

MICRO-DEX BORING BARS

- The minimum cutting diameter is from $\phi 5$.
- l/d is 5 times the diameter.
- 5°, 7° positive insert, carbide shank type.
- Easy-to-use tool geometries.
- Suitable for small workpieces.

SCLC

Carbide shank

CCO inserts

Finish

L-F



(03,04)

PCD/CBN



(03,04)

Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions (mm)					Min. Cutting Diameter	Standard Corner Radius	*2 	
	R			D4	L1	F1	H1	RR°			D1	Re
C04GSCLCR03	●	★1 CCGT NP-CCGW NP-CCMW	03S1 	4	90	2.5	3.7	15	5	0.2	TS16	TKY06F
C05HSCLCR03	●		03S1 	5	100	3.0	4.7	13	6	0.2	TS16	TKY06F
C06JSCLCR04	●		04T0 	6	110	3.5	5.7	13	7	0.2	TS21	TKY08F
C07KSCLCR04	●		04T0 	7	125	4.0	6.7	11	8	0.2	TS21	TKY08F

★1 Diameter of inscribed circle is special. (For SCLC type)

★2 Clamp Torque (N • m) : TS16=0.6, TS21=0.6

SWUB

Carbide shank

WBGT inserts

Finish

L-F



(02,L3)

Right hand tool holder only.

Order Number	Stock	Insert Number		Dimensions (mm)					Min. Cutting Diameter	Standard Corner Radius		
	R			D4	L1	F1	H1	RR°			D1	Re
C05HSWUBR02	●	WBGT	0201 $\bigcirc\bigcirc$ L-F	5	100	3.0	4.7	15	6	0.2	TS21	TKY06F
C06JSWUBR02	●		0201 $\bigcirc\bigcirc$ L-F	6	110	3.5	5.7	13	7	0.2	TS2C	TKY06F
C07KSWUBRL3	●		L302 $\bigcirc\bigcirc$ L-F	7	125	4.0	6.7	15	8	0.2	TS2	TKY06F

★ Clamp Torque (N • m) : TS21=0.6, TS2C=0.6, TS2=0.6

RECOMMENDED CUTTING CONDITIONS

Work Material	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	l/d
P Carbon Steel, Alloy Steel 180—350HB	NX2525	80 (40—120)	0.03 (0.01—0.05)	0.2 (0.1—0.3)	3—5
M Stainless Steel ≤200HB	VP15TF	80 (40—120)	0.03 (0.01—0.05)	0.2 (0.1—0.3)	3—5
K Cast Iron ≤350MPa	VP15TF	80 (40—120)	0.03 (0.01—0.05)	0.2 (0.1—0.3)	3—5
N Non-Ferrous Material	VP15TF	120 (80—160)	0.05 (0.01—0.08)	0.4 (0.1—0.6)	3—5
	MD220	120 (80—160)	0.05 (0.01—0.08)	0.4 (0.1—0.6)	3—5
H Heat Treated Steel 35—65HRC	MB810	80 (40—120)	0.03 (0.01—0.05)	0.1 (0.03—0.2)	3—5

CCGT type inserts > A128

WBGT type inserts > A157

CBN inserts > B035

SPARE PARTS > M001

TECHNICAL DATA > N001