

ANNEXURE – 1
LIST OF STANDARD TOOLS FOR
FLOOR TYPE CNC HORIZONTAL BORING MACHINE

SNO	Tool Description	Qty	Remarks
1	Stub Arbor – ϕ22, 27,32 & 40 mm.	2 Each	Taper: BT-50 (if ATC exists) Or ISO-50
2	Face milling holder for flange mounting ϕ40, 60 mm.	2 Each	Taper: BT-50 (if ATC exists) Or ISO-50
3	Combi milling holders – ϕ16, 22,27,32,40 mm	2 Each	Taper: BT-50 (if ATC exists) Or ISO-50
4	Collet Chuck with Chucking range: ϕ3.0 to 26.0 mm	2 Each	Taper: BT-50 (if ATC exists) Or ISO-50
5	Collets size: ϕ3.0 to 26.0 mm in steps of 1.0 mm	2 Each	Taper: BT-50 (if ATC exists) Or ISO-50
6	End Mill Holders (Weldon Type) : ϕ32 and 40 mm.	2 Each	Taper: BT-50 (if ATC exists) Or ISO-50 (with coolant through flange)
7	Morse Taper Holder with tang for MT-1,MT-2, MT-3, MT-4,MT-5 & MT-6	2 Each	Taper : BT-50/ISO-50 up to MT-6.
8	Pull Studs without coolant hole	10 Nos	Taper: ISO-50 Or BT-50
9	Pull Studs with coolant hole	20 Nos	Taper: ISO-50 Or BT-50
10	Micro fine grain Solid carbide short End mills : Dia 8.0,10.0,12.0,16.0 and 20.0 mm	4 each	
11	Inserted carbide Face Mills : ϕ160, 200, 250.	1 each	Face mills with 75 deg approach angle.
12	Inserted carbide Square shoulder Face Mills : ϕ50,63,80,100,125	1 each	Face mills with 90 deg approach angle.
13	Inserts for the above face mills of Grade GC 4030 & GC 3040 of Sandvik or equivalent grade of other reputed suppliers.	100 Nos each.	

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14	Inserted carbide Full Side & Face milling cutters: φ 160 x 12 thk φ250 x 12 thk and φ 315 x 16 thk	1 each	
15	Inserts for the above side & face mills of Grade GC 4030 & GC 3040 of Sandvik or equivalent grade of other reputed suppliers	100 Nos each	
16	Sandvik Weldon type End mills (Coromill 390) of φ4,6,8,10,12, 14,16 & 18mm	2No. each	
16	Sandvik Weldon type End mills (Coromill 390) of φ20, 25,32 & 40 mm	1 No each	End mill with 90-degree approach angle.
17	Inserts for above End mills of Sandvik grade GC 4030 & GC 3040 or equivalent grade of other reputed suppliers	50 each	
18	U-max Long edge milling cutter φ 32 & φ 40 mm of Sandvik make or equivalent	1 No each	
19	Inserts for above long edge mill of Grade GC 4030 & GC 3040 of Sandvik or equivalent	50 Nos each	
20	Sandvik Coromant U drill or equivalent of following diameters with L/D = 4: <u>φ 12.7, φ 15.0, φ17.0, φ20, φ21, φ 24, φ 26, φ 30, φ 32, φ 35, φ 41, φ 43 , φ58</u>	1 No each	<u>Tap sizes or Dia sizes</u>
21	Inserts for the above drills for ISO P and K materials drilling of Sandvik or equivalent.	50 Nos each	
22	Boring Bars (Std. Type) dia. 30 to dia. 60mm	1 No each	Taper: BT-50 (if ATC exists) Or ISO-50
23	Twin edge boring bars(ROTOFLUX) dia 30 to 84mm	1 No each	Taper: BT-50 (if ATC exists) Or ISO-50
24	Adjustable Boring bars for back Counter boring/Back spot facing From dia 60 to dia 150 (pre drill sizes from dia 30 to dia 60)	1 No. each	Taper: BT-50 (if ATC exists) Or ISO-50

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25	Sleeves for boring bars		
26	Adaptors		