

Spherical turning now for smaller diameters



Wider application for the medical industry

The turning of titanium and cobalt chromium implants of diameters down to 20 mm is now a possibility in our latest innovation for the medical industry. The increased application from the previous diameter range of 34 mm strengthens the offer of holders and inserts to optimize the turning of, for example, the spherical cup in a ball and socket hip joint.

In roughing operations, round inserts impart a strong cutting edge and give excellent resistance to notch wear. They offer reliability, durability and the opportunity to machine longer with the same tool.

New design tool holders

- The preparation of smaller diameter components is facilitated by the extension of the tool holder programme
- The insert is secured in the centre of the bar to enable both left and right hand cuts, when using the new neutral style holders
- For finishing, the boring bar range is extended with bars for positive D-style 55° inserts, designed to reach into cups of diameters down to 20 mm finished size
- Simple setting of the correct cutting edge centre height can be achieved for all bars in the programme using EasyFix®
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Insert assortment

Round insert type 300 geometries –PL and –KL are periphery ground and give excellent chip control and low cutting forces. Recommended grades are GC1030 for cobalt chromium and H13A for titanium.

A smaller size DCGT insert, geometry –UM can now be used for spherical finishing and general turning with the new size bars. Recommended grades are GC1025 for cobalt chromium and H13A for titanium.



Boring bars for medical

CoroTurn® 107 screw clamp design

Cylindrical

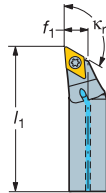
With groove for EasyFix sleeve



 DCMT, DCGT


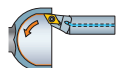
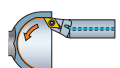
Entering angle:

A...-SDXCR/L
 $\kappa_r 117^\circ$



Max overhang $4 \times dm_m$
With internal coolant supply


Right hand style shown when nothing else is stated

κ_r	Main application		Ordering code	Dimensions, mm					Gauge inserts	Nm ²⁾
				dm_m	D_m min	f_1	l_1	λ_s ¹⁾		
117°		07	A16K-SDXCR/L 07-R	16	20.0	9.0	125.0	-3°	DCMT 07 02 04	0.9
117°		11	A20M-SDXCR/L 11-R	20	25.0	12.0	150.0	-3°	DCMT 11 T3 08	3.0


¹⁾ λ_s = Angle of inclination.

²⁾ Insert tightening torque Nm.

R = Right hand, L = Left hand

 = New item

Main spare parts

Insert size	Bar dia.	Insert screw	Key (Torx Plus)
			
07	16	5513 020-03	5680 051-02 (7IP)
11	20	5513 020-09	5680 049-01 (15IP)

Boring bars for medical

CoroTurn® 107 screw clamp design

Cylindrical

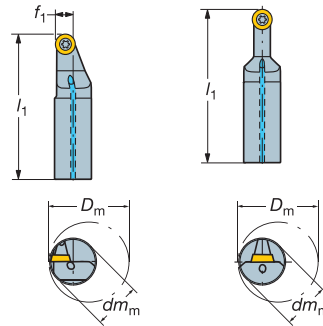
With groove for EasyFix sleeve

A...-SRXDR/L

A...SRDDN



R300



Max overhang 4 x dm_m
With internal coolant supply

Right hand style shown when nothing else is stated

Main application	IO	Ordering code	Dimensions, mm					Gauge inserts	Nm ¹⁾
			dm_m	D_m min	f_1	l_1	λ_s ²⁾		
	08	A20M-SRXDR/L 08-R	20	25.0	9.0	150.0	0°	R300-0828..	1.2
	10	A20M-SRXDR/L 10-R	20	25.0	9.0	150.0	0°	R300-1032..	3.0
	08	A16K-SRDDN 08-R	16	20	4.0	125.0	0°	R300-0828..	0.9

¹⁾ Insert tightening torque Nm.

R = Right hand, L = Left hand

²⁾ λ_s = Angle of inclination.

= New item

Inserts for internal turning



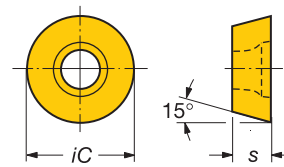
E-xM



M-xH



E-xL



	IO	Ordering code	M															S					H					Dimensions, mm	
			GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	CT	ic	s				
			1030	2030	2040	530	1025	1030	2030	2040	H13A	1025	1030	3020	3040	4020	530												
Light	08	R300-0828E-KL																				8	2.78						
		R300-0828E-PL	☆							☆													8	2.78					
		R300-0828E-PM				☆																☆	8	2.78					
	10	R300-1032E-KL																					10	3.18					
Heavy	08	R300-1032E-PL	☆																				10	3.18					
		R300-1032E-PM				☆																☆	10	3.18					
		R300-0828M-KH																					8	2.78					
	10	R300-1032M-KH																					10	3.18					

Main spare parts

Insert size			
IO	Bar dia.	Insert screw	Key (Torx Plus)
08	16	5513 020-48	5680 051-02 (7IP)
08	20	5513 020-56	5680 046-01 (8IP)
10	20	5513 020-43	5680 046-02 (15IP)