

boring
538(537) CASSETTE
tools for fine boring

Ø 3.937" - 128.150" (100.00mm - 3255.00mm)

- ✓ Available in digital or analog
- ✓ Convenient tool handling
- ✓ Large range of applications
- ✓ Maximum flexibility



*Fine boring cassettes
for a versatile diameter range*



BORING



DRILLING



REAMING



BURNISHING



THREADING



SPECIALS

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& ENGINEERING**

Allied Machine offers a wide range of drilling, boring, reaming, burnishing, and threading tools to lower your **cost per hole**.

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538(537) Fine Boring Cassettes

ENGINEERED FOR EASY PRECISION.

Wohlhaupter® 538 (537) fine boring cassettes offer high accuracy and are available in an easy-to-use digital or analog version. The digital version features a docking port to attach the 3E^{TECH} digital readout module for μ-accurate diameter adjustments while the analog cassettes provide highly accurate adjustments through the vernier scale. The 538 (537) cassettes are made of hardened steel and can be used on serrated tool bodies and all serrated slides from 3.937" - 128.100" (100.00mm - 3255.00mm). The insert holder can be rotated easily for reverse machining applications.

Experience *digital precision boring* for yourself.



Now with a vernier scale.

NOTE: 3E^{TECH} adjustment accuracy of 0.00005" or 0.001 mm on diameter.
NOTE: Vernier adjustment accuracy of 0.0001" or 0.002 mm on diameter.



OLD CASSETTE



NEW CASSETTE

NEW DIGITAL CASSETTE PART NUMBERS

	Old Part No.	NEW Part No. with 3E ^{TECH} Port
i	538001	538052
ii	537001	537052



OLD CASSETTE



NEW CASSETTE

NEW ANALOG CASSETTE PART NUMBERS

	Old Part No.	NEW Part No.
i	338037	538051
ii	337017	537051

Accuracy & Versatility



- ▶ **Robust body**
made of hardened steel
- ▶ **Versatile use**
with serrated tool bodies and slides
- ▶ **Compatible with Combi-Line applications**
for combined rough and finish machining
- ▶ **Reverse machining capabilities**
by rotating the insert holder
- ▶ **Maximum cutting speed**
3,937 SFM (1,200 m/min)

Analog 538(537) Cassettes

	Slide Type	Boring Range	Weight	Part No.	
				Clamping Piece	Cassette
i	Serrated Tool Bodies	3.937 - 8.071	1.323 (lbs)	137026	538051
	Basic / Eco Slides	7.874 - 40.150	1.323 (lbs)	137027	538051
	Flex Slides	19.680 - 128.100	1.323 (lbs)	137019	538051
m	Serrated Tool Bodies	100.00 - 205.00	0.60 (kg)	137026	537051
	Basic / Eco Slides	200.00 - 1020.00	0.60 (kg)	137027	537051
	Flex Slides	500.00 - 3255.00	0.60 (kg)	137019	537051

Digital 538 (537) Cassettes

	Slide Type	Boring Range	Weight	Part No.	
				Clamping Pieces	Cassette
i	Serrated Tool Bodies	3.937 - 8.071	1.323 (lbs)	137026	538052
	Basic / Eco Slides	7.874 - 40.150	1.323 (lbs)	137027	538052
	Flex Slides	19.680 - 128.100	1.323 (lbs)	137019	538052
m	Serrated Tool Bodies	100.00 - 205.00	0.60 (kg)	137026	537052
	Basic / Eco Slides	200.00 - 1020.00	0.60 (kg)	137027	537052
	Flex Slides	500.00 - 3255.00	0.60 (kg)	137019	537052

NOTE: 3E^{TECH+} digital readout module, insert holders, inserts, and clamping pieces ***sold separately***

3E^{TECH+} Digital Readout Module

Part No.	Charging Unit*
536015	536016

NOTE: WEEE-Reg.-Nr. DE 15820388

*Charging unit sold separately



NOTE: 3E^{TECH+} adjustment accuracy of 0.00005" or 0.001 mm on diameter.



Insert Holders

	Boring Range	Insert Form	Part No.
i	3.937 - 128.150	20	210020
	3.937 - 128.150	101	210063
	3.937 - 128.150	103	210064
m	100.00 - 3255.00	20	210020
	100.00 - 3255.00	101	210063
	100.00 - 3255.00	103	210064



Insert Holders for Abrasive Materials

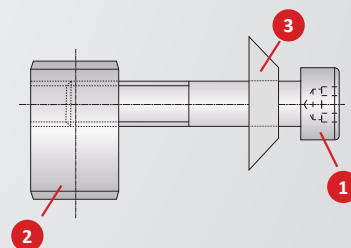
	Boring Range	Insert Form	Part No.
i	3.937 - 128.150	20	211061
	3.937 - 128.150	101	211063
	3.937 - 128.150	103	211065
m	100.00 - 3255.00	20	211061
	100.00 - 3255.00	101	211063
	100.00 - 3255.00	103	211065



NOTE: Insert holders are used for abrasive materials to protect boring head against chip wash

538 (537) Clamping Pieces

Slide Type	Complete Part No.	Service Key	Replacement Components			
			1 Cap Screw	2 Clamping Nut	3 Disk Spring	
Serrated Tool Bodies	137026	115578	s6 / B	215101	140118	337105
Basic and Eco Slides	137027			215102	215105	337105
Flex Slides	137019			415900	215105	337105



538 (537) Counter Weights

	Boring Range	Part No.
i	3.937 - 128.15	538055
m	100.00 - 3255.00	537055

NOTE: Clamping piece sold separately



Allied Machine offers expert engineering support. Whether you need a quote, a test, or an application solution, a highly skilled and trained engineer is standing by, ready to help. www.alliedmachine.com/contactus

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