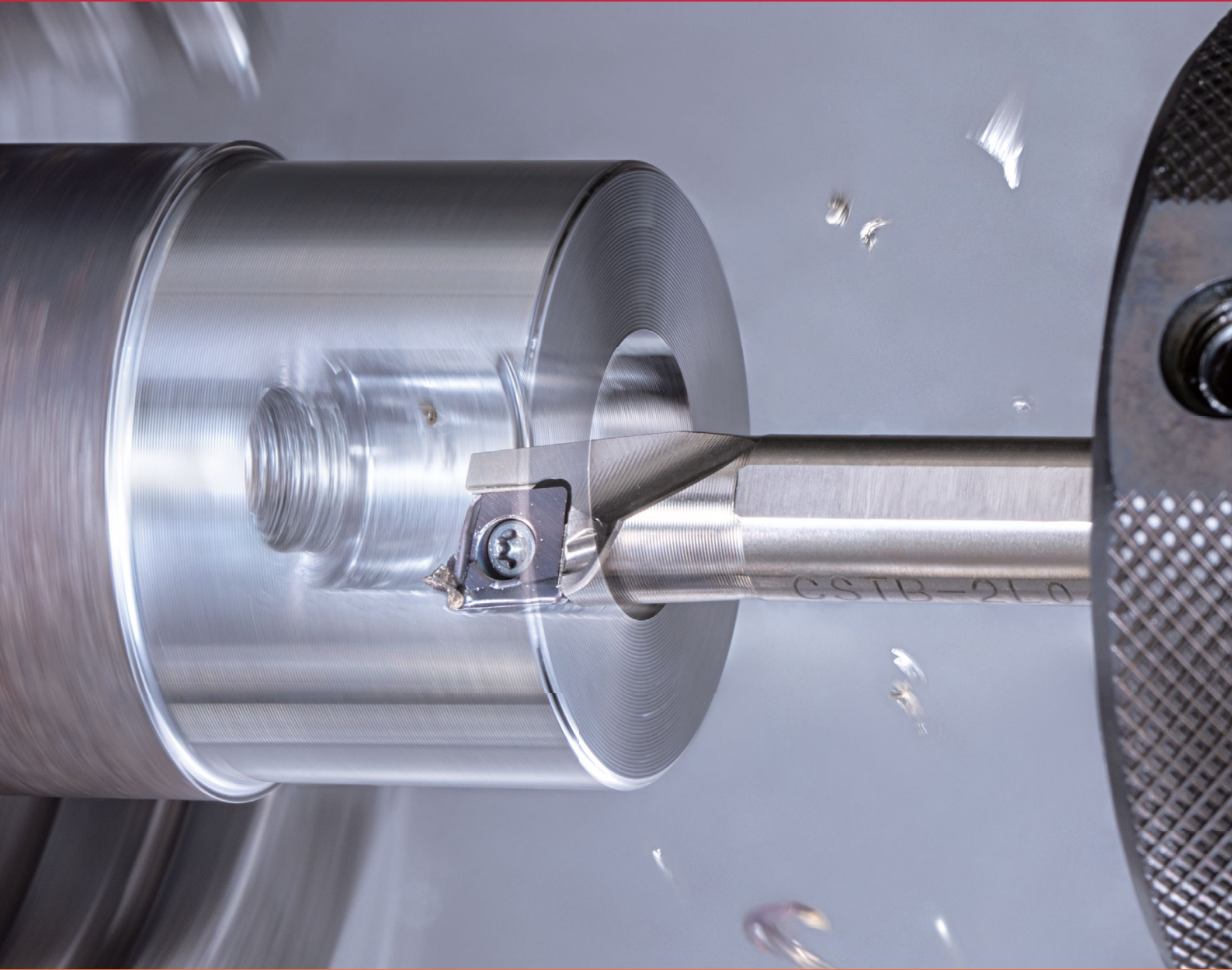


TUNG^{ORE}**B****MINI**

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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

Existing: Multifunctional tool

- Drilling
- Face turning
- Internal boring
- External turning

New

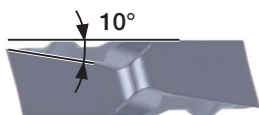
For Internal boring

High chip evacuation
Large pocket clearance

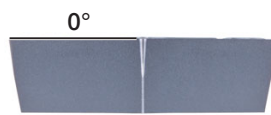
Features

1. Low cutting force

Large inclination angle of XOMU insert



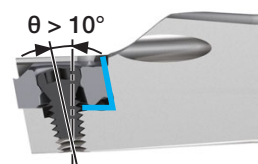
XOMU insert



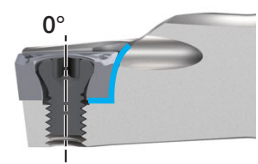
Conventional
(CCMT060204...)

2. High reliability & high rigidity clamping

Dovetail clamping and slanted insert clamping screw

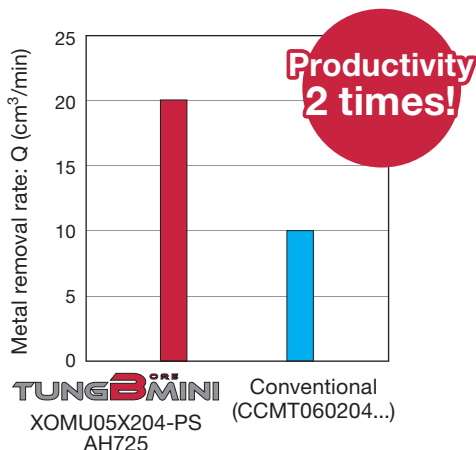


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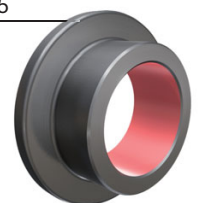
Conventional
(CCMT060204...for boring bar)

CUTTING PERFORMANCE



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

	TUNGB ^{ORE} MINI	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



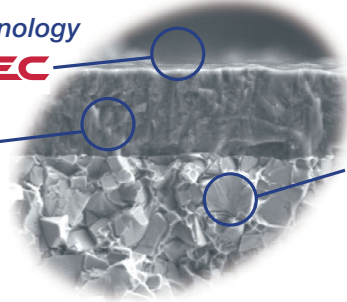
PVD grade: AH725

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

Special surface technology

PREMIUMTEC
TUNGALOY

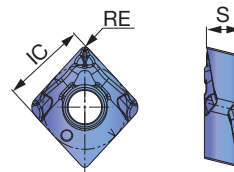
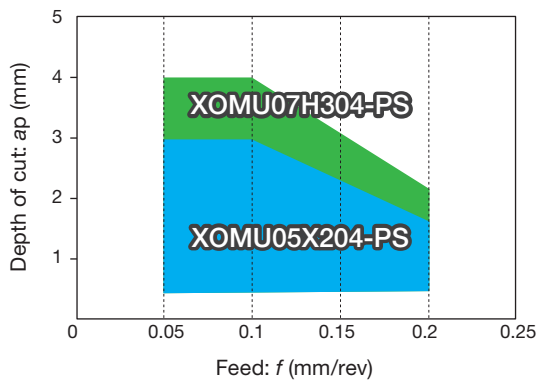
Coating layer with excellent adhesion strength
PVD coating



Remarkable toughness
Fine grain carbide

Standard cutting conditions

DMIN	Description		Depth of cut: a_p (mm)	Feed: f (mm/rev)	Cutting speed: V_c (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



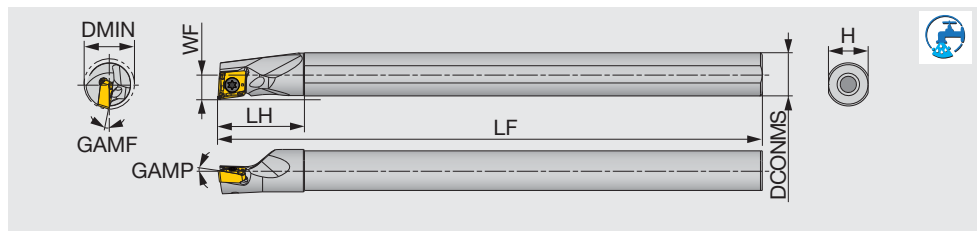
Designation	RE	Coated		S	IC
		AH725			
XOMU05X204-PS	0.4	●		2.3	5.56
XOMU07H304-PS	0.4	●		3.3	7.3

●: 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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