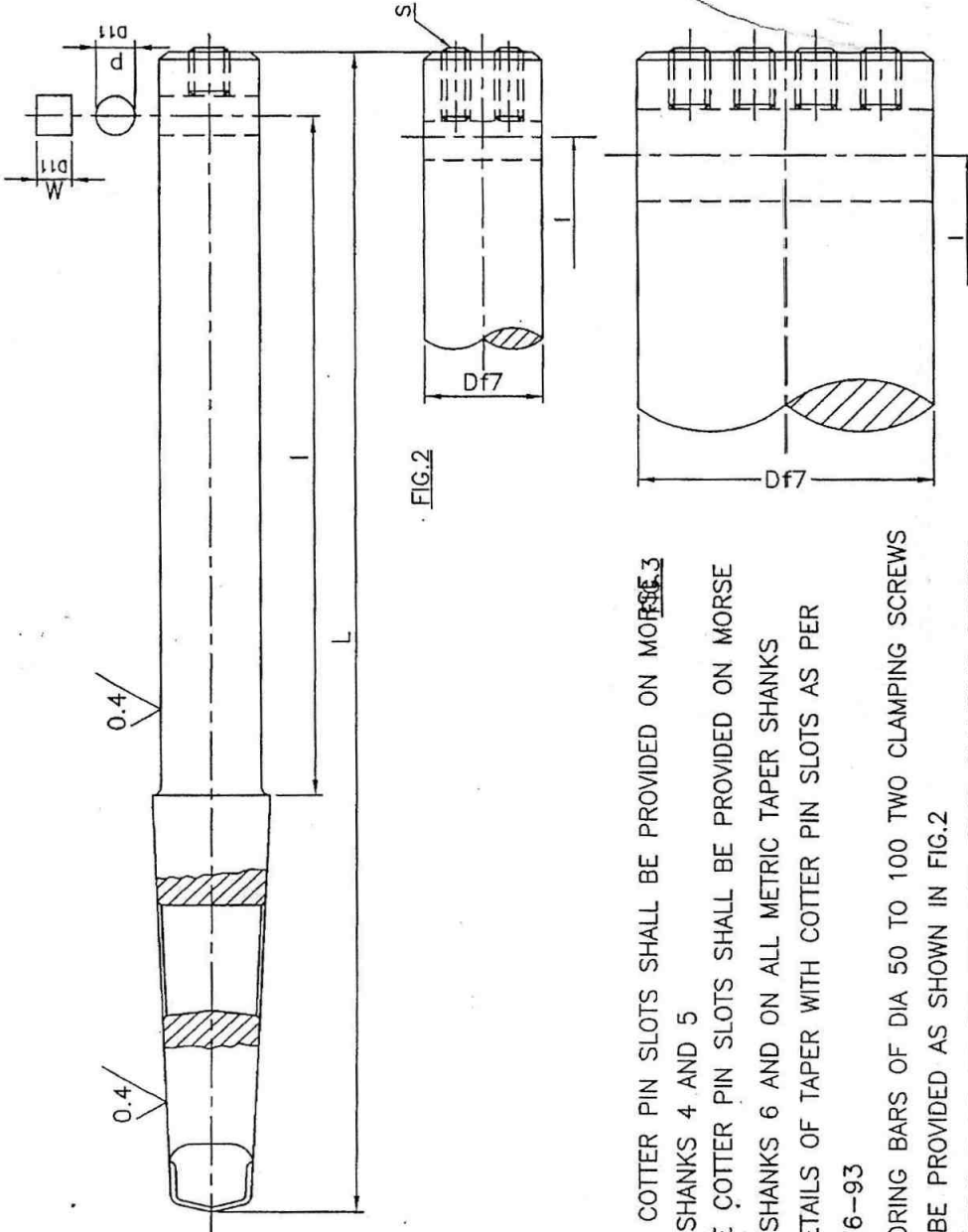


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NOTE:— 1. SINGLE COTTER PIN SLOTS SHALL BE PROVIDED ON MORSE 3 TAPER SHANKS 4 AND 5 2. DOUBLE COTTER PIN SLOTS SHALL BE PROVIDED ON MORSE TAPER SHANKS 6 AND ON ALL METRIC TAPER SHANKS 3. FOR DETAILS OF TAPER WITH COTTER PIN SLOTS AS PER IS:13776-93 4. FOR BORING BARS OF DIA 50 TO 100 TWO CLAMPING SCREWS SHALL BE PROVIDED AS SHOWN IN FIG.2 5. FOR BORING BARS OF DIA 125-160 FOUR CLAMPING SCREWS SHALL BE PROVIDED AS SHOWN IN FIG.3							
Rev.No.	Revisions :	Prepared :	Approved :	Date :			
				20.03.10			



BORING BARS FOR HORIZONTAL BORING MACHINES

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A BORING BAR SUITABLE FOR 7603691

HOLDING CIRCULAR SHANK
BORING TOOLS

B BORING BAR SUITABLE FOR 7603691

HOLDING SQUARE SHANK
BORING TOOLS

TABLE - 2

SIZE CODE TYPE	NOMINAL SIZE TAPER x D x 1		TAPER	Df7	I	L	W D11	d D11	SCREW S	NO.OF SCREWS	BORING TOOLS USED
	A	B									
302		303	4x16x70	MT4	16	70	205	6	M6x8	1	a) CARBIDE TIPPED BORING TOOLS OF STYLES E1,E2&E3 CONFORMING TO CS b) HSS TOOL BITS AFTER GRINDING THE TIP ACCORDING TO THE REQUIREMENT
304		305	4x16x150	MT4	16	150	285	6	M6x8	1	
306		307	4x20x80	MT4	20	80	220	8	M8x12	1	
308		309	4x20x175	MT4	20	175	315	8	M8x12	1	
310		311	4x20x315	MT4	20	315	515	8	M8x12	1	
312		313	4x25x125	MT4	25	125	266	10	M8x12	1	
314		315	4x25x150	MT4	25	150	291	10	M8x12	1	
316		317	4x25x250	MT4	25	250	391	10	M8x12	1	
318		319	4x25x300	MT4	25	300	500	10	M8x12	1	
320		321	4x25x450	MT4	25	450	650	10	M8x12	1	
322		323	4x32x150	MT4	32	150	295	12	M10x15	1	
324		325	4x32x300	MT4	32	300	445	12	M10x15	1	
326		327	4x40x175	MT4	40	175	323	16	M12x15	1	
328		329	4x40x325	MT4	40	325	473	16	M12x15	1	
330		331	5x32x300	MT5	32	300	500	16	M12x15	1	
332		333	5x32x450	MT5	32	450	650	16	M12x15	1	
334		335	5x40x150	MT5	40	150	295	16	M12x15	1	
336		337	5x40x475	MT5	40	475	675	16	M12x15	1	
338		339	5x50x180	MT5	50	180	360	16	M12x15	2	OPEN SLOT 25MM OPEN SLOT 25MM
340		341	5x50x330	MT5	50	330	510	16	M12x15	2	
342		343	5x50x510	MT5	50	510	710	16	M12x15	2	
344		345	5x65x250x250	MT5	65	250	450	25	M12x15	2	
346		347	5x80x250	MT5	80	250	450	25	M12x15	2	
348		349	6x50x180	MT6	50	180	423	16	M12x15	2	
350		351	6x50x330	MT6	50	330	573	16	M12x15	2	

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Prepared :	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2">SIZE CODE TYPE</th> <th>NOMINAL SIZE TAPER x D x L</th> <th>TAPER</th> <th>Df7</th> <th>I</th> <th>L</th> <th>W D11</th> <th>d D11</th> <th>SCREW S</th> <th>NO.OF SCREWS</th> <th>BORING TOOLS USED</th> </tr> <tr> <th>A</th> <th>B</th> <th colspan="10"></th> </tr> </thead> <tbody> <tr><td>352</td><td>353</td><td>6x59x450</td><td>MT6</td><td>59</td><td>450</td><td>693</td><td>20</td><td>-</td><td>M12x15</td><td>2</td><td rowspan="18"> a) STANDARD ISO TOOLS OF SQUARE SHANK WITH MINOR MODIFICATION DEPENDING UPON NECESSITY b) HSS SQUARE TOOL BLANKS AFTER GRINDING THE TIP ACCORDING TO REQUIREMENT c) 'T' MAX TOOLS OF SQUARE SHANK </td> </tr> <tr><td>354</td><td>355</td><td>6x59x650</td><td>MT6</td><td>59</td><td>650</td><td>850</td><td>20</td><td>-</td><td>M12x15</td><td>2</td> </tr> <tr><td>356</td><td>357</td><td>6x60x300</td><td>MT6</td><td>60</td><td>300</td><td>500</td><td>20</td><td>-</td><td>M12x15</td><td>2</td> </tr> <tr><td>358</td><td>359</td><td>6x60x600</td><td>MT6</td><td>60</td><td>600</td><td>800</td><td>20</td><td>-</td><td>M12x15</td><td>2</td> </tr> <tr><td>360</td><td>361</td><td>6x63x200</td><td>MT6</td><td>63</td><td>200</td><td>445</td><td>20</td><td>-</td><td>M12x15</td><td>2</td> </tr> <tr><td>362</td><td>363</td><td>6x63x350</td><td>MT6</td><td>63</td><td>350</td><td>595</td><td>20</td><td>-</td><td>M12x15</td><td>2</td> </tr> <tr><td>364</td><td>365</td><td>6x80x250</td><td>MT6</td><td>80</td><td>250</td><td>498</td><td>25</td><td>-</td><td>M12x15</td><td>2</td> </tr> <tr><td>366</td><td>367</td><td>6x80x400</td><td>MT6</td><td>80</td><td>400</td><td>648</td><td>25</td><td>-</td><td>M12x15</td><td>2</td> </tr> 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SHANK	354	355	6x59x650	MT6	59	650	850	20	-	M12x15	2	356	357	6x60x300	MT6	60	300	500	20	-	M12x15	2	358	359	6x60x600	MT6	60	600	800	20	-	M12x15	2	360	361	6x63x200	MT6	63	200	445	20	-	M12x15	2	362	363	6x63x350	MT6	63	350	595	20	-	M12x15	2	364	365	6x80x250	MT6	80	250	498	25	-	M12x15	2	366	367	6x80x400	MT6	80	400	648	25	-	M12x15	2	368	369	6x80x450	MT6	80	450	698	25	-	M12x15	2	370	371	80x80x250	METRIC 80	80	250	508	25	-	M12x15	2	372	373	80x80x500	METRIC 80	80	500	758	25	-	M12x15	2	374	375	80x100x300	METRIC 80	100	300	561	32	-	M12x15	2	376	377	80x100x600	METRIC 80	100	600	861	32	-	M12x15	2	378	379	100x100x350	METRIC 100	100	350	653	32	-	M12x15	2	380	381	100x100x650	METRIC 100	100	650	953	32	-	M12x15	2	382	383	100x125x400	METRIC 100	125	400	715	40	-	M16x25	4	384	385	100x125x750	METRIC 100	125	750	1065	40	-	M16x25	4	386	387	120x100x350	METRIC 120	100	350	695	32	-	M12x15	2	388	389	120x100x650	METRIC 120	100	650	995	32	-	M12x15	2	390	391	120x125x400	METRIC 120	125	400	758	40	-	M16x25	4	392	393	120x125x750	METRIC 120	125	750	1107	40	-	M16x25	4	394	395	120x160x450	METRIC 120	160	450	807	40	-	M16x25	4	396	397	120x160x850	METRIC 120	160	850	1207	40	-	M16x25	4	BORING BARS FOR HORIZONTAL BORING MACHINES
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BORING BARS FOR HORIZONTAL BORING MACHINES

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REV. No.

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Form No.

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1. MATERIAL AND HARDNESS:

HOLDER : CASE HARDENABLE STEEL C-14 OF I.S 1570-1961,OR EQUIVALENT.

CASE DEPTH TO 0.8MM,HARDENED TO 56-60 HRC AND GROUND.

SCREW : MEDIUM CARDON STEEL C-45 OF I.S.1570-1961,OR EQUIVALENT.

2. THESE BORING BARS FOR HORIZONTAL BORING MACHINES ARE USED ALONG WITH
THE BORING TOOLS AS SPECIFIED IN THE TABLE.

3. CARBIDE TIPPED BORING TOOLS OF BOTH SQUARE AND ROUND CROSS SECTION ARE
INCLUDED IN THE STANDARDS UPTO AND INCLUDING 16MM SIZE.THE REQUIREMENT
OF CARBIDE TIPPED TOOLS OF HIGHER SIZES FOR BORING WITH THE BORING BARS
ARE TO BE MET BY THE STANDARD ISO TOOLS OF SQUARE SECTION.HENCE,BORING
BARS OF DIAMETER 63MM AND ABOVE REQUIRING BORING TOOLS OF SHANK SIZE
20 AND ABOVE ARE PROVIDED WITH ONLY SQUARE HOLES FOR ADOPTING THE TOOLS.

4. DESIGNATION :

A BORING BAR FOR HORIZONTAL BORING MACHINE WITH MORSE TAPER 4 ;

DIAMETER D-16MM,LENGTH L=150MM SHALL BE DESIGNED AS :

BORING BAR FOR HORIZONTAL BORING MACHINE OF NOMINAL SIZE 4x16x150

760369130x

COMP FILE NAME

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Prepared by :

Approved :

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