

section B10-K

Special Boring Solutions

Wohlhaupter[®] Special Boring Solutions



Special Design Tooling

When it comes to special solutions for customers, Wohlhaupter has unique capabilities to effectively design and develop special boring tools. Our special boring tools are designed for specific machines, processes, and materials to help save you time and money.

If you have a particularly unique or difficult application, give our Application Engineering team a call.

phone: 330.343.4283 ext: 7611 | email: appeng@alliedmachine.com

Applicable Industries





Agriculture



Automotive



Machining

Firearms



Energy

Your safety and the safety of others is very important. This catalog contains important safety messages. Always read and follow all safety precautions.



This triangle is a safety hazard symbol. It alerts you to potential safety hazards that can cause tool failure and serious injury.

When you see this symbol in the catalog, look for a related safety message that may be near this triangle or referred to in the nearby text.

There are safety signal words also used in the catalog. Safety messages follow these words.

WARNING

WARNING (shown above) means that failure to follow the precautions in this message could result in tool failure and serious injury.

NOTICE means that failure to follow the precautions in this message could result in damage to the tool or machine but not result in personal injury.

NOTE and IMPORTANT are also used. These are important that you read and follow but are not safety-related.

Visit www.alliedmachine.com for the most up-to-date information and procedures.

Aerospace

Wohlhaupter[®] Special Boring Solutions Table of Contents

Special Tooling Solutions

ES	-Bore Fine Boring Lay Down Cartridge	2
	EK Groover Lay Down Cartridge	3
	Anti-Vibration Multistep Boring Tool	4
OD T	urning Tool Padded Line Boring Tool	5
	3E ^{TECH+} Special Tools	6
	DigiBore Special Boring Tools	7
	Combi-Line Special Boring Tool	8

ES-Bore Fine Boring Lay Down Cartridge

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Μ

INDEX

B10-K: 2

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- ▶ Available with digital 3E^{TECH+} or analog adjustment.
- Accurate adjustments with easy-to-use settings.
- Versatility in many different application types over 1.102" (28.00 mm) on diameter.

INDEX

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B10-K: 3

GROOVING TOOLS

EK GROOVER

• Create complex grooves faster and deeper than ever before.

WOHLHAUPT

- Eliminate chatter in hard-to-reach internal forms.
- ▶ The electronically-controlled insert release can be adapted to most machine tools.
- Single or double grooving in one operation.

ROUGH BORING TOOLS

LAY DOWN CARTRIDGE

- Increase the productivity of your roughing tool while protecting your investment.
- ▶ If the tool is ever damaged, simply replace a cartridge and resume making chips.

Anti-Vibration | Multistep Boring Tool

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Optimized tool weight.

SPECIAL BORING TOOLS

 Used to reduce harmonic vibration in deeper boring applications.

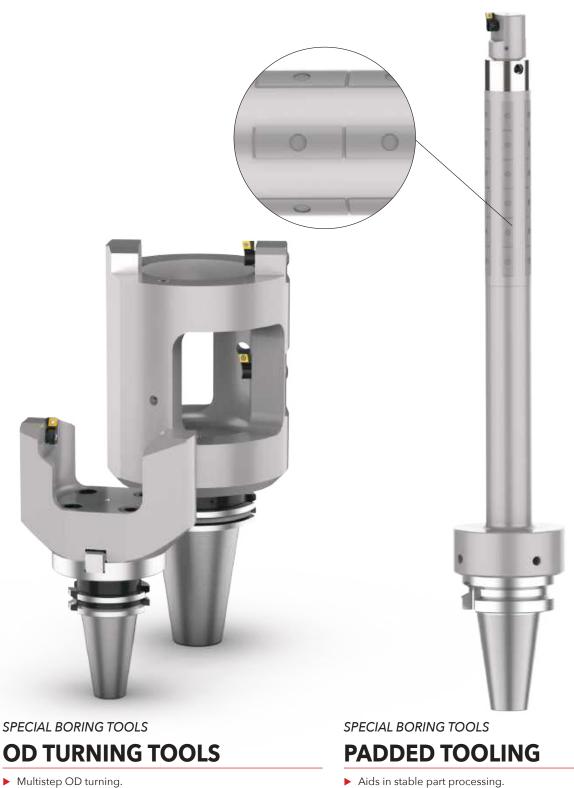
SPECIAL BORING TOOLS MULTISTEP BORING TOOL

- ▶ Fine adjustment tool for reverse machining.
- Combined with multidiameter fine adjustable cartridges for finish machining.

INDEX

Drastically reduce cycle time.

▶ Improve surface finish and feature concentricity.



- ▶ Aids in stable part processing.
- Expands length-to-diameter capabilities.
- ▶ Improves surface finish.
- ▶ Pads are replaceable to extend tool life.

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INDEX

Multistep Boring Tool | Line Boring Tool

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INDEX



NOTE: 3ETECH+ adjustment accuracy of 0.00005" or 0.001 mm on diameter.

3ETECH+ BORING TOOL

LINE BORING TOOL

- One digital readout module used on all steps.
- Easy diameter adjustment at the machine spindle.

NOTE: 3ETECH+ adjustment

accuracy of 0.00005" or

0.001 mm on diameter.



3ETECH+ BORING TOOL

MULTISTEP BORING TOOL

► Easy diameter adjustments with 3E^{TECH+}.

One digital readout module to use on all steps.

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FINISH BORING TOOLS **DIGIBORE WITH 249 (248)**

- Standard DigiBore head, standard 249 (248) head, and special slide for precise two-step bore.
- MVS connection.

FINISH BORING TOOLS

DIGIBORE SPECIAL

- Standard DigiBore boring head with OD turn and OD chamfer insert holder.
- MVS connection.

Combi-Line Special Boring Tool

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ROUGH, FINISH, and CHAMFER BORING TOOLS

- Standard Combi-Line tooling with added chamfer cartridge.
- MVS connection.

B10-K: 8

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17

Online Tools

ToolMD[®] | Wohlhaupter[®] Boring Insert Selector



Design Your Own Solutions

ToolMD is a configurator for Wohlhaupter modular tooling systems that allows customers to virtually build their own solution. This online-based simulator puts the entire Wohlhaupter product line at your fingertips. It provides a digital bank of every individual part that Wohlhaupter manufactures in either inch or metric.

Once you select a component, you will be guided by a series of user-friendly prompts to select the next components until you have built your tooling system. Throughout the process, you can monitor the size of your custom tool and ensure what you're building matches your real-life specifications. Once a complete system is virtually assembled, the program will render the tool in either a 2D or 3D drawing to view on your device.

Designing your tools with ToolMD saves you time and allows you to instantly obtain the right tool for the job.



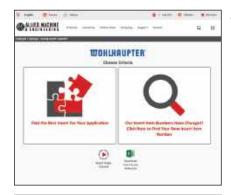
Design anytime from anywhere. Available online 24/7.

GALLER WORLARDPTER

WOHLHAUPTER[®] | Boring Insert Selector

1

www.alliedmachine.com/bis





 Generate the correct boring insert for your application in just six easy steps.

- Choose type, shape, substrate, insert form, nose radius, and workpiece material.
- Order easily by adding the item to your cart.



- Search for your new insert item number by entering your old item number.

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Distributor PO #

The following must be filled out completely before your test will be considered.

Distributor Information					End Us	End User Information					
Company Name:						Name:					
Contact:					Contact:	-					
Account Number:					Industry:	-					
Phone:					Phone:	-					
Email:					Email:	-					
Current Process	List all tooling, coat	ings,	substrat	es, speeds and feeds	s, tool life, and a	ny problem	s you are exper	iencing.			
Test Objective	List what would ma	ike ti	nis a succ	essful test (i.e. pene	tration rate, finis	sh, tool life,	hole size, etc.).				
Application Inform	ation										
Hole Diameter:		_ in/	mm	Tolerance:			Material:				
								(4150, A36	, cast iron, etc.)		
Preexisting Diameter	:	_ in/	mm	Depth of Cut: _	i	in/mm	Hardness:				
								(В	HN, Rc)		
Required Finish:	RMS						State:	(Casting, ho	ot rolled, forging)		
Machine Informat	ion										
	Latha scrow machina				r:(Haas	, Mori Seiki, e		Model #:			
	(Lathe, screw machine, machine center, etc.)					, WOLLSEIKI, G	2((.)				
Shank Required:	(CAT50, Morse taper, etc.)							Power:	HP/KW		
		ie cup		Detetion				Thruct	lbs/N		
Rigidity:	Orientation:			Rotating:				Thrust:	lbs/N		
Excellent	Vertical										
Good	Horizontal			NO							
Poor											
Coolant Information	on										
Coolant Delivery:					Cool	Coolant Pressure:			DSI / har		
	(Through tool, flood)				000	int ressult			i 5i / Dai		
Coolant Type:					Coola	ant Volume			GPM / LPM		
	(Air mist, o	il, syr	nthetic, wa	ater soluble, etc.)							
)											
Requested Tooling									D MACHI		
QTY Item Number			QTY	Item Number							
		_						Allied	Machine & Engine 120 Deeds I		
		-							Dover, OH 4		
		_						Tela	phone: (330) 343-4		

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Warranty Information

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Complete information as to operating conditions, machine, setup, and the application of cutting fluid should accompany any product returned for inspection. This warranty shall not apply to any Allied Machine products which have been subjected to misuse, abuse, improper operating conditions, improper machine setup or improper application of cutting fluid or which have been repaired or altered if such repair or alteration, in the judgement of Allied Machine, would adversely affect the performance of the product.

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