



ALLIED MACHINE & ENGINEERING

Holemaking Solutions for Today's Manufacturing



Drilling



Reaming



Burnishing



Threading



Specials

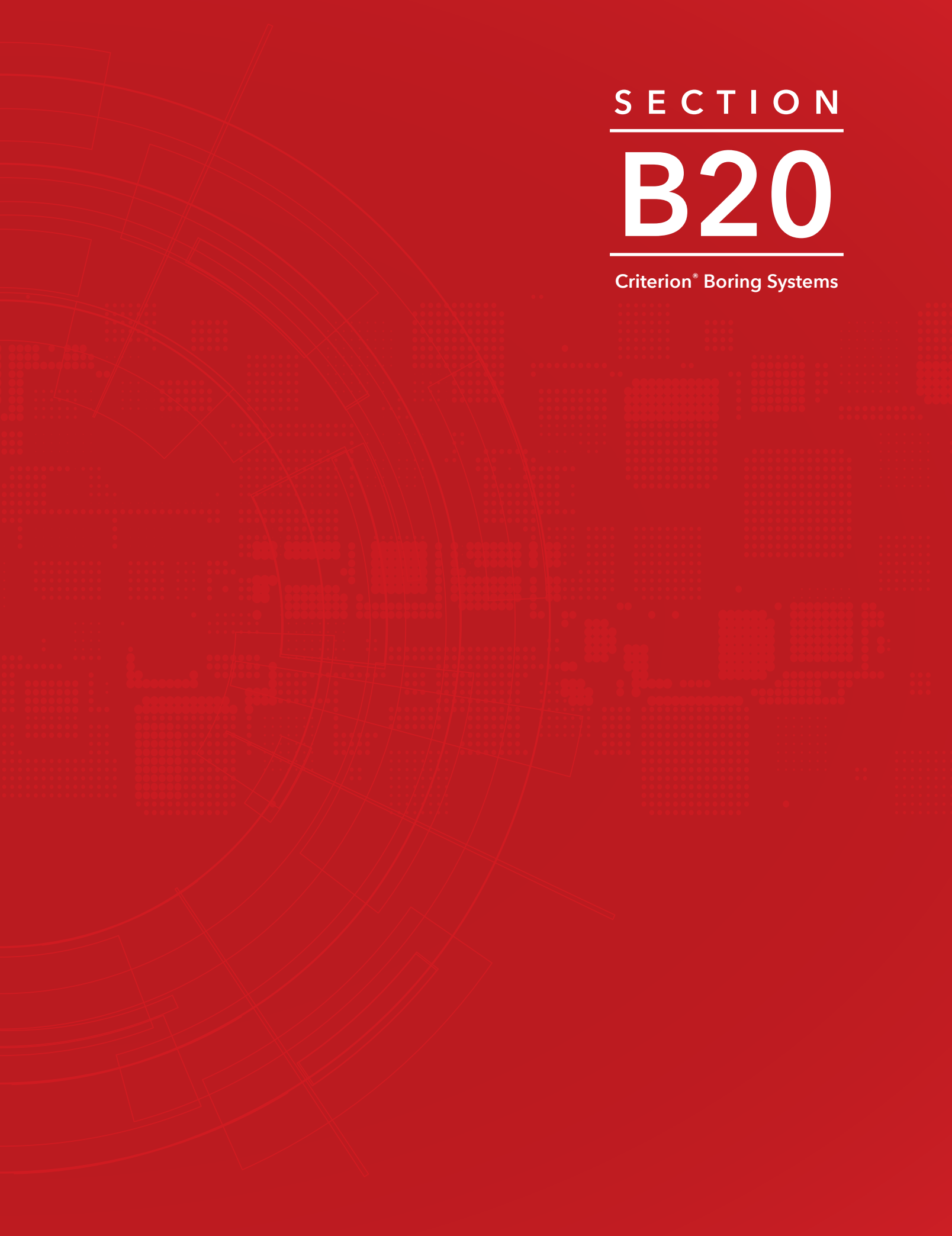


Criterion[®]

► **BORING**

Modular Boring Systems

CRITERION[®]



SECTION

B20

Criterion® Boring Systems

Criterion® Modular Boring Systems

MBS | CBS | MDS | Cri-Bore® | Large Cri-Bore® | CB Style



CRITERION®

Boring holes doesn't have to be boring.

Criterion modular boring systems bring speed, tolerance, toughness, and versatility to your boring applications.

The MBS finish boring tool is ideal for small diameter bores and high spindle speeds to bore quickly and efficiently.

The Cri-Bore boring system is designed for finish boring applications and can be used for extremely tight tolerances. When the tolerance is tight, the Cri-Bore can be adjusted in 0.00005" (fifty-millionths).

The versatile CB style boring heads are available in both microadjusting and standard. Made for maximum toughness, the CB style boring head can produce a wide range of diameters.

Your safety and the safety of others is very important. This catalog contains important safety messages. Always read and follow all safety precautions.



This triangle is a safety hazard symbol. It alerts you to potential safety hazards that can cause tool failure and serious injury.

When you see this symbol in the catalog, look for a related safety message that may be near this triangle or referred to in the nearby text.

There are safety signal words also used in the catalog. Safety messages follow these words.

WARNING

WARNING (shown above) means that failure to follow the precautions in this message could result in tool failure and serious injury.

NOTICE means that failure to follow the precautions in this message could result in damage to the tool or machine but not result in personal injury.

NOTE and **IMPORTANT** are also used. These are important that you read and follow but are not safety-related.

Visit www.alliedmachine.com for the most up-to-date information and procedures.



Aerospace



Agriculture



Automotive



Firearms

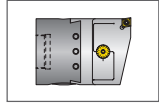


Renewable
Energy

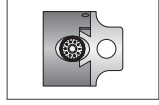
Criterion® Modular Boring Systems Contents

Reference Icons

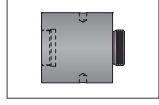
The following icons will appear throughout the catalog to help you navigate between products.



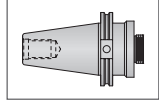
Boring Heads - Insert Holders
Microadjusting boring heads that use inserts for cutting



Boring Heads - Boring Bar Holders
Standard and microadjusting boring heads that use boring bars for cutting



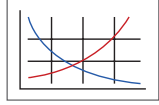
Head-to-Shank Adapters
Extensions and reducers that attach the boring head to the shank



Shanks
A variety of shanks for different machines



Setup / Assembly Information
Detailed instructions and information regarding the corresponding part(s)



Recommended Cutting Data
Speed and feed recommendations for optimum and safe boring

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Series	Bore Diameter Range	
	Imperial (inch)	Metric (mm)
MBS Finish Boring Tools	0.050" - 0.750"	—
CBS Finish Boring Tools	0.050" - 0.750"	—
MDS Finish Boring Tools	0.710" - 1.280"	18.00mm - 33.00mm
Cri-Bore® Micro Adjusting Finish Boring Heads	1.050" - 5.065"	27.00mm - 128.00mm
Large Cri-Bore® Finish Boring / OD Turning System	5.000" - 12.125"	127.00mm - 308.00mm
CB Style Versatile Finish Boring Heads	0.250" - 21.500"	—



WE KNOW

SPEED MATTERS

MBS Finish Boring Tool

Ideal for small diameter bores and high spindle speeds

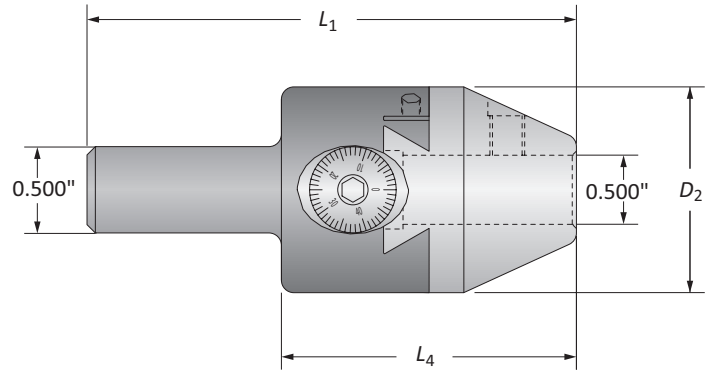
Compact design great for live tooling

Cylindrical shank can be dropped into existing tool holders



MBS Finish Boring Tool

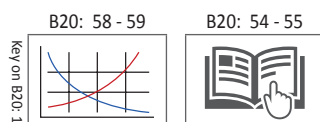
Bore Diameter Range: 0.050" - 0.750"



		Boring Head				
Boring Range		L_1	L_4	D_2	Weight	Part No.
i	0.050 - 0.750	3.500	2.125	1.500	0.900 (lbs)	MBS0500B

IMPORTANT: Wax covered gib screws are factory set and should not be removed. Adjustment of these screws will cause performance issues.

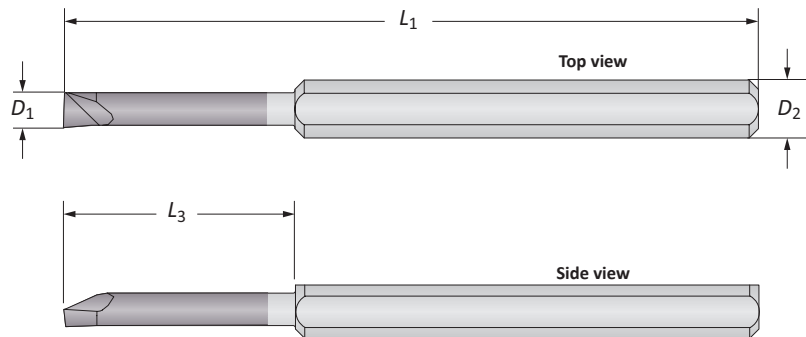
Imperial (in) = 0.001" adjustment on diameter

NOTE: Max spindle speed: 7,000 RPM at 0 radial offset**i** = Imperial (in)
m = Metric (mm)**IMPORTANT:** Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
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Mini Coated Boring Tools

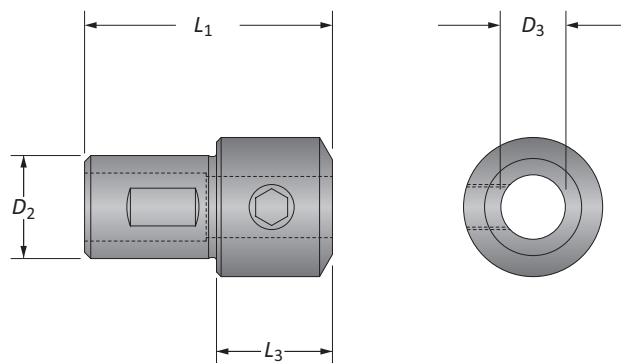
Bore Diameter Range: 0.050" - 0.275"



Mini Coated Boring Bars

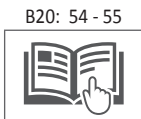
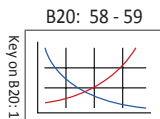
Min. Boring Diameter		Boring Bar				
	D_1	L_3	L_1	D_2	Weight	Part No.
i	0.050	0.300	1.500	0.125*	0.010 (lbs)	0050GA
	0.060	0.300	1.500	0.125*	0.010 (lbs)	0060GA
	0.080	0.500	1.500	0.125*	0.010 (lbs)	0080GA
	0.100	0.600	1.500	0.125*	0.010 (lbs)	0100GA
	0.110	0.700	1.500	0.125*	0.010 (lbs)	0110GA
	0.120	0.750	2.500	0.250*	0.020 (lbs)	0120HA
	0.140	0.750	2.500	0.250*	0.020 (lbs)	0140HA
	0.160	0.875	2.500	0.250*	0.020 (lbs)	0160HA
	0.180	1.125	2.500	0.250*	0.020 (lbs)	0180HA
	0.200	1.250	2.500	0.250*	0.020 (lbs)	0200HA

*Reducing sleeve required



Reducing Sleeves

Reducing Sleeve						
	D_3	D_2	L_1	L_3	Weight	Part No.
i	0.125	0.500	2.000	0.220	0.100 (lbs)	BTH-01250500
	0.250	0.500	1.312	—	0.050 (lbs)	BTH-02500500

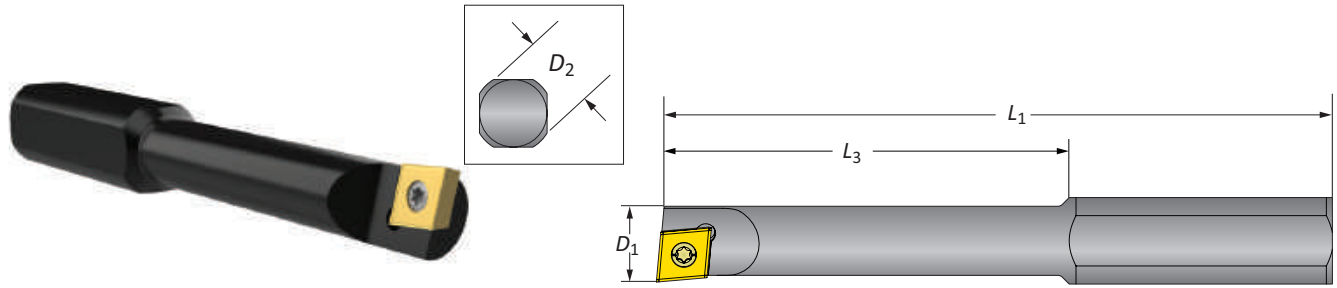


i = Imperial (in)
m = Metric (mm)



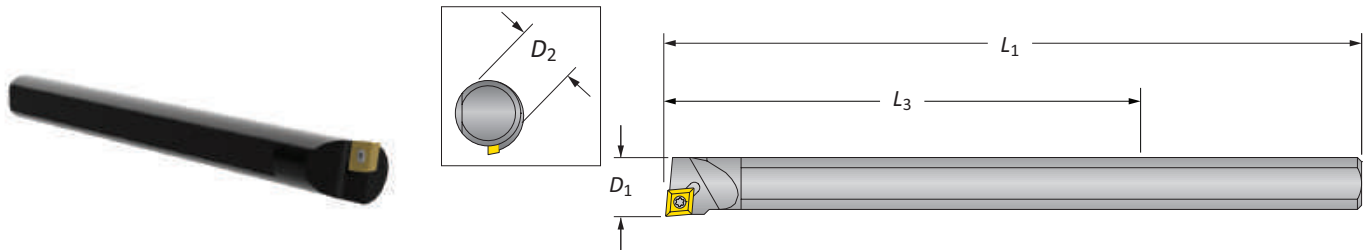
Boring Bars

Bore Diameter Range: 0.250" - 0.750"



Steel Boring Bars | Bore Diameter Range: 0.250" - 0.750"

Min. Boring Diameter	Boring Bar			Weight	Insert Form	Part No.
	D_1	L_3	L_1			
i	0.250	1.062	2.500	0.080 (lbs)	WBGX0301..	0250B
	0.312	1.437	2.750	0.080 (lbs)	WBGX0301..	0312B
	0.375	1.750	3.062	0.100 (lbs)	WBGX0301..	0375B
	0.437	2.062	3.375	0.110 (lbs)	CC..215..	0437B
	0.500	2.187	3.500	0.140 (lbs)	CC..215..	0500B



Heavy Metal Boring Bars | Bore Diameter Range: 0.365" - 0.750"

Min. Boring Diameter	Boring Bar			Weight	Insert Form	Part No.
	D_1	L_3	L_1			
i	0.365	2.250	4.000	0.080 (lbs)	CC..215..	0365HM
	0.550	3.250	6.000	0.300 (lbs)	CC..215..	0550BHM

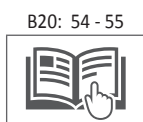
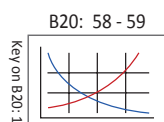
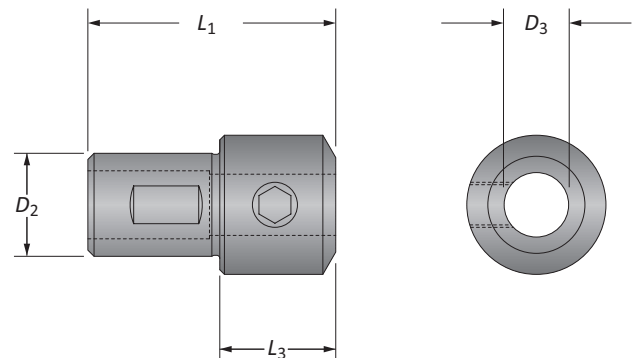
*Reducing sleeve required

Carbide Boring Bars | Bore Diameter Range: 0.625" - 0.750"

Min. Boring Diameter	Boring Bar			Weight	Insert Form	Part No.
	D_1	L_3	L_1			
i	0.625	4.500	8.000	0.410 (lbs)	CC..215..	0625BCS

Reducing Sleeves

Reducing Sleeve				Weight	Part No.
D_3	D_2	L_1	L_3		
i	0.312	0.500	1.312	0.040 (lbs)	BTH-03120500
	0.375	0.500	1.312	0.030 (lbs)	BTH-03750500



i = Imperial (in)
m = Metric (mm)
Inserts sold separately



A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

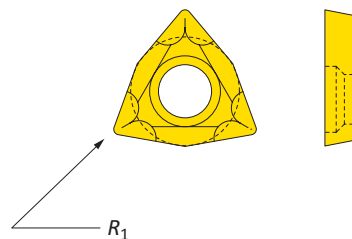
THREADING

X

SPECIALS

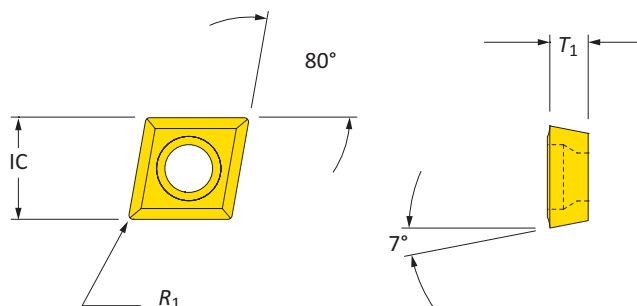
Boring Inserts

Trigon | 80° Diamond



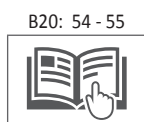
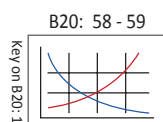
Coated Trigon Insert

Insert Form		Insert	Part No.
		R_1	
i	WBGX0301..	0.004	WBGX030101



Coated 80° Diamond Insert

Insert Form		Insert		Part No.
		IC	T_1	
i	CC..215..	0.250	0.094	0.008
				CCMT060202



i = Imperial (in)
m = Metric (mm)

Inserts sold separately



WE KNOW REACH MATTERS

CBS Finish Boring Tool

Ease the stress of reaching past fixturing

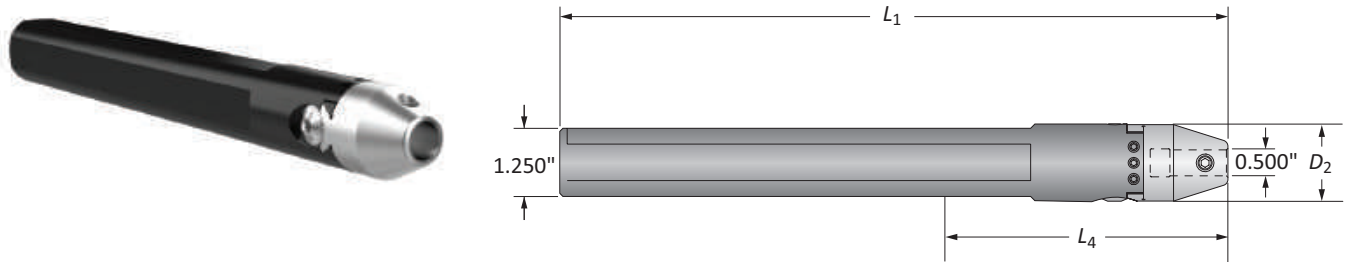
Ideal for small diameter bores with long overhangs

Cylindrical shank can be dropped into existing end mill
(side-lock) holders



CBS Finish Boring Tool

Bore Diameter Range: 0.050" - 0.750"



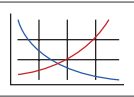
		Boring Head			Weight	Part No.
Boring Range		L ₁	L ₄	D ₂		
 0.050 - 0.750		10.600	8.320	1.250	3.100 (lbs)	CBS1250B

IMPORTANT: Wax covered gib screws are factory set and should not be removed. Adjustment of these screws will cause performance issues.

Imperial (in)= 0.001" adjustment on diameter

NOTE: Max spindle speed: 3,500 RPM at 0 radial offset

B20: 58 - 59



B20: 54 - 55

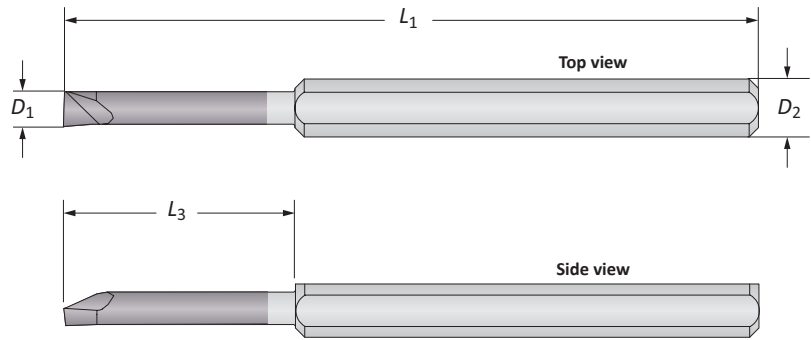


 = Imperial (in)
 = Metric (mm)

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
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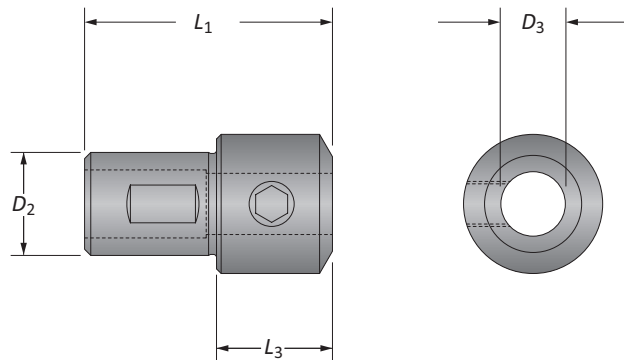
**Mini Coated Boring Tools**

Bore Diameter Range: 0.050" - 0.275"

**Mini Coated Boring Tools**

	Min. Boring Diameter	Boring Bar			Weight	Coated Part No.
	D_1	L_3	L_1	D_2		
i	0.050	0.300	1.500	0.125*	0.010 (lbs)	0050GA
	0.060	0.300	1.500	0.125*	0.010 (lbs)	0060GA
	0.080	0.500	1.500	0.125*	0.010 (lbs)	0080GA
	0.100	0.600	1.500	0.125*	0.010 (lbs)	0100GA
	0.110	0.700	1.500	0.125*	0.010 (lbs)	0110GA
	0.120	0.750	2.500	0.250*	0.020 (lbs)	0120HA
	0.140	0.750	2.500	0.250*	0.020 (lbs)	0140HA
	0.160	0.875	2.500	0.250*	0.020 (lbs)	0160HA
	0.180	1.125	2.500	0.250*	0.020 (lbs)	0180HA
	0.200	1.250	2.500	0.250*	0.020 (lbs)	0200HA

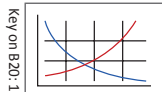
*Reducing sleeve required

**Reducing Sleeves**

	Reducing Sleeve				Weight	Part No.
	D_3	D_2	L_1	L_3		
i	0.125	0.500	2.000	0.220	0.100 (lbs)	BTH-01250500
	0.250	0.500	1.312	—	0.050 (lbs)	BTH-02500500
	0.375	0.500	1.312	—	0.030 (lbs)	BTH-03750500

B20: 58 - 59

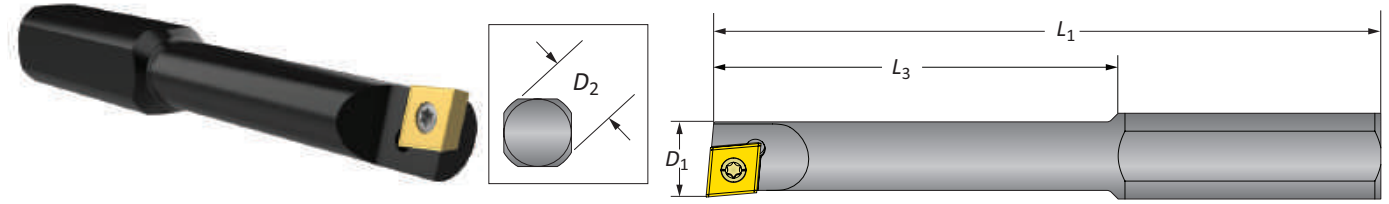
B20: 54 - 55



i = Imperial (in)
m = Metric (mm)

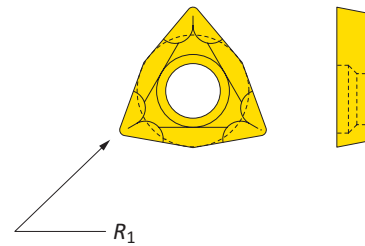
Steel Boring Bars | Boring Inserts

Bore Diameter Range: 0.250" - 0.750"



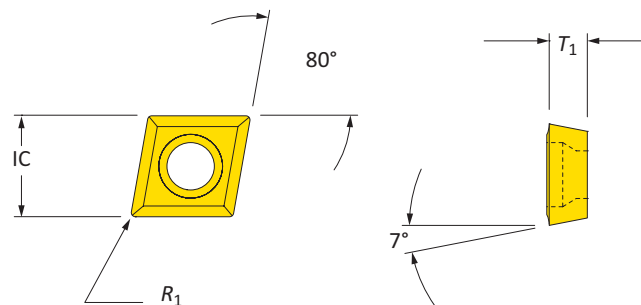
Steel Boring Bars

i	Min. Boring Diameter	Boring Bar			Weight	Insert Form	Part No.
	D_1	L_3	L_1	D_2			
	0.250	1.062	2.500	0.500	0.080 (lbs)	WBGX0301...	0250B
	0.312	1.437	2.750	0.500	0.080 (lbs)	WBGX0301...	0312B
	0.375	1.750	3.062	0.500	0.100 (lbs)	WBGX0301...	0375B
	0.437	2.062	3.375	0.500	0.110 (lbs)	CC..215..	0437B
	0.500	2.187	3.500	0.500	0.140 (lbs)	CC..215..	0500B



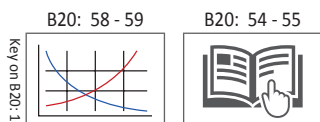
Coated Trigon Insert

i	Insert Form	Insert	Part No.
		R_1	
	WBGX0301...	0.004	WBGX030101



Coated 80° Diamond Insert

i	Insert Form	Insert			Part No.
		IC	T_1	R_1	
	CC..215..	0.250	0.094	0.008	CCMT060202



i = Imperial (in)
m = Metric (mm)
Inserts sold separately



WE KNOW

CONVENIENCE MATTERS

MDS Finish Boring Tool

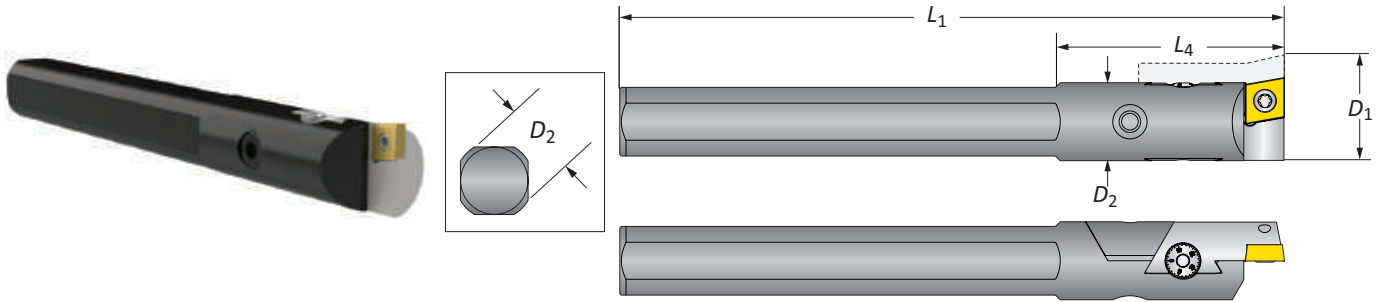
Compact design and rugged insert holder make it one of the toughest boring tools under 1.000" (25.4mm) diameter

Cylindrical shank can be dropped into existing end mill (side-lock) holders

Available in both imperial (in) and metric (mm) versions

MDS Finish Boring Tools | Boring Inserts

Bore Diameter Range: 0.710" - 1.280" (18.00mm - 33.00mm)

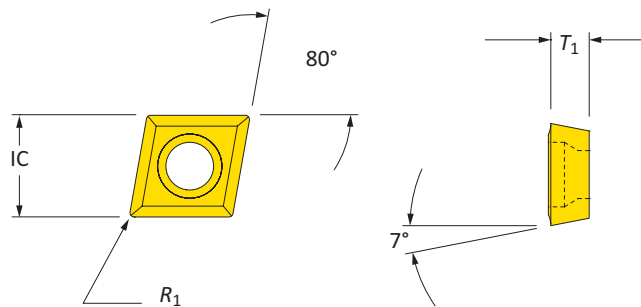


	Boring Range		Shank Diameter		Boring Head		Weight	Insert Form	Part No.
	D_1		D_2		L_1	Max L_4			
i	0.710 - 0.960		0.625		5.250	3.386	0.400 (lbs)	CC..215..	MDS0625
	0.890 - 1.280		0.750		6.310	4.435	0.700 (lbs)	CC..325..	MDS0750
m	18.00 - 24.25		16.00		133.00	85.37	0.18 (kg)	CC..0602..	MDS16M
	22.00 - 33.00		20.00		160.00	112.37	0.32 (kg)	CC..09T3..	MDS20M

Imperial (in) = 0.001" adjustment on diameter

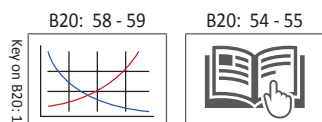
Metric (mm) = 0.020mm adjustment on diameter

NOTE: Max spindle speed: 1,000 SFM (305 M/Min) at 0 radial offset



Coated 80° Diamond Inserts

	Insert				Part No.
	Insert Form	IC	T_1	R_1	
i	CC..215..	0.250	0.094	0.008	CCMT060202
	CC..325..	0.375	0.156	0.008	CCMT09T302
	CC..325..	0.375	0.156	0.016	CCMT09T304
m	CC..0602..	6.35	2.38	0.20	CCMT060202
	CC..09T3..	9.53	3.97	0.20	CCMT09T302
	CC..09T3..	9.53	3.97	0.40	CCMT09T304



i = Imperial (in)
m = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.

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WE KNOW

TOLERANCE MATTERS

Cri-Bore[®] Micro Adjusting

Allows for 0.00005" (0.001mm) on diameter bore increments

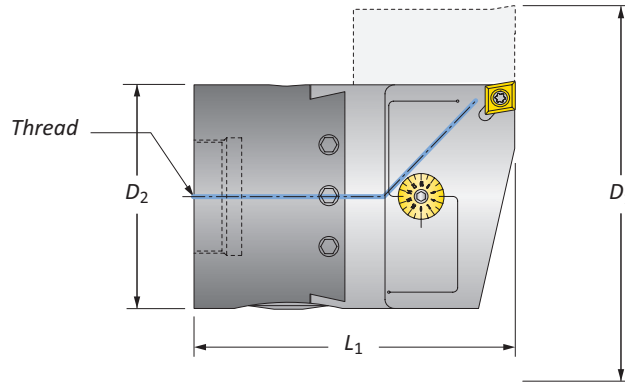
Modular system can be used on virtually any machine

Available in both imperial (in) and metric (mm) versions



Cri-Bore® Micro Adjusting Finish Boring Heads

Bore Diameter Range: 1.050" - 5.065" (27.00mm - 128.00mm)



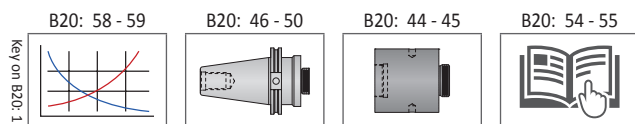
	Boring Range		Boring Head		Weight	Insert Form	Part. No
	D_1	Thread Connection	L_1	D_2			
i	1.050 - 1.320	$\frac{1}{8}$ - 20	2.690	1.000	0.500 (lbs)	CC..215..	CB1000CC
	1.050 - 1.320	$\frac{1}{8}$ - 20	2.690	1.000	0.500 (lbs)	TC..215..	CB1000TC
	1.300 - 1.600	$\frac{1}{8}$ - 20	2.900	1.250	0.800 (lbs)	CC..215..	CB1250CC
	1.300 - 1.600	$\frac{1}{8}$ - 20	2.900	1.250	0.800 (lbs)	TC..215..	CB1250TC
	1.585 - 2.700	$\frac{1}{8}$ - 20	3.200	1.500	1.300 (lbs)	CC..325..	CB1500CC
	1.585 - 2.700	$\frac{1}{8}$ - 20	3.200	1.500	1.300 (lbs)	TC..325..	CB1500TC
	2.060 - 3.320	$\frac{1}{8}$ - 20	3.590	2.000	2.400 (lbs)	CC..325..	CB2000CC
	2.060 - 3.320	$\frac{1}{8}$ - 20	3.590	2.000	2.400 (lbs)	TC..325..	CB2000TC
	3.065 - 5.065	$1\frac{1}{2}$ - 18	4.100	3.000	5.800 (lbs)	CC..325..	CB3000CC
m	3.065 - 5.065	$1\frac{1}{2}$ - 18	4.100	3.000	5.800 (lbs)	TC..325..	CB3000TC
	27.00 - 33.00	$\frac{1}{8}$ - 20	68.35	25.00	0.23 (kg)	CC..0602..	CB025MCC
	27.00 - 33.00	$\frac{1}{8}$ - 20	68.35	25.00	0.23 (kg)	TC..1102..	CB025MTC
	33.00 - 41.00	$\frac{1}{8}$ - 20	73.65	32.00	0.36 (kg)	CC..0602..	CB032MCC
	33.00 - 41.00	$\frac{1}{8}$ - 20	73.65	32.00	0.36 (kg)	TC..1102..	CB032MTC
	41.00 - 68.00	$\frac{1}{8}$ - 20	81.25	38.00	0.59 (kg)	CC..09T3..	CB038MCC
	41.00 - 68.00	$\frac{1}{8}$ - 20	81.25	38.00	0.59 (kg)	TC..16T3..	CB038MTC
	53.00 - 84.00	$\frac{1}{8}$ - 20	91.30	50.00	1.09 (kg)	CC..09T3..	CB050MCC
	53.00 - 84.00	$\frac{1}{8}$ - 20	91.30	50.00	1.09 (kg)	TC..16T3..	CB050MTC
	78.00 - 128.00	$1\frac{1}{2}$ - 18	104.25	76.00	2.36 (kg)	CC..09T3..	CB076MCC
	78.00 - 128.00	$1\frac{1}{2}$ - 18	104.25	76.00	2.36 (kg)	TC..16T3..	CB076MTC

IMPORTANT: Wax covered gib screws are factory set and should not be removed. Adjustment of these screws will cause performance issues.

Imperial (in) = 0.00005" adjustment on diameter

Metric (mm) = 0.001mm adjustment on diameter

NOTE: Max spindle speed: 1,000 SFM (305 M/Min) at 0 radial offset



i = Imperial (in)
m = Metric (mm)

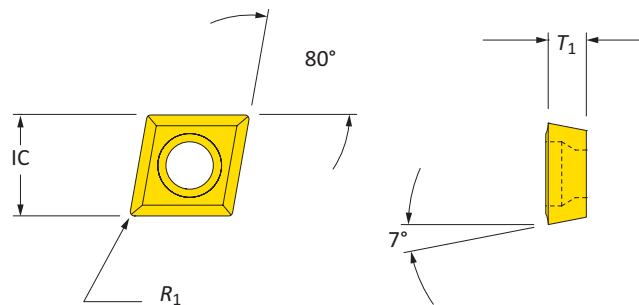
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.

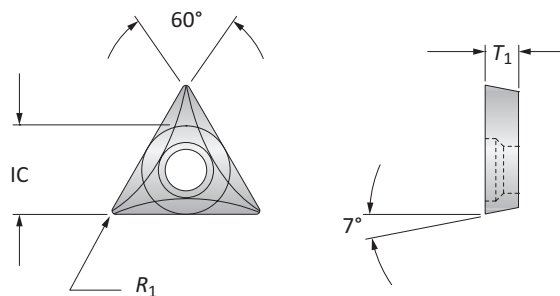
ext: 7611 | email: appeng@alliedmachine.com

**Boring Inserts**

80° Diamond Insert | 60° Triangle Insert

**Coated 80° Diamond Inserts**

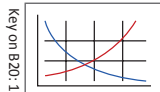
		Insert			Part No.
Insert Form		IC	T ₁	R ₁	
i	CC...215..	0.250	0.094	0.008	CCMT060202
	CC...215..	0.250	0.094	0.016	CCMT060204
	CC...325..	0.375	0.156	0.008	CCMT09T302
	CC...325..	0.375	0.156	0.016	CCMT09T304
m	CC...0602..	6.35	2.38	0.20	CCMT060202
	CC...0602..	6.35	2.38	0.40	CCMT060204
	CC...09T3..	9.53	3.97	0.20	CCMT09T302
	CC...09T3..	9.53	3.97	0.40	CCMT09T304

**Coated 60° Triangle Inserts**

		Insert			Part No.
Insert Form		IC	T ₁	R ₁	
i	TC...215..	0.250	0.094	0.008	TCGT110202
	TC...215..	0.250	0.094	0.016	TCGT110204
	TC...325..	0.375	0.156	0.016	TCGT16T304
m	TC...1102..	6.35	2.38	0.20	TCGT110202
	TC...1102..	6.35	2.38	0.40	TCGT110204
	TC...16T3..	9.53	3.97	0.40	TCGT16T304

B20: 58 - 59

B20: 54 - 55



i = Imperial (in)
m = Metric (mm)

Inserts sold separately



EXTEND YOUR BORING RANGE

Large Cri-Bore[®] Finish Boring / OD Turning System

Extend the diameter range for internal and external boring

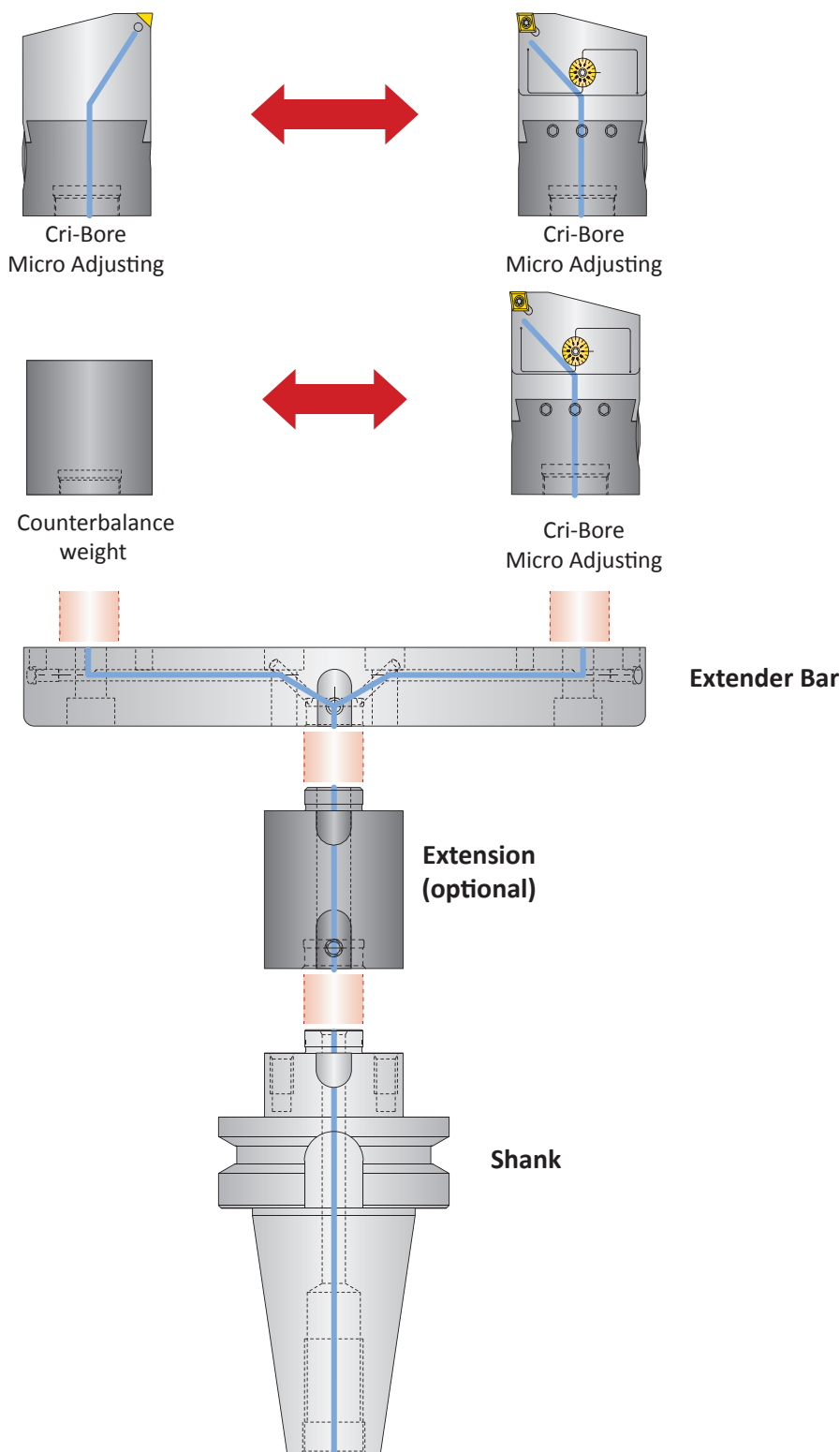
Modular tooling system allows for CAT, BT, or HSK shanks

Allows for 0.00005" (0.001mm) on diameter bore increments



Large Cri-Bore Finish Boring / OD Turning System

Cri-Bore Boring Head / Optional Component Combinations



⚠ WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

- Refer to page B20: 57 to see formula for calculating weight of tool assembly.
- Consult machine tool builder for machine's weight limitations.

Factory technical assistance is also available for specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

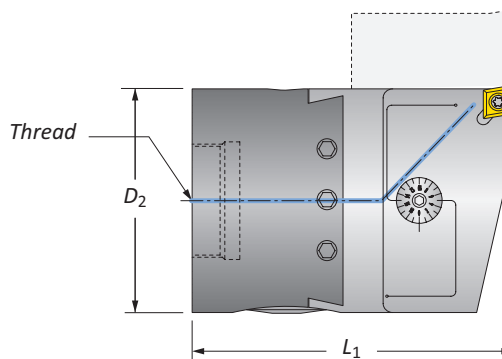
⚠ WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

Cri-Bore Micro Adjusting Finish Boring Heads | Counter Weights

Bore ID Range: 5.000" - 12.125" (127.00mm - 307.90mm) | Bore OD Range: 0.710" - 7.830" (18.10mm - 198.80mm)



Cri-Bore Micro Adjusting Boring Heads

	Connection Thread	Boring Head		Weight	Insert Form	Part No.
		L_1	D_2			
i	$\frac{7}{8}$ - 20	3.200	1.500	1.300 (lbs)	CC..325..	CB1500CC
	$\frac{7}{8}$ - 20	3.200	1.500	1.300 (lbs)	TC..325..	CB1500TC
m	$\frac{7}{8}$ - 20	81.25	38.00	0.59 (kg)	CC..09T3..	CB038MCC
	$\frac{7}{8}$ - 20	81.25	38.00	0.59 (kg)	TC..16T3..	CB038MTC

IMPORTANT: Wax covered gib screws are factory set and should not be removed. Adjustment of these screws will cause performance issues.

Imperial (in) = 0.00005" adjustment on diameter

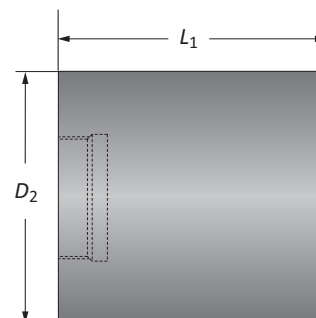
Metric (mm) = 0.001mm adjustment on diameter

NOTE: Max spindle speed ID boring: 1,000 SFM (305 M/Min) at 0 radial offset and used with counter weight or additional boring head

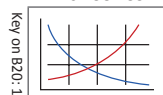
NOTE: Max spindle speed OD boring: Contact our Application Engineering department

Large Cri-Bore Counter Weights

	Counter Weight		Weight	Part No.
	D_2	L_1		
i	1.500	2.580	1.250 (lbs)	LCB1500-CBWTa
m	38.10	65.53	0.57 (kg)	LCB1500-CBWTa



B20: 58 - 59



B20: 54 - 55



i = Imperial (in)

m = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.

ext: 7611 | email: appeng@alliedmachine.com

WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

- Refer to page B20: 57 to see formula for calculating weight of tool assembly.

- Consult machine tool builder for machine's weight limitations.

Factory technical assistance is also available for specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

WARNING Tool failure can cause serious injury. To prevent:

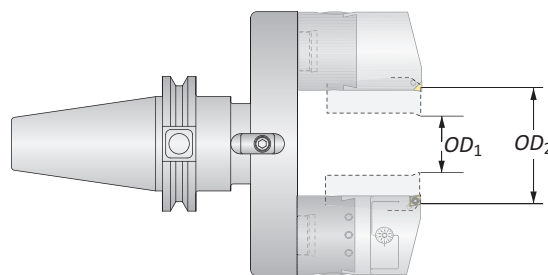
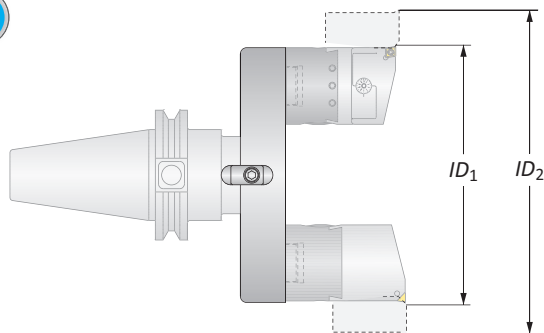
- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)

- Refer to example on page B20: 56 for calculating length to diameter ratio

Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

**Large Cri-Bore Finish Boring / OD Turning System Extender Bars | Extensions**

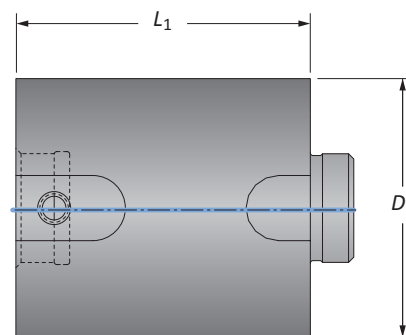
Bore ID Range: 5.000" - 12.125" (127.00mm - 307.90mm) | Bore OD Range: 0.710" - 7.830" (18.10mm - 198.80mm)

**Large Cri-Bore Extender Bars**

Extender Bar					Weight	Part No.
	ID ₁	ID ₂	OD ₁	OD ₂		
i	5.000	6.125	0.710	1.830	1.560 (lbs)	LCB1500-56EBK
	6.000	7.125	1.710	2.830	1.920 (lbs)	LCB1500-67EBK
	7.000	8.125	2.710	3.830	2.290 (lbs)	LCB1500-78EBK
	8.000	9.125	3.710	4.830	2.650 (lbs)	LCB1500-89EBK
	9.000	10.125	4.710	5.830	3.010 (lbs)	LCB1500-910EBK
	10.000	11.125	5.710	6.830	3.370 (lbs)	LCB1500-1011EBK
	11.000	12.125	6.710	7.830	3.730 (lbs)	LCB1500-1112EBK
m	127.00	155.50	18.10	46.40	0.71 (kg)	LCB1500-56EBK
	152.40	180.90	43.50	71.80	0.87 (kg)	LCB1500-67EBK
	177.80	206.30	68.90	97.20	1.04 (kg)	LCB1500-78EBK
	203.20	231.70	94.30	122.60	1.20 (kg)	LCB1500-89EBK
	228.60	257.10	119.70	148.00	1.37 (kg)	LCB1500-910EBK
	254.00	282.50	145.10	173.40	1.53 (kg)	LCB1500-1011EBK
	279.40	307.90	170.50	198.80	1.69 (kg)	LCB1500-1112EBK

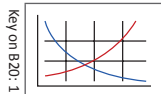
**Large Cri-Bore Extensions**

Extension				Weight	Part No.
	D ₁	L ₁			
i	1.500	1.500	0.660 (lbs)		LCB1500-IA1500
	1.500	3.000	1.330 (lbs)		LCB1500-IA3000
	1.500	4.500	1.980 (lbs)		LCB1500-IA4500
m	38.10	38.10	0.30 (kg)		LCB1500-IA1500
	38.10	76.20	0.60 (kg)		LCB1500-IA3000
	38.10	114.30	0.90 (kg)		LCB1500-IA4500

NOTE: Only one extension can be used per boring assembly. Extensions cannot be combined.

B20: 58 - 59

B20: 54 - 55



i = Imperial (in)

m = Metric (mm)

Inserts sold separately

WARNING

Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

- Refer to page B20: 57 to see formula for calculating weight of tool assembly.
- Consult machine tool builder for machine's weight limitations.

Factory technical assistance is also available for specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

WARNING

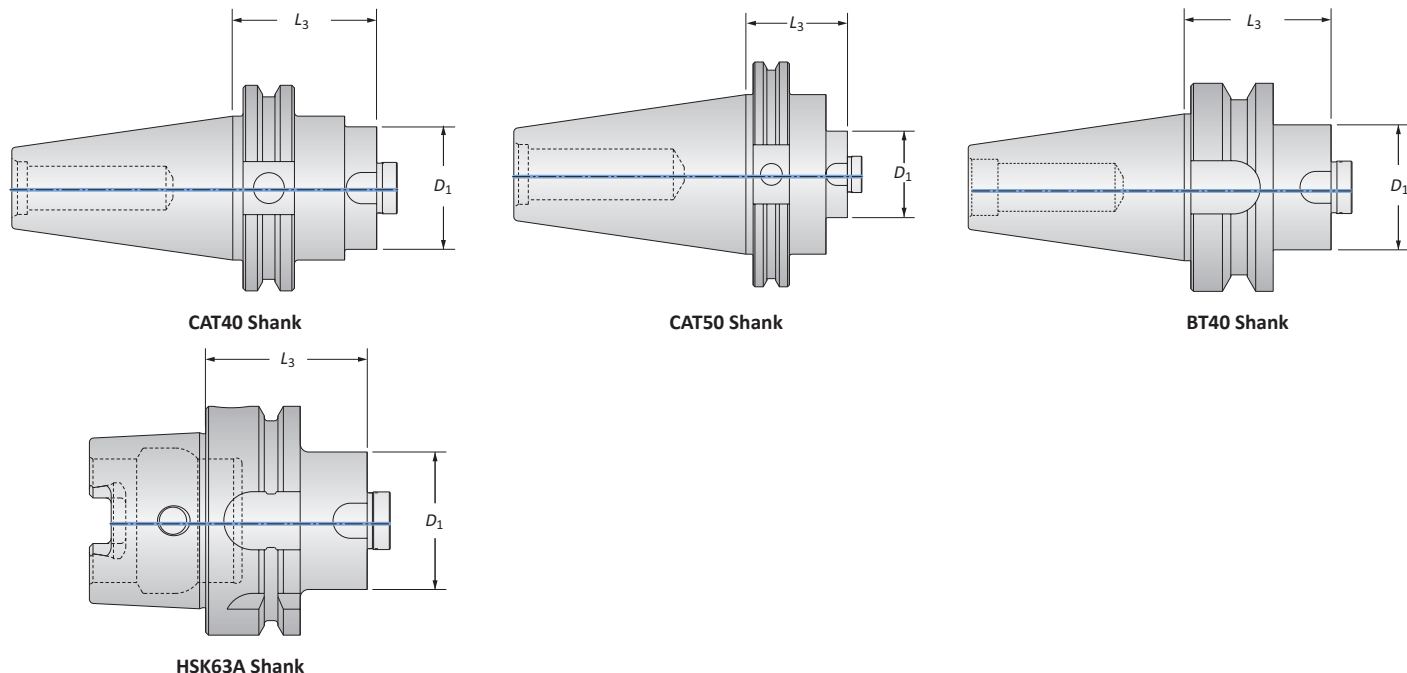
Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

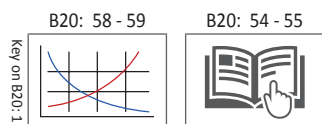
Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

Large Cri-Bore Finish Boring / OD Turning System Shanks

Bore ID Range: 5.000" - 12.125" (127.00mm - 307.90mm) | Bore OD Range: 0.710" - 7.830" (18.10mm - 198.80mm)



		Shank			
L_3		D_1	Taper	Weight	Part No.
i	1.750	1.500	CAT40	2.410 (lbs)	LCB1500-CV40
	1.750	1.500	CAT50	6.960 (lbs)	LCB1500-CV50
	1.750	1.500	BT40	2.460 (lbs)	LCB1500-BT40
	1.750	1.500	HSK63A	1.750 (lbs)	LCB1500-HSK63A
m	44.45	38.10	CAT40	1.09 (kg)	LCB1500-CV40
	44.45	38.10	CAT50	3.16 (kg)	LCB1500-CV50
	44.45	38.10	BT40	1.12 (kg)	LCB1500-BT40
	44.45	38.10	HSK63A	0.79 (kg)	LCB1500-HSK63A



i = Imperial (in)
m = Metric (mm)

Inserts sold separately

⚠ WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

- Refer to page B20: 57 to see formula for calculating weight of tool assembly.
- Consult machine tool builder for machine's weight limitations.

Factory technical assistance is also available for specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

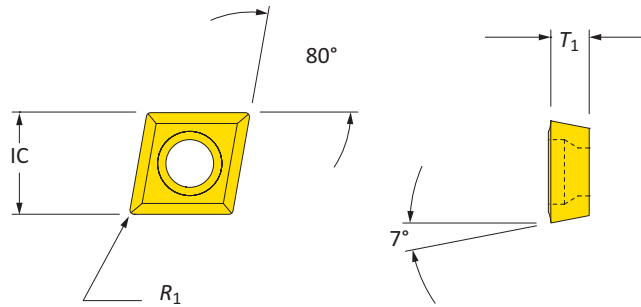
⚠ WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

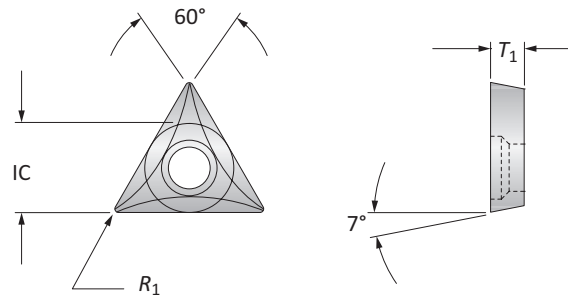
Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

Boring Inserts

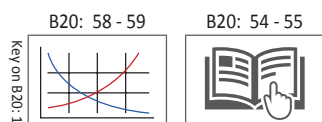
80° Diamond Insert | 60° Triangle Insert

**Coated 80° Diamond Inserts**

Insert Form		Insert			Part No.
		IC	T ₁	R ₁	
i	CC..325..	0.375	0.156	0.008	CCMT09T302
	CC..325..	0.375	0.156	0.016	CCMT09T304
	CC..325..	0.375	0.156	0.031	CCMT09T308
m	CC..09T3..	9.53	3.97	0.20	CCMT09T302
	CC..09T3..	9.53	3.97	0.40	CCMT09T304
	CC..09T3..	9.53	3.97	0.80	CCMT09T308

**Coated 60° Triangle Inserts**

Insert Form		Insert			Part No.
		IC	T ₁	R ₁	
i	TC..325..	0.375	0.156	0.016	TCGT16T304
m	TC..16T3..	9.53	3.97	0.40	TCGT16T304



i = Imperial (in)
m = Metric (mm)
 Inserts sold separately



NEED VERSATILITY? NO PROBLEM.

CB Style Versatile Boring

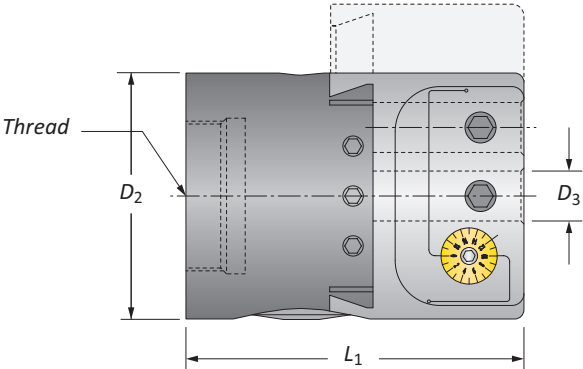
Wide range of diameters produced with
a single boring head

Allows for 0.001" adjustment on bore diameter and
0.000050" with CB2500BMA

Maximum toughness and maximum versatility

CB2500BMA Micro Adjusting Versatile Boring Head

Bore Diameter Range: 0.250" - 3.125"



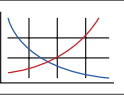
		Boring Head				
	Boring Range	Thread Connection	L ₁	D ₂	D ₃	Weight
i	0.250 - 3.125	1½ - 18	3.375	2.500	0.500	3.400 (lbs)
						Part No.
						CB2500BMA

IMPORTANT: Wax covered gib screws are factory set and should not be removed. Adjustment of these screws will cause performance issues.

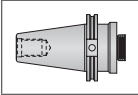
Imperial (in) = 0.00005" adjustment on diameter

NOTE: Max spindle speed: 2,000 RPM at 0 radial offset

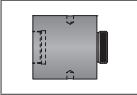
B20: 58 - 59



B20: 46 - 50



B20: 44 - 45



B20: 54 - 55



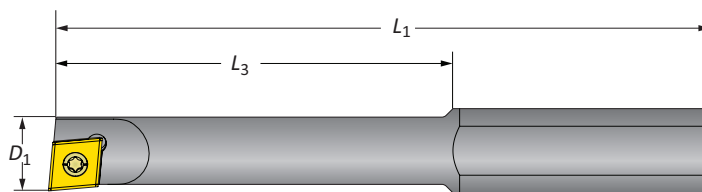
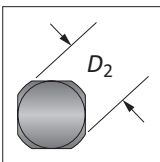
i = Imperial (in)
m = Metric (mm)

Inserts sold separately

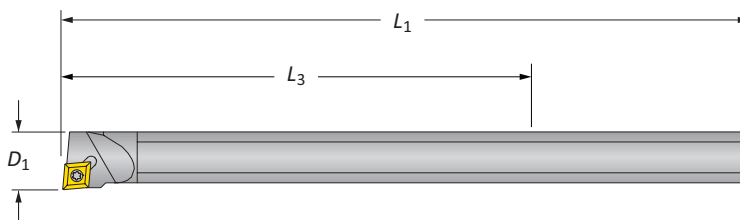
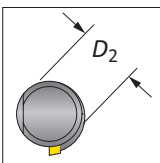
IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
ext: 7611 | email: appeng@alliedmachine.com

**Boring Bars**

Bore Diameter Range: 0.250" - 3.125"

**Steel Boring Bars | Bore Diameter Range: 0.250" - 3.125"**

	Min. Boring Diameter	Boring Bar			Weight	Insert Form	Part No.
	D_1	L_3	L_1	D_2			
i	0.250	1.062	2.500	0.500	0.080 (lbs)	WBGX0301..	0250B
	0.312	1.437	2.750	0.500	0.080 (lbs)	WBGX0301..	0312B
	0.375	1.750	3.062	0.500	0.100 (lbs)	WBGX0301..	0375B
	0.437	2.062	3.375	0.500	0.110 (lbs)	CC..215..	0437B
	0.500	2.187	3.500	0.500	0.140 (lbs)	CC..215..	0500B

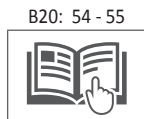
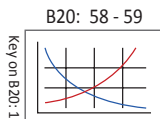
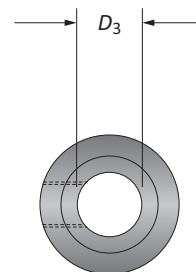
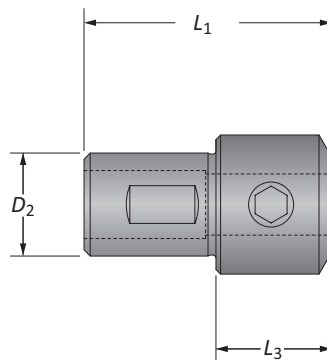
**Heavy Metal Boring Bars | Bore Diameter Range: 0.365" - 3.125"**

	Min. Boring Diameter	Boring Bar			Weight	Insert Form	Part No.
	D_1	L_3	L_1	D_2			
i	0.365	2.250	4.000	0.312*	0.080 (lbs)	CC..215..	0365HM
	0.550	3.250	6.000	0.500	0.300 (lbs)	CC..215..	0550BHM

*Reducing sleeve required

Reducing Sleeves

	Reducing Sleeve				Weight	Part No.
	D_3	D_2	L_1	L_3		
i	0.312	0.500	1.312	—	0.040 (lbs)	BTH-03120500
	0.375	0.500	1.312	—	0.030 (lbs)	BTH-03750500

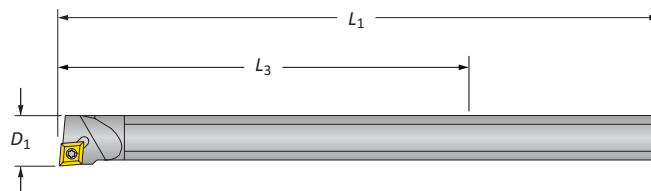
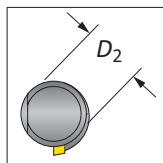


i = Imperial (in)
m = Metric (mm)



Boring Bar | Boring Inserts

Bore Diameter Range: 0.625" - 3.125"

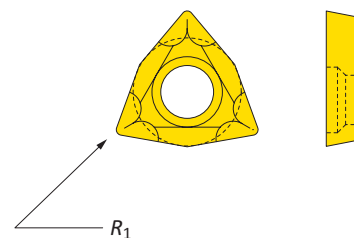


Carbide Boring Bar

Min. Boring Diameter	Boring Bar				Weight	Insert Form	Part No.
	D_1	L_3	L_1	D_2			
i	0.625	4.500	8.000	0.500	0.410 (lbs)	CC..215..	0625BCS

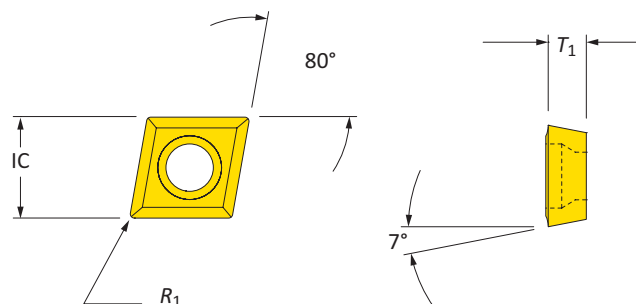
Coated Trigon Insert

Insert		Part No.
Insert Form	R_1	
i WBGX0301..	0.004	WBGX030101



Coated 80° Diamond Inserts

		Insert			
Insert Form		IC	T_1	R_1	Part No.
i	CC..215..	0.250	0.094	0.008	CCMT060202
	CC..215..	0.250	0.094	0.016	CCMT060204
	CC..215..	0.250	0.094	0.031	CCMT060208



A

DRILLING

B

BORING

C

REAMING

D

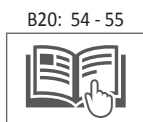
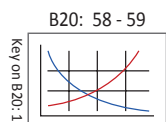
BURNISHING

E

THREADING

X

SPECIALS



i = Imperial (in)
m = Metric (mm)
 Inserts sold separately

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

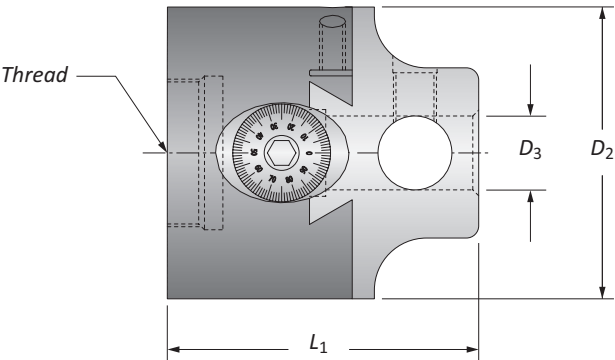
THREADING

X

SPECIALS

CB202B Versatile Boring Head

Bore Diameter Range: 0.250" - 6.687"



	Boring Range	Thread Connection	Boring Head			Weight	Part No.
			L_1	D_2	D_3		
i	0.250 - 6.687	$\frac{7}{8}$ - 20	2.435	2.000	0.500	1.600 (lbs)	CB202B

IMPORTANT: Wax covered gib screws are factory set and should not be removed. Adjustment of these screws will cause performance issues.

NOTICE: Cross hole bars should always be secured in the bar holder with at least two set screws

Imperial (in) = 0.001" adjustment on diameter

NOTE: Max spindle speed: 2,500 RPM at 0 radial offset

B20: 58 - 59

B20: 46 - 50

B20: 44 - 45

B20: 54 - 55

Key on B20: 1

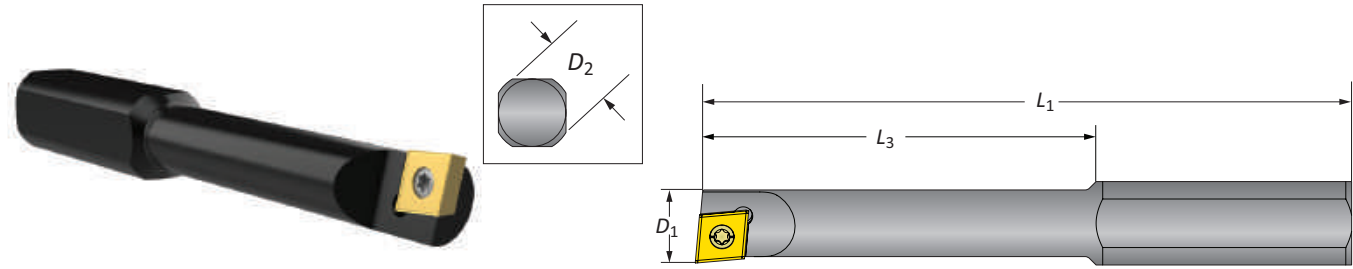
i = Imperial (in)
m = Metric (mm)

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 ext: **7611** | email: appeng@alliedmachine.com



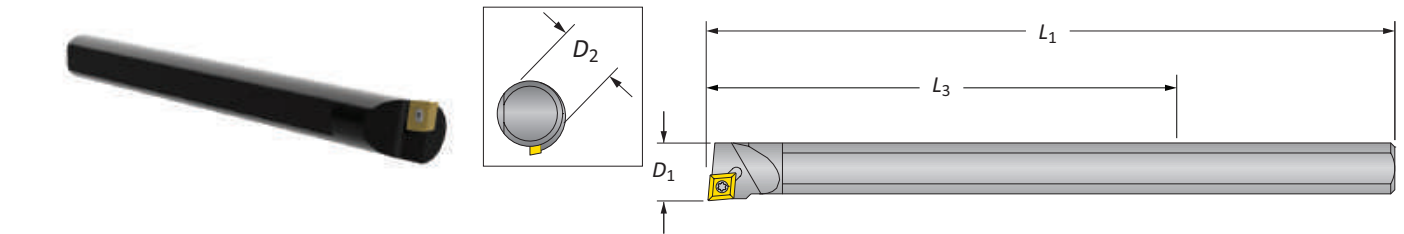
Boring Bars

Bore Diameter Range: 0.250" - 3.000"



Steel Boring Bars | Bore Diameter Range: 0.250" - 3.000"

i	Min. Boring Diameter	Boring Bar			Weight	Insert Form	Part No.
	D_1	L_3	L_1	D_2			
	0.250	1.062	2.500	0.500	0.080 (lbs)	WBGX0301..	0250B
	0.312	1.437	2.750	0.500	0.080 (lbs)	WBGX0301..	0312B
	0.375	1.750	3.062	0.500	0.100 (lbs)	WBGX0301..	0375B
	0.437	2.062	3.375	0.500	0.110 (lbs)	CC..215..	0437B
	0.500	2.187	3.500	0.500	0.140 (lbs)	CC..215..	0500B



Heavy Metal Boring Bars | Bore Diameter Range: 0.365" - 3.000"

i	Min. Boring Diameter	Boring Bar			Weight	Insert Form	Part No.
	D_1	L_3	L_1	D_2			
	0.365	2.250	4.000	0.312*	0.080 (lbs)	CC..215..	0365HM
	0.550	3.250	6.000	0.500	0.300 (lbs)	CC..215..	0550BHM

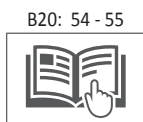
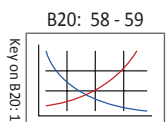
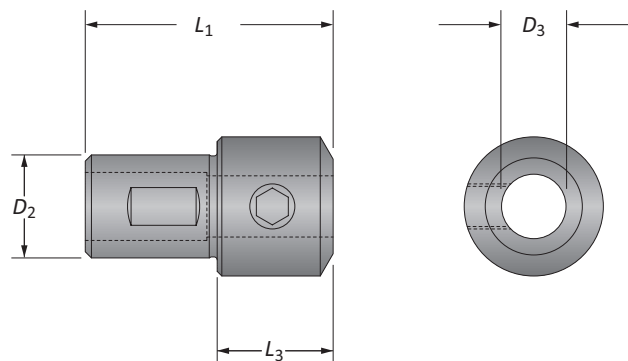
*Reducing sleeve required

Carbide Boring Bar | Bore Diameter Range: 0.625" - 3.000"

i	Min. Boring Diameter	Boring Bar			Weight	Insert Form	Part No.
	D_1	L_3	L_1	D_2			
	0.625	4.500	8.000	0.500	0.410 (lbs)	CC..215..	0625BCS

Reducing Sleeves

i	Reducing Sleeve				Weight	Part No.
	D_3	D_2	L_1	L_3		
	0.312	0.500	1.312	—	0.040 (lbs)	BTH-03120500
	0.375	0.500	1.312	—	0.030 (lbs)	BTH-03750500



i = Imperial (in)
m = Metric (mm)



A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

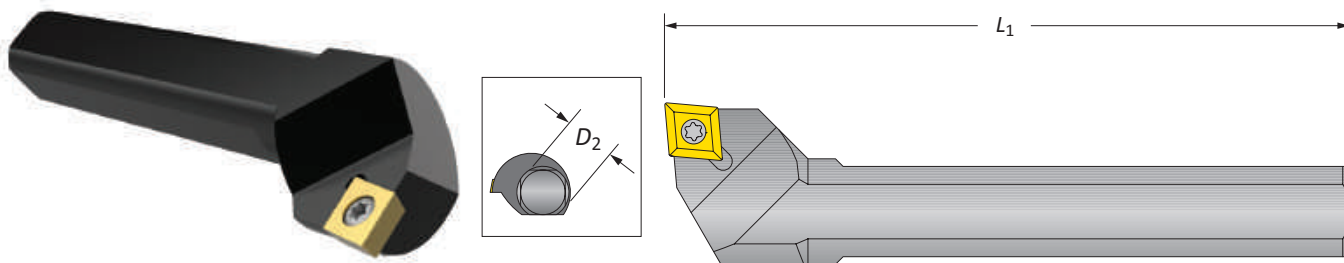
THREADING

X

SPECIALS

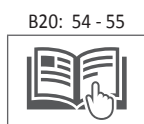
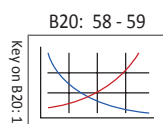
Boring Bar

Bore Diameter Range: 2.875" - 6.687"



	Boring Bar*		Weight	Insert Form	Part No.
	Min. Boring Diameter	L_1			
i	2.875	2.750	0.140 (lbs)	CC..215..	0500BCH

***NOTICE:** Cross hole bars should always be secured in the bar holder with at least two set screws



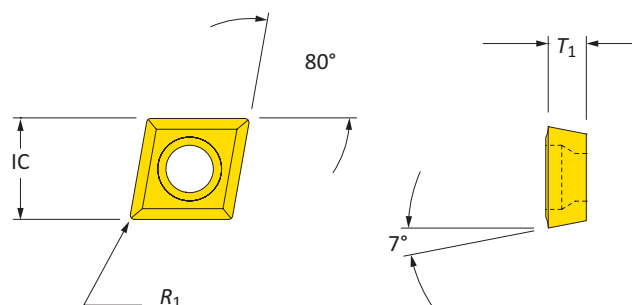
i = Imperial (in)
m = Metric (mm)

Inserts sold separately



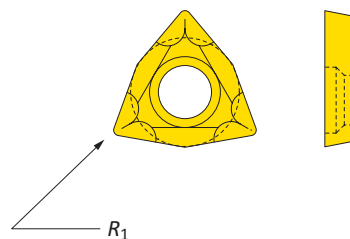
Boring Inserts

80° Diamond Insert | 60° Triangle Insert



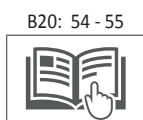
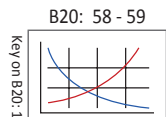
Coated 80° Diamond Inserts

	Insert Form	Insert			Part No.
		IC	T ₁	R ₁	
i	CC..215..	0.250	0.094	0.008	CCMT060202
	CC..215..	0.250	0.094	0.016	CCMT060204
	CC..215..	0.250	0.094	0.031	CCMT060208



Coated Trigon Insert

	Insert Form	Insert		Part No.
		R ₁		
i	WBGX0301..	0.004		WBGX030101



i = Imperial (in)
m = Metric (mm)
Inserts sold separately

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

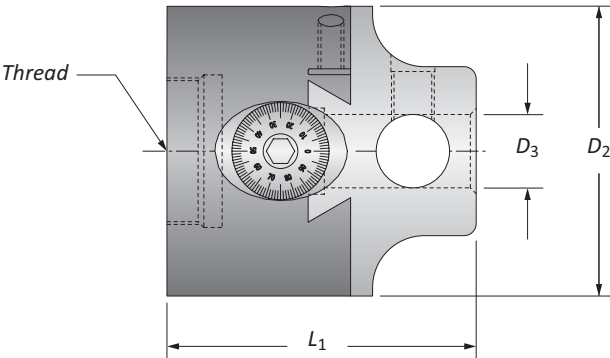
THREADING

X

SPECIALS

CB203D Versatile Boring Head

Bore Diameter Range: 0.250" - 11.000"



	Boring Range	Thread Connection	Boring Head			Weight	Part No.
			L_1	D_2	D_3		
i	0.250 - 11.000	1½ - 18	3.166	3.000	0.750	4.700 (lbs)	CB203D

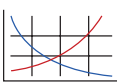
IMPORTANT: Wax covered gib screws are factory set and should not be removed. Adjustment of these screws will cause performance issues.

NOTICE: Cross hole bars should always be secured in the bar holder with at least two set screws

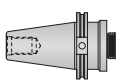
Imperial (in) = 0.001" adjustment on diameter

NOTE: Max spindle speed: 1,750 RPM at 0 radial offset

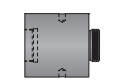
B20: 58 - 59



B20: 46 - 50



B20: 44 - 45



B20: 54 - 55



i = Imperial (in)
m = Metric (mm)
 Inserts sold separately

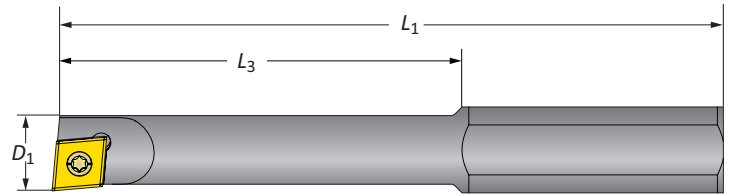
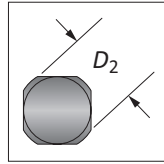
IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 ext: 7611 | email: appeng@alliedmachine.com

WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:
 - Refer to page B20: 57 to see formula for calculating weight of tool assembly.
 - Consult machine tool builder for machine's weight limitations.
 Factory technical assistance is also available for specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com



Boring Bars

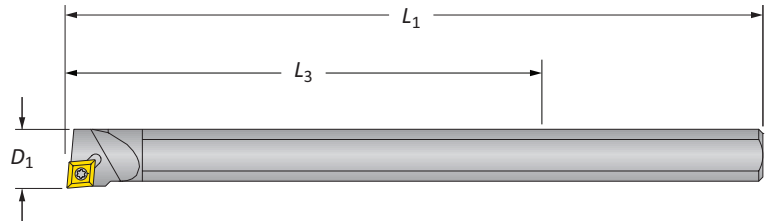
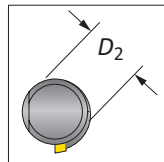
Bore Diameter Range: 0.250" - 5.125"



Steel Boring Bars | Bore Diameter Range: 0.250" - 5.125"

Min. Boring Diameter	Boring Bar				Weight	Insert Form	Part No.
	D_1	L_3	L_1	D_2			
i	0.250	1.062	2.500	0.500*	0.080 (lbs)	WBGX0301..	0250B
	0.312	1.437	2.570	0.500*	0.080 (lbs)	WBGX0301..	0312B
	0.375	1.750	3.062	0.500*	0.100 (lbs)	WBGX0301..	0375B
	0.437	2.062	3.375	0.500*	0.110 (lbs)	CC..215..	0437B
	0.500	2.500	4.250	0.750	0.280 (lbs)	CC..215..	0500D
	0.750	3.000	4.687	0.750	0.430 (lbs)	CC..325..	0750D
	1.000	3.500	5.125	0.750	0.570 (lbs)	CC..325..	1000D
	1.250	4.000	5.562	0.750	0.570 (lbs)	CC..325..	1250D

*Reducing sleeve required



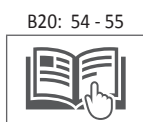
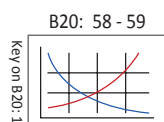
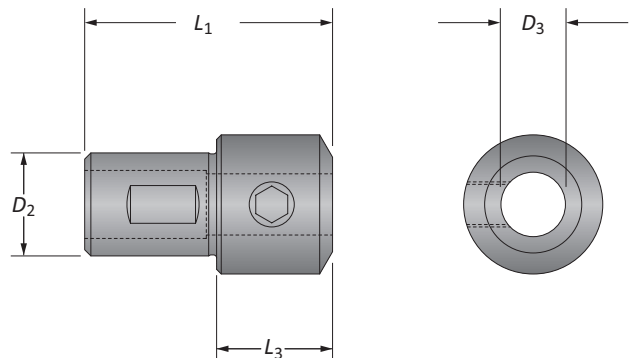
Heavy Metal Boring Bars | Bore Diameter Range: 0.425" - 4.250"

Min. Boring Diameter	Boring Bar				Weight	Insert Form	Part No.
	D_1	L_3	L_1	D_2			
i	0.425	2.250	4.000	0.375*	0.110 (lbs)	CC..215..	0425BHM
	0.550	3.250	6.000	0.500*	0.300 (lbs)	CC..215..	0550BHM
	0.688	4.250	8.000	0.625*	0.630 (lbs)	CC..325..	0688CHM
	0.832	4.750	10.000	0.750	1.150 (lbs)	CC..325..	0832DHM

*Reducing sleeve required

Reducing Sleeves

Reducing Sleeve				Weight	Part No.
D_3	D_2	L_1	L_3		
0.375	0.750	2.406	—	0.190 (lbs)	BTH-03750750
0.500	0.750	2.406	0.910	0.040 (lbs)	BTH-05000750
0.625	0.750	1.500	—	0.060 (lbs)	BTH-06250750



i = Imperial (in)
m = Metric (mm)
Inserts sold separately

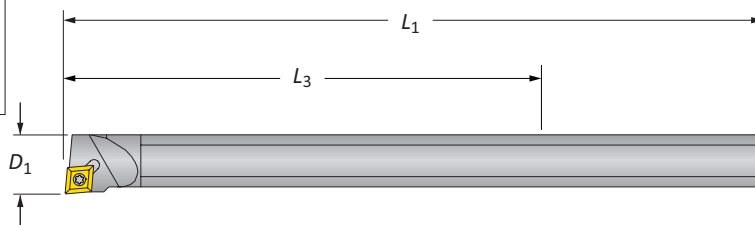
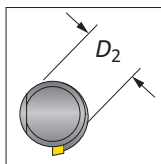


A

DRILLING

Carbide Boring Bars

Bore Diameter Range: 0.625" - 4.250"



B

BORING

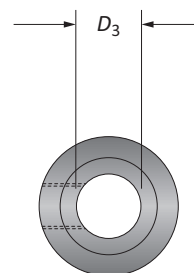
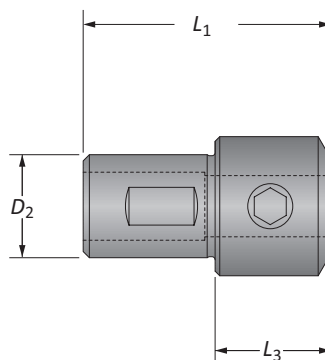
Carbide Boring Bars

Min. Boring Diameter		Boring Bar			Weight	Insert Form	Part No.
D_1	L_3	L_1	D_2				
i	0.625	4.500	8.000	0.500*	0.410 (lbs)	CC..215..	0625BCS
	0.875	6.000	10.000	0.750	1.130 (lbs)	CC..325..	0875DCS

*Reducing sleeve required

C

REAMING



D

BURNISHING

Reducing Sleeve

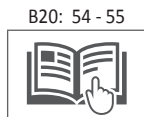
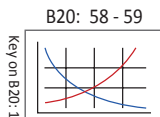
Reducing Sleeve					Weight	Part No.
D_3	D_2	L_1	L_3			
i	0.500	0.750	2.406	0.910	0.040 (lbs)	BTH-05000750

E

THREADING

X

SPECIALS

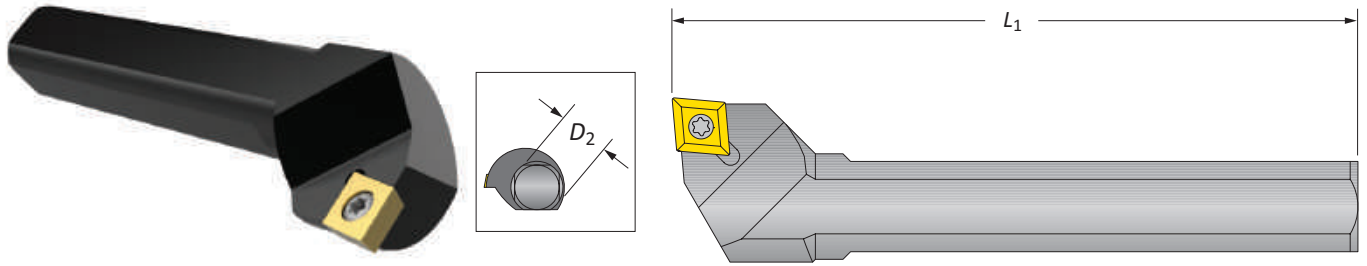


i = Imperial (in)
m = Metric (mm)

Inserts sold separately

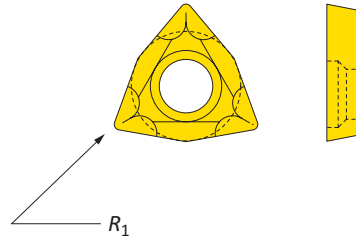
**Cross Hole Boring Bar | Boring Inserts**

Bore Diameter Range: 4.937" - 11.000"

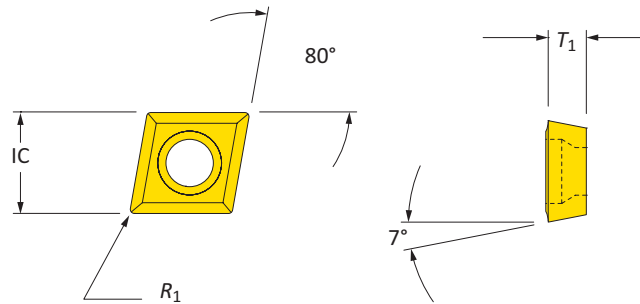
**Cross Hole Boring Bar**

		Boring Bar*				
		Min. Bore Diameter	L_1			
	4.937	4.750	0.750	0.550 (lbs)	CC..325..	0750DCH

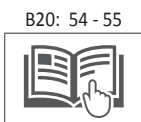
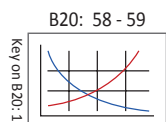
*NOTICE: Cross hole bars should always be secured in the bar holder with at least two set screws

**Coated Trigon Insert**

	Insert		Part No.
	Insert Form	R_1	
i	WBGX0301...	0.004	WBGX030101

**Coated 80° Diamond Inserts**

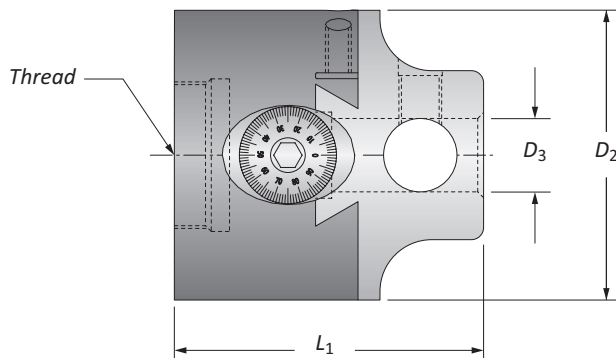
		Insert			
Insert Form		IC	T_1	R_1	Part No.
i	CC..215..	0.250	0.094	0.008	CCMT060202
	CC..215..	0.250	0.094	0.016	CCMT060204
	CC..215.	0.250	0.094	0.031	CCMT060208
	CC..325...	0.375	0.156	0.008	CCMT09T302
	CC..325..	0.375	0.156	0.016	CCMT09T304
	CC..325..	0.375	0.156	0.031	CCMT09T308

**i** = Imperial (in)
m = Metric (mm)

Inserts sold separately

CB204E Versatile Boring Head

Bore Diameter Range: 0.500" - 13.437"



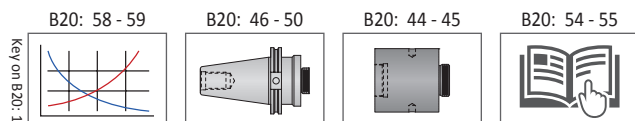
	Boring Range	Thread Connection	Boring Head			Weight	Part No.
			L_1	D_2	D_3		
i	0.500 - 13.437	1½ - 18	3.715	4.000	1.000	9.300 (lbs)	CB204E

IMPORTANT: Wax covered gib screws are factory set and should not be removed. Adjustment of these screws will cause performance issues.

NOTICE: Cross hole bars should always be secured in the bar holder with at least two set screws

Imperial (in) = 0.001" adjustment on diameter

NOTE: Max spindle speed: 800 RPM at 0 radial offset



i = Imperial (in)
m = Metric (mm)

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 ext: 7611 | email: appeng@alliedmachine.com

WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

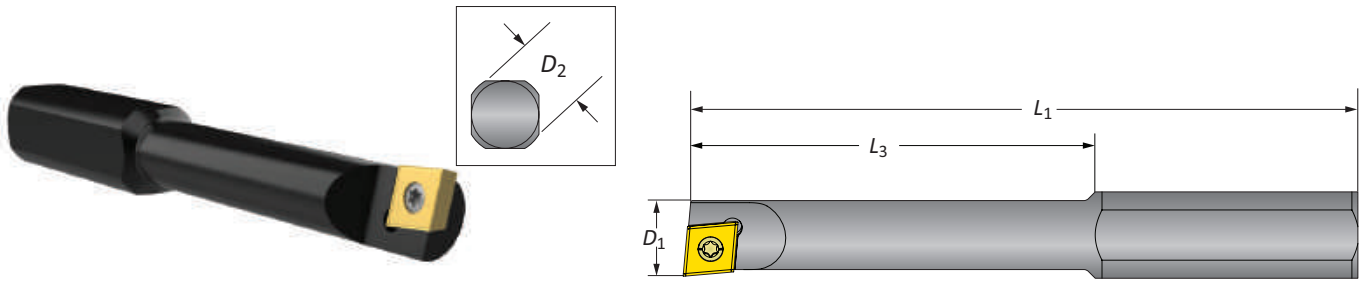
- Refer to page B20: 57 to see formula for calculating weight of tool assembly.
- Consult machine tool builder for machine's weight limitations.

Factory technical assistance is also available for specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com



Boring Bars

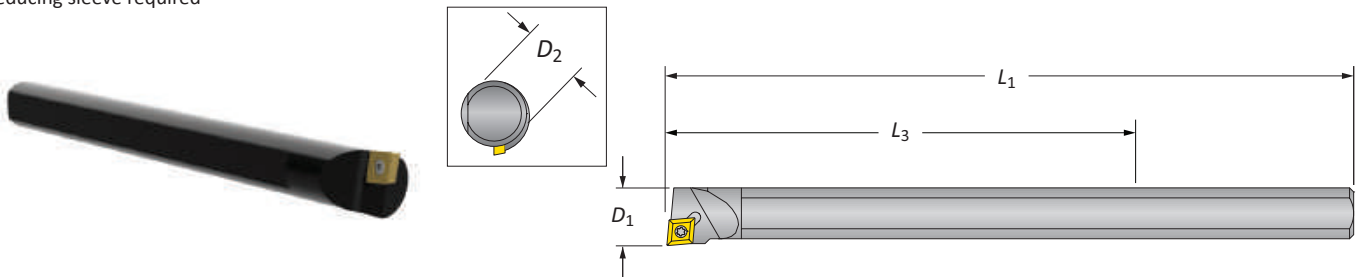
Bore Diameter Range: 0.500" - 5.750"



Steel Boring Bars | Bore Diameter Range: 0.500" - 5.750"

Min. Boring Diameter	Boring Bar			Weight	Insert Form	Part No.
D_1	L_3	L_1	D_2			
0.500	2.500	4.250	0.750*	0.280 (lbs)	CC..215..	0500D
0.750	3.000	4.687	0.750*	0.430 (lbs)	CC..325..	0750D
1.000	3.500	5.125	0.750*	0.510 (lbs)	CC..325..	1000D
1.250	4.000	5.562	0.750*	0.570 (lbs)	CC..325..	1250D

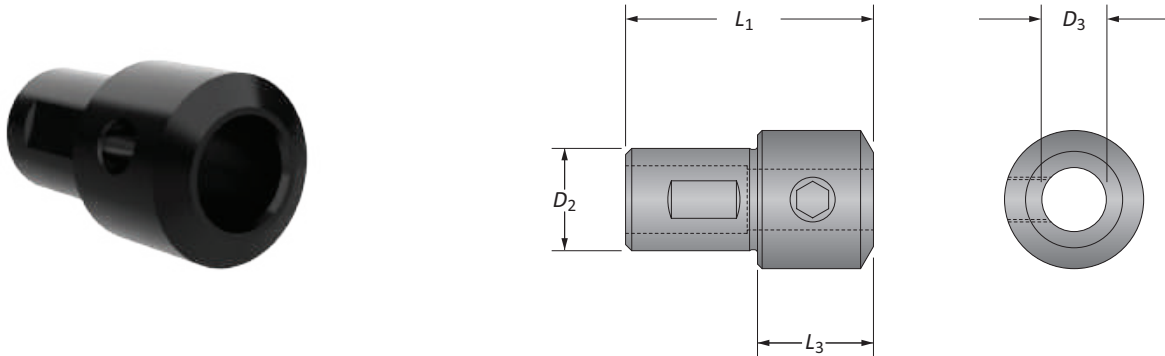
*Reducing sleeve required



Heavy Metal Boring Bar | Bore Diameter Range: 0.832" - 5.125"

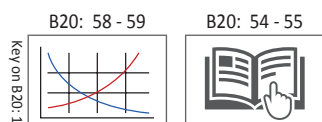
Min. Boring Diameter	Boring Bar			Weight	Insert Form	Part No.
D_1	L_3	L_1	D_2			
0.832	4.750	10.000	0.750*	1.150 (lbs)	CC..325..	0832DHM

*Reducing sleeve required



Reducing Sleeve

Reducing Sleeve				Weight	Part No.
D_3	D_2	L_1	L_3		
0.750	1.000	2.405	1.125	0.400 (lbs)	BTH-07501000



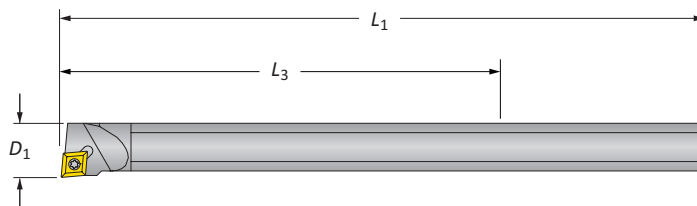
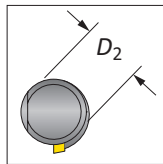
ⓘ = Imperial (in)
Ⓜ = Metric (mm)

Inserts sold separately



Boring Bars

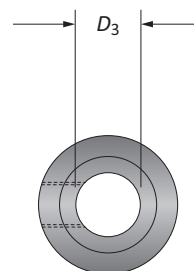
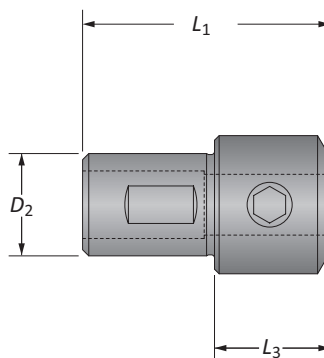
Bore Diameter Range: 0.875" - 5.125"



Carbide Boring Bar

Min. Boring Diameter	Boring Bar				Weight	Insert Form	Part No.
	D_1	L_3	L_1	D_2			
i	0.875	6.000	10.000	0.750*	1.130 (lbs)	CC..325..	0875DCS

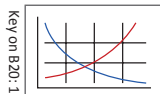
*Reducing sleeve required



Reducing Sleeve

	Reducing Sleeve				Weight	Part No.
	D_3	D_2	L_1	L_3		
i	0.750	1.000	2.405	1.125	0.400 (lbs)	BTH-07501000

B20: 58 - 59



B20: 54 - 55

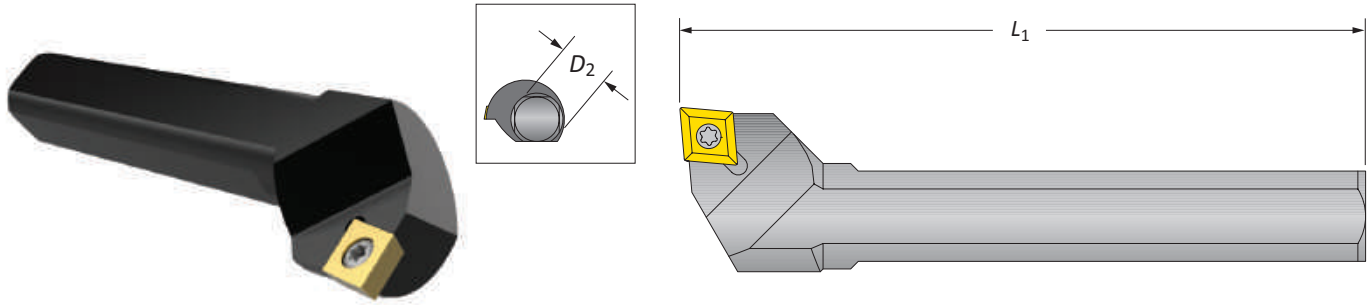


i = Imperial (in)
m = Metric (mm)

Inserts sold separately

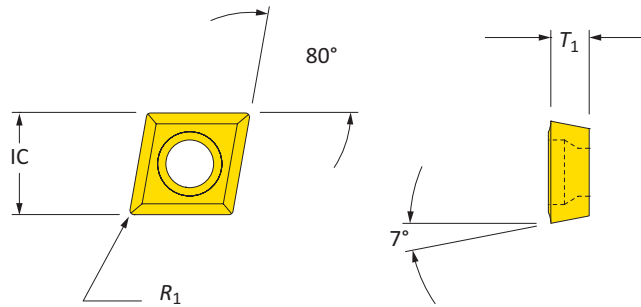
**Cross Hole Boring Bar | Boring Inserts**

Bore Diameter Range: 5.625" - 13.437"

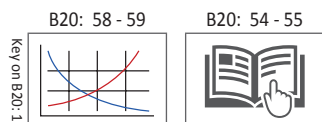
**Cross Hole Boring Bar**

		Boring Bar*				
		Min Boring Diameter	L_1			
	5.625	5.310	1.000	1.020 (lbs)	CC..325..	1000ECH

*NOTICE: Cross hole bars should always be secured in the bar holder with at least two set screws

**Coated 80° Diamond Inserts**

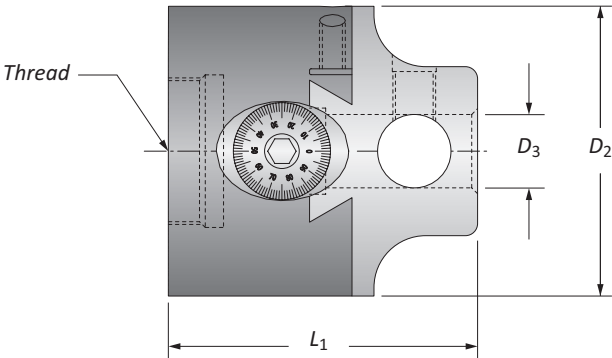
	Insert Form	Insert			Part No.
		IC	T_1	R_1	
i	CC..215..	0.250	0.094	0.008	CCMT060202
	CC..215..	0.250	0.094	0.016	CCMT060204
	CC..215..	0.250	0.094	0.031	CCMT060208
	CC..325..	0.375	0.156	0.008	CCMT09T302
	CC..325..	0.375	0.156	0.016	CCMT09T304
	CC..325..	0.375	0.156	0.031	CCMT09T308



i = Imperial (in)
m = Metric (mm)
 Inserts sold separately

CB206F Versatile Boring Head

Bore Diameter Range: 0.500" - 21.500"



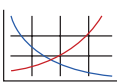
		Boring Head			Weight	Part No.
Boring Range	Thread Connection	L ₁	D ₂	D ₃		
i 0.500 - 21.500	2 ¼ - 10	5.475	6.000	1.500	26.400 (lbs)	CB206F

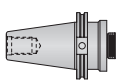
IMPORTANT: Wax covered gib screws are factory set and should not be removed. Adjustment of these screws will cause performance issues.

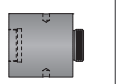
NOTICE: Cross hole bars should always be secured in the bar holder with at least two set screws

Imperial (in) = 0.001" adjustment on diameter

NOTE: Max spindle speed: 500 RPM at 0 radial offset

B20: 58 - 59
 

B20: 46 - 50
 

B20: 44 - 45
 

B20: 54 - 55
 

i = Imperial (in)
m = Metric (mm)

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.

ext: 7611 | email: appeng@alliedmachine.com

⚠ WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

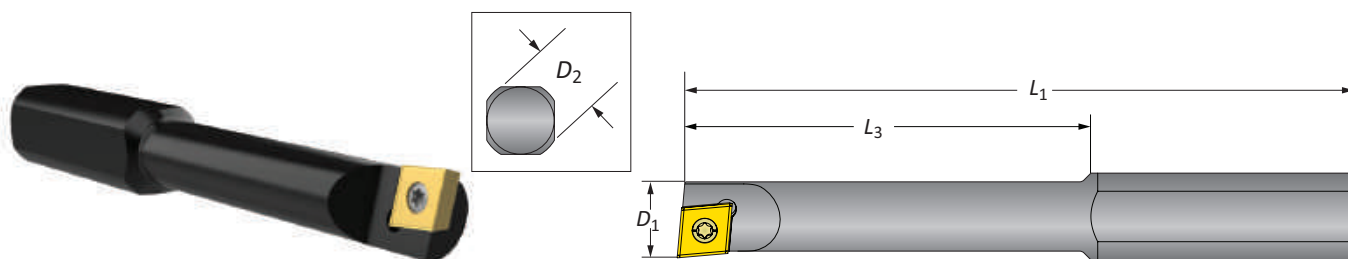
- Refer to page B20: 57 to see formula for calculating weight of tool assembly.
- Consult machine tool builder for machine's weight limitations.

Factory technical assistance is also available for specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com



Boring Bars

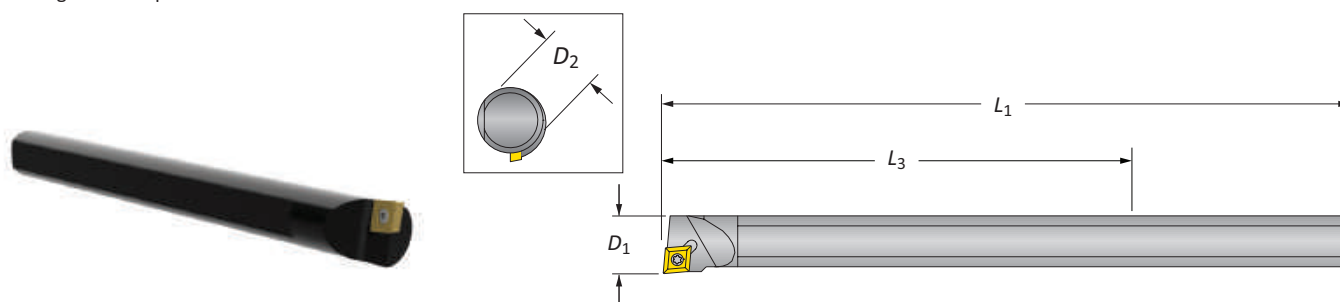
Bore Diameter Range: 0.500" - 9.125"



Steel Boring Bars | Bore Diameter Range: 0.500" - 9.125"

Min. Boring Diameter	Boring Bar					
D_1	L_3	L_1	D_2	Weight	Insert Form	Part No.
0.500	2.500	4.250	0.750*	0.280 (lbs)	CC..215..	0500D
0.750	3.000	4.687	0.750*	0.430 (lbs)	CC..325..	0750D
1.000	3.500	5.125	0.750*	0.510 (lbs)	CC..325..	1000D
1.250	4.000	5.562	0.750*	0.570 (lbs)	CC..325..	1250D

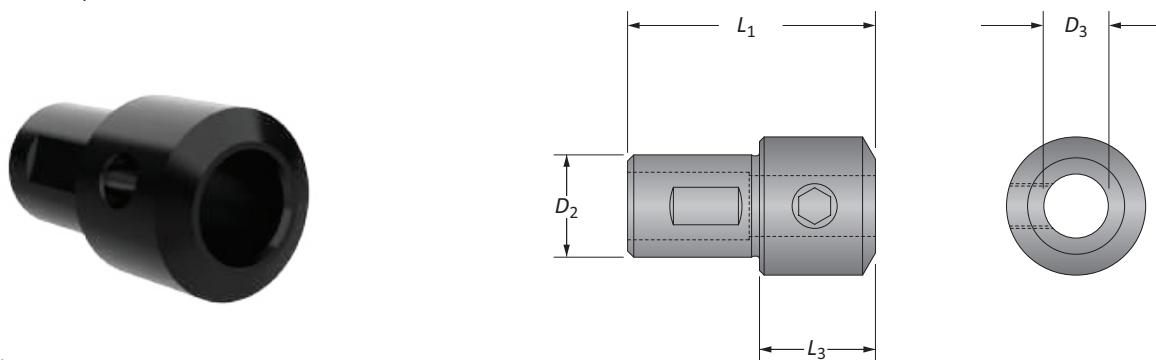
*Reducing sleeve required



Heavy Metal Boring Bar | Bore Diameter Range: 0.832" - 7.125"

Min. Boring Diameter	Boring Bar					
D_1	L_3	L_1	D_2	Weight	Insert Form	Part No.
0.832	4.750	10.000	0.750*	1.150 (lbs)	CC..325..	0832DHM

*Reducing sleeve required



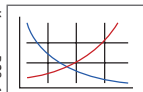
Reducing Sleeve

Reducing Sleeve					
D_3	D_2	L_1	L_3	Weight	Part No.
0.750	1.500	3.000	1.000	1.400 (lbs)	BTH-07501500

B20: 58 - 59

B20: 54 - 55

Key on B20: 1



① = Imperial (in)
Ⓜ = Metric (mm)

Inserts sold separately

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

THREADING

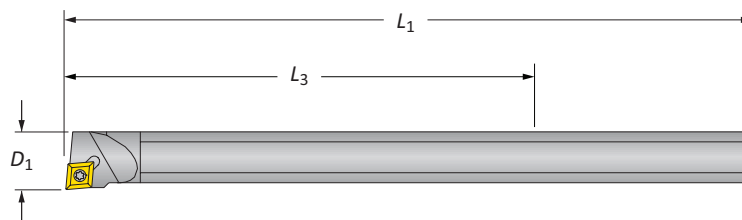
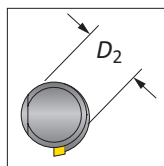
X

SPECIALS



Carbide Boring Bar

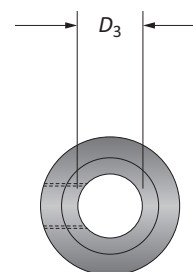
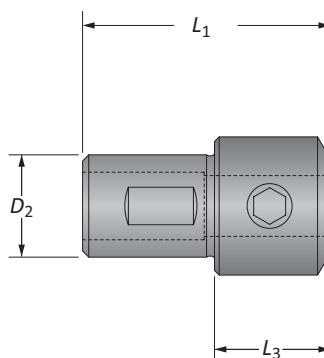
Bore Diameter Range: 0.875" - 7.125"



Carbide Boring Bar

Min. Boring Diameter	Boring Bar				Weight	Insert Form	Part No.
	D_1	L_3	L_1	D_2			
i	0.875	6.000	10.000	0.750*	1.130 (lbs)	CC..325..	0875DCS

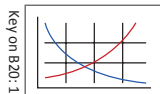
*Reducing sleeve required



Reducing Sleeve

Reducing Sleeve					Weight	Part No.
D_3	D_2	L_1	L_3			
i	0.750	1.500	3.000	1.000	1.400 (lbs)	BTH-07501500

B20: 58 - 59



B20: 54 - 55



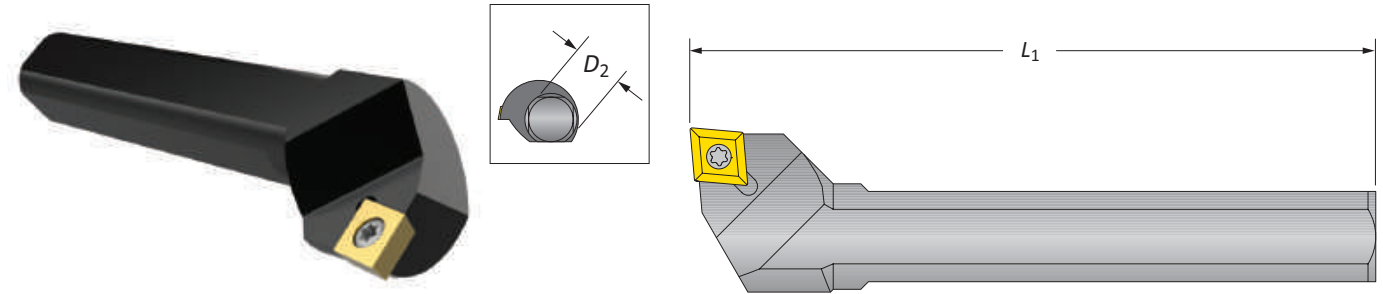
i = Imperial (in)
m = Metric (mm)

Inserts sold separately



Cross Hole Boring Bar | Boring Inserts

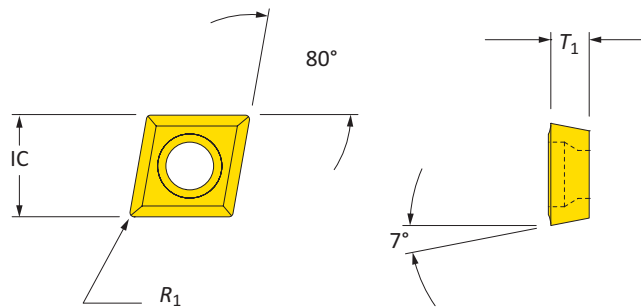
Bore Diameter Range: 9.093" - 21.500"



Cross Hole Boring Bar

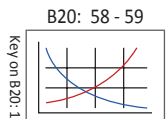
	Boring Bar*		Weight	Insert Form	Part No.
	Min. Boring Diameter				
i	9.093	L_1 9.125 D_2 1.500	4.130 (lbs)	CC..43..	1500FCH

*NOTICE: Cross hole bars should always be secured in the bar holder with at least two set screws

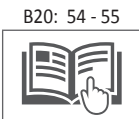


Coated 80° Diamond Inserts

	Insert Form	Insert			Part No.
		IC	T_1	R_1	
i	CC..215..	0.250	0.094	0.008	CCMT060202
	CC..215..	0.250	0.091	0.016	CCMT060204
	CC..215..	0.250	0.094	0.031	CCMT060208
	CC..325..	0.375	0.156	0.008	CCMT09T302
	CC..325..	0.375	0.156	0.016	CCMT09T304
	CC..325..	0.375	0.156	0.031	CCMT09T308
	CC..43..	0.500	0.188	0.031	CCMT120408



B20: 58 - 59

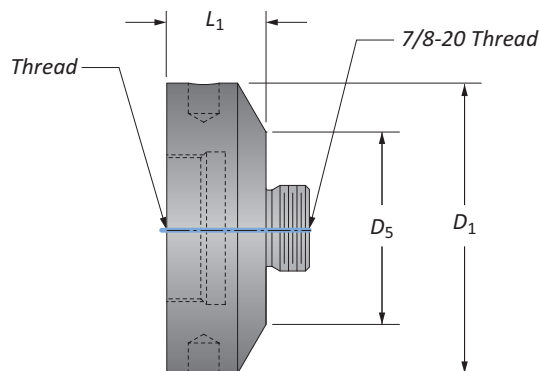


B20: 54 - 55

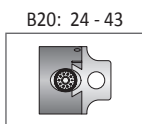
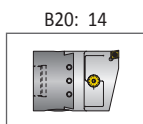
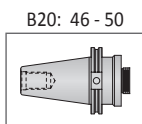
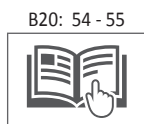
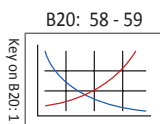
i = Imperial (in)
m = Metric (mm)
Inserts sold separately

Intermediate Modules

Reducers



Reducer						
D_1	D_5	L_1	Weight	Thread	Part No.	
i	1.500	1.000	1.000	0.440 (lbs)	$\frac{7}{8}$ - 20	CB1500-IRCB1000
	1.500	1.250	1.000	0.450 (lbs)	$\frac{7}{8}$ - 20	CB1500-IRCB1250
	2.000	1.000	1.000	0.720 (lbs)	$\frac{7}{8}$ - 20	CB2000-IRCB1000
	2.000	1.250	1.000	0.760 (lbs)	$\frac{7}{8}$ - 20	CB2000-IRCB1250
	2.000	1.500	1.000	0.800 (lbs)	$\frac{7}{8}$ - 20	CB2000-IRCB1500
	3.000	1.000	1.250	1.610 (lbs)	1½ - 18	CB3000-IRCB1000
	3.000	1.250	1.250	1.750 (lbs)	1½ - 18	CB3000-IRCB1250
	3.000	1.500	1.250	1.840 (lbs)	1½ - 18	CB3000-IRCB1500
3.000	2.000	1.250	2.020 (lbs)	1½ - 18	CB3000-IRCB2000	



i = Imperial (in)
 m = Metric (mm)

⚠ WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

- Refer to page B20: 57 to see formula for calculating weight of tool assembly.
- Consult machine tool builder for machine's weight limitations.

Factory technical assistance is also available for specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

⚠ WARNING Tool failure can cause serious injury. To prevent:

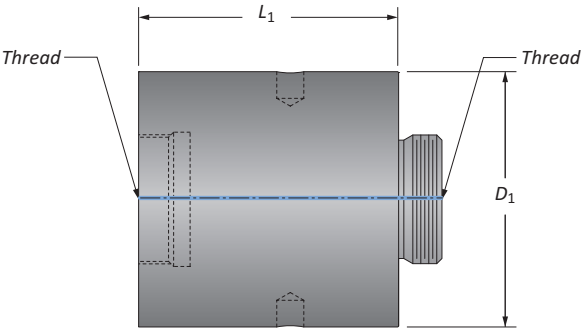
- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com



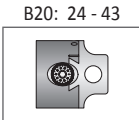
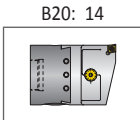
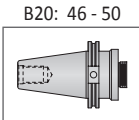
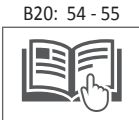
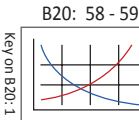
Intermediate Modules

Extensions



Extension				
D_1	L_1	Weight	Thread	Part No.
1.000	1.000	0.190 (lbs)	$\frac{1}{2}$ - 20	CB1000-IA1000
1.000	2.000	0.390 (lbs)	$\frac{1}{2}$ - 20	CB1000-IA2000
1.250	1.250	0.390 (lbs)	$\frac{1}{2}$ - 20	CB1250-IA1250
1.250	2.500	0.800 (lbs)	$\frac{1}{2}$ - 20	CB1250-IA2500
1.500	1.500	0.700 (lbs)	$\frac{1}{2}$ - 20	CB1500-IA1500
1.500	3.000	1.410 (lbs)	$\frac{1}{2}$ - 20	CB1500-IA3000
2.000	2.000	1.660 (lbs)	$\frac{1}{2}$ - 20	CB2000-IA2000
2.000	4.000	3.350 (lbs)	$\frac{1}{2}$ - 20	CB2000-IA4000
3.000	3.000	5.730 (lbs)	1½ - 18	CB3000-IA3000
3.000	6.000	11.500 (lbs)	1½ - 18	CB3000-IA6000

i



i = Imperial (in)
m = Metric (mm)

⚠ WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

- Refer to page B20: 57 to see formula for calculating weight of tool assembly.
- Consult machine tool builder for machine's weight limitations.

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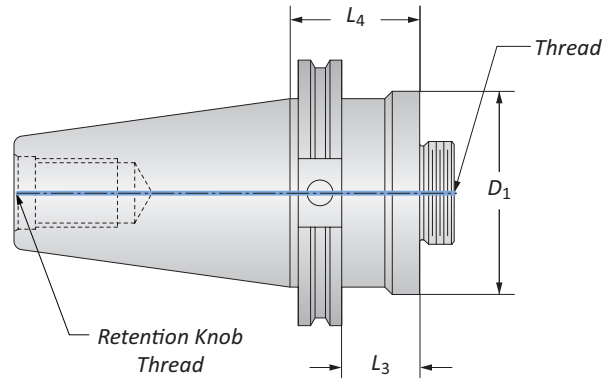
⚠ WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

Criterion Master Shanks

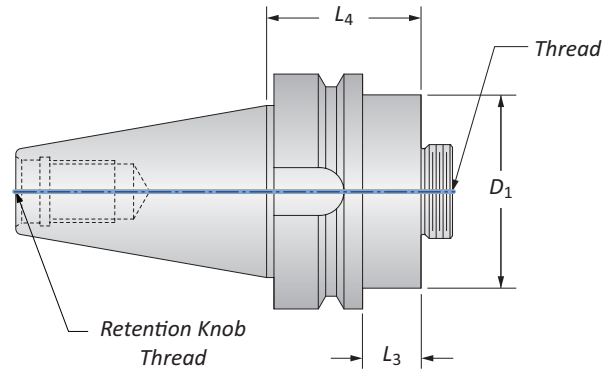
CAT 40/50 | BT Flange



CAT 40/50 Shanks

Style	D_1	L_3	L_4	Shank			Retention Knob Thread	Part No.
				Weight	Thread			
CAT40	1.500	0.370	1.770	2.490 (lbs)	$\frac{3}{8}$ - 20		$\frac{3}{8}$ - 11	CB1500-CV40
CAT40	2.000	1.130	1.880	2.700 (lbs)	$\frac{3}{8}$ - 20		$\frac{3}{8}$ - 11	CB2000-CV40
CAT40	2.500	1.130	1.880	3.120 (lbs)	1½ - 18		$\frac{3}{8}$ - 11	CB2500-CV40
CAT40	3.000	1.180	1.880	3.410 (lbs)	1½ - 18		$\frac{3}{8}$ - 11	CB3000-CV40
i CAT50	1.500	0.370	1.770	7.120 (lbs)	$\frac{3}{8}$ - 20		1 - 8	CB1500-CV50
CAT50	2.000	1.130	1.880	7.330 (lbs)	$\frac{3}{8}$ - 20		1 - 8	CB2000-CV50
CAT50	2.500	1.130	1.880	7.740 (lbs)	1½ - 18		1 - 8	CB2500-CV50
CAT50	3.000	1.130	1.880	8.030 (lbs)	1½ - 18		1 - 8	CB3000-CV50
CAT50	3.380	1.380	2.130	9.440 (lbs)	2¼ - 10		1 - 8	CB6000-CV50

NOTE: Taper ground to AT3 tolerance



BT Flange Shanks

Style	D_1	L_3	L_4	Shank			Retention Knob Thread	Part No.
				Weight	Thread			
BT30	1.500	0.900	1.770	1.360 (lbs)	$\frac{3}{8}$ - 20		M12 x 1.75	CB1500-BT30
BT40	1.500	0.710	1.770	2.540 (lbs)	$\frac{3}{8}$ - 20		M16 x 2	CB1500-BT40
BT40	2.000	0.500	1.560	2.620 (lbs)	$\frac{3}{8}$ - 20		M16 x 2	CB2000-BT40
BT40	2.500	0.870	2.060	3.690 (lbs)	1½ - 18		M16 x 2	CB2500-BT40
i BT40	3.000	1.000	2.060	3.980 (lbs)	1½ - 18		M16 x 2	CB3000-BT40
BT50	1.500	0.270	1.770	8.220 (lbs)	$\frac{3}{8}$ - 20		M24 x 3	CB1500-BT50
BT50	2.000	0.060	1.560	8.250 (lbs)	$\frac{3}{8}$ - 20		M24 x 3	CB2000-BT50
BT50	3.000	0.500	2.060	9.410 (lbs)	1½ - 18		M24 x 3	CB3000-BT50
BT50	3.380	0.630	2.130	10.500 (lbs)	2¼ - 10		M24 x 3	CB6000-BT50

NOTE: Taper ground to AT3 tolerance

⚠ WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

- Refer to page B20: 57 to see formula for calculating weight of tool assembly.
- Consult machine tool builder for machine's weight limitations.

Factory technical assistance is also available for specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

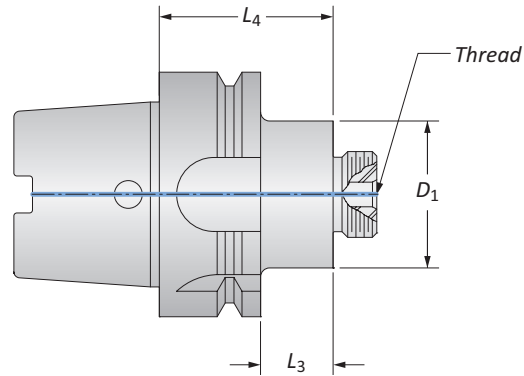
⚠ WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

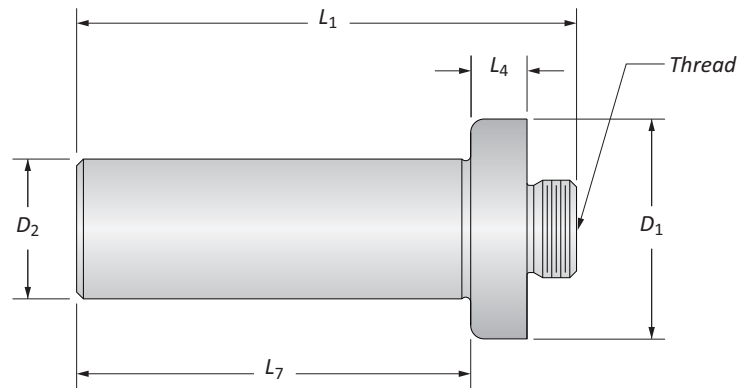
Criterion Master Shanks

HSK | Straight Shank



HSK Shanks

			Shank				
Style		D_1	L_3	L_4	Weight	Thread	Part No.
i	HSK63	1.500	0.730	1.750	1.820 (lbs)	$\frac{7}{8}$ - 20	CB1500-HSK63A
	HSK63	2.000	0.730	1.750	2.090 (lbs)	$\frac{7}{8}$ - 20	CB2000-HSK63A
	HSK63	3.000	0.500	2.150	3.200 (lbs)	1½ - 18	CB3000-HSK63A
	HSK100	1.500	0.500	2.270	6.300 (lbs)	$\frac{7}{8}$ - 20	CB1500-HSK100A
	HSK100	2.000	0.500	2.270	6.470 (lbs)	$\frac{7}{8}$ - 20	CB2000-HSK100A
	HSK100	3.000	0.500	2.270	7.180 (lbs)	1½ - 18	CB3000-HSK100A



Straight Shanks

		Shank				Thread	Part No.
D_1	D_2	L_4	L_7	L_1	Weight		
i	1.110	0.500	0.250	2.000	2.690	$\frac{7}{8}$ - 20	SS0500-087520
	1.110	0.625	0.250	2.370	3.060	$\frac{7}{8}$ - 20	SS0625-087520
	1.110	0.750	0.250	2.750	3.440	$\frac{7}{8}$ - 20	SS0750-087520
	1.110	1.000	0.250	3.120	3.810	$\frac{7}{8}$ - 20	SS1000-087520
	1.860	0.750	0.250	3.120	3.870	$1\frac{1}{2}$ - 18	SS0750-150018
	1.860	1.000	0.250	3.120	3.870	$1\frac{1}{2}$ - 18	SS1000-150018
	1.860	1.250	0.250	3.880	4.630	$1\frac{1}{2}$ - 18	SS1250-150018
	1.860	1.500	0.250	4.630	5.380	$1\frac{1}{2}$ - 18	SS1500-150018
	2.000	2.000	—	6.380	6.880	$1\frac{1}{2}$ - 18	SS2000-150018

WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

- Refer to page B20: 57 to see formula for calculating weight of tool assembly.
- Consult machine tool builder for machine's weight limitations.

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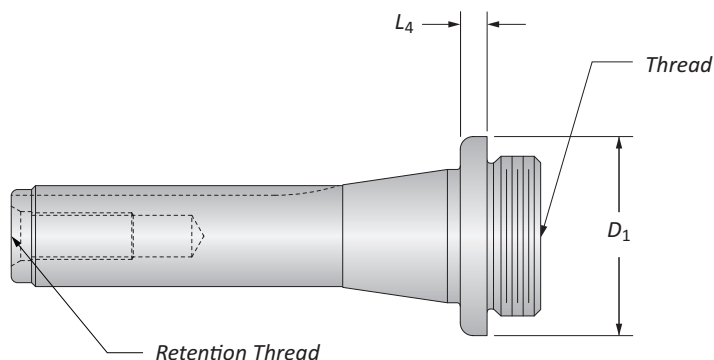
WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

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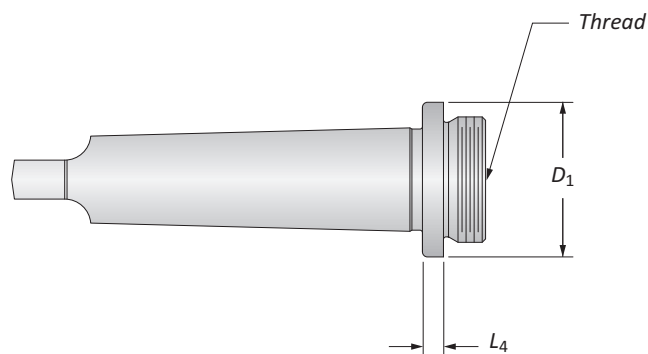
Criterion Shanks

R-8 | Morse Taper



R-8 Shanks

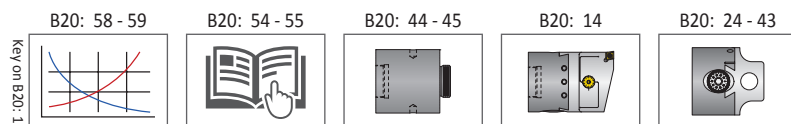
	Shank					Part No.
	D_1	L_4	Weight	Thread	Retention Thread	
i	1.110	0.470	0.990 (lbs)	$\frac{7}{8}$ - 20	$\frac{7}{16}$ - 20	R8-087520
	1.860	0.370	1.270 (lbs)	1- $\frac{1}{2}$ - 18	$\frac{7}{16}$ - 20	R8-150018



Morse Taper Shanks

	Style	Shank				Part No.
		D_1	L_4	Weight	Thread	
i	2 Taper	1.110	0.250	0.380 (lbs)	$\frac{7}{8}$ - 20	MT2-375THD87520*
	2 Taper	1.110	0.250	0.390 (lbs)	$\frac{7}{8}$ - 20	MT2-087520
	3 Taper	1.110	0.250	0.710 (lbs)	$\frac{7}{8}$ - 20	MT3-087520
	3 Taper	1.860	0.250	1.000 (lbs)	1 $\frac{1}{2}$ - 18	MT3-150018
	4 Taper	1.230	0.250	1.350 (lbs)	$\frac{7}{8}$ - 20	MT4-087520
	4 Taper	1.860	0.250	1.700 (lbs)	1 $\frac{1}{2}$ - 18	MT4-150018
	5 Taper	1.860	0.250	3.770 (lbs)	1 $\frac{1}{2}$ - 18	MT5-150018

*Item features a $\frac{3}{4}$ - 16 thread instead of tang



i = Imperial (in)
m = Metric (mm)

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- Refer to page B20: 57 to see formula for calculating weight of tool assembly.
- Consult machine tool builder for machine's weight limitations.

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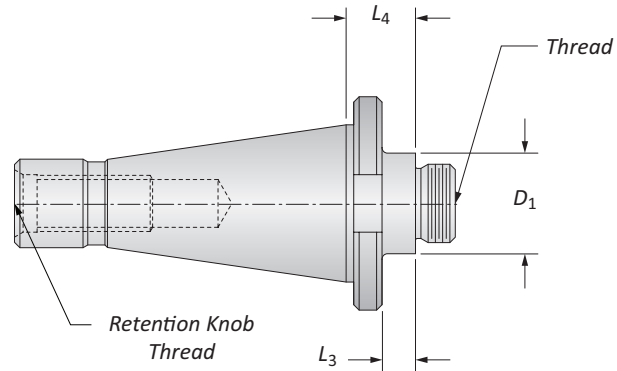
WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

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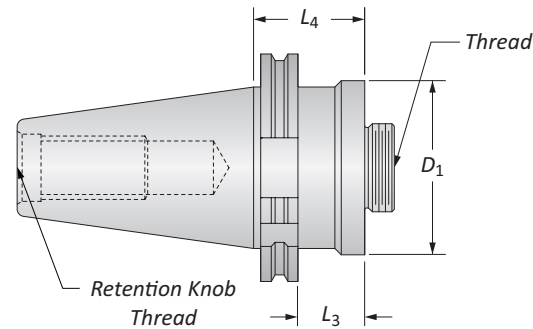
Criterion Master Shanks

NMTB Taper | DIN69871A



NMTB Taper Shanks

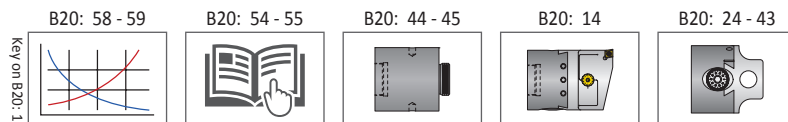
	Style	D_1	L_3	L_4	Shank			Part No.
					Weight	Thread	Retention Thread	
i	NMTB 30	1.120	0.370	0.790	0.810 (lbs)	$\frac{7}{8}$ - 20	$\frac{1}{2}$ - 13	NMTB30-087520
	NMTB 30	1.850	0.630	1.050	1.190 (lbs)	$1\frac{1}{2}$ - 18	$\frac{1}{2}$ - 13	NMTB30-150018
	NMTB 40	1.120	0.370	0.770	1.780 (lbs)	$\frac{7}{8}$ - 20	$\frac{5}{8}$ - 11	NMTB40-087520
	NMTB 40	1.850	0.630	1.020	2.310 (lbs)	$1\frac{1}{2}$ - 18	$\frac{5}{8}$ - 11	NMTB40-150018
	NMTB 50	1.970	0.510	1.250	6.750 (lbs)	$\frac{7}{8}$ - 20	1 - 8	NMTB50-087520
	NMTB 50	1.870	0.400	1.210	6.870 (lbs)	$1\frac{1}{2}$ - 18	1 - 8	NMTB50-150018
	NMTB 50	3.380	0.500	1.250	8.320 (lbs)	$2\frac{1}{4}$ - 10	1 - 8	NMTB50-225010



DIN 69871A

	D_1	L_3	L_4	Shank			Part No.
				Weight	Thread	Retention Thread	
m	38.00	19.00	38.40	1.18 (kg)	$\frac{7}{8}$ - 20	M16 x 2.0	CB038M-DIN40
	50.00	22.00	41.50	1.18 (kg)	$\frac{7}{8}$ - 20	M16 x 2.0	CB050M-DIN40
	76.00	45.00	48.00	1.68 (kg)	$1\frac{1}{2}$ - 18	M16 x 2.0	CB076M-DIN40
	38.00	19.00	38.40	3.36 (kg)	$\frac{7}{8}$ - 20	M24 x 3.0	CB038M-DIN50
	50.00	22.00	41.50	3.45 (kg)	$\frac{7}{8}$ - 20	M24 x 3.0	CB050M-DIN50
	76.00	22.00	48.00	3.66 (kg)	$1\frac{1}{2}$ - 18	M24 x 3.0	CB076M-DIN50

NOTE: Taper ground to AT3 tolerance



i = Imperial (in)
m = Metric (mm)

WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

- Refer to page B20: 57 to see formula for calculating weight of tool assembly.
- Consult machine tool builder for machine's weight limitations.

Factory technical assistance is also available for specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

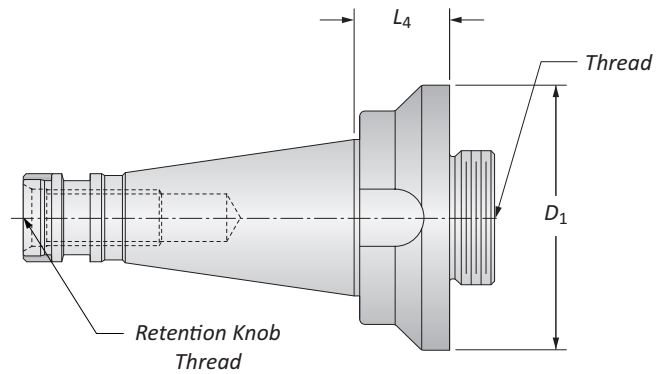
WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

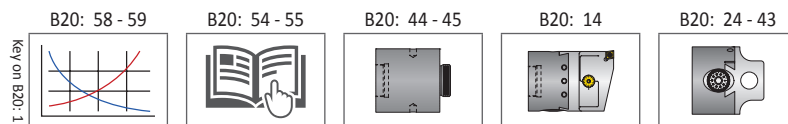
Criterion Shanks

DIN 2080



DIN 2080

		Shank					Part No.
	D_1	L_3	L_4	Weight	Thread	Retention Thread	
m	50.00	17.00	25.70	0.45 (kg)	$\frac{3}{8}$ - 20	M12	CB050M-ISO30
	50.00	11.00	27.70	0.91 (kg)	$\frac{3}{8}$ - 20	M16	CB050M-ISO40
	76.00	22.00	27.70	1.32 (kg)	1½ - 18	M16	CB076M-ISO40
	50.00	11.00	39.40	2.88 (kg)	$\frac{3}{4}$ - 20	M24	CB038M-ISO50
	76.00	36.00	39.40	3.36 (kg)	1½ - 18	M24	CB076M-ISO50



i = Imperial (in)
m = Metric (mm)

WARNING Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

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- Consult machine tool builder for machine's weight limitations.

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- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

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Criterion Accessories

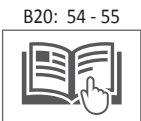
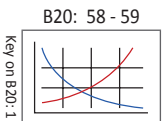
Insert Screws | Drivers | Pin Spanner Wrenches

Insert Screws & Drivers

 Insert Form	 Part No.	 Thread	 Part No.	Technical Information	
				Torque Specs	Key Size
WBGX0301..	215377	M2x4	115537	0.6 (Nm)	T6
CC..215.. CC..0602..	115676	M2.5x5	115590	1.2 (Nm)	T8
CC..32500 CC..09T3 (<Ø37mm)	115672	M3.5x7.5	115664	3.0 (Nm)	T15
CC..32500 CC..09T3 (<Ø36mm)	115673	M3.5x9	115664	3.0 (Nm)	T15
CC..43.. CC..1204..	215149	M4.5x11.5	215150	5.0 (Nm)	T20
TC..215.. TC..1102..	115676	M2.5x5	115590	1.2 (Nm)	T8
TC..325.. TC..16T3	115673	M3.5x9	115664	3.0 (Nm)	T15

Pin Spanner Wrenches

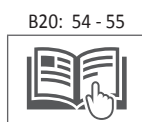
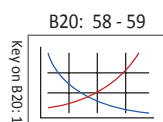
 Body Diameter	Pin Spanner Wrench Part No.
1.000" (25.00mm)	CB1000-PSW
1.250" (32.00mm)	CB1250-PSW
1.500" (38.00mm)	CB1500-PSW
2.000" (38.00mm)	CB2000-PSW
2.500" (63.50mm)	CB2500-PSW
3.000" (76.00mm)	CB3000-PSW
4.000" (101.00mm)	CB4000-PSW





Criterion Hardware Kits

Corresponding Boring Head Item Number	Hardware Kit Part No.
CBR-0625CP, CBR-0628TP, CBR-0625SG, CBS-0625CP, CBS-0625TP, CBS-0625SG, CBER16S-SG, CBER16-SG, CBER20S-SG, CBER20-SG, CBER16MS-CP, CBER16M-CP, CBER16MS-TP, CBER16M-TP, CBER20MS-CP, CBER20M-CP, CBER20MS-TP, CBER20M-TP, CBER16S-CP, CBER16-CP, CBER16S-TP, CBER16-TP, CBER20S-CP, CBER20-CP, CBER20S-TP, CBER20-TP	CB0625-HDW
CBS-0750CP, CBS-0750TP, CBS-0750SH, CBR-0750CP, CBR-0750TP, CBR-0750SH, CBER25S-SH, CBER25-SH, CBER25S-CP, CBER25-CP, CBER25S-TP, CBER25-TP, CBER25-TP, CBER25MS-CP, CBER25M-CP, CBER25MS-TP	CB0750-HDW
TMT-0750H, TMT-1000H	TMT0750-HDW
CB1000CC, CB1000TC CBS-1000CP, CBS-1000TP, CBS-1000CPMA, CBS-1000TPMA, CBS-1000SA, CBR-1000CP, CBR-1000TP, CBR-1000CPMA, CBR-1000TPMA, CBR-1000SA, CBER32S-CPMA, CBER32-CPMA, CBER32S-TPMA, CBER32-TPMA, CBER32MS-CPMA, CBER32M-CPMA, CBER32MS-TPMA, CBER32M-TPMA, CBER32S-SA, CBER32-SA, CBER32S-CP, CBER32-CP, CBER32S-TP, CBER32-TP, CBER32MS-CP, CBER32M-CP, CBER32MS-TP, CBER32M-TP, CB1000-TPMA, CB1000-CPMA, CB1000-TP, CB1000-CP	CB1000-HDW
CT1000-0, CT1000-1, CT1000-2	CT1000-HDW
CB025MCC, CB025MTC, CB025M-TPMA, CB025M-CPMA, CB025M-TP, CB025M-CP	CB025M-HDW
CT025M-0, CT025M-1, CT025M-2	CT025M-HDW
CBS1250B, CB1250CC, CB1250TC, CBS-1250CP, CBS-1250TP, CBS-1250CPMA, CBS-1250TPMA, CBS-1250SB, CBR-1250CP, CBR-1250TP, CBR-1250CPMA, CBR-1250TPMA, CBR-1250SB, CBER40S-CPMA, CBER40-CPMA, CBER40S-TPMA, CBER40-TPMA, CBER40S-CPMA, CBER40M-CPMA, CBER40MS-TPMA, CBER40M-TPMA, CBER40S-SB, CBER40-SB, CBER40S-CP, CBER40-CP, CBER40S-TP, CBER40-TP, CBER40MS-CP, CBER40M-CP, CBER40MS-TP, CBER40M-TP, CB1250-TPMA, CB1250-CPMA, CB1250-TP, CB1250-CP	CB1250-HDW
CT1250-0, CT1250-1, CT1250-2	CT1250-HDW
CB032MCC, CB032MTC, CB032M-TPMA, CB032M-CPMA, CB032M-TP, CBO32M-CP	CB032M-HDW
CT032M-0, CT032M-1, CT032M-2	CT032M-HDW
MBS0500B, CB1500CC, CB1500TC, MB002-500, MB002-625, MB002-750, MB152-500, MB152-625, MB152-750, CB-2375A, CB-1500B, CB-1500AMA, CB1500-TPMA, CB1500-CPMA, CB1500-TP, CB1500-CP	CB1500-HDW
CT1500-0, CT1500-1, CT1500-2	CT1500-HDW
SQ-1500B	S1500-HDW
CB038MCC, CB038MTC, CB-038MA, CB-038MB, CB038M-TPMA, CB038M-CPMA, CB038M-TP, CB038M-CP	CB038-HDW
CT038M-0, CT038M-1, CT038-2	CT038M-HDW
SQ-2000B	S2000-HDW
CB2000CC, CB2000TC, CB202B, CB2500BMA	CB2000-HDW
CSL-202, CB-202A, CB-202B, CB-2500BMA, CB2000-TPMA, CB2000-CPMA, CB050M-TP, CB050M-CP	CB2000-HDW
CT2000-0, CT2000-1, CT2000-2	CT2000-HDW
CB050MCC, CB050MTC, CB-050MA, CB-050MB, CB-064MBMA, CB050M-TPMA, CB050M-TPMA, CB050M-TPMA, CB050M-CPMA, CB050M-TP, CP050M-CP	CB050M-HDW
CT050M-0, CT050M-1, CT050M-2	CT050M-HDW
SQ-3000D, SQ-3000E	S3000-HDW
CB3000CC, CB3000TC, CB203D, CSL-203, CB-203D, CB-3000DMA, CB3000-TPMA, CB3000-CPMA, CB3000-TP, CB3000-CP	CB3000-HDW
CT3000-0, CT3000-1, CT3000-2	CT3000-HDW
CB076MCC, CB076MTC, CB-076MD, CB-076MDMA, CB076M-TPMA, CB076M-CPMA, CBO76M-TP, CB076M-CP	CB076M-HDW
CT076M-0, CT076M-1, CT076M-2	CT076M-HDW
CB204E, CSL-204, CB-204E, CB4000-TP, CB4000-TP, CB4000-TP, CB4000-CP	CB4000-HDW
CB-101ME, CB101M-TP, CB101-CP	CB101M-HDW
CB206F, CB-206F	CB6000-HDW



Technical Information

Assembly Item Number	Torque Specs					
	Lock Screw	Locking Screw Allen Key Size	Dial Adjust Allen Key Size	Micro Adjusting Dial Allen Key Size	Clamping Screw Allen Key Size	Insert Torx® Screw Driver Size
MBS0500B	1.4 (Nm)	5/64	5/32	-	1/8	-
CBS1250B	0.7 (Nm)	1/16	5/32	-	1/8	-
MDS0625	1.4 (Nm)	9/64	7/64	-	-	T8
MDS0750	1.5 (Nm)	5/32	7/64	-	-	T15
MDS16M	1.4 (Nm)	2.5mm	2.5mm	-	-	T8
MDS20M	1.5 (Nm)	3.0mm	2.5mm	-	-	T15
CB1000CC	0.6 (Nm)	0.050	5/32	3/32	-	T8
CB1000TC	0.6 (Nm)	0.050	5/32	3/32	-	T8
CB1250CC	0.7 (Nm)	1/16	5/32	3/32	-	T8
CB1250TC	0.7 (Nm)	1/16	5/32	3/32	-	T8
CB1500CC	1.4 (Nm)	5/64	5/32	7/64	-	T15
CB1500TC	1.4 (Nm)	5/64	5/32	7/64	-	T15
CB2000CC	2.3 (Nm)	3/32	5/32	7/64	-	T15
CB2000TC	2.3 (Nm)	3/32	5/32	7/64	-	T15
CB3000CC	5.3 (Nm)	1/8	1/4	7/64	-	T15
CB3000TC	5.3 (Nm)	1/8	1/4	7/64	-	T15
CB025MCC	0.6 (Nm)	1.5mm	4.0mm	2.5mm	-	T8
CB025MTC	0.6 (Nm)	1.5mm	4.0mm	2.5mm	-	T8
CB032MCC	0.7 (Nm)	2.0mm	4.0mm	2.5mm	-	T8
CB032MTC	0.7 (Nm)	2.0mm	4.0mm	2.5mm	-	T8
CB038MCC	1.4 (Nm)	2.0mm	4.0mm	3.0mm	-	T15
CB038MTC	1.4 (Nm)	2.0mm	4.0mm	3.0mm	-	T15
CB050MCC	2.3 (Nm)	2.5mm	4.0mm	3.0mm	-	T15
CB050MTC	2.3 (Nm)	2.5mm	4.0mm	3.0mm	-	T15
CB076MCC	5.3 (Nm)	3.0mm	6.0mm	3.0mm	-	T15
CB076MTC	5.3 (Nm)	3.0mm	6.0mm	3.0mm	-	T15
CB2500BMA	2.3 (Nm)	3/32	1/4	7/64	7/32	-
CB202B	2.3 (Nm)	3/32	5/32	-	5/32	-
CB203D	5.3 (Nm)	1/8	1/4	-	7/32	-
CB204E	12.4 (Nm)	5/32	1/4	-	7/32	-
CB206F	12.4 (Nm)	5/32	5/16	-	1/4	-

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

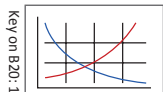
THREADING

X

SPECIALS

B20: 58 - 59

B20: 54 - 55



Setup Instructions | Standard Adjusting Boring Heads

Adjusting Standard Adjusting Boring Heads (see figure B1)

1. Loosen locking screw (6).
2. Turn dial screw (3) to desired graduation.
3. Tighten locking screw (6) to proper torque spec (laser marked on tool).

IMPORTANT: Do not loosen the gib screws (5). It can cause poor performance.

NOTE: To machine smaller bore diameters, turn dial screw (3) counterclockwise one full rotation to remove any backlash. Once backlash is mitigated, turn dial screw (3) clockwise to desired graduation.

No.	Part
1	Bar holder
2	Boring head body
3	Dial screw
4	Bar holder set screws
5	Gib screws (DO NOT ADJUST)
6	Locking screw

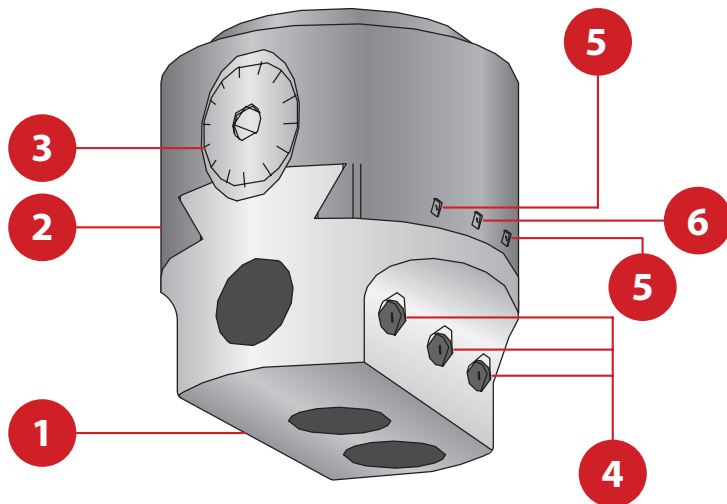
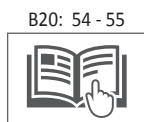
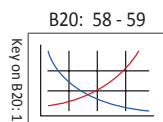


Figure B1



Setup Instructions | Micro Adjusting Boring Heads

Setting Up Micro Adjusting Boring Heads (see figure B2)

Set the microadjusting dial screw range

- 1. The microadjusting dial screws (4) only have a total range of 0.006" (0.152mm) on diameter. To zero, turn dial (4) clockwise until dial screw bottoms out. Turn the dial (4) two complete turns counterclockwise. Turn dial (4) one half turn clockwise. Dial is now centered for 0.003" (0.076mm) positive or negative travel.

Setting the diameter of the boring head

- 2. Loosen locking screw (6).
- 3. Turn dial screw (3) to adjust to the desired diameter using a presetter or plunge indicator or the dial screw (3).
- 4. Tighten the locking screw (6) to the proper torque spec (laser marked on the tool).
 - Microadjustments will be made at the machine.
- 5. Make a shallow test cut (roughly 0.250" deep) to determine the actual diameter.
- 6. Use the microadjusting dial (4) to adjust to the finish diameter. Do not release the locking screw (6) for microadjustments.
 - If the hole diameter is more than .002" from the target hole size return to step two.

IMPORTANT: Do not loosen the gib screws (5). It can cause poor performance.

NOTE: Backlash occurs when the diameter of the boring head needs to be decreased. To remove backlash, turn the dial (3) counterclockwise at least one half of a full rotation past the desired adjustment. Once backlash is mitigated, turn dial screw (3) clockwise to the desired adjustment.

No.	Part
1	Insert holder
2	Boring head body
3	Dial screw
4	Microadjusting dial screw
5	Gib screws (DO NOT ADJUST)
6	Locking screw

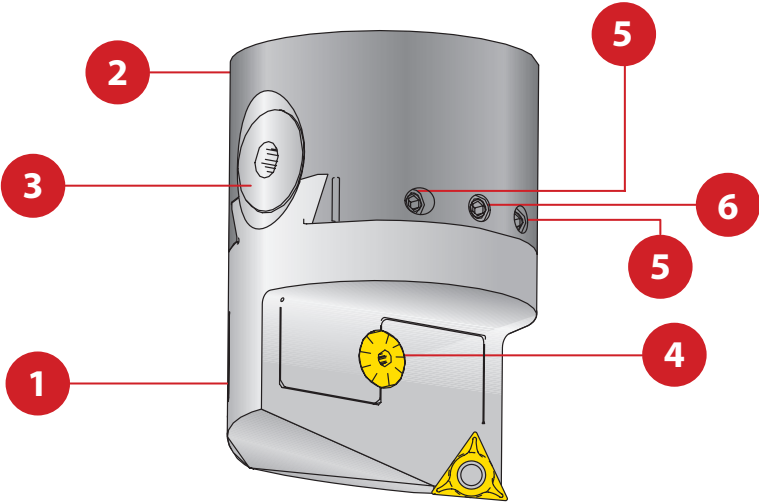
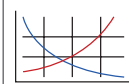


Figure B2

B20: 58 - 59

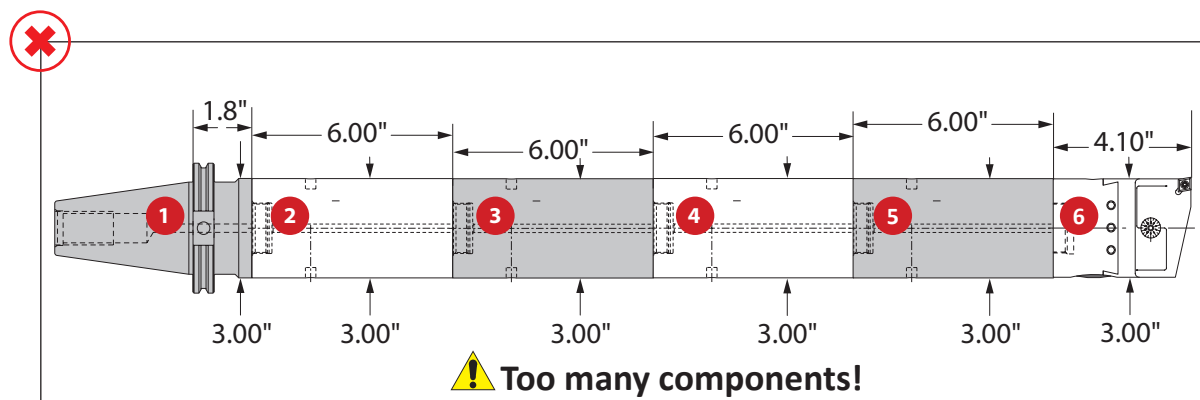


B20: 54 - 55



Guidelines for Not Exceeding Recommended Length-to-Diameter Ratio

To calculate, see graphics below:



*Length to diameter ratio is calculated using body diameters, not cutting diameter.

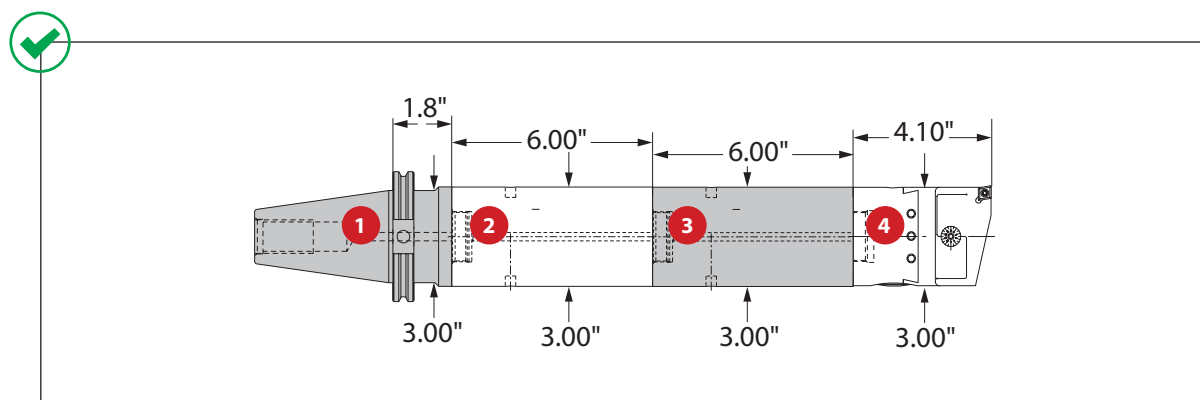
Step 1: Find L : D by component

- 1 $0.6 = 1.88/3.00$
- 2 $2.0 = 6.00/3.00$
- 3 $2.0 = 6.00/3.00$
- 4 $2.0 = 6.00/3.00$
- 5 $2.0 = 6.00/3.00$
- 6 $1.4 = 4.10/3.00$

Step 2: Add each L : D Average

0.6	→	0.6
2.0	→	2.0
2.0	→	2.0
2.0	→	2.0
2.0	→	2.0
2.0	→	2.0
1.4	→	1.4
		+ 1.4
		10.0 = L : D ratio

! Too Long!



*Length-to-diameter ratio is calculated using body diameters, not cutting diameter.

Step 1: Find L : D by component

- 1 $0.6 = 1.88/3.00$
- 2 $2.0 = 6.00/3.00$
- 3 $2.0 = 6.00/3.00$
- 4 $1.4 = 4.10/3.00$

Step 2: Add each L : D Average

0.6	→	0.6
2.0	→	2.0
2.0	→	2.0
1.4	→	1.4
		+ 1.4
		6.0 = L : D ratio

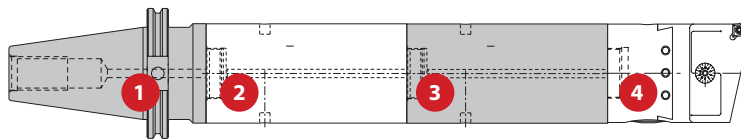
⚠ WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)

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Calculating Tool Assembly Weight

To calculate, see graphics below:



Step 1: Find weight for each component

Example:

Boring Range	D_1	Thread Connection	4 Boring Head		Weight	Insert Form	Order Number
			L_1	D_2			
i	1.050 - 1.320	$\frac{1}{8}$ - 20	2.690	1.000	0.50 (lbs)	CC..215...	CB1000CC
	1.050 - 1.320	$\frac{1}{8}$ - 20	2.690	1.000	0.50 (lbs)	TC..215...	CB1000TC
	1.300 - 1.600	$\frac{1}{8}$ - 20	2.900	1.250	0.80 (lbs)	CC..215...	CB1250CC
	1.300 - 1.600	$\frac{1}{8}$ - 20	2.900	1.250	0.80 (lbs)	TC..215...	CB1250TC
	1.585 - 2.700	$\frac{1}{8}$ - 20	3.200	1.500	1.30 (lbs)	CC..325...	CB1500CC
	1.585 - 2.700	$\frac{1}{8}$ - 20	3.200	1.500	1.30 (lbs)	TC..325...	CB1500TC
	2.060 - 3.320	$\frac{1}{8}$ - 20	3.590	2.000	2.40 (lbs)	CC..325...	CB2000CC
	2.060 - 3.320	$\frac{1}{8}$ - 20	3.590	2.000	2.40 (lbs)	TC..325...	CB2000TC
	3.065 - 5.065	$1\frac{1}{2}$ - 18	4.100	3.000	5.80 (lbs)	CC..325...	CB3000CC
m	3.065 - 5.065	$1\frac{1}{2}$ - 18	4.100	3.000	5.80 (lbs)	TC..325...	CB3000TC
	27.00 - 33.00	$\frac{1}{8}$ - 20	68.35	25	0.23 (kg)	CC..0602...	CB025MCC
	27.00 - 33.00	$\frac{1}{8}$ - 20	68.35	25	0.23 (kg)	TC..1102...	CB025MTC
	33.00 - 41.00	$\frac{1}{8}$ - 20	73.65	32	0.36 (kg)	CC..0602...	CB032MCC
	33.00 - 41.00	$\frac{1}{8}$ - 20	73.65	32	0.36 (kg)	TC..1102...	CB032MTC
	41.00 - 68.00	$\frac{1}{8}$ - 20	81.25	38	0.59 (kg)	CC..09T3...	CB038MCC
	41.00 - 68.00	$\frac{1}{8}$ - 20	81.25	38	0.59 (kg)	TC..16T3...	CB038MTC
	53.00 - 84.00	$\frac{1}{8}$ - 20	91.30	50	1.09 (kg)	CC..09T3...	CB050MCC
	53.00 - 84.00	$\frac{1}{8}$ - 20	91.30	50	1.09 (kg)	TC..16T3...	CB050MTC
	78.00 - 128.00	$1\frac{1}{2}$ - 18	104.25	76	2.36 (kg)	CC..09T3...	CB076MCC
	78.00 - 128.00	$1\frac{1}{2}$ - 18	104.25	76	2.36 (kg)	TC..16T3...	CB076MTC

Imperial (in) = 0.00005" adjustment on diameter

Metric (mm) = 0.001mm adjustment on diameter

Step 2: Calculate total assembly weight

$$\begin{array}{r}
 1 \quad 8.03 \text{ lbs} \\
 2 \quad 11.50 \text{ lbs} \\
 3 \quad 11.50 \text{ lbs} \\
 + 4 \quad 5.80 \text{ lbs} \\
 \hline
 36.83 \text{ lbs}
 \end{array}$$

Step 3: Consult machine tool builder to ensure tool assembly weight does not exceed machine capabilities.

⚠ WARNING

Exceeding weight capacity for machine tool spindle and tool changer can cause machine damage and/or serious injury. To prevent:

- Consult machine tool builder for machine's weight limitations.

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Recommended Cutting Data | Imperial (inch)

ISO	Material	(BHN) Hardness	Grade	*Speed SFM	Recommended Feed (inch / tooth) Nose Radius			
					0.004"	0.008"	0.016"	0.031"
P	Free-Machining Steel 1118, 1215, 12L14, etc.	100 - 250	Carbide	525 - 975	0.001 - 0.003	0.002 - 0.005	0.004 - 0.006	0.006 - 0.009
	Low-Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 275	Carbide	475 - 925	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Medium-Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 325	Carbide	475 - 825	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Alloy Steel 4140, 5140, 8640, etc.	125 - 375	Carbide	400 - 700	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	High-Strength Alloy 4340, 4330V, 300M, etc.	225 - 400	Carbide	325 - 600	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Structural Steel A36, A285, A516, etc.	100 - 350	Carbide	475 - 925	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Tool Steel H-13, H-21, A-4, O-2, S-3, etc.	150 - 250	Carbide	325 - 600	0.001 - 0.002	0.002 - 0.003	0.003 - 0.004	0.004 - 0.006
S	High-Temp Alloy Hastelloy B, Inconel 600, etc.	140 - 310	Carbide	100 - 225	0.001 - 0.002	0.002 - 0.003	0.003 - 0.005	0.004 - 0.006
	Titanium Alloy	140 - 310	Carbide	125 - 300	0.001 - 0.002	0.002 - 0.003	0.003 - 0.005	0.004 - 0.006
	Aerospace Alloy S82	185 - 350	Carbide	125 - 300	0.001 - 0.002	0.002 - 0.003	0.003 - 0.005	0.004 - 0.006
M	Stainless Steel 400 Series 416, 420, etc.	185 - 350	Carbide	300 - 525	0.001 - 0.002	0.002 - 0.004	0.003 - 0.004	0.004 - 0.006
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	Carbide	300 - 525	0.001 - 0.002	0.002 - 0.004	0.003 - 0.004	0.004 - 0.006
	Super Duplex Stainless Steel	135 - 275	Carbide	300 - 525	0.001 - 0.002	0.002 - 0.004	0.003 - 0.004	0.004 - 0.006
H	Wear Plate	400 - 600	Carbide	100 - 200	0.001 - 0.002	0.002 - 0.003	0.003 - 0.004	0.004 - 0.006
	Hardened Steel	300 - 500	Carbide	125 - 275	0.001 - 0.002	0.002 - 0.003	0.003 - 0.004	0.004 - 0.006
K	SG / Nodular Cast Iron	120 - 320	Carbide	475 - 850	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Grey / White Iron	180 - 320	Carbide	600 - 1000	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
N	Cast Aluminum	30 - 180	Carbide	850 - 1000	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Wrought Aluminum	30 - 180	Carbide	675 - 1000	0.001 - 0.003	0.002 - 0.005	0.004 - 0.006	0.006 - 0.009
	Aluminum Bronze	100 - 250	Carbide	475 - 925	0.001 - 0.002	0.002 - 0.004	0.004 - 0.005	0.005 - 0.008
	Brass	100	Carbide	675 - 1000	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Copper	60	Carbide	325 - 600	0.001 - 0.002	0.002 - 0.003	0.003 - 0.004	0.004 - 0.005

*Not to exceed max recommended RPM for boring head

Deep Hole Boring Speed Adjustment

⚠ For Dynamic Boring Tool Length			
Boring Type	7xD	8xD	9xD
Finishing	0.70	0.50	0.30

Recommended Speed Example

If the recommended speed for a finish boring assembly under 5xD is 400 SFM, then the speed for an 8xD finish boring assembly in the same application would be 200 SFM. (400 SFM x 0.50 = 200 SFM)

5xD = 400 SFM

8xD = 200 SFM

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
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⚠ WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

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Recommended Cutting Data | Metric (mm)

ISO	Material	(BHN) Hardness	Grade	*Speed M/min	Recommended Feed (mm / tooth) Nose Radius			
					0.1mm	0.2mm	0.4mm	0.8mm
P	Free-Machining Steel 1118, 1215, 12L14, etc.	100 - 250	Carbide	160 - 300	0.02 - 0.07	0.05 - 0.13	0.10 - 0.15	0.15 - 0.23
	Low-Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 275	Carbide	145 - 280	0.02 - 0.05	0.05 - 0.10	0.07 - 0.13	0.13 - 0.20
	Medium-Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 325	Carbide	145 - 250	0.02 - 0.05	0.05 - 0.10	0.07 - 0.13	0.13 - 0.20
	Alloy Steel 4140, 5140, 8640, etc.	125 - 375	Carbide	120 - 210	0.02 - 0.05	0.05 - 0.10	0.07 - 0.13	0.13 - 0.20
	High-Strength Alloy 4340, 4330V, 300M, etc.	225 - 400	Carbide	100 - 180	0.02 - 0.05	0.05 - 0.10	0.07 - 0.13	0.13 - 0.20
	Structural Steel A36, A285, A516, etc.	100 - 350	Carbide	145 - 280	0.02 - 0.05	0.05 - 0.10	0.07 - 0.13	0.13 - 0.20
	Tool Steel H-13, H-21, A-4, O-2, S-3, etc.	150 - 250	Carbide	100 - 180	0.02 - 0.05	0.05 - 0.07	0.07 - 0.10	0.10 - 0.15
S	High-Temp Alloy Hastelloy B, Inconel 600, etc.	140 - 310	Carbide	30 - 70	0.02 - 0.05	0.05 - 0.07	0.07 - 0.13	0.10 - 0.15
	Titanium Alloy	140 - 310	Carbide	40 - 90	0.02 - 0.05	0.05 - 0.07	0.07 - 0.13	0.10 - 0.15
	Aerospace Alloy S82	185 - 350	Carbide	40 - 90	0.02 - 0.05	0.05 - 0.07	0.07 - 0.13	0.10 - 0.15
M	Stainless Steel 400 Series 416, 420, etc.	185 - 350	Carbide	90 - 160	0.02 - 0.05	0.05 - 0.10	0.07 - 0.10	0.10 - 0.15
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	Carbide	90 - 160	0.02 - 0.05	0.05 - 0.10	0.07 - 0.10	0.10 - 0.15
	Super Duplex Stainless Steel	135 - 275	Carbide	90 - 160	0.02 - 0.05	0.05 - 0.10	0.07 - 0.10	0.10 - 0.15
H	Wear Plate	400 - 600	Carbide	30 - 60	0.02 - 0.05	0.05 - 0.07	0.07 - 0.10	0.10 - 0.15
	Hardened Steel	300 - 500	Carbide	40 - 80	0.02 - 0.05	0.05 - 0.07	0.07 - 0.10	0.10 - 0.15
K	SG / Nodular Cast Iron	120 - 320	Carbide	145 - 260	0.02 - 0.05	0.05 - 0.10	0.07 - 0.13	0.13 - 0.20
	Grey / White Iron	180 - 320	Carbide	180 - 306	0.02 - 0.05	0.05 - 0.10	0.07 - 0.13	0.13 - 0.20
N	Cast Aluminum	30 - 180	Carbide	260 - 306	0.02 - 0.05	0.05 - 0.10	0.07 - 0.13	0.13 - 0.20
	Wrought Aluminum	30 - 180	Carbide	205 - 305	0.02 - 0.07	0.05 - 0.13	0.10 - 0.15	0.15 - 0.23
	Aluminum Bronze	100 - 250	Carbide	145 - 280	0.02 - 0.05	0.05 - 0.10	0.10 - 0.13	0.13 - 0.20
	Brass	100	Carbide	205 - 305	0.02 - 0.05	0.05 - 0.10	0.07 - 0.13	0.13 - 0.20
	Copper	60	Carbide	100 - 180	0.02 - 0.05	0.05 - 0.07	0.07 - 0.10	0.10 - 0.13

*Not to exceed max recommended RPM for boring head

Deep Hole Boring Speed Adjustment

⚠ For Dynamic Boring Tool Length			
Boring Type	7xD	8xD	9xD
Finishing	0.70	0.50	0.30

Recommended Speed Example

If the recommended speed for a finish boring assembly under 5xD is 260 M/min, then the speed for an 8xD finish boring assembly in the same application would be 260 M/min. (260 M/min x 0.50 = 130 M/min)

5xD = 260 M/min

8xD = 130 M/min

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Refer to page B20: 58 for recommended application specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
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⚠ WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 9xD length-to-diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B20: 56 for calculating length to diameter ratio

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Notes

A

DRILLING

B

BORING

C

REAIMING

D

BURNISHING

E

THREADING

X

SPECIALS



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