

MICRO-MINI BORING BARS

- Solid carbide type with minimum cutting diameter $\phi 3.2$ mm.
- l/d is 5 times the diameter.
- Cutting edge can be shaped according to the application thus, it covers a wide cutting range (threading, grooving, copying, etc.).

STANDARD MICRO-MINI BORING BARS (Solid carbide boring bar)

Order Number	Stock	Dimensions (mm)				Min. Cutting Diameter	Max. Depth of Groove	Geometry
	TF15	W3	D4	L1	L2			
C03FR-BLS	★	2.0	3	80	15	3.2	1.0	
C04FR-BLS	★	2.5	4	80	20	4.2	1.5	
C05HR-BLS	★	3.0	5	100	25	5.2	2.0	

RECOMMENDED CUTTING CONDITIONS

	Work Material	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	l/d	Edge Condition	
						★ Corner Radius or C	★ Honing
P	General Steel	40 (30—50)	0.05 (—0.1)	0.2 (0.1—0.3)	5	0.1—0.5	0.01—0.05
M	Stainless Steel	40 (30—50)	0.05 (—0.1)	0.2 (0.1—0.3)	5	≤0.4	≤0.03 (Honing not required)
K	Cast Iron	40 (30—50)	0.05 (—0.05)	0.2 (0.1—0.3)	5	0.1—0.5	0.01—0.05
N	Non-Ferrous Material	80 (60—100)	0.05 (—0.1)	0.3 (0.1—0.5)	5	0.1—0.5	≤0.03 (Honing not required)

★ Cutting edge is not honed. Please hone according to the workpiece before machining.

GRINDING THE CUTTING EDGE OF MICRO-MINI BORING BAR

- MICRO-MINI boring bar can be applied to boring and grooving without any modifications. It can also be reground as shown below.
 - For shaping and regrinding, use diamond whetstone approximately #250—#400.
- Please grind according to application using the figure below as a reference.

Application	Boring	Grooving	Threading
Grinding Examples			

★ : Inventory maintained in Japan.

SPARE PARTS > M001
TECHNICAL DATA > N001