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General product information

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Added products



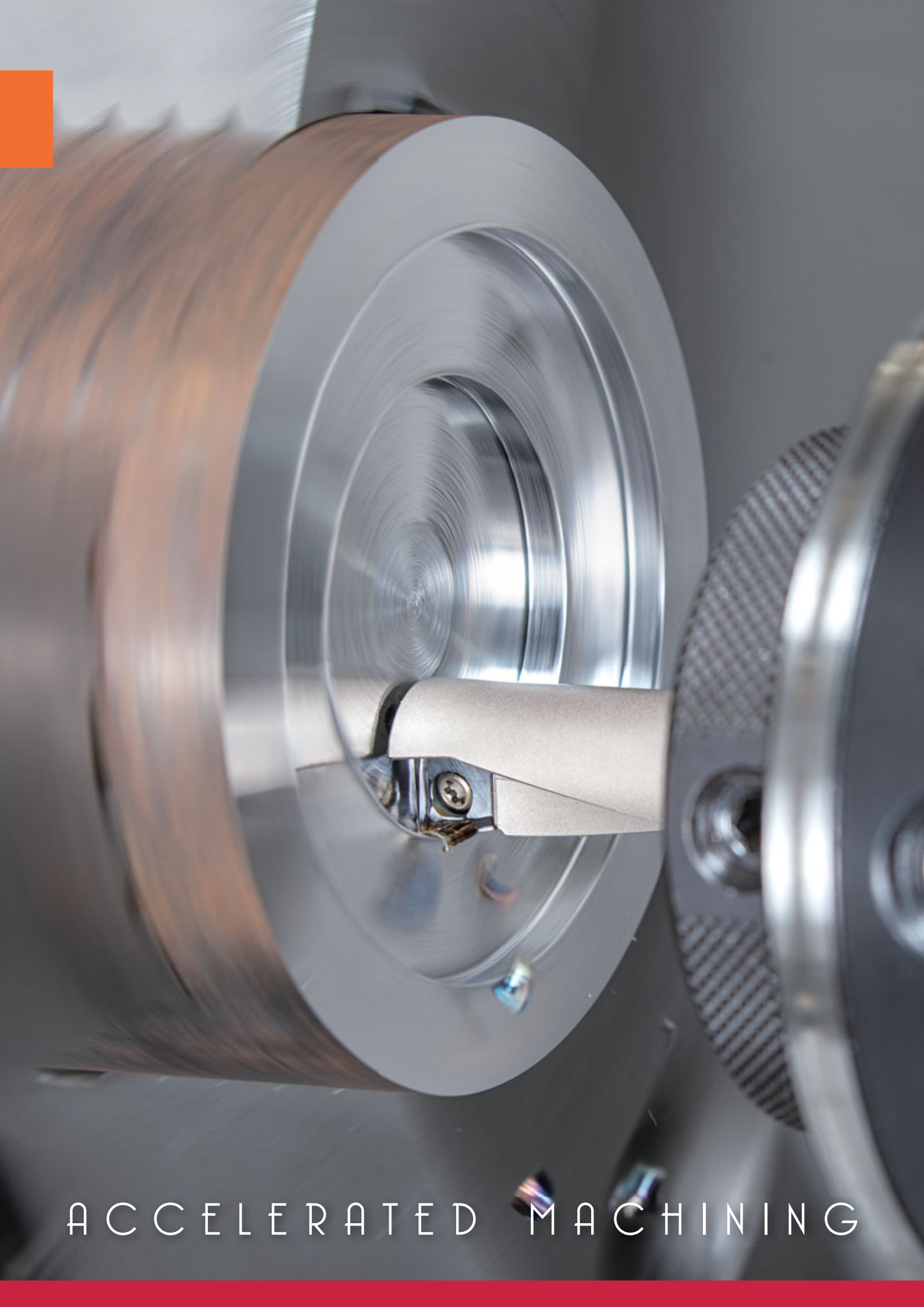
A/E-SXUOR/L

High reliability internal boring bar now offers low cutting force & high chip evacuation!!

[View](#)

Multifunctional tool for drilling and turning





ACCELERATED MACHINING



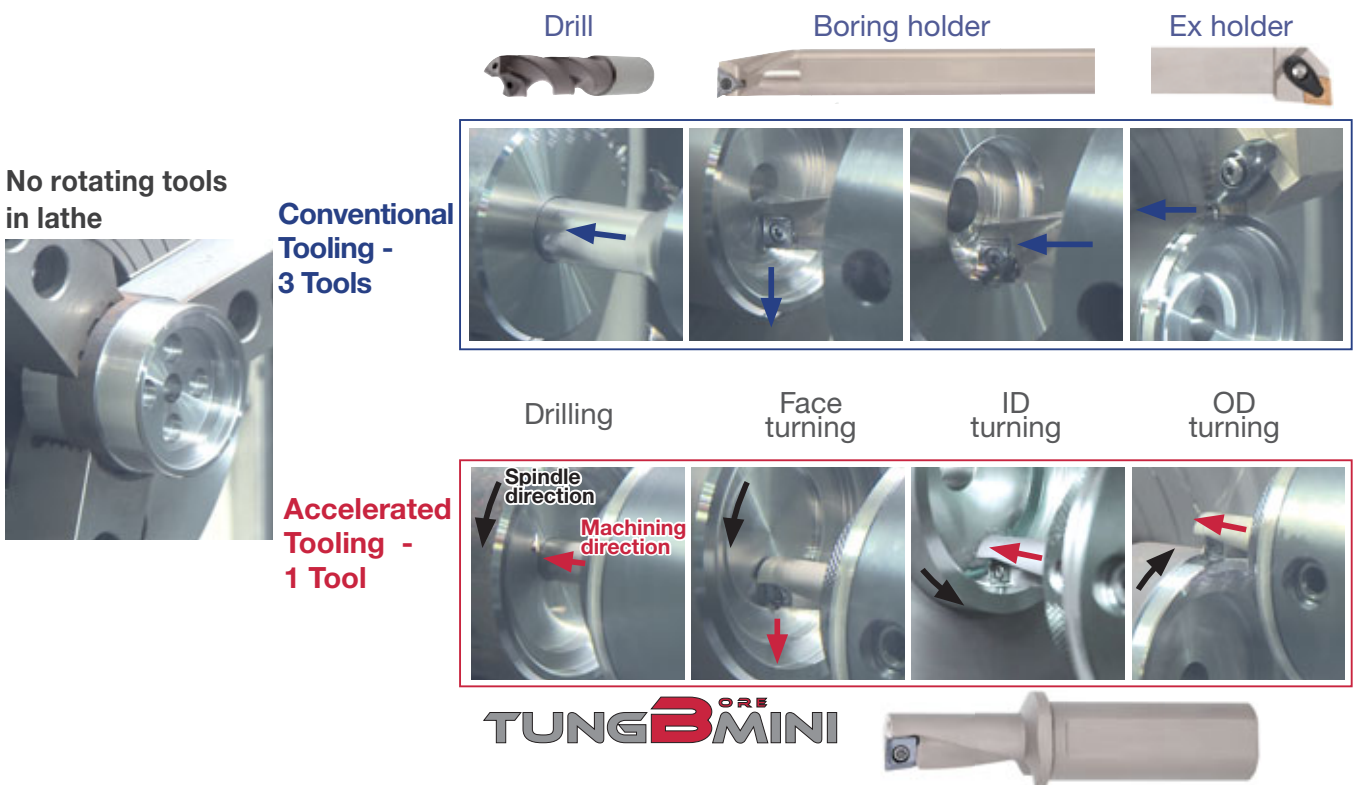
Reduced machine downtime thanks to eliminating the need for tool changes.

Multifunctional Tool for Drilling and Turning.

Multifunctional tool for improved productivity!

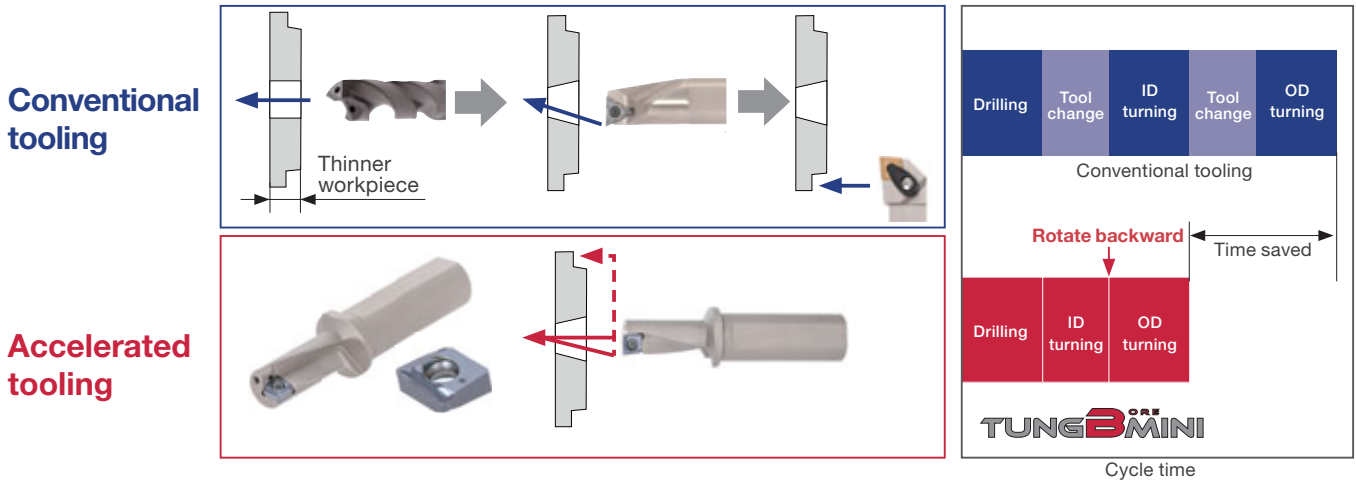
Minimum number of tools for maximum productivity

- A single TungBoreMini tool can handle multiple operations such as ID turning after drilling without exchanging the tools
- Allows drilling and hole enlargement on various materials, instead of using a drill and turning tool
- Can be used just like a standard ISO turning tool for ID, OD, and/or face turning applications

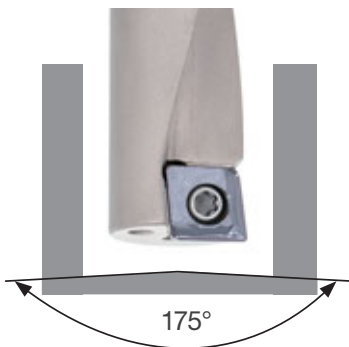


Reduced machine downtime

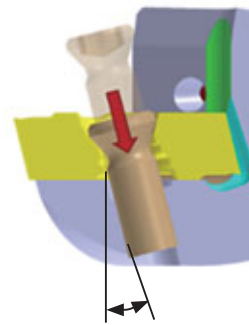
Multifunctional TungBoreMini eliminates tool changeover time, resulting in significantly reduced cycle time - this is especially effective in applications where individual processing time is short and quick, resulting in tremendous improvement in cycle time.



Features



Hole bottoms is almost flat because the front cutting edge of TungBoreMini does not have a point angle as with a twisted drill.



Slant clamping screw design allows increased screw the length of engagement for improved clamping rigidity.

PVD grade: AH725

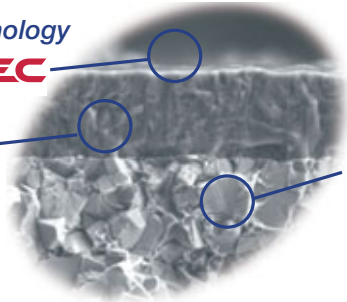
AH725 features a super tough substrate with a new PVD coating layer.

Special surface technology

PREMIUMTEC

Excellent adhesion strength of coating layer

PVD coating



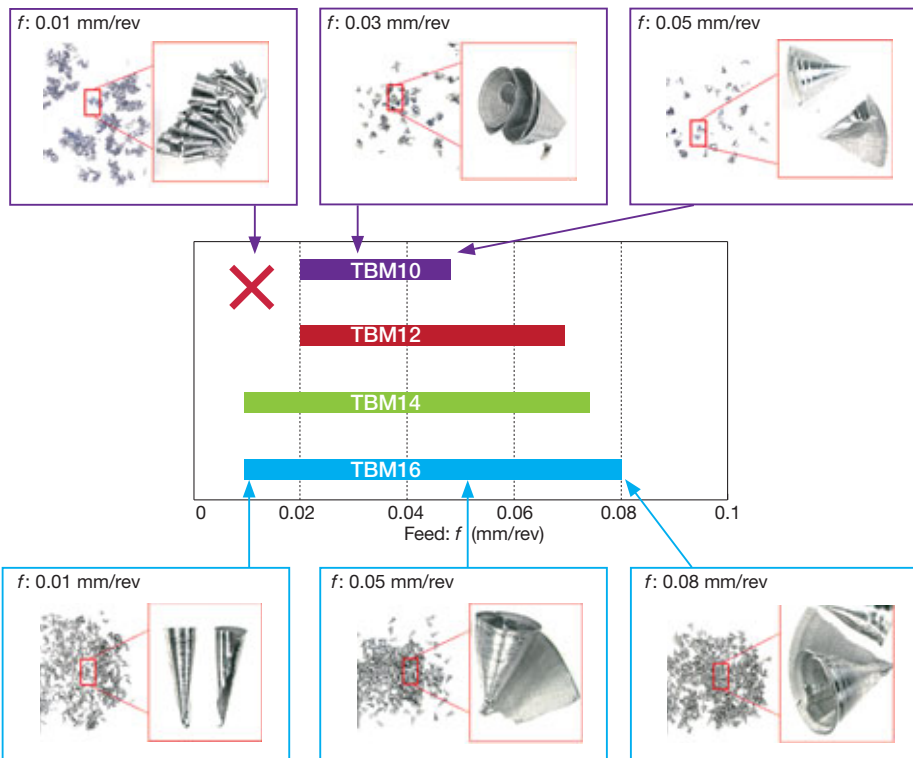
Remarkable toughness
Fine grain carbide

Standard cutting conditions and chip control for drilling

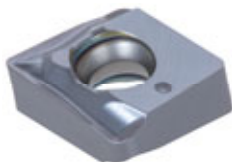
| DMIN | Description | | Feed: <i>f</i> (mm/rev) | Cutting speed: <i>Vc</i> (m/min) | |
|------|------------------|---------------|----------------------------|----------------------------------|-----------------|
| | Holder | Insert | | Carbon steel, Alloy steel | Stainless steel |
| ø10 | TBM10R/LF12-2.25 | XOMU05X204-PS | 0.02 - 0.050 | 50 - 180 m/min | 50 - 160 m/min |
| ø12 | TBM12R/LF16-2.25 | XOMU06H204-PS | 0.02 - 0.070 | | |
| ø14 | TBM14R/LF16-2.25 | XOMU07H304-PS | 0.01 - 0.075 | | |
| ø16 | TBM16R/LF20-2.25 | XOMU08T304-PS | 0.01 - 0.080 | | |



Drilling



Please adjust the center height of the tool post before use



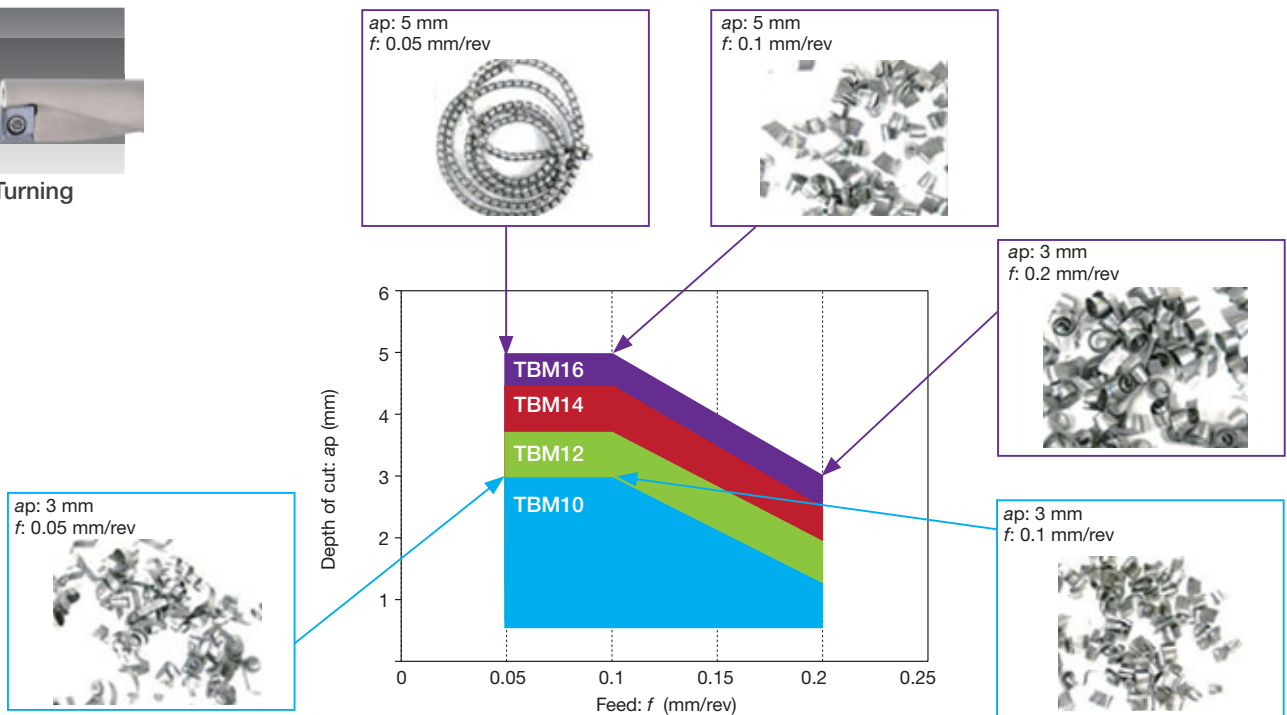
Improved chip evacuation during drilling by optimizing rake angle and breaker width. (2 corner)

Standard cutting conditions and chip control for turning

| DMIN | Description | | Depth of cut: a_p (mm) | Feed: f (mm/rev) | Cutting speed: V_c (m/min) | |
|-----------|------------------|---------------|--------------------------|--------------------|------------------------------|-----------------|
| | Holder | Insert | | | Carbon steel, Alloy steel | Stainless steel |
| $\phi 10$ | TBM10R/LF12-2.25 | XOMU05X204-PS | 0.5 - 3.0 | 0.05 - 0.2 | 50 - 180 m/min | 50 - 160 m/min |
| $\phi 12$ | TBM12R/LF16-2.25 | XOMU06H204-PS | 0.5 - 3.5 | | | |
| $\phi 14$ | TBM14R/LF16-2.25 | XOMU07H304-PS | 0.5 - 4.5 | | | |
| $\phi 16$ | TBM16R/LF20-2.25 | XOMU08T304-PS | 0.5 - 5.0 | | | |



Turning

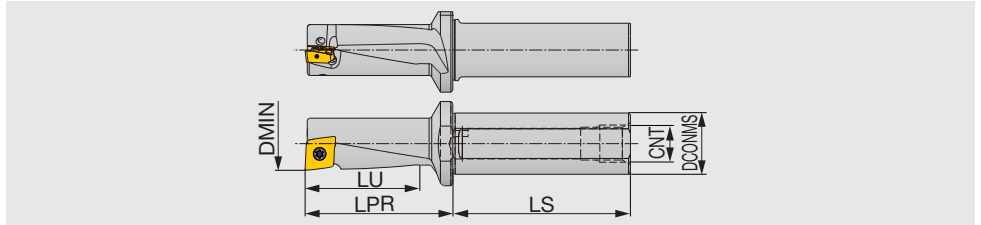


The first protrusion is effective for improving chip control at low feed rate machining.



TBM

Maximum hole depth for LH/DC = 2.25



| Designation | DMIN | DCONMS | LU | LS | LPR | CNT | Insert |
|------------------|------|--------|------|------|-------|-------------|---------------|
| TBM10R/LF12-2.25 | 10 | 12 | 22.5 | 41.5 | 28.45 | UNF 5/16-24 | XOMU05X204-PS |
| TBM12R/LF16-2.25 | 12 | 16 | 27 | 43.9 | 33.53 | G1/8 | XOMU06H204-PS |
| TBM14R/LF16-2.25 | 14 | 16 | 31.5 | 46.4 | 38.57 | G1/8 | XOMU07H304-PS |
| TBM16R/LF20-2.25 | 16 | 20 | 36 | 57.1 | 42.9 | G1/8 | XOMU08T304-PS |

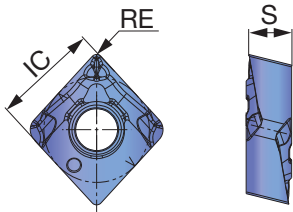
SPARE PARTS



| Designation | Clamping screw | Wrench |
|------------------|----------------|--------|
| TBM10R/LF12-2.25 | CSTB-2L040 | T-6D |
| TBM12R/LF16-2.25 | CSPB-2.2 | IP-7D |
| TBM14R/LF16-2.25 | CSPB-2.5 | IP-8D |
| TBM16R/LF20-2.25 | CSTB-3 | T-9D |

INSERT

XOMU-PS



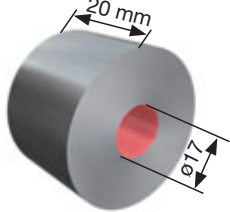
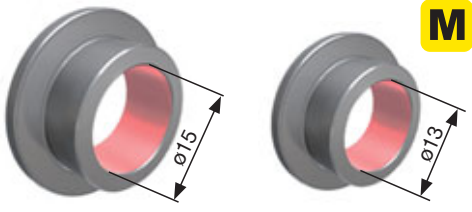
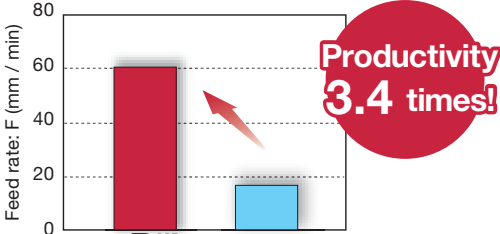

| | | | | | | | | | | | | | | | | | | | |
|-------------------------|---|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|
| P Steel | ★ | | | | | | | | | | | | | | | | | | |
| M Stainless | ★ | | | | | | | | | | | | | | | | | | |
| K Cast iron | ★ | | | | | | | | | | | | | | | | | | |
| N Non-ferrous | ★ | | | | | | | | | | | | | | | | | | |
| S Superalloys | | | | | | | | | | | | | | | | | | | |
| H Hard materials | | | | | | | | | | | | | | | | | | | |

★ : First choice
☆ : Second choice

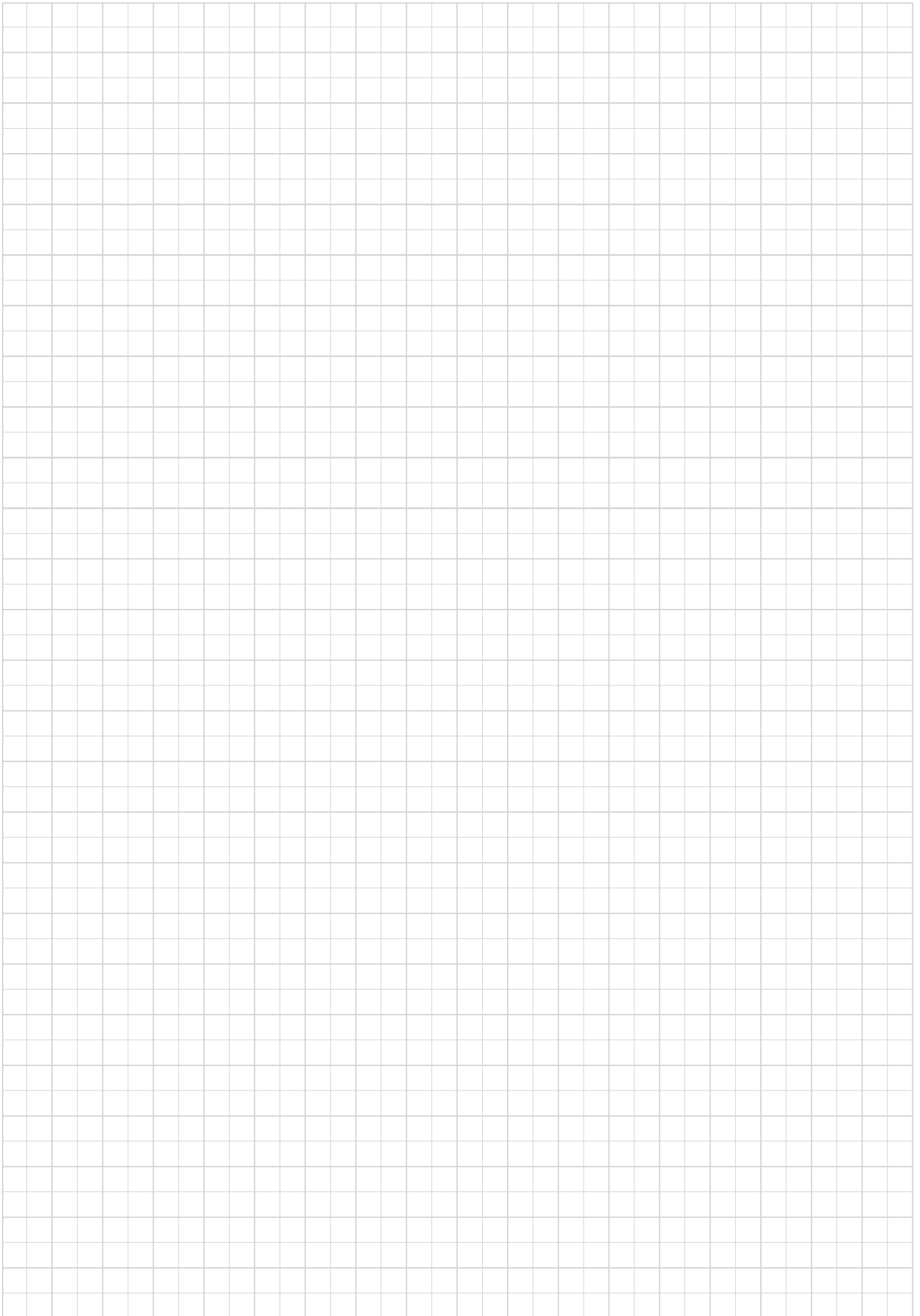
| Designation | RE | Coated | | | | | | | | | | S | IC | | |
|---------------|-----|--------|--|--|--|--|--|--|--|--|--|---|----|-----|------|
| | | AH725 | | | | | | | | | | | | | |
| XOMU05X204-PS | 0.4 | ● | | | | | | | | | | | | 2.3 | 5.56 |
| XOMU06H204-PS | 0.4 | ● | | | | | | | | | | | | 2.7 | 6.3 |
| XOMU07H304-PS | 0.4 | ● | | | | | | | | | | | | 3.3 | 7.3 |
| XOMU08T304-PS | 0.4 | ● | | | | | | | | | | | | 4.0 | 8.3 |

● : Line up

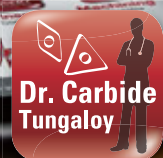
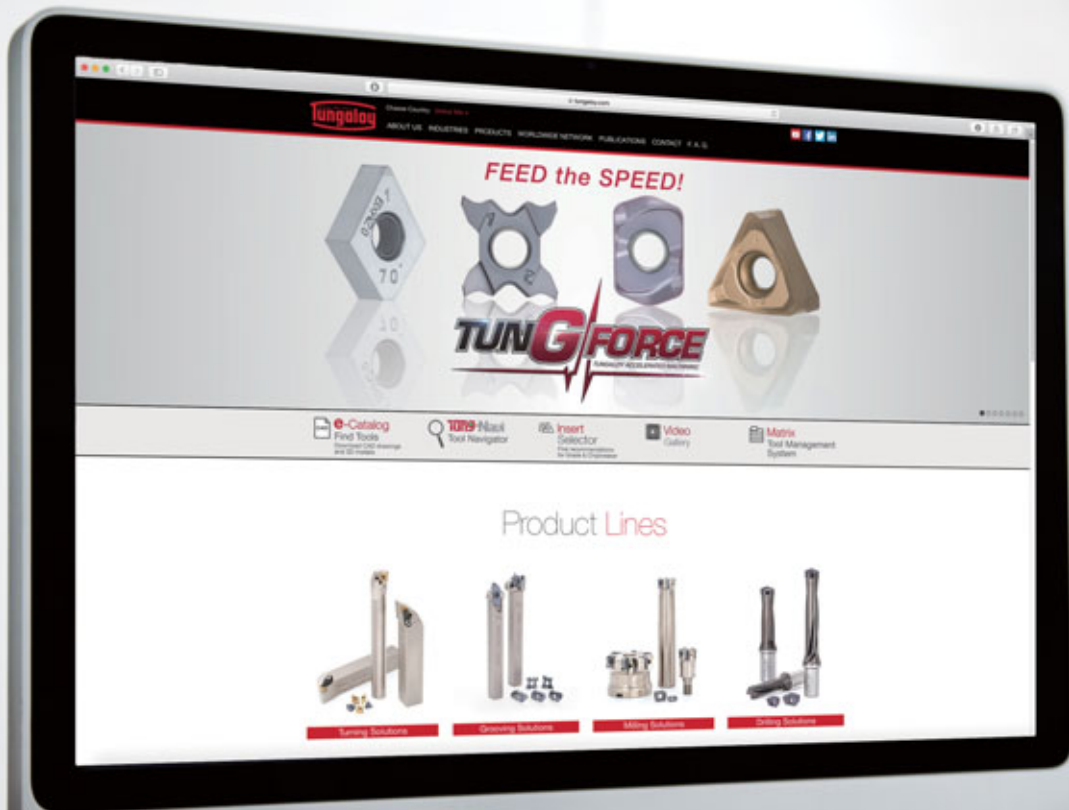
PRACTICAL EXAMPLES

| Workpiece type | | Machine parts | Machine parts |
|---------------------------|----------------------------------|---|--|
| Holder | | TBM12R/LF16-2.25 | TBM12R/LF16-2.25 |
| Insert | | XOMU06H204-PS | XOMU06H204-PS |
| Grade | | AH725 | AH725 |
| | | SUS440 | SUS304 / X5CrNi18-9 |
| Workpiece material | |  M |  M |
| Cutting conditions | Cutting speed: Vc (m/min) | 80 | 100 |
| | Feed : f (mm/rev) | 0.15 | Drilling: 0.03, Internal turning : 0.1 - 0.15 |
| | Depth of cut : ap (mm) | 2.5 | 0.5 |
| | Coolant | Wet | Wet |
| Results | |  <p>Productivity 3.4 times!</p> <p>TungBoreMini has improved feed rate by 3.4 times for drilling and 1.7 times for ID turning over the competitor's multifunction tool. Tool life has been improved by as much as 1.2 times.</p> |  <p>TungBoreMini</p> <p>Existing tooling</p> <p>TungBoreMini can reduce the number of tools from 3 to 1.</p> |

MEMO

A large grid of graph paper for taking notes, consisting of 20 columns and 30 rows of small squares.

Check our site and our App to get more info!



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TUNG^{ORE}**B****MINI**

www.tungaloy.com

Tungaloy Report No. 529S1-G

**High reliability internal boring bar now offers
low cutting force & high chip evacuation!!**



INDUSTRY 4.0
FEED the SPEED!



XOMU inserts optimized for internal boring with high rake angle

New

Existing: Multifunctional tool

- Drilling
- Face turning
- Internal boring
- External turning



Same insert

For Internal boring

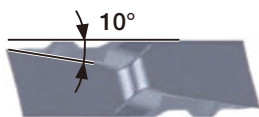
High chip evacuation
Large pocket clearance



Features

1. Low cutting force

Large inclination angle of XOMU insert



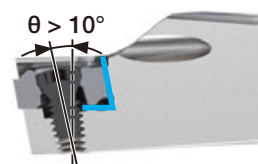
XOMU insert



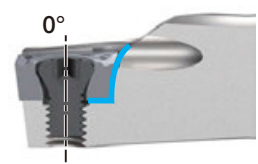
Conventional
(CCMT060204...)

2. High reliability & high rigidity clamping

Dovetail clamping and slanted insert clamping screw

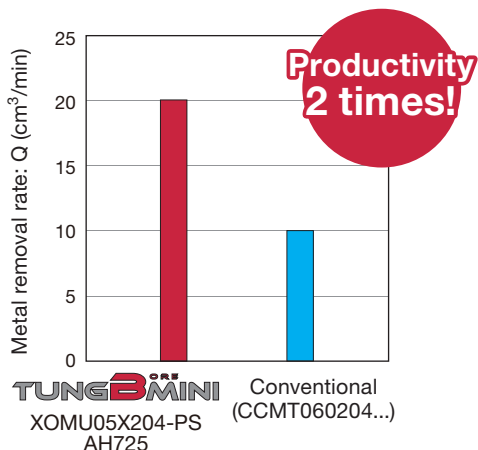


TUNGBOREMINI



Conventional
(CCMT060204...for boring bar)

CUTTING PERFORMANCE



P Machining : Internal turning
Workpiece material : S45C / C45
Coolant : Wet

| | TUNGBOREMINI | Conventional |
|----------------------------|--------------|--------------|
| Cutting speed : Vc (m/min) | 100 | 100 |
| Feed : f (mm/rev) | 0.08 | 0.08 |
| Depth of cut : ap (mm) | 2.5 | 1.25 |
| Number of passes | 1 | 2 |



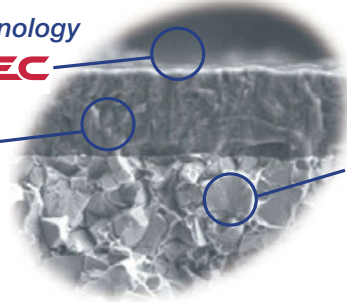
PVD grade: AH725

AH725 features a super tough substrate with a new PVD coating layer.

Special surface technology

PREMIUMTEC
TUNGALOY

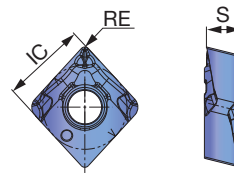
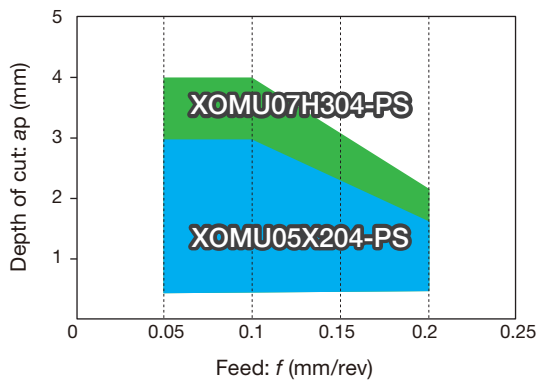
Coating layer with excellent adhesion strength
PVD coating



Remarkable toughness
Fine grain carbide

Standard cutting conditions

| DMIN | Description | | Depth of cut: ap (mm) | Feed: f (mm/rev) | Cutting speed: Vc (m/min) | |
|------|-----------------------|---------------|-----------------------|------------------|---------------------------|-----------------|
| | Holder | Insert | | | Carbon steel, Alloy steel | Stainless steel |
| ø10 | A/E08*-SXUOR/L05-D100 | XOMU05X204-PS | 0.5 - 3 | 0.05 - 0.2 | 50 - 180 | 50 - 160 |
| ø14 | A/E12*-SXUOR/L07-D140 | XOMU07H304-PS | 0.5 - 4.5 | 0.05 - 0.2 | 50 - 180 | 50 - 160 |



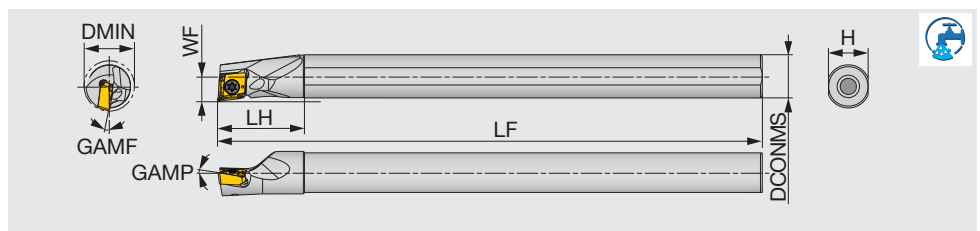
| Designation | RE | Coated | | |
|---------------|-----|--------|-----|------|
| | | AH725 | S | IC |
| XOMU05X204-PS | 0.4 | ● | 2.3 | 5.56 |
| XOMU07H304-PS | 0.4 | ● | 3.3 | 7.3 |

●: Line up

New

A/E-SXUOR/L

Screw-on boring bar, for XOMU rhombic inserts



| Designation | DMIN | DCONMS | WF | LF | LH | H | GAMP | GAMF | Insert |
|---------------------|------|--------|----|-----|----|-----|------|------|---------------|
| A08H-SXUOR/L05-D100 | 10 | 8 | 5 | 100 | 16 | 7.5 | -7 | -0.8 | XOMU05X204-PS |
| A12M-SXUOR/L07-D140 | 14 | 12 | 7 | 150 | 24 | 11 | -7.2 | 3.2 | XOMU07H304-PS |
| E08K-SXUOR/L05-D100 | 10 | 8 | 5 | 125 | 22 | 7.5 | -7 | -0.8 | XOMU05X204-PS |
| E12Q-SXUOR/L07-D140 | 14 | 12 | 7 | 180 | 27 | 11 | -7.2 | 3.2 | XOMU07H304-PS |

SPARE PARTS

| Designation | Clamping screw | Wrench |
|---------------------|----------------|--------|
| A08H-SXUOR/L05-D100 | CSTB-2L040 | T-6F |
| A12M-SXUOR/L07-D140 | CSPB-2.5 | IP-8D |
| E08K-SXUOR/L05-D100 | CSTB-2L040 | T-6F |
| E12Q-SXUOR/L07-D140 | CSPB-2.5 | IP-8D |

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