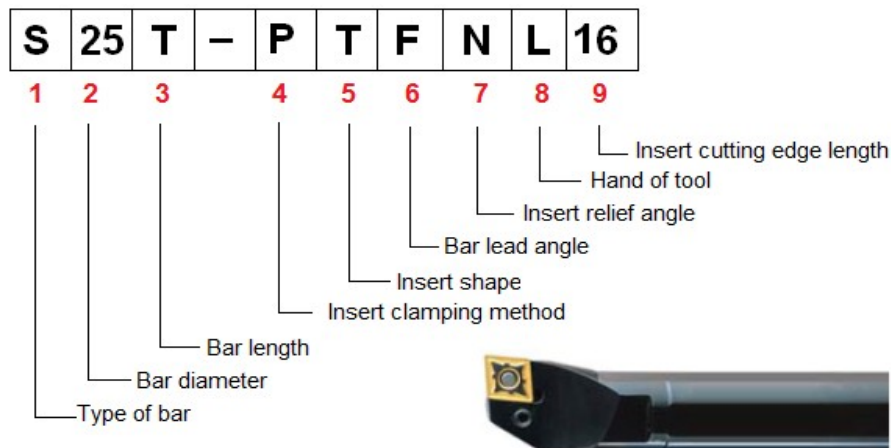


Boring holders – ISO nomenclature

Boring holders are known by an ISO naming convention that describes their shape and size. Each alphabet and number in the name signifies an aspect of the shape or size. The example below is for an S25T-PTFNL16 holder.



How do you select the parameters in the holder ?

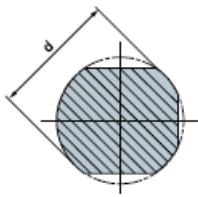
	Parameter	How is this decided ?
1	Type of bar	Decide based on rigidity required, whether coolant through, etc.
2	Bar diameter	Decided by the bore diameter – use maximum possible, for rigidity.
3	Bar length	Decided by bore length.
4	Insert clamping method	Select based on clamping method – top and hole clamping is the most sturdy, screw clamping the least.
5	Insert shape	Decide based on contour you want to bore and
6	Bar lead angle	Decide based on contour you want to bore.
7	Insert relief angle	Positive/Negative, based on application.
8	Hand of tool	Decide based on turret position, tool face up/down.
9	Insert cutting edge length	Depends on in insert size, which depends on bar diameter, which in turn is decided by bore diameter.

The tables below may show only some of the options in each parameter. These keep evolving, and for a full list you must refer to the catalog of the cutting tool manufacturer.

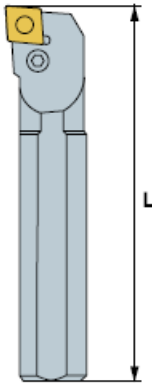
1 Type of Bar

- "A" Steel with coolant hole
- "E" Carbide bar with fixed steel head and coolant hole
- "C" Carbide shank
- "S" Steel shank
- "X" Special type

2 Bar diameter







3 Bar length

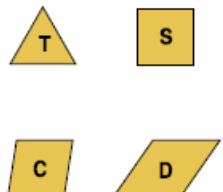


Length (L)	(mm)
H	100
K	125
M	150
N	160
Q	180
R	200
S	250
T	300
U	350
V	400

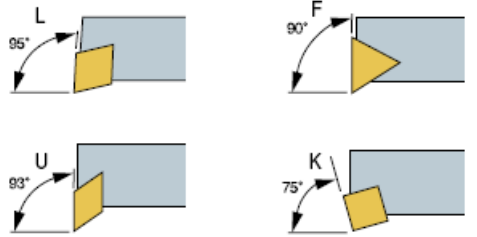
4 Method of Mounting Insert

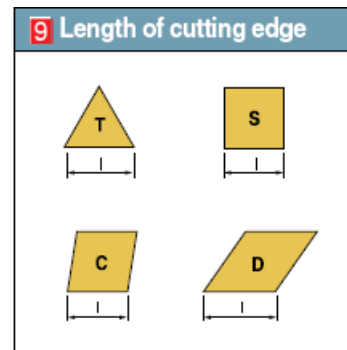
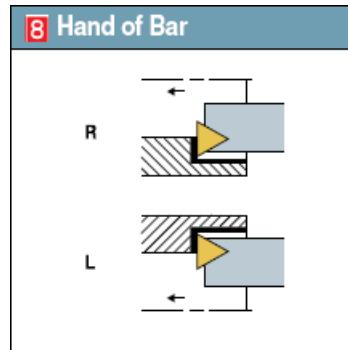
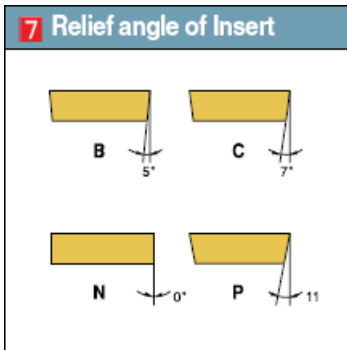
			
Top Clamping	Hole Clamping	Top and hole clamping	Screw on
C	P	M	S

5 Insert shape



6 Lead angle of boring bar





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