2030-0117		TI5030-0201	TI5930-0202	TI5530-0202
WCGW 020102 FF	3,97	1,59	0,20	DP2030-0113		TI5030-0205	TI5930-0207	TI5530-0207
WCGW 020104 FF	3,97	1,59	0,40	DP2030-0114		TI5030-0210	TI5930-0212	TI5530-0212

Application range:

- CVD-D Aluminum, Brass, Brass lead-free, Composites (CFRP, GFRP, MMC), Graphite, Titanium ...
- U-Diamond Acrylic, Carbide < 10% Binder, Ceramics, Zirconium ...
- CBN-H Steel hardened up to 72 HRC
- CBN-X Tool Steel hardened up to 72 HRC, Tool Steel low alloy, Stellite, powder metallurgical Steel ...
- CBN-K Grey Cast Iron (GCI), Ductile Cast Iron (DCI) ...

Your Notes



Clamping Systems

Hydraulic Expansion Chuck


Take advantage!

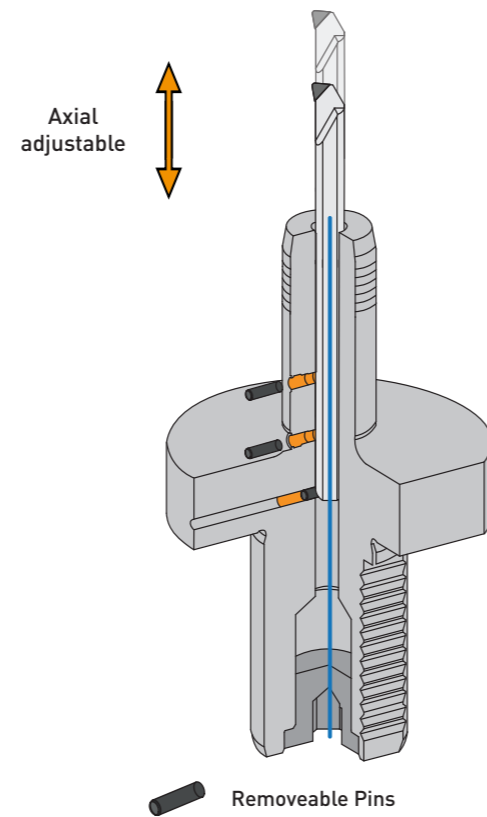
- ✓ High damping
- ✓ Tool life increase up to approximately 30%
- ✓ Automatic cutting edge adjustment
- ✓ Excellent surface quality
- ✓ High dimensional stability
- ✓ Easy and quick change of the boring bar

Functionality

Automatic adjustment of center height through pin, resulting in a very high repeat accuracy

This gives you a very high repeat accuracy.

 Cooling through the clamping surface



Adjustment Guide

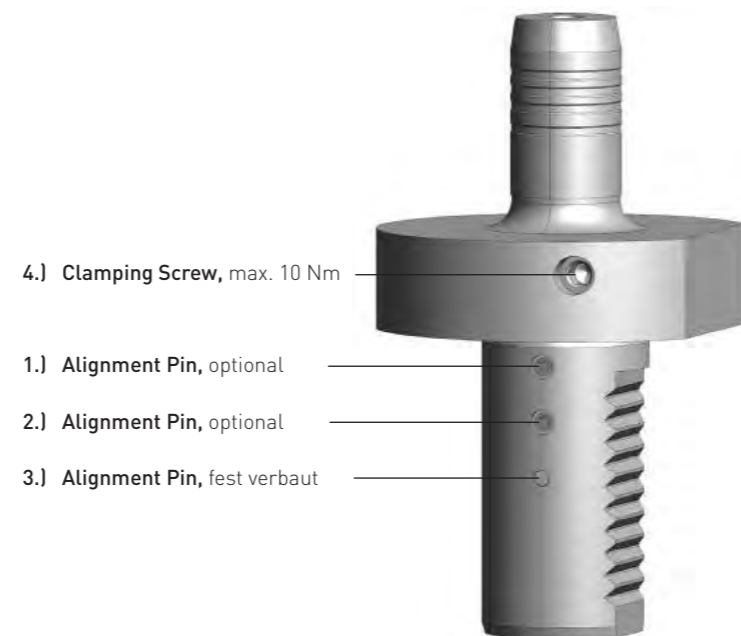
for tool change

1. Loosen screw 4
2. Insert boring bar
3. Turn tool slightly at stop until resistance is felt
4. Tighten screw 4 with max. 10Nm

-> Tool ready for use

Extended length too long?

1. Loosen screw 4
2. Remove threaded pin 1 (if necessary 2 also)
3. Remove alignment pin
4. Insert threaded pin 1 (if necessary 2 also)
5. Repeat adjustment guide from point 2



*Positioning of alignment pins may deviate due to manufacturing process


Clamping Systems

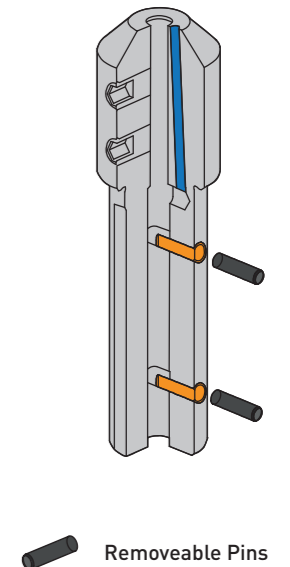
Clamping Adapter round or 4-sided

Take advantage!


- ✓ Excellent surface quality
- ✓ High dimensional stability
- ✓ High repeat accuracy

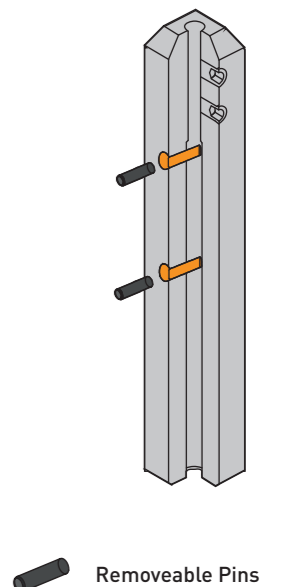
Functionality

- ✓ Automatic adjustment of center height through pin and 45° bevel on the tool
- ✓ Safe and stable positioning of the tool due to the 3-point fixing system
- ✓ Defined coolant supply 
- ✓ Adapter with shank tolerance $\varnothing 16h6$



Functionality

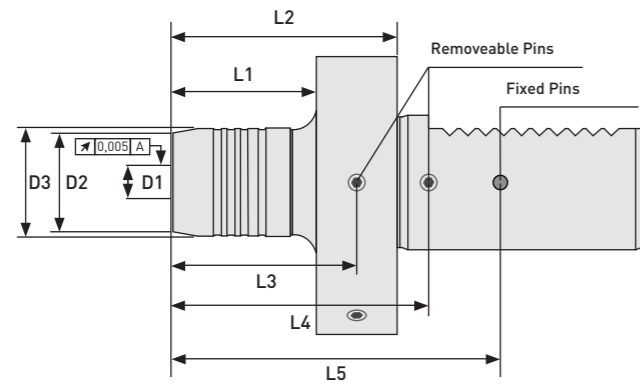
- ✓ Automatic adjustment of center height through pin and 45° bevel on the tool
- ✓ Safe and stable positioning of the tool due to the 3-point fixing system
- ✓ Grinded 4-sided for flexible use in almost all processing machines
- ✓ General coolant supply through clamping surface 



Hydraulic Expansion Chuck

with VDI

for brazed boring tools



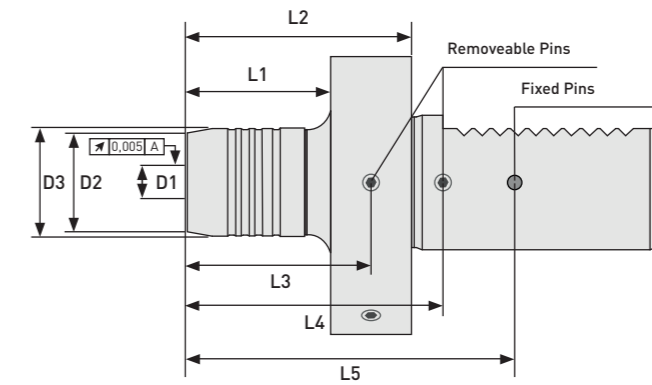
D1	VDI	D2	D3	L1	L2	L3	L4	L5	Item No.
4,00	16	18,00	20,00	33,00	58,00	46,00	54,00	62,00	BA7090-2040
	20	18,00	20,00	32,00	50,00	46,00	54,00	62,00	BA7090-2240
	25	18,00	20,00	32,00	50,00	46,00	54,00	62,00	BA7090-2245
	30	18,00	20,00	32,00	50,00	46,00	54,00	62,00	BA7090-2340
	40	18,00	20,00	58,00	76,00	46,00	54,00	62,00	BA7090-2440
5,00	16	18,00	20,00	51,00	76,00	62,00	72,00	82,00	BA7090-2050
	20	18,00	20,00	48,00	66,00	62,00	72,00	82,00	BA7090-2250
	25	18,00	20,00	48,00	66,00	62,00	72,00	82,00	BA7090-2255
	30	18,00	20,00	38,00	56,00	62,00	72,00	82,00	BA7090-2350
	40	18,00	20,00	56,00	76,00	62,00	72,00	82,00	BA7090-2450
6,00	16	18,00	20,00	45,00	71,00	55,00	67,00	79,00	BA7090-2060
	20	18,00	20,00	42,00	60,00	55,00	67,00	79,00	BA7090-2260
	25	18,00	20,00	42,00	60,00	55,00	67,00	79,00	BA7090-2265
	30	18,00	20,00	42,00	60,00	55,00	67,00	79,00	BA7090-2360
	40	18,00	20,00	58,00	76,00	55,00	67,00	79,00	BA7090-2460
8,00	16	22,00	24,00	37,00	62,00	41,00	57,00	73,00	BA7090-2080
	20	22,00	24,00	35,00	53,00	41,00	57,00	73,00	BA7090-2280
	25	22,00	24,00	34,00	52,00	41,00	57,00	73,00	BA7090-2285
	30	22,00	24,00	32,00	50,00	41,00	57,00	73,00	BA7090-2380
	40	22,00	24,00	60,00	80,00	41,00	57,00	73,00	BA7090-2480

Spare parts and torque wrench available on request.

Hydraulic Expansion Chuck

with VDI

for boring tools with indexable inserts

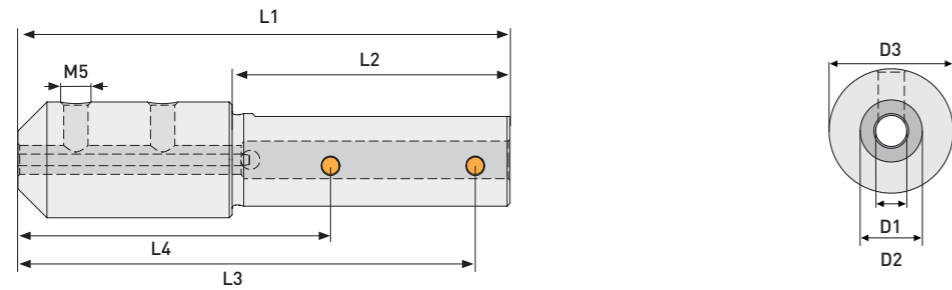


D1	VDI	D2	D3	L1	L2	L3	L4	L5	Item No.
4,00	16	18,00	20,00	40,00	65,00	52,00	60,00	68,00	BA7090-3140
	20	18,00	20,00	30,00	48,00	52,00	60,00	68,00	BA7090-3240
5,00	16	18,00	20,00	51,00	76,00	62,00	72,00	82,00	BA7090-3150
	20	18,00	20,00	48,00	66,00	62,00	72,00	82,00	BA7090-3250
6,00	16	18,00	20,00	45,00	71,00	55,00	67,00	79,00	BA7090-3160
	20	18,00	20,00	42,00	60,00	55,00	67,00	79,00	BA7090-3260
8,00	16	22,00	24,00	37,00	62,00	41,00	57,00	73,00	BA7090-3180
	16	22,00	24,00	17,00	42,00	22,00	38,00	54,00	BA7090-3181
	16	22,00	24,00	62,00	87,00	67,00	83,00	99,00	BA7090-3182
	20	22,00	24,00	27,00	45,00	22,00	38,00	54,00	BA7090-3280
	20	22,00	24,00	35,00	53,00	51,00	57,00	73,00	BA7090-3281
10,00	20	22,00	24,00	57,00	75,00	67,00	83,00	99,00	BA7090-3282
	20	24,00	26,00	87,00	105,00	77,00	97,00	117,00	BA7090-3911
	25	24,00	26,00	72,00	90,00	77,00	97,00	117,00	BA7090-3913
	30	26,00	28,00	32,00	50,00	37,00	57,00	77,00	BA7090-3915
	40	24,00	26,00	65,00	85,00	77,00	97,00	117,00	BA7090-3917

Spare parts and torque wrench available on request.

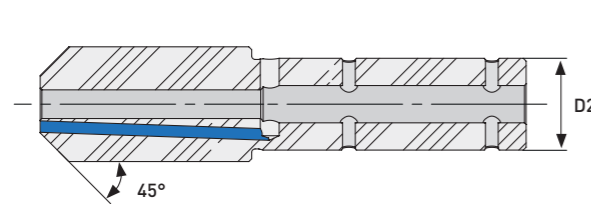
Clamping Adapter


optional with or without internal cooling



without internal cooling (light cooling through clamping surface)

D1	D2	D3	L1	L2	L3	L4	Item No.
3G6	16h6	20,00	75,00	48,00	64,00	34,00	BA7090-0000
4G6	16h6	20,00	75,00	48,00	64,00	34,00	BA7090-0001
5G6	16h6	20,00	85,00	48,00	79,00	49,00	BA7090-0002
6G6	16h6	20,00	84,00	48,00	78,00	48,00	BA7090-0003
8G6	16h6	20,00	82,00	48,00	77,00	47,00	BA7090-0004



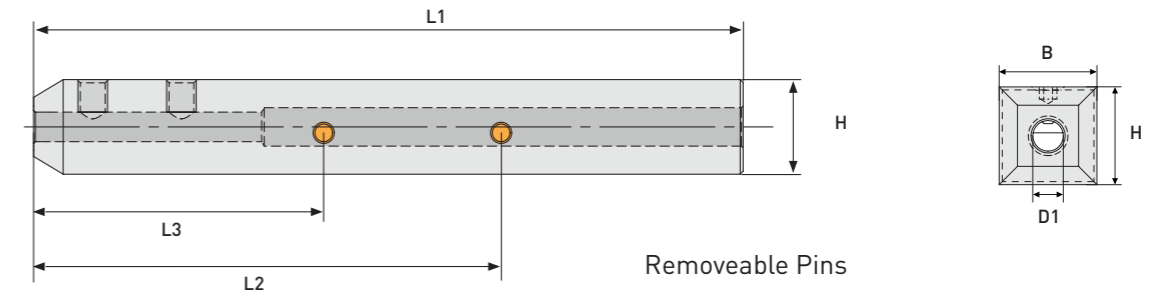
 with internal cooling

D1	D2	D3	L1	L2	L3	L4	Version	Item No.
4G6	16h6	20,00	75,00	48,00	64,00	39,00	R	BA7090-1001
							L	BA7090-2001
5G6	16h6	20,00	85,00	48,00	79,00	54,00	R	BA7090-1002
							L	BA7090-2002
6G6	16h6	20,00	84,00	48,00	78,00	53,00	R	BA7090-1003
							L	BA7090-2003
8G6	16h6	20,00	82,00	48,00	77,00	52,00	R	BA7090-1004
							L	BA7090-2004

Spare parts and torque wrench available on request.

Clamping Adapter

4-sided



without internal cooling (light cooling through clamping surface)

D1	HxB	L1	L2	L3	Item No.
4G6	12x12	120,00	64,06	39,06	BA7090-4040
	16x16	120,00	64,06	39,06	BA7090-4140
	20x20	120,00	64,06	39,06	BA7090-4240
	25x25	120,00	64,06	39,06	BA7090-4340
5G6	12x12	120,00	79,06	49,06	BA7090-4050
	16x16	120,00	79,06	49,06	BA7090-4150
	20x20	120,00	79,06	49,06	BA7090-4250
	25x25	120,00	79,06	49,06	BA7090-4350
	6G6	16x16	120,00	78,06	48,06
6G6	20x20	120,00	78,06	48,06	BA7090-4260
	25x25	120,00	78,06	48,06	BA7090-4360
	8G6	16x16	120,00	77,06	47,06
8G6	20x20	120,00	77,06	47,06	BA7090-4280
	25x25	120,00	77,06	47,06	BA7090-4380

Spare parts and torque wrench available on request.

Cutting Parameters

for our Boring Tools

Vc X 3.28 = SFM
 ap / 25.4 = DOC inches
 F / 25.4 = inch per revolution

Material		PCD								
		n [rev/min]			a _p [mm]			F [mm/rev]		
		Ø1,0-3,5	Ø4,0-6,0	Ø7,0-10,0	Ø1,0-3,5	Ø4,0-6,0	Ø7,0-10,0	Ø1,0-3,5	Ø4,0-6,0	Ø7,0-10,0
Acrylic (PMMA)	min.	5.000	4.500	3.500	0,01	0,01	0,01	0,01	0,01	0,01
	max.	20.000	20.000	20.000	0,05	0,80	2,00	0,05	0,10	0,12
Al Si <10%	min.	5.000	4.000	3.000	0,01	0,01	0,01	0,01	0,01	0,01
	max.	20.000	20.000	20.000	0,30	1,50	2,50	0,05	0,10	0,18
Al Si >10%	min.	5.000	5.000	3.000	0,01	0,01	0,01	0,01	0,01	0,01
	max.	20.000	20.000	20.000	0,20	1,00	2,00	0,05	0,10	0,18
Brass, Brass, lead-free	min.	4.000	3.500	2.500	0,01	0,01	0,01	0,01	0,01	0,01
	max.	15.000	15.000	15.000	0,30	1,50	2,50	0,05	0,10	0,18
Carbide, Ceramics, Green	min.	on request								
	max.	on request								
CFRP	min.	5.000	3.000	2.000	0,01	0,01	0,01	0,01	0,01	0,01
	max.	15.000	12.000	10.000	0,10	0,50	2,00	0,05	0,10	0,15
Copper	min.	4.000	3.500	3.000	0,01	0,01	0,01	0,01	0,01	0,01
	max.	20.000	20.000	20.000	0,10	0,50	1,00	0,05	0,10	0,15
GFRP	min.	5.000	4.000	3.500	0,01	0,01	0,01	0,01	0,01	0,01
	max.	15.000	15.000	12.000	0,05	0,50	1,00	0,05	0,10	0,12
Gold, Silver, Platinum	min.	4.000	3.000	2.000	0,01	0,01	0,01	0,01	0,01	0,01
	max.	15.000	15.000	15.000	0,10	0,50	1,00	0,05	0,10	0,15
Graphite	min.	3.000	2.500	2.000	0,01	0,01	0,01	0,01	0,01	0,01
	max.	15.000	16.000	12.000	0,10	0,50	2,50	0,05	0,15	0,2
MMC	min.	5.000	3.000	2.000	0,01	0,01	0,01	0,01	0,01	0,01
	max.	15.000	12.000	10.000	0,10	0,50	2,00	0,05	0,10	0,15
Plastics	min.	4.000	3.500	3.000	0,02	0,01	0,01	0,01	0,01	0,01
	max.	18.000	15.000	15.000	0,10	1,00	2,50	0,05	0,10	0,20
Titanium	min.	4.000	3.500	2.000	0,010	0,01	0,01	0,01	0,01	0,01
	max.	10.000	8.000	6.000	0,025	0,05	0,10	0,05	0,06	0,08
Zirconium	min.	5.000	4.000	3.000	0,01	0,01	0,01	0,01	0,01	0,01
	max.	20.000	20.000	20.000	0,30	1,50	2,50	0,05	0,10	0,2

Vc X 3.28 = SFM
 ap / 25.4 = DOC inches
 F / 25.4 = inch per revolution

Material		CVD-D									Cooling				
		n [rev/min]			a _p [mm]			F [mm/rev]			Dry	Air	Emulsion	Oil	MQL
		Ø1,0-3,5	Ø4,0-6,0	Ø7,0-10,0	Ø1,0-3,5	Ø4,0-6,0	Ø7,0-10,0	Ø1,0-3,5	Ø4,0-6,0	Ø7,0-10,0					
Acrylic (PMMA)	min.	4000	3500	2500	0,01	0,01	0,01	0,01	0,01	0,01		2. Choice	1. Choice		
	max.	30000	25000	22000	0,05	0,80	2,00	0,05	0,10	0,12		2. Choice	1. Choice		
Al Si <10%	min.	4500	4000	2000	0,01	0,01	0,01	0,01	0,01	0,01			1. Choice	2. Choice	
	max.	30000	30000	30000	0,30	1,50	2,50	0,05	0,10	0,18			1. Choice	2. Choice	
Al Si >10%	min.	4500	4000	2000	0,01	0,01	0,01	0,01	0,01	0,01			1. Choice	2. Choice	
	max.	30000	30000	30000	0,20	1,00	2,00	0,05	0,10	0,18			1. Choice	2. Choice	
Brass, Brass, lead-free	min.	3000	2500	1500	0,01	0,01	0,01	0,01	0,01	0,01			1. Choice	1. Choice	
	max.	20000	20000	18000	0,30	1,50	2,50	0,05	0,10	0,18			1. Choice	1. Choice	
Carbide, Ceramics, Green	min.	on request									on request				
	max.	on request									on request				
CFRP	min.	4000	3000	1000	0,01	0,01	0,01	0,01	0,01	0,01		1. Choice			
	max.	20000	18000	15000	0,10	0,50	2,00	0,05	0,10	0,15		1. Choice			
Copper	min.	3000	2500	2000	0,01	0,01	0,01	0,01	0,01	0,01			1. Choice	2. Choice	
	max.	30000	25000	20000	0,10	0,50	1,00	0,05	0,10	0,15			1. Choice	2. Choice	
GFRP	min.	4000	3000	1500	0,01	0,01	0,01	0,01	0,01	0,01			1. Choice		
	max.	20000	20000	18000	0,05	0,50	1,00	0,05	0,10	0,12			1. Choice		
Gold, Silver, Platinum	min.	3000	2500	1000	0,01	0,01	0,01	0,01	0,01	0,01			1. Choice	2. Choice	
	max.	20000	20000	18000	0,10	0,50	1,00	0,05	0,10	0,15			1. Choice	2. Choice	
Graphite	min.	2000	1500	1000	0,01	0,01	0,01	0,01	0,01	0,01	1. Choice				
	max.	20000	18000	15000	0,10	0,50	2,50	0,05	0,15	0,20	1. Choice				
MMC	min.	4000	3000	1000	0,01	0,01	0,01	0,01	0,01	0,01			1. Choice		
	max.	20000	15000	15000	0,10	0,50	2,00	0,05	0,10	0,15			1. Choice		
Plastics	min.	3000	2500	2000	0,02	0,01	0,01	0,01	0,01	0,01			1. Choice		
	max.	20000	20000	18000	0,10	1,00	2,50	0,05	0,10	0,20			1. Choice		
Titanium	min.	3500	2000	1200	0,01	0,01	0,01	0,01	0,01	0,01			1. Choice		
	max.	12000	8000	6000	0,025	0,05	0,10	0,05	0,06	0,08			1. Choice		
Zirconium	min.	4000	3000	2000	0,01	0,01	0,01	0,01	0,01	0,01			1. Choice	2. Choice	
	max.	30000	30000	30000	0,30	1,50	2,50	0,05	0,10	0,20			1. Choice	2. Choice	

Cutting Parameters

for our Boring Tools

Vc X 3.28 = SFM
 ap / 25.4 = DOC inches
 F / 25.4 = inch per revolution

Material		CBN								
		n [rev/min]			a _p [mm]			F [mm/rev]		
		Ø1,0-3,5	Ø4,0-6,0	Ø7,0-10,0	Ø1,0-3,5	Ø4,0-6,0	Ø7,0-10,0	Ø1,0-3,5	Ø4,0-6,0	Ø7,0-10,0
Carbide >20%Co	min.	on request								
	max.									
Carbide-Steel Composite	min.	on request								
	max.									
Ni-, Co-, Fe- and Cr-Alloys	min.	2.000	1.500	1.000	0,02	0,025	0,025	0,01	0,02	0,03
	max.	8.000	6.000	5.000	0,05	0,30	0,5	0,05	0,10	0,20
Steel hardened up to 42 HRC	min.	3.000	3.000	2.000	0,01	0,01	0,01	0,004	0,005	0,005
	max.	12.000	10.000	8.000	0,025	0,20	0,50	0,008	0,08	0,18
Steel hardened up to 52 HRC	min.	3.000	3.000	2.000	0,01	0,01	0,01	0,004	0,005	0,005
	max.	12.000	10.000	8.000	0,025	0,20	0,50	0,008	0,08	0,18
Steel hardened up to 60 HRC	min.	3.000	2.500	2.000	0,01	0,01	0,01	0,004	0,005	0,005
	max.	10.000	8.000	8.000	0,025	0,20	0,50	0,008	0,10	0,18
Steel hardened up to 68 HRC	min.	2.500	2.000	1.500	0,01	0,01	0,01	0,004	0,005	0,005
	max.	8.000	6.000	6.000	0,025	0,15	0,3	0,03	0,12	0,15
Special Alloys (ASP, CPM, HARDOX)	min.	2.000	2.000	1.500	0,01	0,01	0,01	0,004	0,005	0,005
	max.	8.000	6.000	6.000	0,025	0,015	0,30	0,03	0,12	0,15
Titanium	min.	2.000	1.500	1.000	0,01	0,03	0,05	0,01	0,02	0,03
	max.	10.000	8.000	6.000	0,015	0,15	0,25	0,05	0,06	0,08
Tool Steel, hardened	min.	2.000	2.200	2.500	0,02	0,02	0,02	0,01	0,02	0,03
	max.	8.000	6.000	6.000	0,05	0,30	0,40	0,05	0,10	0,20

Cooling recommended

In machining with CBN inserts, proper cooling is a key to successful machining.

Here you will find our recommendation:

When machining interrupted cuts, we recommend dry machining or cooling by air.

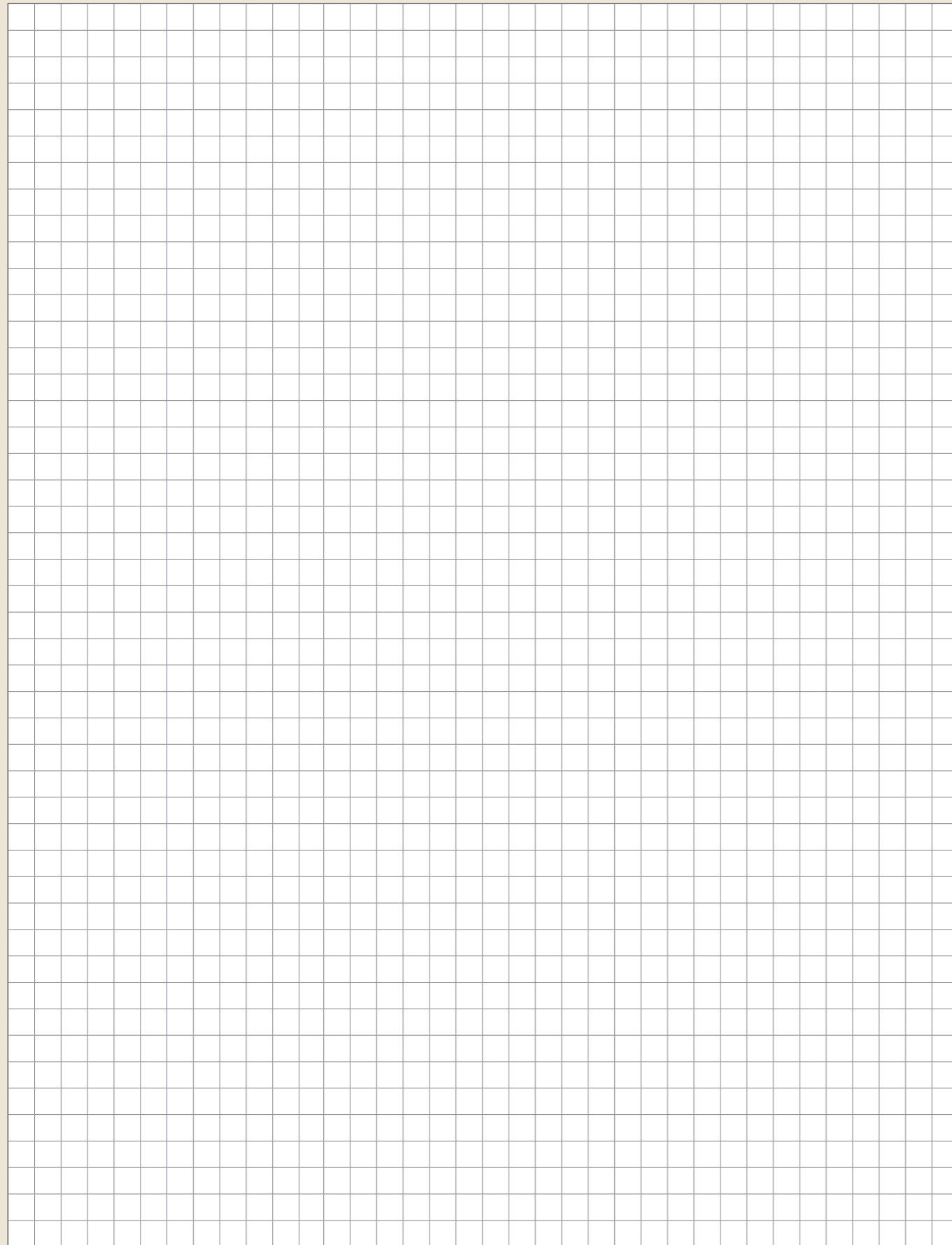
Material	Cooling				
	Dry	Air	Emulsion	Oil	MQL
Carbide >20%Co	on request				
Carbide-Steel Composite					
Ni-, Co-, Fe- and Cr-Alloys		3. Choice	1. Choice		2. Choice
Steel hardened up to 42 HRC		3. Choice	1. Choice	2. Choice	
Steel hardened up to 52 HRC		3. Choice	1. Choice	2. Choice	
Steel hardened up to 60 HRC		3. Choice	1. Choice	2. Choice	
Steel hardened up to 68 HRC		3. Choice	1. Choice	2. Choice	
Special Alloys (ASP, CPM, HARDOX)		3. Choice	1. Choice	2. Choice	
Titanium			1. Choice		2. Choice
Tool Steel hardened		3. Choice	1. Choice	2. Choice	



If you have any further technical questions, please do not hesitate to contact us by phone or e-mail!

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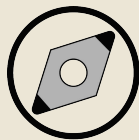
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All rights are reserved. Errors, misprints or printing errors do not entitle to claims. The pictorial and graphic representation of our tools do not necessarily have to correspond to the actual tool in all details.

We reserve the right to make production-related technical changes and changes to the delivery program. The cutting values given are guide values which must be adjusted according to the process environment.

Safety Instructions:

- ▶ Tools equipped with ultra-hard cutting edges are very sharp laser cut tools.
- ▶ Careful handling of the tools during unpacking and their use is recommended.
- ▶ Wearing protective gloves reduces the risk of injury.
- ▶ Material chipping and tool breakage may occur during machining, wearing safety glasses is recommended.
- ▶ Balanced holders are recommended for speeds above 10,000 rpm.
- ▶ We do not accept any responsibility for tools that have been modified, reground or used incorrectly and beyond their normal service life.
- ▶ Protective goggles are recommended when using tools, sparks may also occur, make sure that no fire can occur.



DTS GmbH

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PASSION FOR DIAMOND



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