


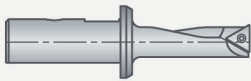
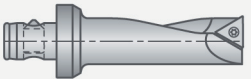
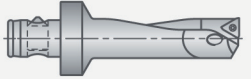


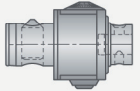


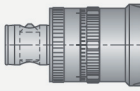

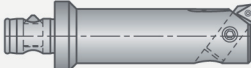
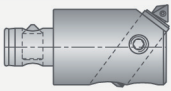
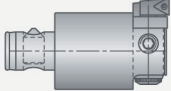




Help table for tool selection

Ø mm	L / D	Machining							
		through hole	blind hole	angled start and drilling out, interrupted cut	cross bore	reverse machining	HRC > 54 through hole	HRC > 54 blind hole	vibration dampening
0,5 - 9	> 3,5 × D	●	●	◐	◐				●
3 - 8	> 3,5 × D	●	●	◐	◐				●
4 - 8	3 × D	●	●	◐	◐		●	●	●
5,6 - 24	3,5 × D	●	●	◐	◐		●	●	
7,9 - 44	3,5 × D	●	●	◐	◐		●	●	
11,9 - 30	3,5 × D	●	●	◐	◐		●	●	
15,9 - 26	3 × D	●	●	◐	◐		●	●	
5,6 - 26	> 3,5 × D	●	●	◐	◐		○	○	◐
0,5 - 103	3-6 × D	●	●	◐	◐		●	●	
0,5 - 103	3-6 × D	●	●	◐	◐	●	◐	◐	
24,8 - 206	> 3,5 × D	●	●	◐	◐	●	●	●	●
28 - 44	3,5 × D	●	●	◐	◐		●	●	●
20 - 175	> 3,5 × D	●	●	◐	◐		●	●	●
29,5 - 199	> 3,5 × D	●	●	◐	◐		●	●	●
196 - 401	3,5 × D	●	●	◐	◐		●	●	
> 206	> 3,5 × D	●	●	◐	◐				



Coolant		IT area		Tool		Connection	
Emulsion		MQL				right	
internal	external	internal	external			ABS	Cylindrical shank
	●			subject to mounting in micro-adjustable head		Boring bar	3.19
●	●			subject to mounting in micro-adjustable head		UniTurn®	3.21 3.22
	●	●	●	subject to mounting in micro-adjustable head		UniTurn®	3.23
●	●	●	●	subject to mounting in micro-adjustable head		Boring bar	3.24
●	●	●	●	subject to mounting in micro-adjustable head		Boring bar	3.25
●	●	●	●	subject to mounting in micro-adjustable head		Boring bar	3.28
●	●	●	●	IT7		Boring bar	3.42
●	●	●	●	subject to mounting in micro-adjustable head		Low-vibration boring bar	3.30
●	●	●	●	< IT7		Micro-adjustable drilling head M020	3.14
●	●	●	●	< IT7	 	Micro-adjustable drilling head M040 Replaceable bridge	3.12 3.32
●	●	●	●	< IT7	 	Micro-adjustable drilling head M03Speed Replaceable bridge	3.56 3.60
●	●	●	●	> IT7		Micro-adjustable drilling head	3.50
●	●	●	●	> IT7		Micro-adjustable drilling head (FZ)	3.44
●	●	●	●	> IT7		Micro-adjustable drilling head (FF)	3.51
●	●	●	●	< IT7		Twin Cutter Roughing Tool G01	3.74
●	●	●	●	< IT7		Lightweight Twin Cutter Roughing Tool	3.77