

Introduction of EMB Boring Bar



What are EMB Boring Bars ?

EMB boring bars are "Eccentric Mechanism Boring bars" which can adjust to required diameter via an eccentric mechanism. The boring bar is not at the center of the holder, but offset from the center.

Patent No:108599(Taiwan), ZL96201178.9(China)
 1265836(Taiwan), ZL200510101469.5(China), US 7455487 B2(USA)

EMB Boring Bars Family

- 00-99101: 0.03 mm/div. adjustment range ± 0.5
- 00-99121: 0.01 mm/div. adjustment range ± 0.1
- 00-99111: 0.01 mm/div. & 0.03 mm/div. Interchangeable type.
- 00-99146: 0.01 mm/div. adjustment range ± 0.12
 $\varnothing 5\text{mm} \sim \varnothing 50\text{mm}$ boring bars are interchangeable.
 G6.3, 10000 r.p.m.



00-99101
00-99121



00-99111-01xx
00-99111-03xx



00-99146-BT30
00-99146-BT40
00-99146-BT50
00-99146-CAT40
00-99146-SK40
00-99146-HSK63A

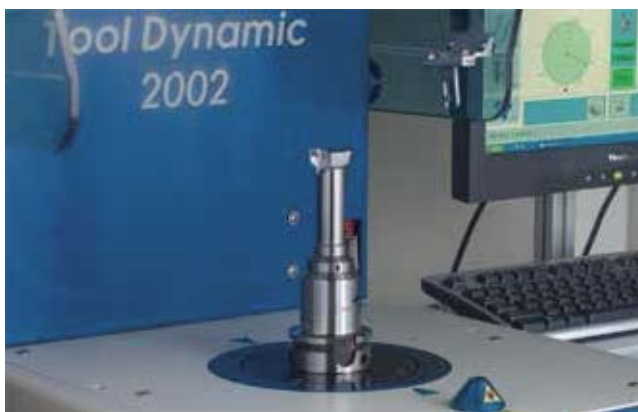


00-99146-01-32HB



00-99151A-xxxxW

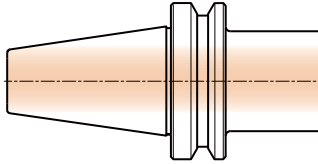
USA Patent



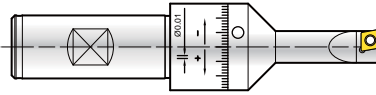
00-99146-xx
 Interchangeable boring bar
 Standard balanced grade
 10000 r.p.m. G6.3
 both of shank and bar.

EMB Boring Bars

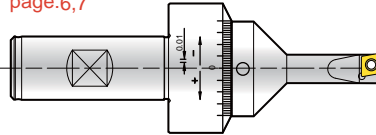
Side lock holders
Hydraulic chucks
Spring collet chucks



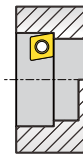
00-99101-07...25
00-99121-05...25
page:4,5



00-99111-01-05...25
page:6,7



Dia. 5...25 mm

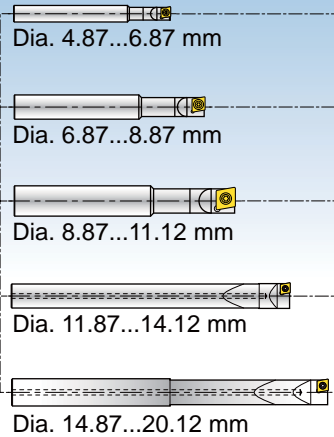


Insert

CCGT030102
CCGT040102
CCGH060204
page:16

Quick Change High Speed Boring Bars

Solid Carbide Shank page:15
00-99151-xxxxW



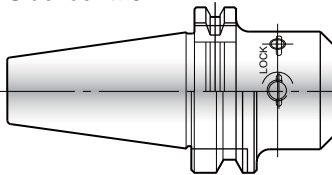
Dia. 4.87...20.12 mm

Insert

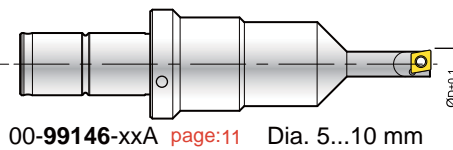
CCGT030102
CCGT040102
CCGH060204
page:16

Quick Change
Adjustment boring head shank

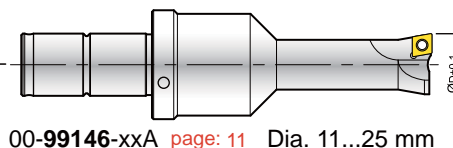
DIN 69871 SK40A
JIS 6339/MAS BT 30/40/50
ANSI CAT40
DIN 69893 HSK63A
Side lock Ø32mm



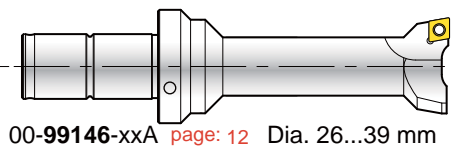
00-99146-xxxH page:10



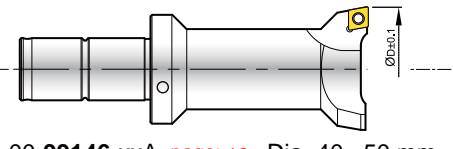
00-99146-xxA page:11 Dia. 5...10 mm



00-99146-xxA page:11 Dia. 11...25 mm

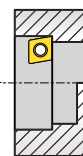


00-99146-xxA page:12 Dia. 26...39 mm



00-99146-xxA page:12 Dia. 40...50 mm

Dia. 5...50 mm



Insert

CCGT030102
CCGT040102
CCGH060204
page:16

Mechanical Design

- Adjusted by eccentric mechanism, it is simple and backlash free.
(Patented in ROC Taiwan, patent no. 108599, PR China ZL96 2 01178.9)
- It can replace end mill and brazed tool bits.

Easy Handling

- Each division 0.03mm shown on the tools, they are adjustable on the tool presetter or machine easily.
- Total adjustment range $\pm 0.5\text{mm}$

Economic

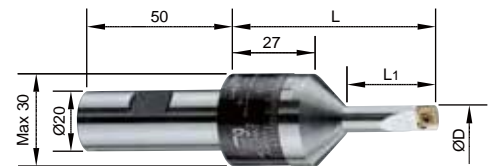
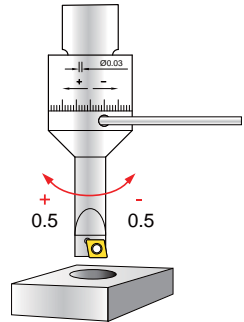
- Low cost, high efficiency.
- The indexable insert allows a variety of materials to be cut .

Application

- Minimum readout division is 0.03 mm, it is easy for setting up fine boring.
- Ideal as small hole boring tool with excellent accuracy.
- For fine boring operation on milling machines, machining centres and special purpose machines.

* H type with internal coolant can be ordered on request from Dia. 7mm.
Ordering example: 00-99101-07H.

* Other sizes are available on request.



Ordering Code	Part No.		ØD	L1	L	Insert	Screw & Key
00-99101-07	SB20-0721-03	Adjustment range: $\pm 0.5\text{mm}$ Each Division 0.03mm	6.5-7.5	21	60	CCGT040102	NK-T6 NS-20036
00-99101-08	SB20-0824-03		7.5-8.5	24	63		
00-99101-09	SB20-0927-03		8.5-9.5	27	65		
00-99101-10	SB20-1030-03		9.5-10.5	30	68	CCGH060204	NK-T7 NS-25045
00-99101-11	SB20-1133-03		10.5-11.5	33	70		
00-99101-12	SB20-1236-03		11.5-12.5	36	73		
00-99101-13	SB20-1339-03		12.5-13.5	39	75		
00-99101-14	SB20-1442-03		13.5-14.5	42	78		
00-99101-15	SB20-1545-03		14.5-15.5	45	80		
00-99101-16	SB20-1648-03		15.5-16.5	48	83		
00-99101-17	SB20-1751-03		16.5-17.5	51	85		
00-99101-18	SB20-1850-03		17.5-18.5	50	82		
00-99101-19	SB20-1950-03		18.5-19.5	50	82		
00-99101-20	SB20-2050-03		19.5-20.5	50	82		
00-99101-21	SB20-2150-03		20.5-21.5	50	82		
00-99101-22	SB20-2250-03		21.5-22.5	50	82		
00-99101-23	SB20-2350-03		22.5-23.5	50	82		
00-99101-24	SB20-2450-03		23.5-24.5	50	82		
00-99101-25	SB20-2550-03		24.5-25.5	50	82	CCGH060204	NK-T7 NS-25060

99121 EMB Boring Bars 0.01 mm/div.



Mechanical Design

- Adjusted by eccentric mechanism, it is simple and backlash free.
(Patented in ROC Taiwan, patent no. 108599, PR China ZL96 2 01178.9)
- It can replace end mill and brazed tool bits.

Easy Handling

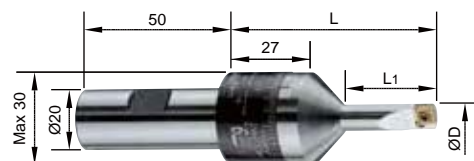
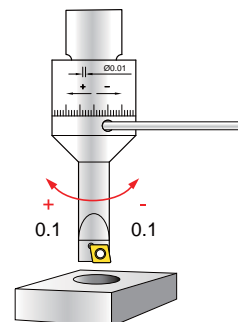
- Each division 0.01mm shown on the tools, they are adjustable on the tool presetter or machine easily.
- Total adjustment range ± 0.1 mm

Economic

- Low cost, high efficiency.
- The indexable insert allows a variety of materials to be cut .

Application

- Minimum readout division is 0.01 mm, it is easy for setting up fine boring.
- Ideal as small hole boring tool with excellent accuracy.
- For fine boring operation on milling machines, machining centres and special purpose machines.



* H type with internal coolant can be ordered on request from Dia. 7mm.

Ordering example: 00-99101-07H.

* Other sizes are available on request.

Ordering Code	Part No.		ØD	L1	L	Insert	Screw & Key
00-99121-05	SB20-0515-01	Adjustment range: ± 0.1 mm Each Division 0.01mm	4.9-5.1	15	54	CCGT030102	NK-T6 NS-16030
00-99121-06	SB20-0618-01		5.9-6.1	18	57		
00-99121-07	SB20-0721-01		6.9-7.1	21	60	CCGT040102	NK-T6 NS-20036
00-99121-08	SB20-0824-01		7.9-8.1	24	63		
00-99121-09	SB20-0927-01		8.9-9.1	27	65	CCGH060204	NK-T7 NS-25045
00-99121-10	SB20-1030-01		9.9-10.1	30	68		
00-99121-11	SB20-1133-01		10.9-11.1	33	70		
00-99121-12	SB20-1236-01		11.9-12.1	36	73		
00-99121-13	SB20-1339-01		12.9-13.1	39	75		
00-99121-14	SB20-1442-01		13.9-14.1	42	78		
00-99121-15	SB20-1545-01		14.9-15.1	45	80		
00-99121-16	SB20-1648-01		15.9-16.1	48	83		
00-99121-17	SB20-1751-01		16.9-17.1	51	85		
00-99121-18	SB20-1850-01		17.9-18.1	50	82		
00-99121-19	SB20-1950-01		18.9-19.1	50	82		
00-99121-20	SB20-2050-01		19.9-20.1	50	82	CCGH060204	NK-T7 NS-25060
00-99121-21	SB20-2150-01		20.9-21.1	50	82		
00-99121-22	SB20-2250-01		21.9-22.1	50	82		
00-99121-23	SB20-2350-01		22.9-23.1	50	82		
00-99121-24	SB20-2450-01		23.9-24.1	50	82		
00-99121-25	SB20-2550-01		24.9-25.1	50	82		

Easy adjustment mechanism:

- The boring head adapter is 20mm shank; the receiving hole is eccentric from the center of the shank. The diameter is adjusted by rotating the boring bar.
- Boring bar has preloaded by spring and M6 screw to fix boring bar and adapter together securely. The recommended torque is 0.9-1.0 Nm.
- Boring bar is locked by M8 setscrew; clamping torque is 8-9 Nm.
- Repair and replace boring bars easily.

Economical

- The e-boring bar is more economical than solid carbide reamer. Nine 9 e-boring bars are adjustable to compensate the wearing of insert, but the solid carbide reamer has to be replaced by new reamer.

Applications

- For fine boring operation to get IT7 tolerance; Using Nine9 fine ground inserts, tolerance IT6 is also possible.
- To replace solid carbide reamer for machining precise hole for dowel pin and other small diameter applications; this should be done by reamer in traditional.

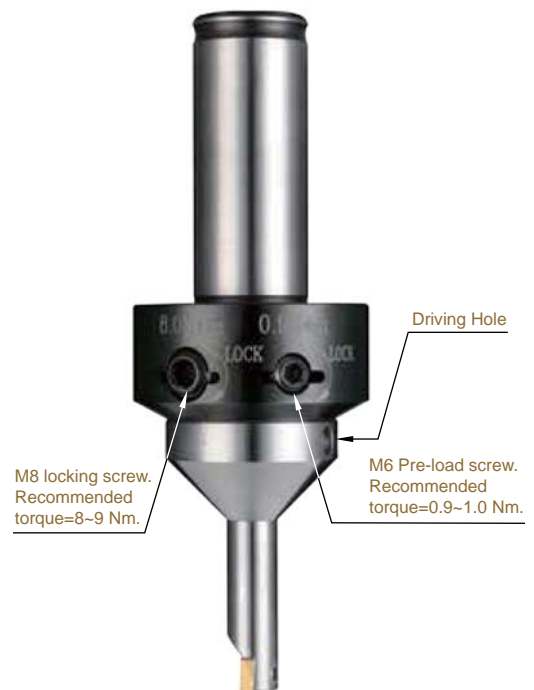
Procedures For Assembly

1. Use 4 mm allen-key to **loosen locking screw M8**, take care not to remove the screw.
2. Use 3 mm allen-key to **loosen pre-load screw M6**, take care not to remove the screw.
3. Remove the original boring bar and insert the new boring bar.
4. **Tighten the M6 pre-load screw** using the torque screwdriver with hex head key.
(Recommended torque = 0.9~1.0 Nm)
5. Ensure the boring head and boring bar fit together securely.
6. Measure the boring diameter of the boring bar using tool presetter and adjust it to the required diameter.
7. **Tighten the M8 locking screw** using the torque screwdriver with hex head key (Recommended torque = 8~9Nm)

Procedures For Adjustment

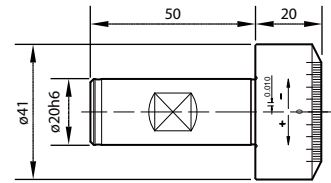
1. **Loosen locking screw M8**.
2. Put a 4 mm allen-key into the adjustable driving hole.
3. Turn to " + " to increase and turn to " - " to reduce boring diameter.
4. **Tighten the M8 locking screw** using the torque screwdriver with hex head key.
(Recommended torque = 8~9Nm)

To replace reamer!



Boring Head Adapter

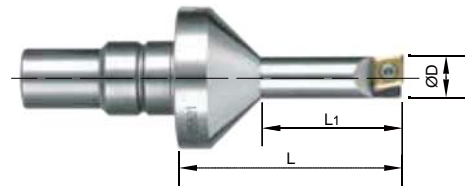
- 2 size adapters are designed for receiving all 00-99111-xxA boring bars.
- Change the boring bar in just one minute.
- 20mm shank to fit any kind of tool holder properly.



Ordering Code	Part No.	Shank (h6)	Adjustable range	Each division
00-99111-01-20HB	SB20-111-01	20mm	±0.1mm	0.01mm
00-99111-03-20HB	SB20-111-03	20mm	±0.5mm	0.03mm

Interchangeable Boring Bar

- Made by high alloy tool steel, the rigidity is enough for 3xD boring depth.
- All of 00-99111-xxA boring bars are interchangeable to fit same boring head adapter.



* H type with internal coolant can be order on request.
ordering code:00-99111-07AH

* Other sizes are available on request.

Ordering Code	Part No.	ØD		L1	L	Insert	Key / Screw
		99111-03-20HB	99111-01-20HB				
00-99111-05A	C16-0515	-	4.9-5.1	15	34	CC030102	NK-T6 NS-16030
00-99111-06A	C16-0618	-	5.9-6.1	18	37		
00-99111-07A	C16-0721	6.5-7.5	6.9-7.1	21	40	CC040102	NK-T6 NS-20036
00-99111-08A	C16-0824	7.5-8.5	7.9-8.1	24	43		
00-99111-09A	C16-0927	8.5-9.5	8.9-9.1	27	45	CC060204	NK-T7 NS-25045
00-99111-10A	C16-1030	9.5-10.5	9.9-10.1	30	48		
00-99111-11A	C16-1133	10.5-11.5	10.9-11.1	33	50		
00-99111-12A	C16-1236	11.5-12.5	11.9-12.1	36	53		
00-99111-13A	C16-1339	12.5-13.5	12.9-13.1	39	55		
00-99111-14A	C16-1442	13.5-14.5	13.9-14.1	42	58		
00-99111-15A	C16-1545	14.5-15.5	14.9-15.1	45	60		
00-99111-16A	C16-1648	15.5-16.5	15.9-16.1	48	63		
00-99111-17A	C16-1751	16.5-17.5	16.9-17.1	51	65		
00-99111-18A	C16-1850	17.5-18.5	17.9-18.1	50	62		
00-99111-19A	C16-1950	18.5-19.5	18.9-19.1	50	62	CC060204	NK-T7 NS-25060
00-99111-20A	C16-2050	19.5-20.5	19.9-20.1	50	62		
00-99111-21A	C16-2150	20.5-21.5	20.9-21.1	50	62		
00-99111-22A	C16-2250	21.5-22.5	21.9-22.1	50	62		
00-99111-23A	C16-2350	22.5-23.5	22.9-23.1	50	62		
00-99111-24A	C16-2450	23.5-24.5	23.9-24.1	50	62		
00-99111-25A	C16-2550	24.5-25.5	24.9-25.1	50	62		

Easy Handling:

- Dimensions are easy to read. They are indicated on the tools and are easily adjustable on a tool presetter or in machining center.
- No backlash.
- Change the boring bar and set the boring dimension on the tool presetter in just one minute.

Interchangeable Boring Bars from Diameters of 5 mm to 50 mm

- This simple boring tool has minimal components.
- In minutes, the boring bar may be changed and the boring dimension set on the tool presetter.

Low Cost For Machining Small Holes

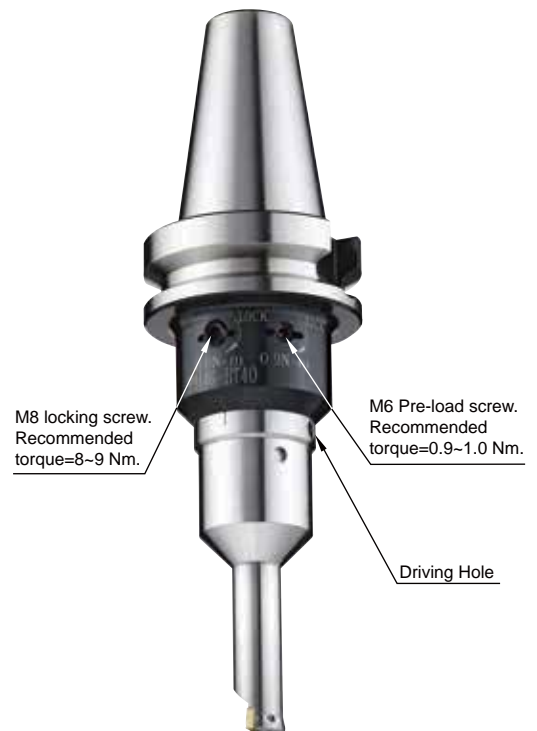
- The cost of this product is low compared to other micro adjustable boring heads.

High Speed

- Boring bar design ensures accurate high speed boring. Grade balance is G6.3 10000 r.p.m., all sizes are guaranteed.
- Surface speeds of carbide inserts up to 700 m/min.
- Combination bore / chamfer / facing tools can be ordered on request.

Procedures For Assembly

1. Use 4 mm allen-key to **loosen locking screw M8**, take care not to remove the screw.
2. Use 3 mm allen-key to **loosen pre-load screw M6**, take care not to remove the screw.
3. Remove the original boring bar and insert the new boring bar.
4. **Tighten the M6 pre-load screw** using the torque screwdriver with hex head key.
(Recommended torque = 0.9~1.0 Nm)
5. Ensure the boring head and boring bar fit together securely.
6. Measure the boring diameter of the boring bar using tool presetter and adjust it to the required diameter.
7. **Tighten the M8 locking screw** using the torque screwdriver with hex head key (Recommended torque = 8~9Nm)

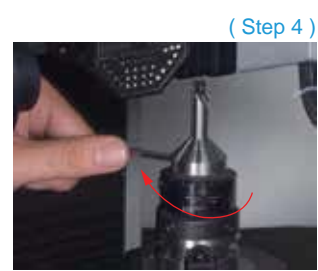
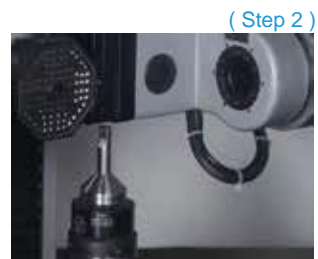


99146 Quick Change High Speed Boring Bar

Procedures For Adjustment

On Tool Presetter

1. Loosen M8 locking screw. (Step 1)
2. Set the boring bar at the neutral position. (Step 1)
3. Measure the boring diameter using the tool presetter and compare with the required diameter. (Step 2)
4. If boring diameter is too big or too small, please put an allen-key into the adjusting driving hole. Turn to “ + ” to increase and turn to “ - ” to reduce boring diameter. (Step 3 and 4)
5. Tighten M8 locking screw.

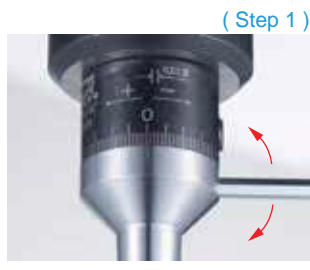


To Increase Diameter

To Reduce Diameter

On Milling Machine And Machining Centers

1. Set the boring bar at the neutral position. (Step 1)
2. Tighten M8 locking screw.
3. Test cut on work piece, about 3-5mm depth on the machine.
4. Measuring boring diameter of workpiece and compare with required diameter.
5. If boring diameter is too big or too small, loosen M8 locking screw, please put an allen-key into the adjusting driving hole. Turn to “ + ” to increase and turn to “ - ” to reduce boring diameter. (Step 2 and 3)
6. Tighten M8 locking screw. (Step 4)



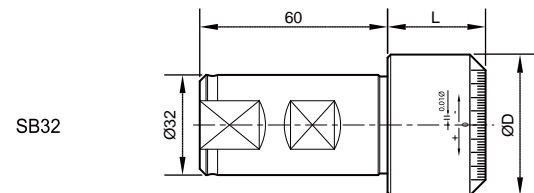
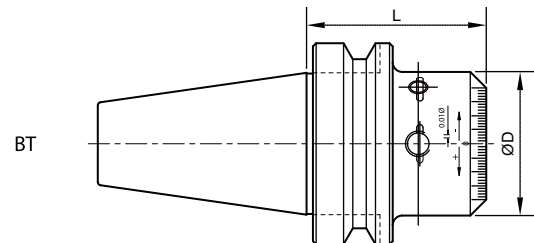
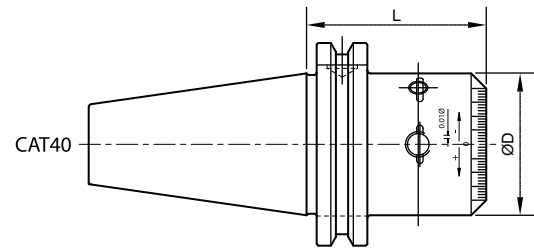
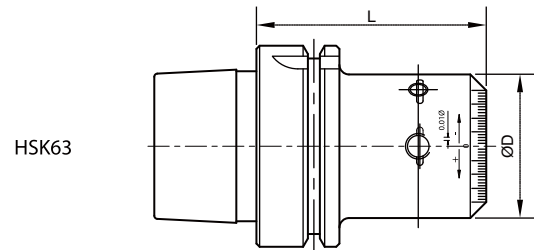
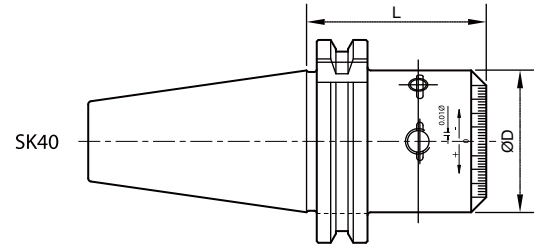
To Increase Diameter



To Reduce Diameter

Boring Head Shank

- Adjustable range: +0.12 /-0.13 mm.
- Each adjustment division is 0.01 mm.
- Balance grade : G6.3 10000 r.p.m.



Ordering Code	Part No.	ØD	L
00-99146-SB32HB	SB32-146-31	45	31.3
00-99146-BT30H	BT30-146-51	45	51.3
00-99146-BT40H	BT40-146-56	45	56.3
00-99146-BT50H	BT50-146-77	45	77.3
00-99146-CAT40H	CAT40-146-56	45	56.3
00-99146-HSK63AH	HSK63A-146-72	45	72
00-99146-SK40H	SK40-146-56	45	56.3

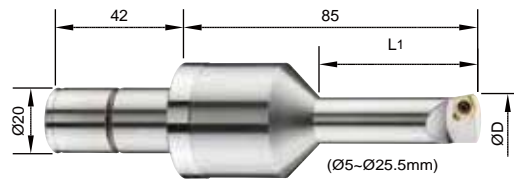
99146 Quick Change High Speed Boring Bar



99146

Ø5~Ø25mm

- Alloy Steel Shank
- Boring Depth : L1, 2~3xD



* H type with internal coolant can be ordered on request from Dia. 10mm.
Ordering example: 00-99146-1000SH.

* Other sizes are available on request.

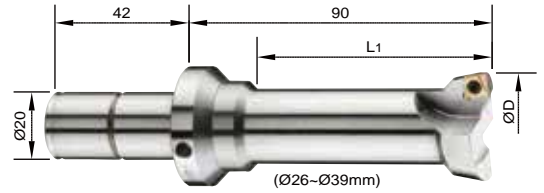
Ordering Code	Part No.	ØD	L1	Insert	Ordering Code	Part No.	ØD	L1	Insert
00-99146-0500S	C20-0500-10L	4.87~5.12	10.00	CCGT030102-NC30 NS-16030, NK-T6	00-99146-1725S	C20-1725-42L	17.12~17.37	42.50	CCGT060204 CCFT060204 Screw: NS-25045 Key: NK-T7
00-99146-0600S	C20-0600-12L	5.87~6.12	12.00		00-99146-1750S	C20-1750-43L	17.37~17.62	43.75	
00-99146-0700S	C20-0700-14L	6.87~7.12	14.00	00-99146-1775S	C20-1775-43L	17.62~17.87	43.75		
00-99146-0800S	C20-0800-16L	7.87~8.12	16.00	00-99146-1800S	C20-1800-45L	17.87~18.12	45.00		
00-99146-0900S	C20-0900-18L	8.87~9.12	18.00	00-99146-1825S	C20-1825-45L	18.12~18.37	45.00		
00-99146-1000S	C20-1000-25L	9.87~10.12	25.00	00-99146-1850S	C20-1850-46L	18.37~18.62	46.25		
00-99146-1025S	C20-1025-25L	10.12~10.37	25.00	00-99146-1875S	C20-1875-46L	18.62~18.87	46.25		
00-99146-1050S	C20-1050-26L	10.37~10.62	26.25	00-99146-1900S	C20-1900-47L	18.87~19.12	47.50		
00-99146-1075S	C20-1075-26L	10.62~10.87	26.25	00-99146-1925S	C20-1925-47L	19.12~19.37	47.50		
00-99146-1100S	C20-1100-27L	10.87~11.12	27.50	00-99146-1950S	C20-1950-48L	19.37~19.62	48.75		
00-99146-1125S	C20-1125-27L	11.12~11.37	27.50	00-99146-1975S	C20-1975-48L	19.62~19.87	48.75		
00-99146-1150S	C20-1150-28L	11.37~11.62	28.75	00-99146-2000S	C20-2000-50L	19.87~20.12	50.00		
00-99146-1175S	C20-1175-28L	11.62~11.87	28.75	00-99146-2025S	C20-2025-50L	20.12~20.37	50.00		
00-99146-1200S	C20-1200-30L	11.87~12.12	30.00	00-99146-2050S	C20-2050-50L	20.37~20.62	50.00		
00-99146-1225S	C20-1225-30L	12.12~12.37	30.00	00-99146-2075S	C20-2075-50L	20.62~20.87	50.00		
00-99146-1250S	C20-1250-31L	12.37~12.62	31.25	00-99146-2100S	C20-2100-50L	20.87~21.12	50.00		
00-99146-1275S	C20-1275-31L	12.62~12.87	31.25	00-99146-2125S	C20-2125-50L	21.12~21.37	50.00		
00-99146-1300S	C20-1300-32L	12.87~13.12	32.50	00-99146-2150S	C20-2150-50L	21.37~21.62	50.00		
00-99146-1325S	C20-1325-32L	13.12~13.37	32.50	00-99146-2175S	C20-2175-50L	21.62~21.87	50.00		
00-99146-1350S	C20-1350-33L	13.37~13.62	33.75	00-99146-2200S	C20-2200-50L	21.87~22.12	50.00		
00-99146-1375S	C20-1375-33L	13.62~13.87	33.75	00-99146-2225S	C20-2225-50L	22.12~22.37	50.00		
00-99146-1400S	C20-1400-35L	13.87~14.12	35.00	00-99146-2250S	C20-2250-50L	22.37~22.62	50.00		
00-99146-1425S	C20-1425-35L	14.12~14.37	35.00	00-99146-2275S	C20-2275-50L	22.62~22.87	50.00		
00-99146-1450S	C20-1450-36L	14.37~14.62	36.25	00-99146-2300S	C20-2300-50L	22.87~23.12	50.00		
00-99146-1475S	C20-1475-36L	14.62~14.87	36.25	00-99146-2325S	C20-2325-50L	23.12~23.37	50.00		
00-99146-1500S	C20-1500-37L	14.87~15.12	37.50	00-99146-2350S	C20-2350-50L	23.37~23.62	50.00		
00-99146-1525S	C20-1525-37L	15.12~15.37	37.50	00-99146-2375S	C20-2375-50L	23.62~23.87	50.00		
00-99146-1550S	C20-1550-38L	15.37~15.62	38.75	00-99146-2400S	C20-2400-50L	23.87~24.12	50.00		
00-99146-1575S	C20-1575-38L	15.62~15.87	38.75	00-99146-2425S	C20-2425-50L	24.12~24.37	50.00		
00-99146-1600S	C20-1600-40L	15.87~16.12	40.00	00-99146-2450S	C20-2450-50L	24.37~24.62	50.00		
00-99146-1625S	C20-1625-40L	16.12~16.37	40.00	00-99146-2475S	C20-2475-50L	24.62~24.87	50.00		
00-99146-1650S	C20-1650-41L	16.37~16.62	41.25	00-99146-2500S	C20-2500-50L	24.87~25.12	50.00		
00-99146-1675S	C20-1675-41L	16.62~16.87	41.25	00-99146-2525S	C20-2525-50L	25.12~25.37	50.00		
00-99146-1700S	C20-1700-42L	16.87~17.12	42.50	00-99146-2550S	C20-2550-50L	25.37~25.62	50.00		
				CCGT060204 CCFT060204 Screw: NS-25060 Key: NK-T7					CCGT060204 CCFT060204 Screw: NS-25060 Key: NK-T7



99146 Quick Change High Speed Boring Bar

Ø26~Ø39mm

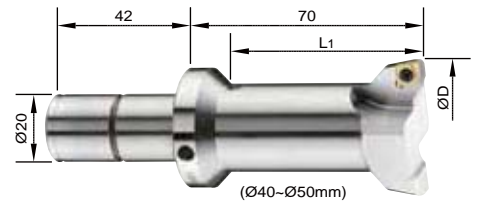
- Alloy Steel Shank
- Boring Depth : L1, 2~3xD
- * H type with internal coolant can be ordered on request.
Ordering example: 00-99146-36AH.



Ordering Code	Part No.	ØD	L1	Insert
00-99146-26A	C20-2600-50L	25.87~26.12	50.00	CCGT060204 CCFT060204 Screw: NS-25060 Key: NK-T7
00-99146-27A	C20-2700-50L	26.87~27.12	50.00	
00-99146-28A	C20-2800-50L	27.87~28.12	50.00	
00-99146-29A	C20-2900-50L	28.87~29.12	50.00	
00-99146-30A	C20-3000-50L	29.87~30.12	50.00	
00-99146-31A	C20-3100-70L	30.87~31.12	70.00	
00-99146-32A	C20-3200-70L	31.87~32.12	70.00	
00-99146-33A	C20-3300-70L	32.87~33.12	70.00	
00-99146-34A	C20-3400-70L	33.87~34.12	70.00	
00-99146-35A	C20-3500-70L	34.87~35.12	70.00	
00-99146-36A	C20-3600-70L	35.87~36.12	70.00	
00-99146-37A	C20-3700-70L	36.87~37.12	70.00	
00-99146-38A	C20-3800-70L	37.87~38.12	70.00	
00-99146-39A	C20-3900-70L	38.87~39.12	70.00	

Ø40~Ø50mm

- Alloy Steel Shank
- Boring Depth : L1, 2~3xD
- * H type with internal coolant can be ordered on request.
Ordering example: 00-99146-45AH.



Ordering Code	Part No.	ØD	L1	Insert
00-99146-40A	C20-4000-70L	39.87-40.12	70.00	CCGT060204 CCFT060204 Screw: NS-25060 Key: NK-T7
00-99146-41A	C20-4100-70L	40.87-41.12	70.00	
00-99146-42A	C20-4200-70L	41.87-42.12	70.00	
00-99146-43A	C20-4300-70L	42.87-43.12	70.00	
00-99146-44A	C20-4400-70L	43.87-44.12	70.00	
00-99146-45A	C20-4500-70L	44.87-45.12	70.00	
00-99146-46A	C20-4600-70L	45.87-46.12	70.00	
00-99146-47A	C20-4700-70L	46.87-47.12	70.00	
00-99146-48A	C20-4800-70L	47.87-48.12	70.00	
00-99146-49A	C20-4900-70L	48.87-49.12	70.00	
00-99146-50A	C20-5000-70L	49.87-50.12	70.00	

High Speed Boring Bar Kit

Ordering Code	Contents	
00-99146-32HB-05SET	SB32-146-31 Weldon Shank	Boring head shank: 1pc Boring bar: any 5 pcs from Ø5~Ø50 Key: 3~5 pcs Plastic box: 1pc
00-99146-BT30-05SET	BT30H Boring head shank	
00-99146-BT40-05SET	BT40H Boring head shank	
00-99146-BT50-05SET	BT50H Boring head shank	
00-99146-CAT40-05SET	CAT40H Boring head shank	
00-99146-SK40-05SET	SK40H Boring head shank	
00-99146-HSK63A-05SET	HSK63A Boring head shank	

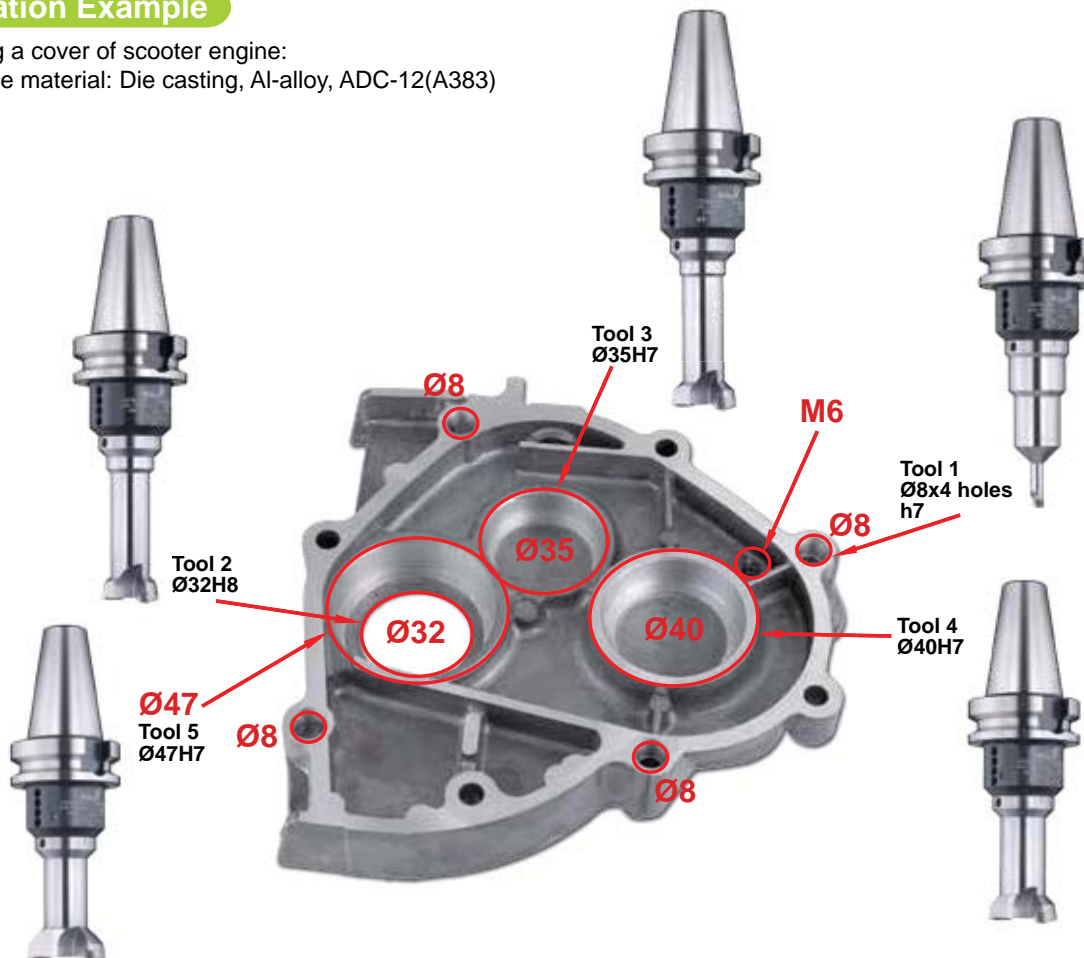


(Insert is not included, please order separately)
• Note: BT50 boring head shank is packed in a separate box.

99146 Quick Change High Speed Boring Bar

Application Example

- Machining a cover of scooter engine:
Work piece material: Die casting, Al-alloy, ADC-12(A383)



TOOL LIST by Nine9 Boring Bar 99146-series, Spindle Size: BT40

No.	Boring Bar	Grade of insert	Dia. mm	Depth	r.p.m.	F = mm/min.	Machining time
1	00-99146-08A	CCGT040102 NC30	Ø8H7	8 mm	8000	400	1.2 sec.
2	00-99146-32A	CCGT060202HP NC9031	Ø32H8	8 mm	2985	209	2.3 sec.
3	00-99146-35A	CCGT060202HP NC9031	Ø35H7	12 mm	2730	191	3.8 sec.
4	00-99146-40A	CCGT060202HP NC9031	Ø40H7	15 mm	2400	168	5.4 sec.
5	00-99146-47A	CCGT060202HP NC9031	Ø47H7	15 mm	2030	142	6.4 sec.

Working Example

Material	Vc m/min.	f mm/rev.	Roughness			Tool holder	Insert
			Ra	Rz	Rmax		
Al alloy, 6061	150	0.2	0.076µm	0.50µm	0.6µm	99146-BT40-26A	CCGH0602U NC9096

