

# BORING BARS

## MICRO-DEX BORING BARS

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

# STUC

Carbide shank

TCGT inserts

Finish

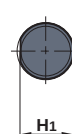
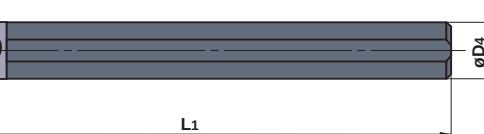
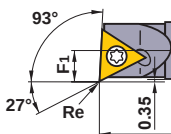
L-F



(06)

93°

Depth of cut is limited when cutting backwards.



Right hand tool holder only.

| Order Number | Stock | Insert Number  | Dimensions (mm) |     |     |     |     | Min. Cutting Diameter | Standard Corner Radius | ★    | Wrench |
|--------------|-------|----------------|-----------------|-----|-----|-----|-----|-----------------------|------------------------|------|--------|
|              |       |                | D4              | L1  | F1  | H1  | RR° |                       |                        |      |        |
| C07KSTUCR06  | ●     | TCGT 060100L-F | 7               | 125 | 4.0 | 6.7 | 12  | 8                     | 0.2                    | TS2C | TKY06F |

★ Clamp Torque (N • m) : TS2C=0.6

## RECOMMENDED CUTTING CONDITIONS

|   | Work Material                       | Grade  | Cutting Speed (m/min) | Feed (mm/rev)    | Depth of Cut (mm) | I/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 |

● : Inventory maintained. ★ : Inventory maintained in Japan.