

Internal turning tool

BOREMEISTER

Tungaloy Report No. 517S4-US

Expansion of PSC anti-vibration adapters for L/D = 9 and reducer sleeves for anti-vibration bars

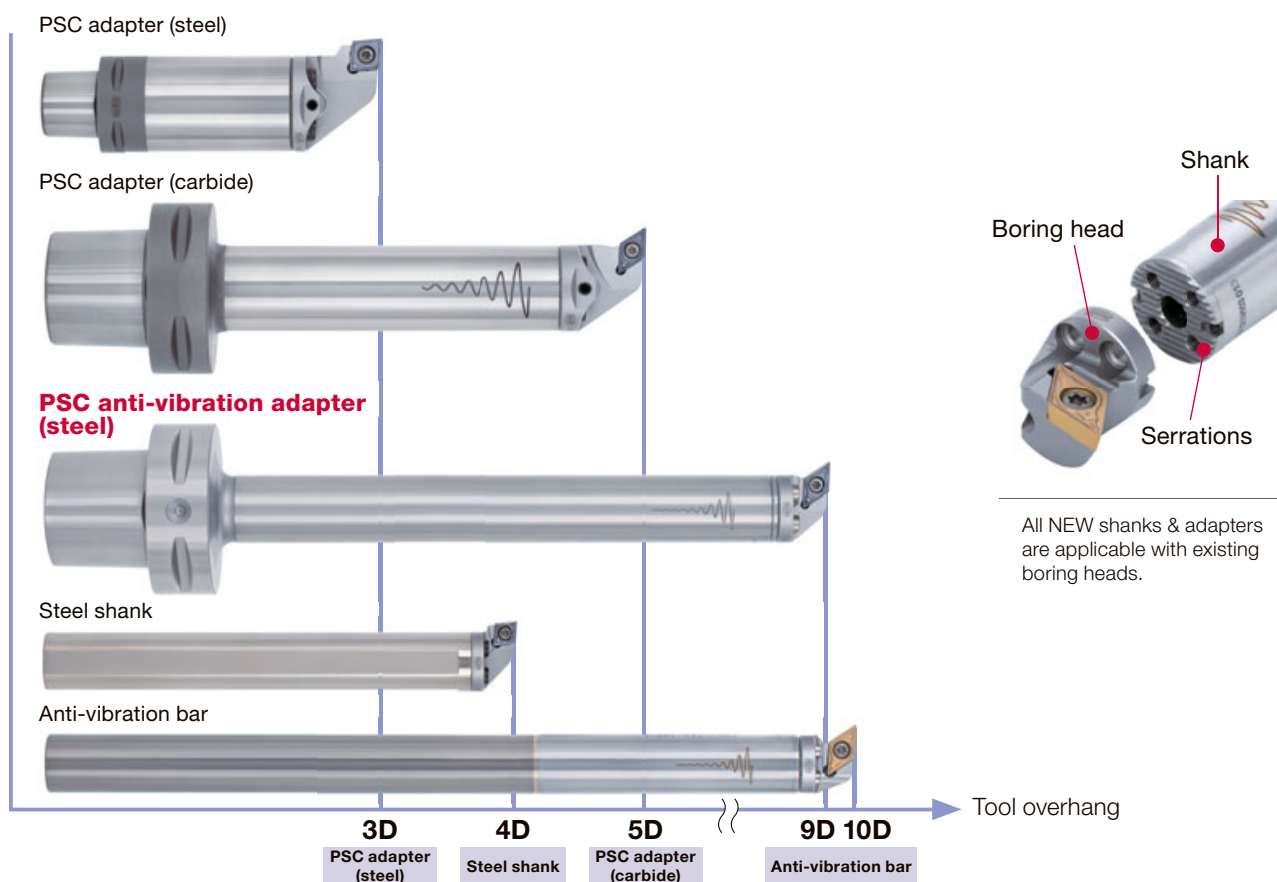








Reinforcing the lineup for various ID boring applications

Expansion of PSC anti-vibration adapter for L/D = 9

Applicable for various ID boring applications with wider lineup



■ Machining comparison of L/D = 5 vs. 9

Tool	PSC anti-vibration adapter (steel) L/D = 9 With anti-vibration system Overhang length = 8.740"	PSC adapter (carbide) L/D = 5 Without anti-vibration system Overhang length = 4.528"
Cutting speed $V_c = 492 \text{ sfm}$ Feed $f = 0.004 \text{ ipr}$ Depth of cut $ap = 0.020"$	 Good	 Good
Cutting speed $V_c = 492 \text{ sfm}$ Feed $f = 0.004 \text{ ipr}$ Depth of cut $ap = 0.020"$	 Good	 Good

Head : S25-SCLCR09-H
 Insert : CCMT 32.51 PS AH725
 Shank size : $\varnothing 0.980"$
 Workpiece material : 1045
 Hole diameter : $\varnothing 1.181"$
 Machine : NC lathe

BoreMeister L/D = 9 has the same performance as regular L/D = 5 tool with excellent surface quality and precision

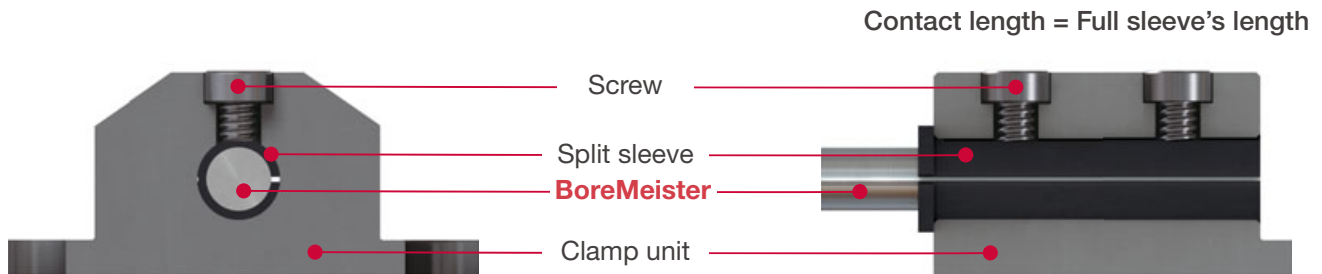
Dedicated sleeve for anti-vibration effect enhancement

To maximize anti-vibration capability of BoreMeister, holder clamping stability must be taken into consideration. The use of split sleeve is recommended which can provide a full grip on the cylindrical shank with maximum gripping contact. Do not use a screw clamping method as it may cause damage to the holder and impede anti-vibration capability.

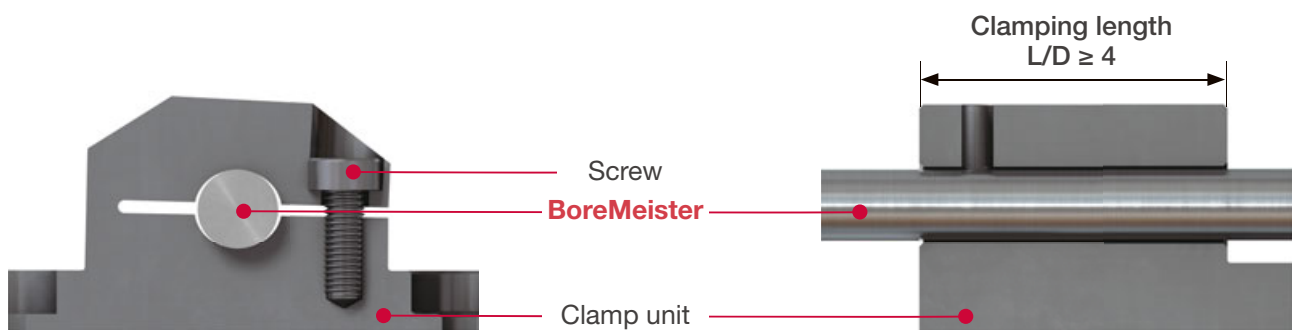


Clamping method

Direct screw clamping with split sleeve



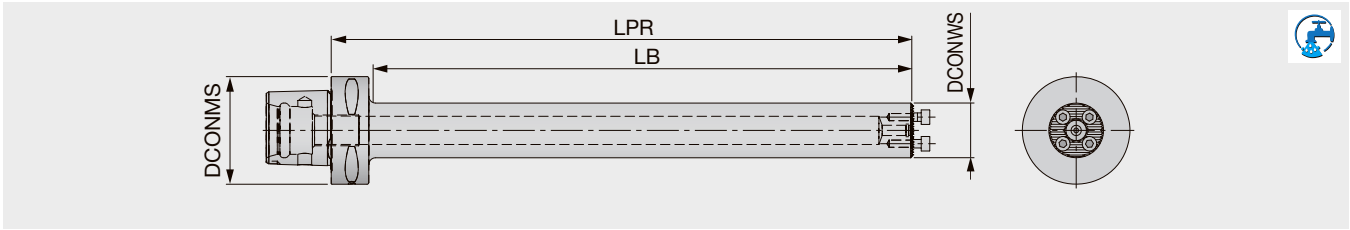
Side screw clamping unit



For custom tooling inquiries, contact Tungaloy

C6-9D-C

PSC adapter with anti vibration, L/D = 9



Metric	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

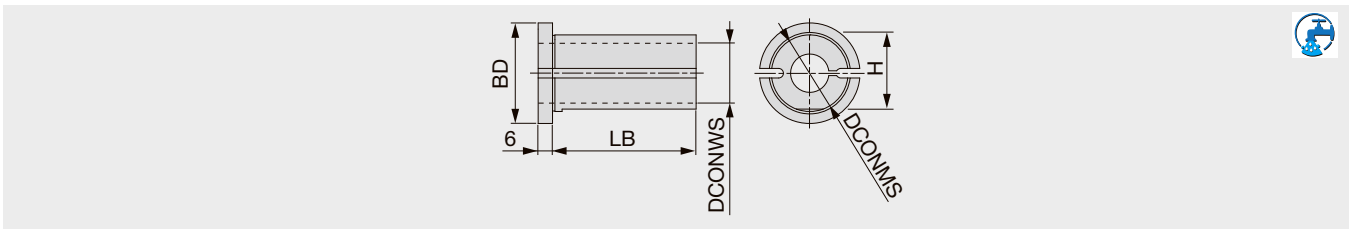
SPARE PARTS



Designation	Clamping screw	Wrench
C6-D25...	SRM4X12DIN912	HW3.0
C6-D32...	SRM5X12DIN912	HW4.0
C6-D40...	SRM6X16DIN912-12.9	HW5.0

RSL sleeve

Split sleeve for anti-vibration bar



Metric	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



www.tungaloy.com/us

follow us at:

facebook.com/tungaloyamerica
twitter.com/tungaloy
instagram.com/tungaloyamerica
linkedin.com/company/tungaloy-america

To see Tungaloy products in action visit:



www.youtube.com/tungaloycorporation

Distributed by:



FIND US ON THE CLOUD!
machiningcloud.com



Oct. 2023 (TJ)