Member IMC Group Tungaloy

TurnLine

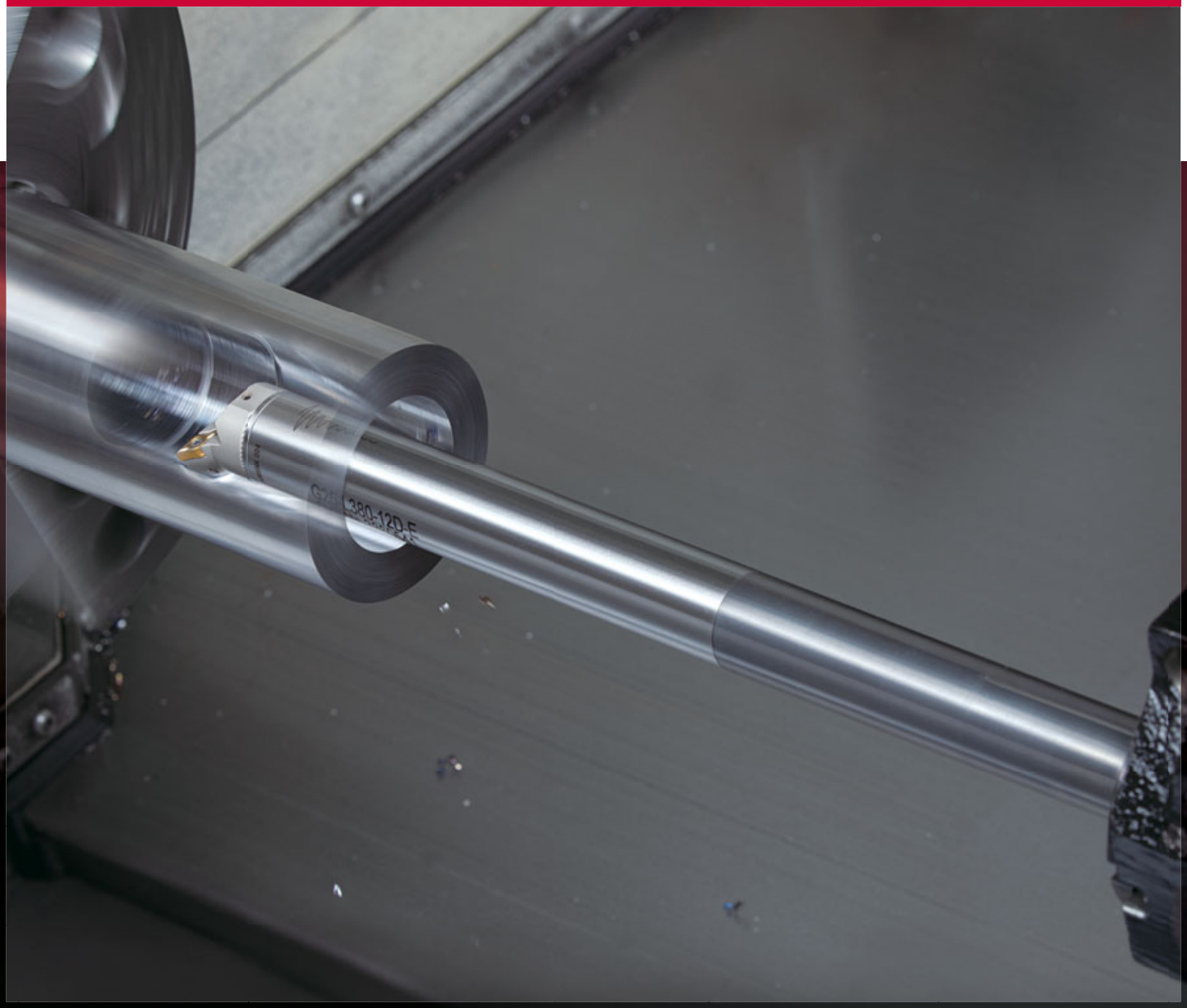
For more information

Internal turning tool

BOREMEISTER

Tungaloy Report No. 517-G

Expansion of L/D = 12 and L/D = 14 anti-vibration bars with new alignment feature for easy center height setup



TUNGALOY ADDFORCE ACCELERATED LINES

TUNGALOY ADDFORCE TURN

ACCELERATED TURNING & THREADING

BOREMEISTER

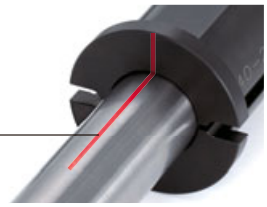
The ultimate solution for long overhang turning, threading and grooving operations

BOREMEISTER

Anti-vibration bars

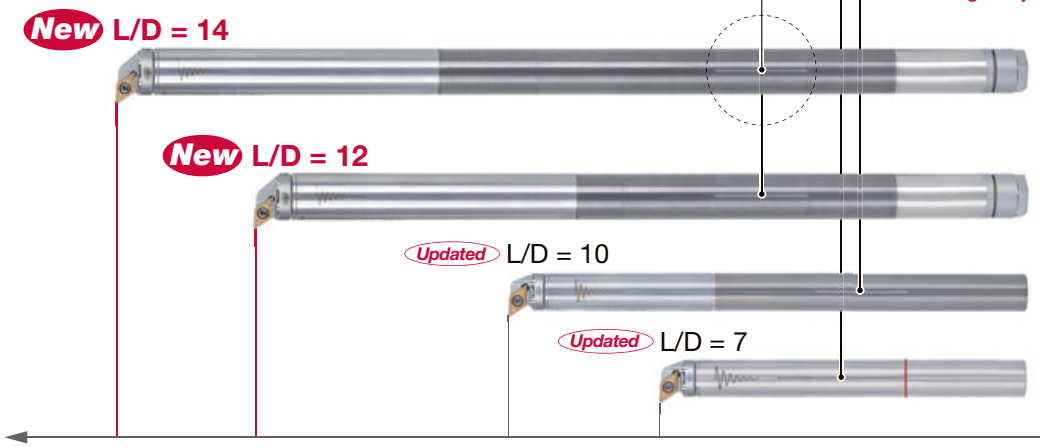
- **NEW L/D = 12 and L/D = 14 boring bars**
- **NEW quick alignment line feature for easy center height setup**
- UPDATED existing bars with the easy alignment feature

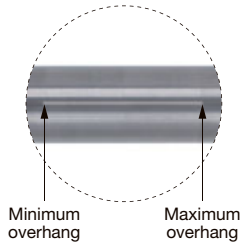
P.17



Detail for easy set up process

Center height adjustment line





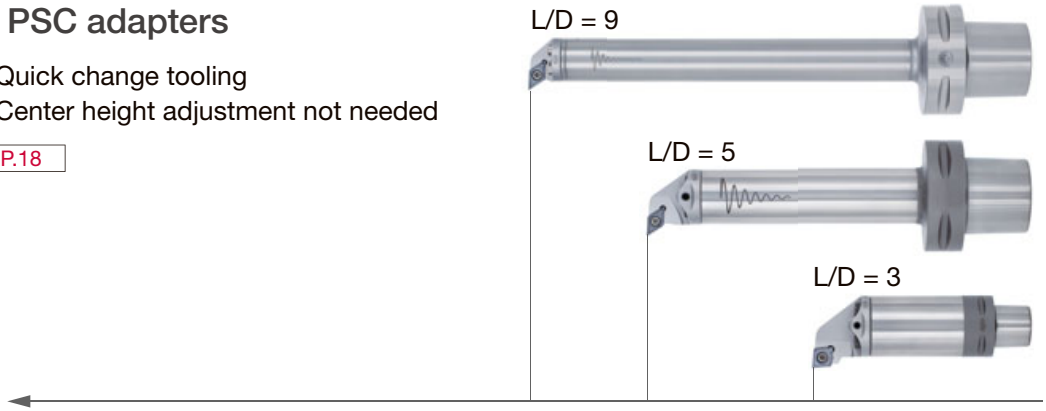
		Diameter of anti-vibration bar (mm)						
		ø16	ø20	ø25	ø32	ø40	ø50	ø60
L/D	7	○	○	○	○	○	○	○
	10	●	●	○	○	○	○	○
	12	-	-	●	●	●	△	△
	14	-	-	●	●	●	△	△

● : New product (carbide shank)
○ : Steel shank
● : Carbide shank
△ : On demand

PSC adapters

- Quick change tooling
- Center height adjustment not needed

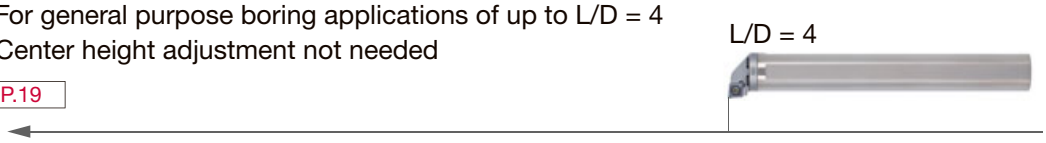
P.18



Steel shank

- For general purpose boring applications of up to L/D = 4
- Center height adjustment not needed

P.19



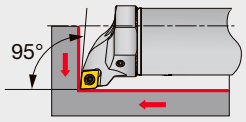
Boring head lineup

Series	Head / Insert	DMIN (mm)	Application	Shank size (mm) ø16	ø20	ø25	ø32	ø40 ø50 ø60	Page
MINIFORCE TURN	CXMU... DXG/MU... WXGU...	ø32	Internal turning			✓	✓	✓	6, 7
TUNGBORE MINI	XOMU...	ø25	Internal turning		✓	✓			7
ISOECOTURN	CNMG09... TNMG11... DNMG11...	ø40	Internal turning				✓	✓	8, 13
ISOTURN Positive insert	CCMT... DCMT... VCMT... TPMT...	ø20	Internal turning	✓	✓	✓	✓	✓	9 - 12
ISOTURN Negative insert	DNMG... VNMG...	ø40	Internal turning				✓	✓	13
TUNGTHREAD	16IR..., 22IR..., 27IR...	ø25	Threading		✓	✓	✓	✓	9
ADDICUT INTERNAL	TCIG...	ø22	Grooving CW = 0.5 - 3 mm CDX = 3 mm	✓					14
TUNGSCUT SHORT	DGS*S, DTR*S	ø32	Grooving CW = 2, 3 mm CDX = 7 mm			✓	✓		14
TUNGCUT	DG..., DT..., SG..., ST...	ø52	Grooving CW = 2, 3, 4 mm CDX = 17 mm				✓	✓	15
ADDFORCE CUT	QGM/S...	ø55	Grooving CW = 2, 3, 4 mm CDX = 32 mm			✓	✓		15

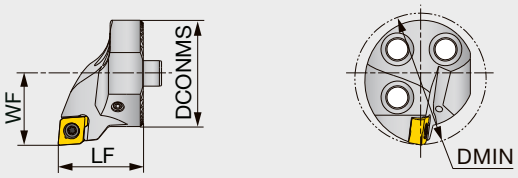
S-SCLXR/L-H

MINIFORCE TURN

Screw-on clamp exchangeable boring head, for CXMU inserts



Cutting edge style **L**



Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S25-SCLXR/L06-H	32	25	17	20	D/G25	CXMU0603**L/R...
S32-SCLXR/L06-H	40	32	22	32	D/G32	CXMU0603**L/R...
S40-SCLXR/L06-H	50	40	27	32	D/G40, D50, D60	CXMU0603**L/R...

Use right-hand toolholders (SCLXR...) with left-hand inserts (L); and left-hand toolholders (SCLXL...) with right-hand inserts (R).
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

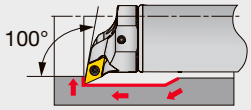
SPARE PARTS

Designation	Clamping screw	Wrench
S**-SCLXR/L06-H	SR 34-514	T-7F

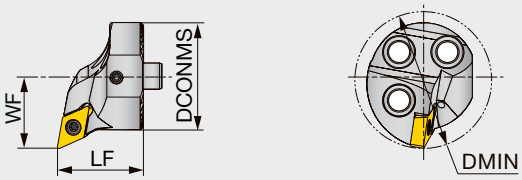
S-SDXXR/L-H

MINIFORCE TURN

Screw-on clamp exchangeable boring head, for DXG/MU inserts



Cutting edge style **X**



Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S25-SDXXR/L07-H	32	25	17	20	D/G25	DXG/MU0703**L/R...
S32-SDXXR/L07-H	40	32	22	32	D/G32	DXG/MU0703**L/R...
S40-SDXXR/L07-H	50	40	27	32	D/G40, D50, D60	DXG/MU0703**L/R...

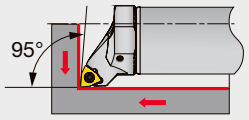
Use right-hand toolholders (SDXXR...) with left-hand inserts (L); and left-hand toolholders (SDXXL...) with right-hand inserts (R).
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

SPARE PARTS

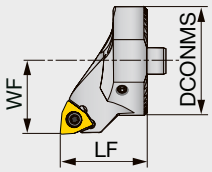
Designation	Clamping screw	Wrench
S**-SDXXR/L07-H	SR 34-514	T-7F

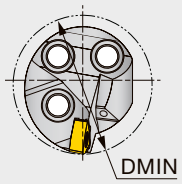
S-SWLXR/L-H

Screw-on clamp exchangeable boring head, for WXGU inserts



Cutting edge style **L**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S25-SWLXR/L04-H	32	25	17	20	D/G25	WXGU…
S32-SWLXR/L04-H	40	32	22	32	D/G32	WXGU…
S40-SWLXR/L04-H	50	40	27	32	D/G40, D50, D60	WXGU…

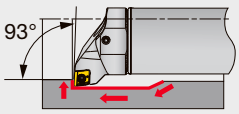
Use right-hand toolholders (SWLXR...) with left-hand inserts (L); and left-hand toolholders (SWLXL...) with right-hand inserts (R).
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

SPARE PARTS

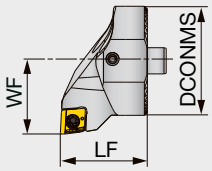
Designation	Clamping screw	Wrench
S**-SWLXR/L04-H	SR 34-514	T-7F

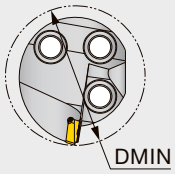
S-SXUOR05-H

Screw-on clamp exchangeable boring head, for XOMU inserts



Cutting edge style **U**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S20-SXUOR05-H	25	20	13	20	D/G20	XOMU05X204-PS
S25-SXUOR05-H	32	25	17	20	D/G25	XOMU05X204-PS

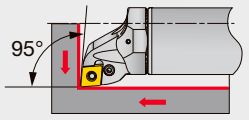
SPARE PARTS

Designation	Clamping screw	Wrench
S**-SXUOR05-H	CSTB-2L040	T-6F

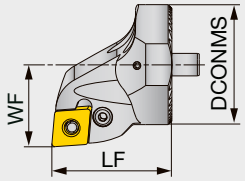
S-PCLNR/L-H

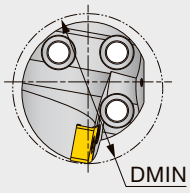
ISOCOTURN

Lever-lock clamp exchangeable boring head, for negative 80°/70° rhombic inserts



Cutting edge style **L**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S32-PCLNR/L09-H	40	32	22	32	D/G32	CN**/GNMG0904...
S40-PCLNR/L09-H	50	40	27	32	D/G40, D50, D60	CN**/GNMG0904...

Use right-hand toolholders (PCLNR...) with left-hand inserts (L); and left-hand toolholders (PCLNL...) with right-hand inserts (R).
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

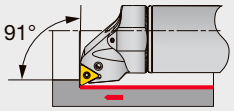
SPARE PARTS

Designation	Lever	Clamping screw	Shim	Spring pin	Wrench
S32-PCLNR/L09-H	LCL33N	LCS33	-	-	P-2F
S40-PCLNR/L09-H	LCL33	LCS3	LSC317	LSP3	P-2.5

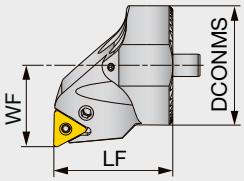
S-PTFNR/L-H

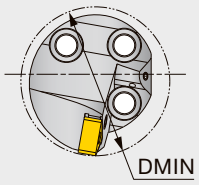
ISOCOTURN

Lever-lock clamp exchangeable boring head, for negative 60° triangular inserts



Cutting edge style **F**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S32-PTFNR/L11-H	40	32	22	32	D/G32	TN**1104...
S40-PTFNR/L11-H	50	40	27	32	D/G40, D50, D60	TN**1104...

Use right-hand toolholders (PTFNR...) with left-hand inserts (L); and left-hand toolholders (PTFNL...) with right-hand inserts (R).
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

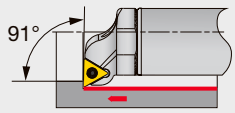
SPARE PARTS

Designation	Lever	Clamping screw	Wrench
S**-PTFNR/L11-H	LCL23	LCS23A	P-2.5

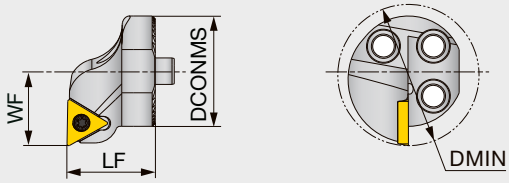
S-STFPR/L-H

ISOTURN

Screw-on clamp exchangeable boring head, for positive 60° triangular inserts



Cutting edge style **F**



Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S16-STFPR/L09-H	20	16	11	20	D/G16	TP**0902...
S16-STFPR/L11-H	20	16	11	20	D/G16	TP**1102...
S20-STFPR/L11-H	25	20	13	20	D/G20	TP**1102...
S25-STFPR/L11-H	32	25	17	20	D/G25	TP**1102...
S32-STFPR/L16-H	40	32	22	32	D/G32	TP**16T3...
S40-STFPR/L16-H	50	40	27	32	D/G40, D50, D60	TP**16T3...

Use right-hand toolholders (STFPR...) with left-hand inserts (L); and left-hand toolholders (STFPL...) with right-hand inserts (R).
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

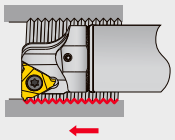
SPARE PARTS

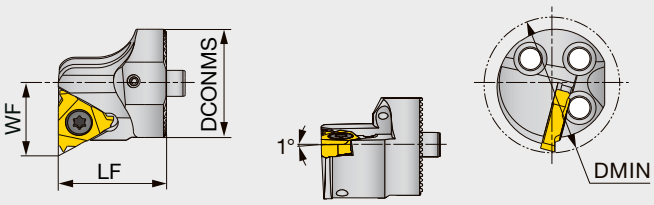
Designation	Clamping screw	Wrench
S16-STFPR/L09-H	CSTB-2.2S	T-7F
S16-STFPR/L11-H	CSTB-2.5	T-8F
S20-STFPR/L11-H	CSTB-2.5	T-8F
S25-STFPR/L11-H	CSTB-2.5	T-8F
S32-STFPR/L16-H	CSTB-4M	T-15F
S40-STFPR/L16-H	CSTB-4M	T-15F

S-SNR-H

TUNGTHREAD

Screw-on clamp exchangeable boring head, for threading inserts





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S20-SNR16-H	25	20	14	25	D/G20	16IR...
S25-SNR16-H	32	25	17	25	D/G25	16IR...
New S25-SNR22-H	32	25	19	28	D/G25	22IR...
S32-SNR16-H	40	32	22	32	D/G32	16IR...
New S32-SNR22-H	40	32	22	32	D/G32	22IR...
S40-SNR16-H	50	40	27	32	D/G40, D50, D60	16IR...
New S40-SNR22-H	50	40	27	32	D/G40, D50, D60	22IR...
New S40-SNR27-H	50	40	27	36	D/G40, D50, D60	27IR...

DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

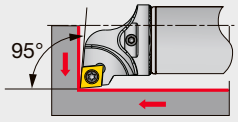
SPARE PARTS

Designation	Clamping screw	Wrench
S**-SNR16-H	CSTB-3.5	T-15F
S**-SNR22-H	CSTB-4	T-15F
S**-SNR27-H	CSTB-6	T-25TL

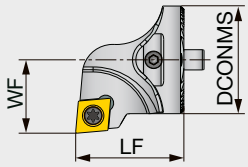
S-SCLCR/L-H

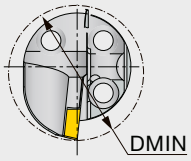
ISOTURN

Screw-on clamp exchangeable boring head, for positive 80° rhombic inserts



Cutting edge style **L**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S16-SCLCR/L06-H	20	16	11	20	D/G16	CC**0602...
S20-SCLCR/L09-H	25	20	13	20	D/G20	CC**09T3...
S25-SCLCR/L09-H	32	25	17	22	D/G25	CC**09T3...
S32-SCLCR/L09-H	40	32	22	32	D/G32	CC**09T3...
S40-SCLCR/L12T-H	50	40	27	38	D/G40, D50, D60	CC**1204...

Use right-hand toolholders (SCLCR...) with left-hand inserts (L); and left-hand toolholders (SCLCL...) with right-hand inserts (R).
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

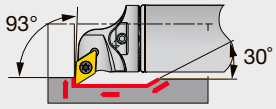
SPARE PARTS

Designation	Clamping screw	Wrench	Shim	Shim screw
S16-SCLCR/L06-H	SR 14-548	T-7/5	-	-
S20-SCLCR/L09-H	SR 16-236	T-15/5	-	-
S25-SCLCR/L09-H	SR 16-236	T-15/5	-	-
S32-SCLCR/L09-H	SR 16-236	T-15/5	-	-
S40-SCLCR/L12T-H	SR16-212	T-20/5	TCC4-2	SRTC-4

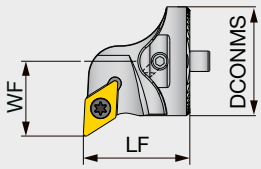
S-SDUCR/L-H

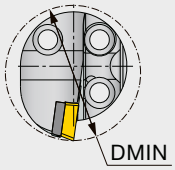
ISOTURN

Screw-on clamp exchangeable boring head, for positive 55° rhombic inserts



Cutting edge style **U**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S16-SDUCR/L07-H	20	16	11	20	D/G16	DC**0702...
S20-SDUCR/L11-H	25	20	13	20	D/G20	DC**11T3...
S25-SDUCR/L11-H	32	25	17	20	D/G25	DC**11T3...
S32-SDUCR/L11T-H	40	32	22	32	D/G32	DC**11T3...
S40-SDUCR/L11T-H	50	40	27	32	D/G40, D50, D60	DC**11T3...

Use right-hand toolholders (SDUCR...) with left-hand inserts (L); and left-hand toolholders (SDUCL...) with right-hand inserts (R).
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

SPARE PARTS

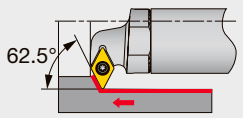
Designation	Clamping screw	Wrench	Shim	Shim screw
S16-SDUCR/L07-H	SR 14-548	T-7/5	-	-
S20-SDUCR/L11-H	SR 16-236 P	T-15/5	-	-
S25-SDUCR/L11-H	SR 16-236 P	T-15/5	-	-
S32-SDUCR/L11T-H	SR 16-236 P	T-15/5	TDC3-1P	SR TC-3P
S40-SDUCR/L11T-H	SR 16-236 P	T-15/5	TDC3-1P	SR TC-3P

New

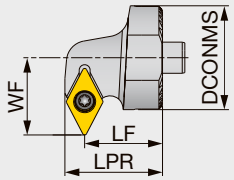
S-SDXCR/L-H

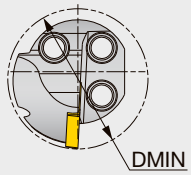
ISOTURN

Screw-on clamp exchangeable boring head, for positive 55° rhombic inserts



Cutting edge style **X**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	LPR	Shank	Insert
S16-SDXCR/L07-H	22	16	13	15	18.8	D/G16	DC**0702...
S20-SDXCR/L07-H	27	20	15	15	18.8	D/G20	DC**0702...
S25-SDXCR/L07-H	33	25	18	15	18.8	D/G25	DC**0702...
S32-SDXCR/L11T-H	40	32	22	20	28	D/G32	DC**11T3...
S40-SDXCR/L11T-H	50	40	27	20	28	D/G40, D50, D60	DC**11T3...

Use right-hand toolholders (SDXCR...) with left-hand inserts (L); and left-hand toolholders (SDXCL...) with right-hand inserts (R).
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

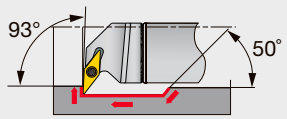
SPARE PARTS

Designation	Clamping screw	Wrench	Shim	Shim screw
S16-SDXCR/L07-H	CSTB-2.5	T-8F	-	-
S20-SDXCR/L07-H	CSTB-2.5	T-8F	-	-
S25-SDXCR/L07-H	CSTB-2.5	T-8F	-	-
S32-SDXCR/L11T-H	SR 16-236 P	T-15F	TDC3-1P	SR TC-3P
S40-SDXCR/L11T-H	SR 16-236 P	T-15F	TDC3-1P	SR TC-3P

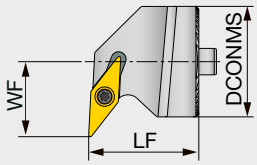
S-SVUCR/L-H

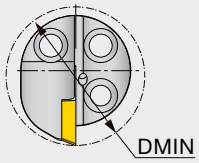
ISOTURN

Screw-on clamp exchangeable boring head, for positive 35° rhombic inserts



Cutting edge style **U**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S20-SVUCR/L11-H	27	20	16	20	D/G20	VC**1103...
S25-SVUCR/L11-H	31	25	17	25	D/G25	VC**1103...

Use right-hand toolholders (SVUCR...) with left-hand inserts (L); and left-hand toolholders (SVUCL...) with right-hand inserts (R).

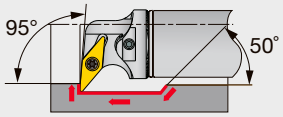
SPARE PARTS

Designation	Clamping screw	Wrench
S20-SVUCR/L11-H	SR 14-560	T-8/5
S25-SVUCR/L11-H	SR 14-560	T-8/5

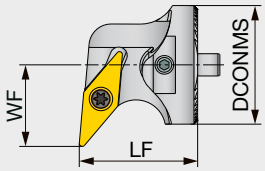
S-SVLCR/L-H

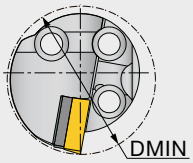
ISOTURN

Screw-on clamp exchangeable boring head, for positive 35° rhombic inserts



Cutting edge style **L**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S32-SVLCR/L16T-H	40	32	22	32	D/G32	VC**1604...
S40-SVLCR/L16T-H	50	40	27	32	D/G40, D50, D60	VC**1604...

Use right-hand toolholders (SVLCR...) with left-hand inserts (L); and left-hand toolholders (SVLCL...) with right-hand inserts (R).
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

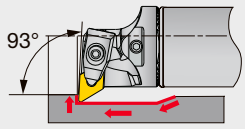
SPARE PARTS

Designation	Clamping screw	Wrench	Shim	Shim screw
S32-SVLCR/L16T-H	SR 16-236 P	T-15/5	TVC 3-1P	SR TC-3P
S40-SVLCR/L16T-H	SR 16-236 P	T-15/5	TVC 3-1P	SR TC-3P

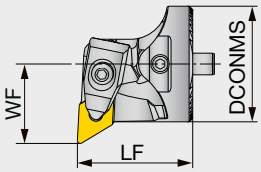
S-DDUNR/L-H

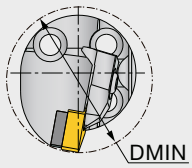
ISOTURN

Double-clamp exchangeable boring head, for negative 55°/45° rhombic inserts



Cutting edge style **U**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S32-DDUNR/L11T-H	40	32	22	32	D/G32	DN**/FNMG1104...
S40-DDUNR/L15T-H(1)	50	40	27	38	D/G40, D50, D60	DN**/FNGA1506(04)...

(1) DN**/FNGA1504... inserts require a separate shim (# RDT443).
When using a right or left hand insert, the right hand insert (R) is used for the left hand toolholders (DDUNL... type), and the left hand insert (L) is used for the right hand toolholders (DDUNR... type).
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

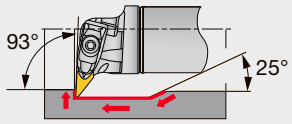
SPARE PARTS

Designation	Shim 1	Shim 2 (Optional)	Shim screw	Clamp	Clamping screw	Spring	Wrench
S32-DDUNR/L11T-H	RDT3-2	-	SR40085I	LCGR-3	SRRC3	KSP3	HW 2.5
S40-DDUNR/L15T-H	RDT433	(RDT443)	SR14-506	DLM4	DLS4	DSP4	HW 3.0

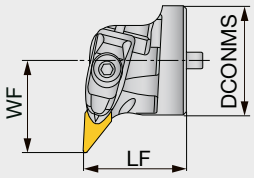
S-DVUNR/L-H

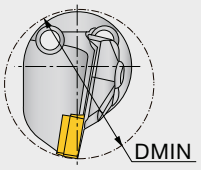
ISOTURN

Double-clamp exchangeable boring head, for negative 35° rhombic inserts



Cutting edge style **U**





Right hand (R) shown.

Designation	DMIN	DCONMS	WF	LF	Shank	Insert
S40-DVUNR/L16T-H	56	40	34	38	D/G40, D50, D60	VN**1604...

DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

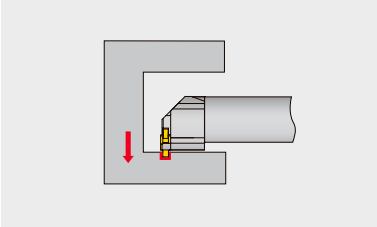
SPARE PARTS

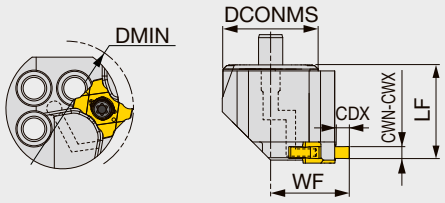
Designation	Shim	Shim screw	Clamp	Clamp screw	Spring	Wrench
S40-DVUNR/L16T-H	ASV322	SR35080I	DLM3V	SR10402267	KSP5	HW4.0

S-STCIR/L-H

ADDICUT INTERNAL

Exchangeable boring head, for internal grooving





Right hand (R) shown.

Designation	CWN	CWX	CDX	DMIN	DCONMS	Seat size	LF(1)	WF	Shank
S16-STCIR/L10-D220-H	0.5	3	2	22	16	10	16	13	D/G16
S16-STCIR/L12-D240-H	1	3	3	24	16	12	16	14.3	D/G16

(1) The LF value is true when the insert with 3 mm cutting width is mounted.

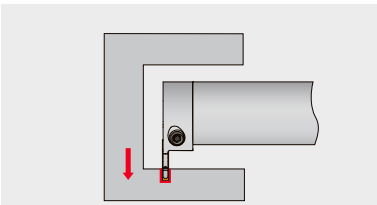
SPARE PARTS

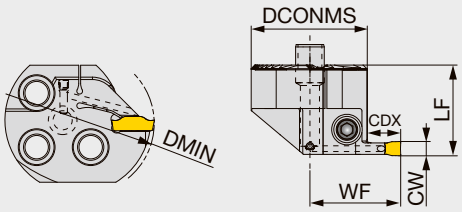
Designation	Clamping screw	Wrench
S16-STCIR/L10...	CSTB-2.2L053DR/L	T-7F
S16-STCIR/L12...	CSTB-2.5L054DR/L	T-7F

S-CTIRS-H

TUNGSHORT CUT

Exchangeable boring head, for internal grooving





Right hand (R) shown.

Designation	CW	CDX	DMIN	DCONMS	Seat size	LF(1)	WF	Shank	Insert
S25-CTIRS2T06D320-H	2	6	32	25	S2	19	19	D/G25	D**2S...
S32-CTIRS2T07D400-H	2	7	40	32	S2	23	23.5	D/G32	D**2S...
S25-CTIRS3T06D320-H	3	6	32	25	S3	19	19	D/G25	D**3S...
S32-CTIRS3T07D400-H	3	7	40	32	S3	23	23.5	D/G32	D**3S...

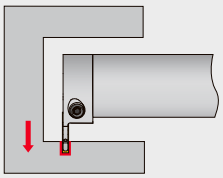
(1) The LF value is true when the insert with the same CW as indicated in the matching line is mounted in the pocket.

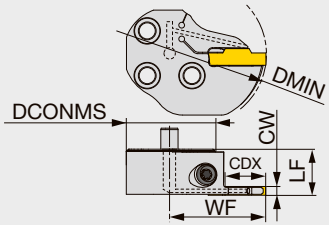
SPARE PARTS

Designation	Clamping screw	Wrench
S25-CTIRS*T06D320-H	CM3X0.5X6	P-2.5
S32-CTIRS*T07D400-H	CM5X0.8X8	P-4

S-CTIR/L-H

Exchangeable boring head, for internal grooving





Right hand (R) shown.

Designation	CW	CDX	DMIN	DCONMS	Seat size	LF(1)	WF	Shank
S32-CTIR/L-2T13D520-H	2	13	52	32	2	16	33.5	D/G32
S40-CTIR/L-2T17D620-H	2	17	62	40	2	16	39.5	D/G40, D50, D60
S32-CTIR/L-3T13D520-H	3	13	52	32	3	16	33.5	D/G32
S40-CTIR/L-3T17D620-H	3	17	62	40	3	16	39.5	D/G40, D50, D60
S32-CTIR/L-4T13D520-H	4	13	52	32	4	16	33.5	D/G32
S40-CTIR/L-4T17D620-H	4	17	62	40	4	16	39.5	D/G40, D50, D60

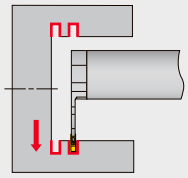
(1) The LF value is true when the insert with the same CW as indicated in the matching line is mounted in the pocket.
DMIN for a 50 mm shank is equal to the requested head size plus 10 mm. For a 60 mm shank, the DMIN is the requested head size plus 20 mm.

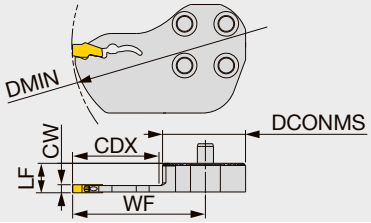
SPARE PARTS

Designation	Clamping screw	Grip	Torx bit
S**-CTIR/L...	CSTB-5	H-TB2W	BT20S

S-QSIR/L-H

Exchangeable boring head, for internal grooving





Left hand (L) shown.

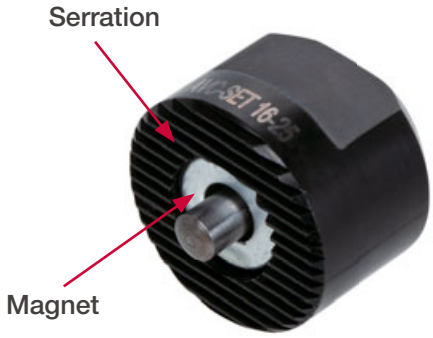
Designation	CW	CDX	DMIN	DCONMS	Seat size	LF	WF	Shank
S25-QSIR/L2T26D550-H	2	26	55	25	2	8.5	40.1	D/G25
S25-QSIR/L3T26D550-H	3	26	55	25	3	9	40.1	D/G25
S32-QSIR/L3T32D700-H	3	32	70	32	3	11	49.6	D/G32
S32-QSIR/L4T32D700-H	4	32	70	32	4	11.5	49.6	D/G32

SPARE PARTS

Designation	Wrench
S**-QSIR/L...	QL-39

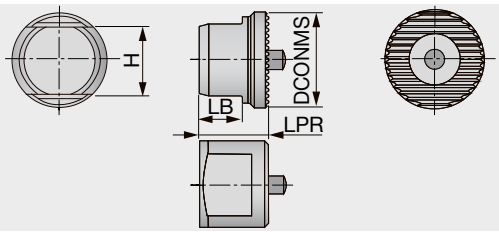
Center height positioning

Precise center height positioning is another important factor to achieve the right dimensional tolerances and surface finish. **BoreMeister** features a cylindrical shank without flats, necessitating the use of a center height device and dial gauge for precise tool center adjustment. The serrated head, equipped with a magnetic core, ensures a fixed position on the shank without the need for screws.



AVC-SET

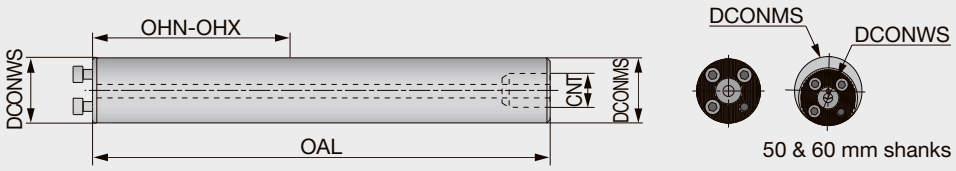
Center height set up device



Designation	DCONMS	H	LPR	LB	Applicable shank
AVC-SET 16-25	20	15	14.5	8.9	16, 20, 25
AVC-SET 32-60	29	16	17.5	11.43	32, 40, 50, 60

Anti-vibration bar

Anti-vibration bar for exchangeable turning heads, with through coolant



Designation	Material	DCONWS	DCONMS	OAL	OHN(1)	OHX(2)	CNT	CP(3)
D16-L156-7D-C	Steel	16	16	156.3	55	92	G1/8	3
G16-L204-10D-E	Carbide	16	16	204.3	96	140	-	3
D20-L200-7D-C	Steel	20	20	200.3	70	120	G1/4	3
G20-L260-10D-E	Carbide	20	20	260.3	120	180	-	3
D25-L255-7D-C	Steel	25	25	257.5	88	155	G1/4	4
D25-L330-10D-C	Steel	25	25	332.5	155	230	G1/4	4
New G25-L380-12D-E	Carbide	25	25	380	230	280	G1/8	4
New G25-L430-14D-E	Carbide	25	25	430	280	330	G1/8	4
D32-L320-7D-C	Steel	32	32	323	120	192	G3/8	5
D32-L416-10D-C	Steel	32	32	419	192	288	G3/8	5
New G32-L480-12D-E	Carbide	32	32	480	288	352	G1/4	5
New G32-L544-14D-E	Carbide	32	32	544	352	416	G1/4	5
D40-L408-7D-C	Steel	40	40	411	128	248	G1/2	7
D40-L528-10D-C	Steel	40	40	531	248	368	G1/2	7
New G40-L608-12D-E	Carbide	40	40	608	368	448	G3/8	7
New G40-L688-14D-E	Carbide	40	40	688	448	528	G3/8	7
D50-L518-7D-C	Steel	40	50	523	168	318	G1/2	7
D50-L668-10D-C	Steel	40	50	673	310	468	G1/2	7
D60-L628-7D-C	Steel	40	60	633	208	388	G3/4	7
D60-L808-10D-C	Steel	40	60	813	388	568	G3/4	7

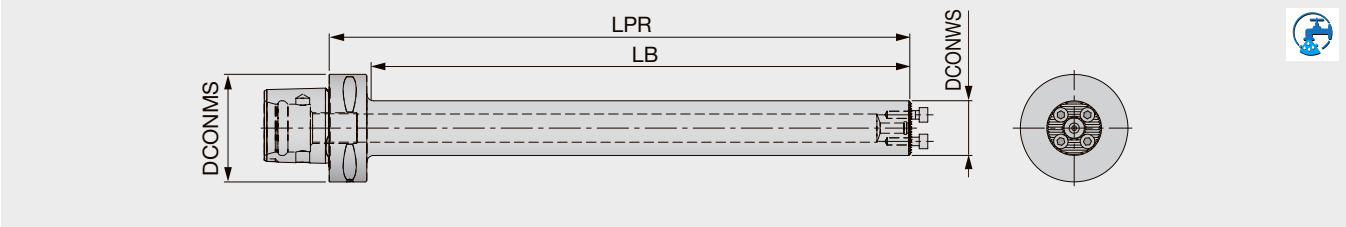
(1) OHN: Minimum overhang
(2) OHX: Maximum overhang
(3) Maximum coolant pressure (MPa)
Note: When assembling a BoreMeister in a split sleeve, be aware that, depending on the clamp unit, the protruding bar end of the BoreMeister may interfere with the machine.

SPARE PARTS

Designation	Clamping screw	Wrench
D16-L..., G16-L...	SRM3X10DIN912	HW 2.5
D20-L..., G20-L...	SR55-2M3.5X10	HW 2.5
D25-L..., G25-L...	SR M4X12DIN912	HW 3.0
D32-L..., G32-L...	SR M5X12 DIN912	HW4.0
D40-L..., G40-L..., D50-L..., D60-L...	SRM6X16DIN912-12.9	HW 5.0

C6-9D-C

PSC adapter with anti-vibration, L/D = 9



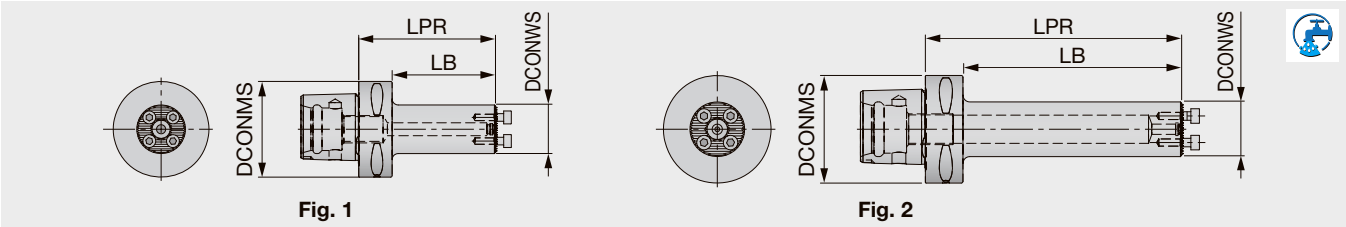
Designation	Material	DCONWS	DCONMS	LPR	LB	WT (kg)
C6-D25-L230-9D-C	Steel	25	63	230.5	200.1	1.65
C6-D32-L288-9D-C	Steel	32	63	288.5	259.5	2.73
C6-D40-L368-9D-C	Steel	40	63	368.5	339	4.45

SPARE PARTS

Designation	Clamping screw	Wrench
C6-D25...	SR M4X12DIN912	HW 3.0
C6-D32...	SR M5X12 DIN912	HW4.0
C6-D40...	SRM6X16DIN912-12.9	HW 5.0

C#-SH-CHP / C#-SH-E-CHP

PSC adapter with steel or carbide core



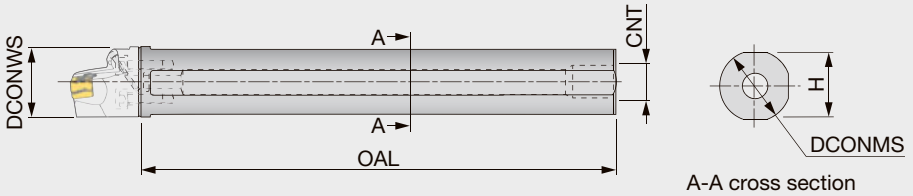
Designation	Material	DCONWS	DCONMS	LPR	LB	Fig
C4-SH-D16-2.5D-CHP	Steel	16	40	40	20	1
C4-SH-D20-2.5D-CHP	Steel	20	40	50	30	1
C4-SH-D25-2.5D-CHP	Steel	25	40	55	35	1
C4-SH-D32-2.5D-CHP	Steel	32	40	75	55	1
C4-SH-D40-3D-CHP	Steel	40	40	80	80	1
C6-SH-D20-5D-E-CHP	Carbide	20	63	100	78	2
C6-SH-D25-5D-E-CHP	Carbide	25	63	115	93	2
C6-SH-D32-5D-E-CHP	Carbide	32	63	150	128	2
C6-SH-D40-5D-E-CHP	Carbide	40	63	185	163	2

SPARE PARTS

Designation	Clamping screw	Wrench
C4**D16...	SRM3X10DIN912	HW 2.5
C4/C6**D20...	SR55-2M3.5X10	HW 2.5
C4/C6**D25...	SR M4X12DIN912	HW 3.0
C4/C6**D32...	SR M5X12 DIN912	HW4.0
C4/C6**D40...	SRM6X16DIN912-12.9	HW 5.0

D#4D-SH

Steel shank for internal turning, with through coolant



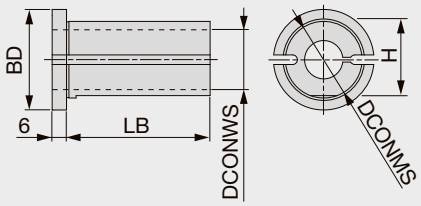
Designation	Material	DCONWS	DCONMS	OAL	CNT	H
D16-L105-4D-SH	Steel	16	16	105	UNC-2B 3/8"-16	15
D20-L140-4D-SH	Steel	20	20	140	UNFC-2B 3/8"-24	18
D25-L200-4D-SH	Steel	25	25	200	UNF-2B 1/2"-20	23
D32-L218-4D-SH	Steel	32	32	218	UNF-2B 1/2"-20	29
D40-L283-4D-SH	Steel	40	40	283	UNF-2B 1/2"-20	36

SPARE PARTS

Designation	Clamping screw	Wrench
D16**4D-SH	SRM3X10DIN912	HW 2.5
D20**4D-SH	SR55-2M3.5X10	HW 2.5
D25**4D-SH	SR M4X12DIN912	HW 3.0
D32**4D-SH	SR M5X12 DIN912	HW4.0
D40**4D-SH	SRM6X16DIN912-12.9	HW 5.0

RSL

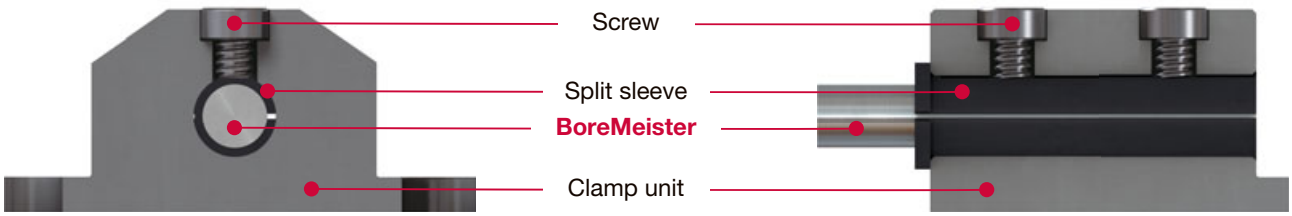
Split sleeve for anti-vibration bar



Designation	DCONWS	DCONMS	BD	LB	H
RSL-32-16-L66	16	32	42	60	31
RSL-32-20-L66	20	32	42	60	31
RSL-32-25-L66	25	32	42	60	31
RSL-40-16-L76	16	40	50	70	38.5
RSL-40-20-L76	20	40	50	70	38.5
RSL-40-25-L76	25	40	50	70	38.5
New RSL-40-32-L106	32	40	50	100	38.5
New RSL-50-32-L126	32	50	60	120	48.5
New RSL-50-40-L126	40	50	60	120	48.5
New RSL-60-32-L156	32	60	70	150	58.5
New RSL-60-40-L156	40	60	70	150	58.5
New RSL-60-50-L156	50	60	70	150	58.5

Clamping method Direct screw clamping with split sleeve

Contact length = Full sleeve's length



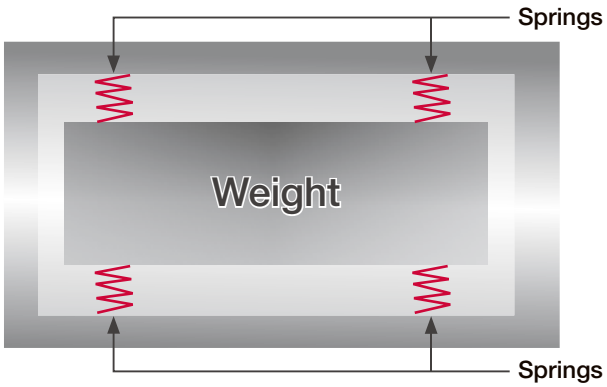
Note: When assembling a BoreMeister in a split sleeve, be aware that, depending on the clamp unit, the protruding bar end of the BoreMeister may interfere with the machine.

ADDITIONAL INFORMATION

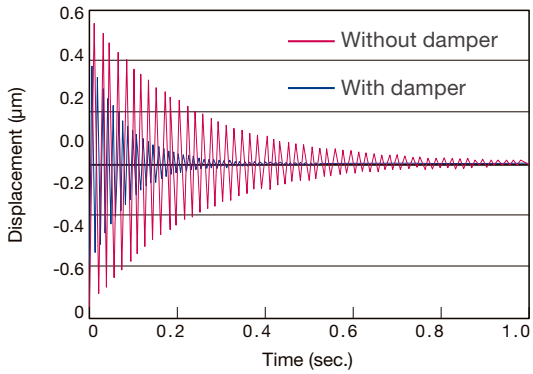
Vibration Dampening Mechanism

When cutting forces create vibration on a boring bar set up with long overhangs, the bar's dampening mechanism counters the tools motion and cancels the vibration.
The dampening mechanism consists of a weight supported by spring elements.
The vibrations die out quickly eliminating noise and chatter marks.

■ **Concept image of dampening mechanism**



■ **Tool vibration with and without vibration damper**



BoreMeister is comprised of the anti-vibration bar and interchangeable boring head, featuring serrated interfaces for high precision indexing. They are connected by screws, allowing the fitting of a wide range of cutting heads for increased flexibility.

Shortening the bar:

In case the bar is too long for your machine or application, it is possible to shorten it.
Each bar has a **red marking** that shows the maximum length to which the bar can be shortened.

Bar diameter DCONMS (mm)	Maximum length after shortening			
	7D		10D	
	Material	OAL (mm)	Material	OAL (mm)
ø16	Steel	100	Carbide	Not recommended
ø20	Steel	125	Carbide	Not recommended
ø25	Steel	158	Steel	255
ø32	Steel	190	Steel	320
ø40	Steel	240	Steel	410
ø50	Steel	305	Steel	520
ø60	Steel	380	Steel	630

Shortening is not recommended on 12D and 14D carbide shanks.

MEMO

Tungaloy Corporation (Head office)
11-1 Yoshima-Kogyodanchi
Iwaki-city, Fukushima 970-1144 Japan
Phone: +81-246-36-8501
Fax: +81-246-36-8542
www.tungaloy.co.jp

Tungaloy-NTK America Inc.
3726 N Ventura Drive
Arlington Heights,IL 60004, U.S.A.
Phone: +1-888-554-8394
Fax: +1-888-554-8392
www.tungaloy.com/us

Tungaloy Canada
432 Elgin St. Unit 3
Brantford, Ontario N3S 7P7, Canada
Phone: +1-519-758-5779
Fax: +1-519-758-5791
www.tungaloy.com/ca

Tungaloy-NTK De Mexico S.A.
C Los Arellano 113,
Parque Industrial Siglo XXI
Aguascalientes, AGS, Mexico 20290
Phone: +52-449-929-5410
Fax: +52-449-929-5411
www.tungaloy.com/mx

Tungaloy-NTK do Brasil Ltda.
Avd. Independencia N4158 Residencial Flora
13280-000 Vinhedo, São Paulo, Brasil
Phone: +55-19-38262757
Fax: +55-19-38262757
www.tungaloy.com/br

Tungaloy-NTK Germany GmbH.
Katzbergstr. 3a
D-40764 Langenfeld, Germany
Phone: +49-2173-90420-0
Fax: +49-2173-90420-19
www.tungaloy.com/de

Tungaloy France s.a.s
Les Fjords
19 avenue de Norvège
91140 Villebon Sur Yvette, France
Phone: +33-1-6486-4300
Fax: +33-1-6907-7817
www.tungaloy.com/fr

Tungaloy Italia S.r.l.
Via E. Andolfato 10
I-20126 Milano, Italy
Phone: +39-02-252012-1
Fax: +39-02-252012-65
www.tungaloy.com/it

Tungaloy Czech s.r.o.
Turanka 115
CZ-627 00 Brno, Czech Republic
Phone: +420-532 123 391
Fax: +420-532 123 392
www.tungaloy.com/cz

Tungaloy Ibérica S.L.
C/Miquel Servet, 43B, Nau 7
Pol. Ind. Bufalvent
ES-08243 Manresa (BCN), Spain
Phone: +34 93 113 1360
Fax: +34 93 876 2798
www.tungaloy.com/es

Tungaloy Scandinavia AB
Bultgatan 38
442 40 Kungälv, Sweden
Phone: +46-462119200
Fax: +46-462119207
www.tungaloy.com/se

Tungaloy Rus, LLC
Andropova avenue, h.18/7,
11 floor, office 3, 115432,
Moscow, Russia
Phone: +7-499-683-01-80
Fax: +7-499-683-01-81
www.tungaloy.com/ru

Tungaloy Polska Sp. z o.o.
Ul. Irysowa 1, 55-040 Bielany
Wrocławskie, Poland
Phone: +48 607 907 237
www.tungaloy.com/pl

Tungaloy-NTK UK Ltd.
Suite 3, Pioneer House, Mill Street,
Cannock, WS11 0EF, UK
Phone: +44 121 4000 231
Fax: +44 121 270 9694
www.tungaloy.com/uk

Tungaloy Hungary Kft
Erzsébet királyné útja 125
H-1142 Budapest, Hungary
Phone: +36 1 781-6846
Fax: +36 1 781-6866
www.tungaloy.com/hu

Tungaloy Turkey
Serifali Mah.bayraktar Bulvari Kule Sk. No:26
34775 Umraniye / Istanbul / Turkey
Phone: +90 216 540 04 67
Fax: +90 216 540 04 87
www.tungaloy.com/tr

Tungaloy Benelux b.v.
Tjalk 70
NL-2411 NZ Bodegraven, Netherlands
Phone: +31 172 630 420
Fax: +31 172 630 429
www.tungaloy.com/nl

Tungaloy Croatia
Ulica bana Josipa Jelačića 87,
10430, Samobor, Croatia
Phone: +385 1 3326 604
Fax: +385 1 3327 683
www.tungaloy.com/hr

Tungaloy Cutting Tool (Shanghai) Co. Ltd.
Rm No 401 No.88 Zhabei
Jiangchang No.3 Rd
Shanghai 200436, China
Phone: +86-21-3632-1880
Fax: +86-21-3621-1918
www.tungaloy.com/cn

Tungaloy Cutting Tools Taiwan Co. Ltd.
9F. No.293, Zhongyang Rd,
Xinzhuang Dist, New Taipei City,
24251 Taiwan
Phone: +886-2-8521-9986
Fax: +886-2-8521-8935
www.tungaloy.com/tw

Tungaloy-NTK Cutting Tool (Thailand) Co.,Ltd.
Interlink tower 4th Fl.
1858/5-7 Bangna-Trad Road
km.5 Bangna, Bangna, Bangkok 10260
Thailand
Phone: +66-2-751-5711
Fax: +66-2-751-5715
www.tungaloy.com/th

Tungaloy Singapore (Pte.), Ltd.
62 Ubi Road 1, #06-11 Oxley BizHub 2
Singapore 408734
Phone: +65-6391-1833
Fax: +65-6299-4557
www.tungaloy.com/sg

Tungaloy Vietnam
LE04.38, Lexington Residence
67 Mai Chi Tho St., Dist. 2,
Ho Chi Minh City, Vietnam
Phone: +84-2837406660
www.tungaloy.com/sg

Tungaloy India Pvt. Ltd.
One International Center,
Unit # 902-A, 9th Floor,
Tower 1, Senapati Bapat Marg,
Elphinstone Road (West),
Mumbai 400013, India
Phone: +91-22-6124-8803
Fax: +91-22-6124-8899
www.tungaloy.com/in

Tungaloy Korea Co., Ltd
#1312, Byucksan Digital Valley 5-cha
Beotkkot-ro 244, Geumcheon-gu
153-788 Seoul, Korea
Phone: +82-2-2621-6161
Fax: +82-2-6393-8952
www.tungaloy.com/kr

Tungaloy Malaysia Sdn Bhd
50 K-2, Kelana Mall, Jalan SS6/14
Kelana Jaya, 47301
Petaling Jaya, Selangor Darul Ehsan
Malaysia
Phone: +603-7805-3222
Fax: +603-7804-8563
www.tungaloy.com/my

Tungaloy Australia Pty Ltd
Unit 68 1470 Ferntree Gully Road
Knoxfield 3180 Victoria, Australia
Phone: +61-3-9755-8147
Fax: +61-3-9755-6070
www.tungaloy.com/au

PT. Tungaloy Indonesia
Ruko Blok AA.10 No3&5, Grand Wisata,
Lambangjaya, Tambun Selatan, Bekasi,
17510 Indonesia
Phone: +62-21-8261-5808
Fax: +62-21-8261-5809
www.tungaloy.com/id

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