



**ALLIED MACHINE
& ENGINEERING**

WOHLHAUPTER®

Holemaking Solutions for Today's Manufacturing



Drilling



Reaming



Burnishing



Threading



Specials



Wohlhaupter®

► **BORING**

Versatile Fine Boring

WOHLHAUPTER®

SECTION

B10-A

Versatile Fine Boring

Wohlhaupter® Versatile Fine Boring

VarioBore | 248 | PrimeBore | Digital 510 | DigiBore

► Diameter Range: 0.40 mm - 208.00 mm



WOHLHAUPTER®

Precision boring at its finest.

From high precision to high production, Wohlhaupter has the right solution for your hole finishing applications. With the most reliable digital readout displays, the Wohlhaupter versatile boring product line offers the most precise and flexible modular system on the market.

Your safety and the safety of others is very important. This catalogue 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 catalogue, 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 catalogue. 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.

Applicable Industries



Aerospace



Agriculture



Automotive



Firearms



General Machining



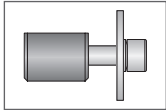
Oil & Gas



Renewable Energy

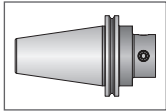
Reference Icons

The following icons will appear throughout the catalogue to help you navigate between products.



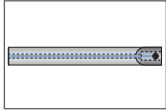
Clamping Elements

For use with insert holders and boring heads



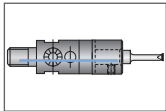
Shanks

A variety of shanks for different machines



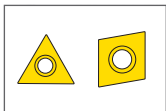
248 Shanks

A variety of shanks for different machines



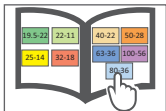
248 Boring Head

248 boring head that connects into the adapter shanks



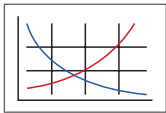
Inserts

For use with insert holder boring heads and boring bars using indexable inserts



MVS Connection Colour Guide

Detailed instructions and information regarding the MVS connection(s)



Recommended Cutting Data

Speed and feed recommendations for optimum and safe boring



Through Coolant Option

Indicates that the product is through coolant

| Series | Diameter Range |
|-----------------|----------------|
| | Metric (mm) |
| VarioBore 536 | 0.40 - 152.00 |
| 248 Boring Head | 3.00 - 30.20 |
| PrimeBore 450 | 3.00 - 208.00 |
| Digital 510 | 0.40 - 12.00 |
| DigiBore 501 | 3.00 - 208.00 |

Versatile Fine Boring Contents

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VarioBore Product Overview



VarioBore with 3E^{TECH+} VERSATILE FINE BORING

Need more versatility?

The Wohlhaupter® VarioBore head offers precision and versatility, and the 3E^{TECH+} docking port provides convenient and simple diameter adjustments.

Experience *precision boring* for yourself.

- Diameter range: 0.40 mm - 152.00 mm
- Offers outside turning capabilities: 2.00 mm - 66.00 mm
- Ease the stress of working on different day-to-day projects with boring kits
- 3E^{TECH+} module provides a simple digital readout
- Max spindle speed: 27,500 RPM



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

NOTE: Vernier adjustment accuracy of 0.002 mm on diameter

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com



3E TECH+
Universal Digital
Module



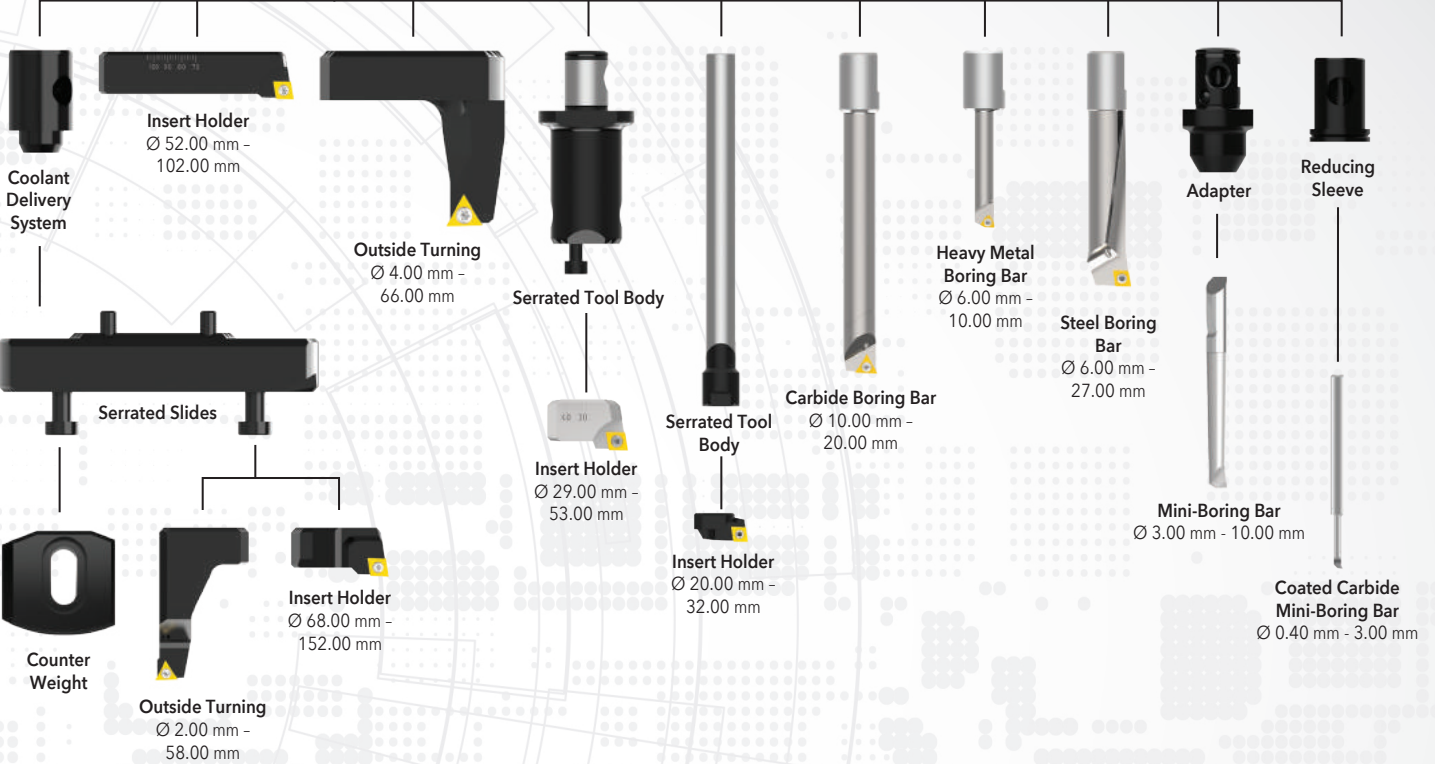
VarioBore Head

VARIO BORE

with **3E TECH+** Universal Digital
Readout Module

NOTE: 3E TECH+ adjustment accuracy of 0.001 mm on diameter

NOTE: Vernier adjustment accuracy of 0.002 mm on diameter



OPERATION **VERSATILITY**

from **0.40 mm** to **152.00 mm**
plus outside turning



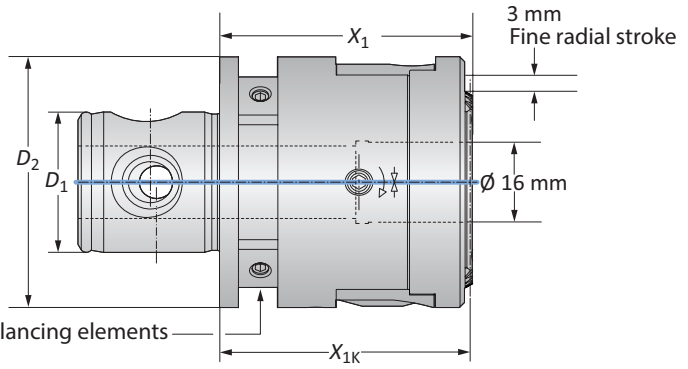
NOTE: 3E TECH+ adjustment accuracy of 0.001 mm on diameter

NOTE: Vernier adjustment accuracy of 0.002 mm on diameter



Digital 3E^{TECH+} Boring Head

Diameter Range: 0.40 mm - 152.00 mm



NOTE: Vernier adjustment accuracy of 0.002 mm on diameter

VarioBore Digital 3E^{TECH+} Boring Head

| MVS Connection | Boring Head | | Weight | Part No. |
|----------------|---------------|-------|----------|---------------|
| $D_2 D_1$ | Boring Range | X_1 | X_{1K} | |
| 50 - 28 | 0.40 - 152.00 | 50.00 | 49.50 | 536002 |

NOTE: Balancing elements, 3E^{TECH+} digital readout module, and charging unit must be ordered separately.
NOTE: VarioBore heads are compatible with Kaiser® connection

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 0.001 mm on diameter

Key on B10-A:1

B10-M: 12-13

B10-F

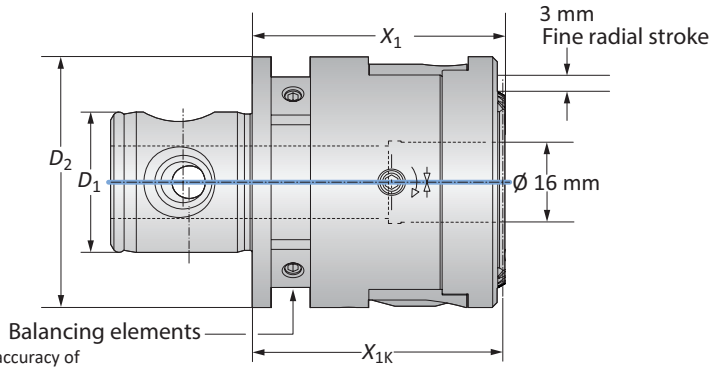
B10: VI-VII

= Metric (mm)

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com


Non-Digital Boring Head

Diameter Range: 0.40 mm - 152.00 mm



NOTE: Vernier adjustment accuracy of 0.002 mm on diameter

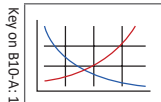
VarioBore Non-Digital Boring Head

| MVS Connection | | Boring Head | | | Weight | Part No. |
|---|---------------|-------------|----------|-----------|--------|----------|
| $D_2 D_1$ | Boring Range | X_1 | X_{1K} | | | |
|  50 - 28 | 0.40 - 152.00 | 50.00 | 49.50 | 0.70 (kg) | 536001 | |

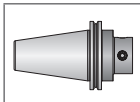
NOTE: Balancing elements must be ordered separately.

NOTE: VarioBore heads are compatible with Kaiser® connection

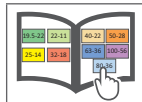
B10-M: 12-13



B10-F



B10: VI-VII

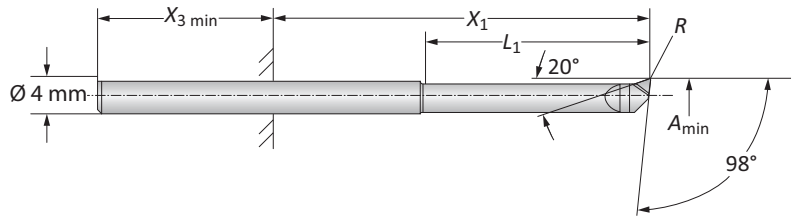


 = Metric (mm)

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

Mini Boring Bars

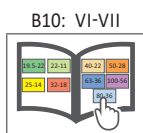
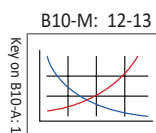
WHC126 Coated Carbide | Diameter Range: 0.40 mm - 3.00 mm



Mini Boring Bars

| | Boring Range | | Boring Bar* | | | | Part No. |
|---|--------------|---------------|--------------|-------|------|--------------|----------|
| | A_{min} | X_1 | $X_{3\ min}$ | L_1 | R | | |
| m | 0.40 | 3.00 - 17.00 | 25.00 | 2.00 | 0.03 | 081401WHC126 | |
| | 0.60 | 4.00 - 18.00 | 25.00 | 3.00 | 0.04 | 081402WHC126 | |
| | 0.80 | 5.00 - 19.00 | 25.00 | 4.00 | 0.04 | 081403WHC126 | |
| | 1.00 | 6.00 - 20.00 | 25.00 | 5.00 | 0.05 | 081404WHC126 | |
| | 1.50 | 8.50 - 22.50 | 25.00 | 7.50 | 0.05 | 081405WHC126 | |
| | 2.00 | 11.00 - 25.00 | 25.00 | 10.00 | 0.05 | 081406WHC126 | |
| | 2.50 | 13.50 - 27.50 | 25.00 | 12.50 | 0.05 | 081407WHC126 | |
| | 2.80 | 15.00 - 28.00 | 25.00 | 14.00 | 0.07 | 081408WHC126 | |

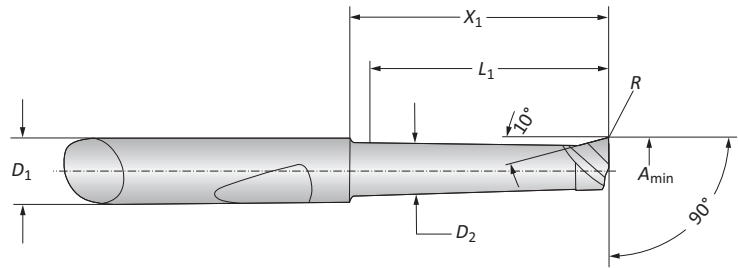
*Fixture-through reducing sleeve (B10-A: 17)



m = Metric (mm)

Mini Boring Bars

WHC05 | WHW04 | WBN150 | Diameter Range: 3.00 mm - 10.00 mm



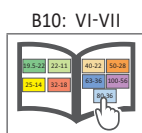
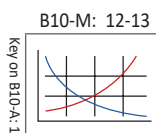
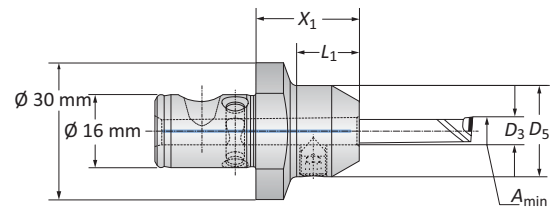
Mini Boring Bars

| Boring Range | Boring Bar | | | | | Part No. | | | |
|--------------|------------|-------|-------|-------|-------|----------|----------------|------------------|--------------|
| | A_{min} | D_1 | D_2 | X_1 | L_1 | R | Coated Carbide | Uncoated Carbide | CBN |
| 3.00 | 6.00 | 2.60 | 11.50 | 10.00 | 0.10 | 0.10 | 081306WHC05 | - | 081322WBN150 |
| 3.00 | 6.00 | 2.60 | 16.50 | 15.00 | 0.10 | 0.10 | 081307WHC05 | 081307WHW04 | - |
| 4.00 | 6.00 | 3.60 | 12.00 | 10.00 | 0.20 | 0.20 | 081308WHC05 | - | 081317WBN150 |
| 4.00 | 6.00 | 3.60 | 17.00 | 15.00 | 0.20 | 0.20 | 081309WHC05 | - | 081341WBN150 |
| 4.00 | 6.00 | 3.60 | 22.00 | 20.00 | 0.20 | 0.20 | 081310WHC05 | 081310WHW04 | - |
| 5.00 | 6.00 | 4.60 | 12.00 | 10.00 | 0.20 | 0.20 | 081311WHC05 | - | 081318WBN150 |
| 5.00 | 6.00 | 4.60 | 22.00 | 20.00 | 0.20 | 0.20 | 081312WHC05 | - | 081319WBN150 |
| 5.00 | 6.00 | 4.60 | 32.00 | 30.00 | 0.20 | 0.20 | 081313WHC05 | 081313WHW04 | - |
| 6.00 | 6.00 | 5.60 | 22.00 | 20.00 | 0.20 | 0.20 | 081314WHC05 | - | 081320WBN150 |
| 6.00 | 6.00 | 5.60 | 32.00 | 30.00 | 0.20 | 0.20 | 081315WHC05 | - | 081321WBN150 |
| 6.00 | 6.00 | 5.60 | 42.00 | 40.00 | 0.20 | 0.20 | 081316WHC05 | 081316WHW04 | - |
| 8.00 | 8.00 | 7.60 | 25.00 | 23.00 | 0.20 | 0.20 | 081323WHC05 | - | - |
| 8.00 | 8.00 | 7.60 | 50.00 | 48.00 | 0.20 | 0.20 | 081324WHC05 | - | - |



Adapters

| Boring Range | Adapter | | | | Part No. |
|--------------|-----------|-------|-------|-------|----------|
| | A_{min} | D_3 | D_5 | X_1 | |
| 3.00 | 6.00 | 20.00 | 22.50 | 14.00 | 319010 |
| 8.00 | 8.00 | 22.00 | 22.50 | 14.00 | 236071 |



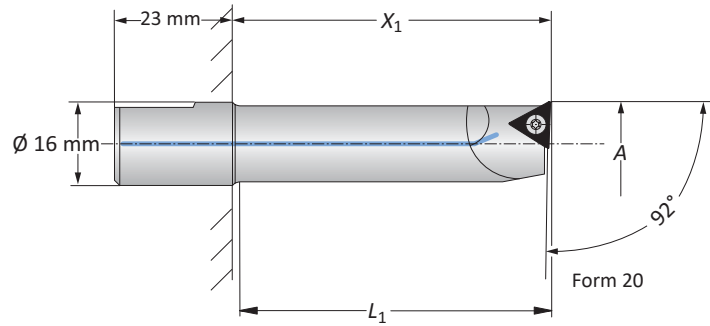
m = Metric (mm)

Boring Bars

Steel | Diameter Range: 6.00 mm - 27.00 mm

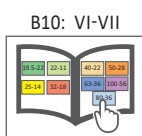
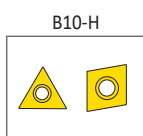
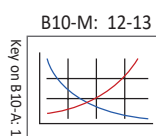


Form 101



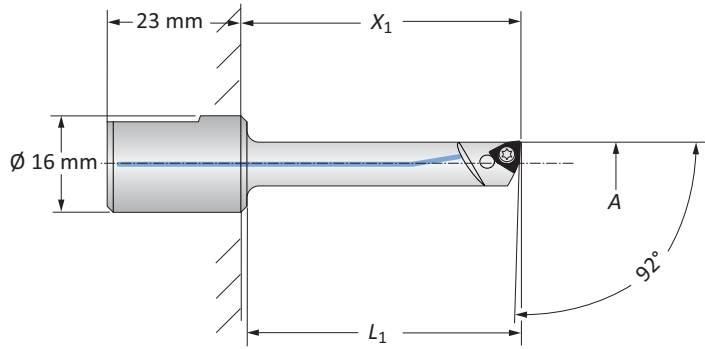
| Boring Range | Boring Bar | | Weight | Insert Form | Part No. | Insert Form | Part No. | |
|-----------------|------------|----------------|--------|-------------|----------|-------------|----------|----------------|
| | A | X ₁ | | | | | | L ₁ |
| 6.00 - 8.00 | | 22.00 | 19.00 | 0.03 (kg) | - | - | 211* | 081053 |
| 8.00 - 10.00 | | 30.00 | 27.00 | 0.04 (kg) | - | - | 211* | 218071 |
| 10.00 - 12.00 | | 45.00 | 42.00 | 0.05 (kg) | - | - | 20* | 081044 |
| 10.00 - 12.00 | | 25.00 | 22.00 | 0.04 (kg) | 101 | 218047 | 20* | 218058 |
| 10.00 - 12.00 | | 35.00 | 32.00 | 0.05 (kg) | 101 | 218048 | 20* | 218059 |
| 12.00 - 14.00 | | 30.00 | 27.00 | 0.05 (kg) | 101 | 218012 | 20* | 218014 |
| 12.00 - 14.00 | | 45.00 | 42.00 | 0.06 (kg) | 101 | 218049 | 20* | 218060 |
| 14.00 - 16.00 | | 35.00 | 32.00 | 0.06 (kg) | 101 | 218050 | 20* | 218061 |
| m 14.00 - 16.00 | | 50.00 | 47.00 | 0.08 (kg) | 101 | 218051 | 20* | 218062 |
| 15.00 - 17.00 | | 37.00 | 34.00 | 0.06 (kg) | - | - | 20* | 081048 |
| 15.00 - 17.00 | | 60.00 | 57.00 | 0.08 (kg) | 101 | 081041 | 20* | 081045 |
| 16.00 - 20.00 | | 40.00 | 37.00 | 0.08 (kg) | 101 | 218052 | 20* | 218063 |
| 16.00 - 20.00 | | 60.00 | 57.00 | 0.09 (kg) | 101 | 218053 | 20* | 218064 |
| 20.00 - 25.00 | | 37.00 | 34.00 | 0.07 (kg) | - | - | 20* | 081049 |
| 20.00 - 25.00 | | 70.00 | 67.00 | 0.11 (kg) | 101 | 081042 | 20* | 081046 |
| 25.00 - 27.00 | | 37.00 | 34.00 | 0.07 (kg) | - | - | 20* | 081050 |
| 25.00 - 27.00 | | 70.00 | 67.00 | 0.11 (kg) | 101 | 081043 | 20* | 081047 |

*Not suitable for indexable inserts with a radius of 0.80 mm



Boring Bars

Heavy Metal | Carbide Diameter Range: 6.00 mm - 20.00 mm



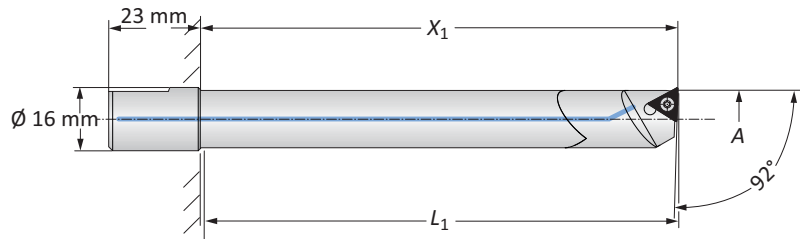
Heavy Metal Boring Bars | Diameter Range: 6.00 mm - 10.00 mm

| m | Boring Range | | Boring Bar | | Weight | Insert Form | Part No. |
|---|--------------|----------------|----------------|--|-----------|-------------|----------|
| | A | X ₁ | L ₁ | | | | |
| | 6.00 - 8.00 | 32.00 | 29.00 | | 0.08 (kg) | 211* | 081055 |
| | 8.00 - 10.00 | 45.00 | 42.00 | | 0.09 (kg) | 211* | 218072 |

*Not suitable for indexable inserts with a radius of 0.80 mm



Form 101

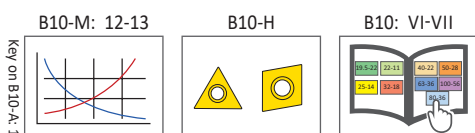


Form 20

Carbide Boring Bars | Diameter Range: 10.00 mm - 20.00 mm

| m | Boring Range | | Boring Bar | | Weight | Insert Form | Part No. | Insert Form | Part No. |
|---|---------------|----------------|----------------|--|-----------|-------------|----------|-------------|----------|
| | A | X ₁ | L ₁ | | | | | | |
| | 10.00 - 12.00 | 55.00 | 52.00 | | 0.07 (kg) | 101 | 218042 | 20* | 218037 |
| | 10.00 - 12.00 | 75.00 | 72.00 | | 0.09 (kg) | 101 | 218032 | 20* | 218029 |
| | 12.00 - 14.00 | 70.00 | 67.00 | | 0.10 (kg) | 101 | 218043 | 20* | 218038 |
| | 12.00 - 14.00 | 90.00 | 87.00 | | 0.15 (kg) | 101 | 218033 | 20* | 218030 |
| | 14.00 - 16.00 | 75.00 | 72.00 | | 0.16 (kg) | 101 | 218044 | 20* | 218039 |
| | 14.00 - 16.00 | 100.00 | 97.00 | | 0.20 (kg) | 101 | 218045 | 20* | 218040 |
| | 16.00 - 20.00 | 90.00 | 87.00 | | 0.26 (kg) | 101 | 218046 | 20* | 218041 |
| | 16.00 - 20.00 | 120.00 | 117.00 | | 0.33 (kg) | 101 | 218034 | 20* | 218031 |

*Not suitable for indexable inserts with a radius of 0.80 mm



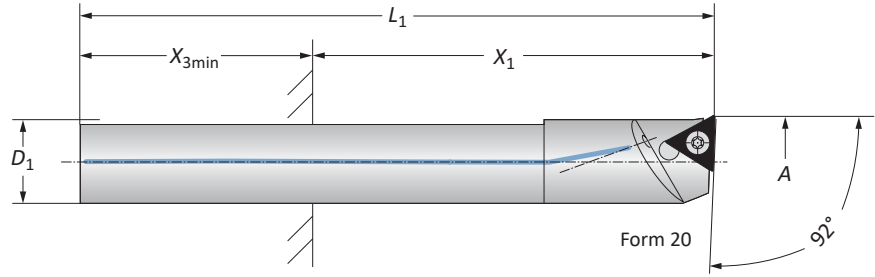
m = Metric (mm)
Inserts sold separately

Boring Bars

Steel | Carbide | Diameter Range: 6.00 mm - 20.00 mm



Form 101



Steel Boring Bars | Diameter Range: 6.00 mm - 20.00 mm

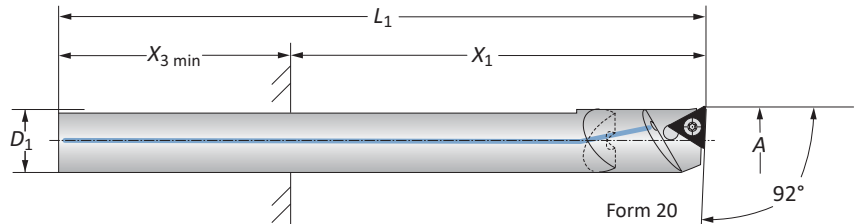
| Boring Range | Boring Bar | | | | | Weight | Part No. | | | |
|---------------|------------|----------------|----------------|--------------------|----------------|--------|-------------|------------|-------------|------------|
| | A | D ₁ | X ₁ | X _{3 min} | L ₁ | | Insert Form | Boring Bar | Insert Form | Boring Bar |
| 6.00 - 8.00 | 5.00* | 12.50 - 25.00 | 25.00 | 70.00 | 0.01 (kg) | 211** | 514032 | - | - | |
| 8.00 - 10.00 | 7.00* | 17.50 - 35.00 | 25.00 | 81.00 | 0.02 (kg) | 211** | 514033 | - | - | |
| 10.00 - 12.00 | 8.00* | 20.00 - 40.00 | 25.00 | 85.00 | 0.03 (kg) | 101 | 514003 | 20** | 514004 | |
| 12.00 - 14.00 | 10.00* | 25.00 - 50.00 | 25.00 | 100.00 | 0.05 (kg) | 101 | 514005 | 20** | 514006 | |
| 14.00 - 16.00 | 12.00* | 30.00 - 60.00 | 30.00 | 114.00 | 0.09 (kg) | 101 | 514007 | 20** | 514008 | |
| 16.00 - 18.00 | 14.00* | 56.00 - 70.00 | 30.00 | 121.00 | 0.13 (kg) | 101 | 514009 | 20** | 514010 | |
| 18.00 - 20.00 | 14.00* | 56.00 - 70.00 | 30.00 | 121.00 | 0.13 (kg) | 101 | 514011 | 20** | 514012 | |

*Fixture-through reducing sleeve required (B10-A: 17)

**Not suitable for indexable inserts with a radius of 0.8 mm



Form 101

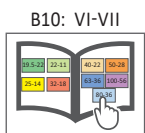
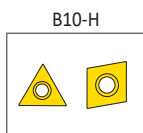
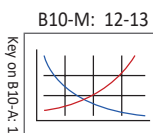


Carbide Boring Bars | Diameter Range: 6.00 mm - 20.00 mm

| Boring Range | Boring Bar | | | | | Weight | Part No. | | | |
|---------------|------------|-----------------|----------------|--------------------|----------------|--------|-------------|------------|-------------|------------|
| | A | D ₁ | X ₁ | X _{3 min} | L ₁ | | Insert Form | Boring Bar | Insert Form | Boring Bar |
| 6.00 - 8.00 | 5.00* | 12.50 - 40.00 | 25.00 | 90.00 | 0.02 (kg) | 211** | 514034 | - | - | |
| 8.00 - 10.00 | 7.00* | 21.00 - 56.00 | 25.00 | 109.00 | 0.05 (kg) | 211** | 514035 | - | - | |
| 10.00 - 12.00 | 8.00* | 22.00 - 64.00 | 25.00 | 117.00 | 0.07 (kg) | 101 | 514015 | 20** | 514016 | |
| 12.00 - 14.00 | 10.00* | 51.00 - 80.00 | 25.00 | 140.00 | 0.13 (kg) | 101 | 514017 | 20** | 514018 | |
| 14.00 - 16.00 | 12.00* | 68.00 - 96.00 | 30.00 | 162.00 | 0.22 (kg) | 101 | 514019 | 20** | 514020 | |
| 16.00 - 18.00 | 14.00* | 77.00 - 112.00 | 30.00 | 142.00 | 0.26 (kg) | 101 | 514021 | 20** | 514022 | |
| 16.00 - 18.00 | 14.00* | 112.00 - 147.00 | 30.00 | 177.00 | 0.33 (kg) | 101 | 514023 | 20** | 514024 | |
| 18.00 - 20.00 | 14.00* | 77.00 - 112.00 | 30.00 | 142.00 | 0.26 (kg) | 101 | 514025 | 20** | 514026 | |
| 18.00 - 20.00 | 14.00* | 112.00 - 147.00 | 30.00 | 177.00 | 0.33 (kg) | 101 | 514027 | 20** | 514028 | |

*Fixture-through reducing sleeve required (B10-A: 17)

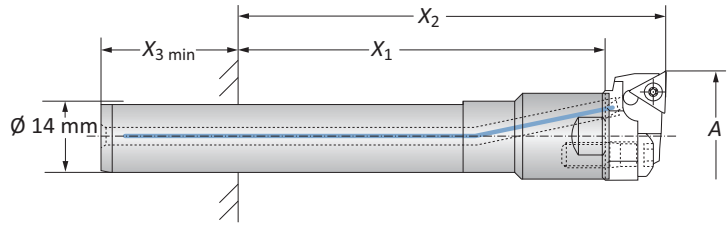
**Not suitable for indexable inserts with a radius of 0.80 mm



m = Metric (mm)
Inserts sold separately

Serrated Tool Bodies | Insert Holders

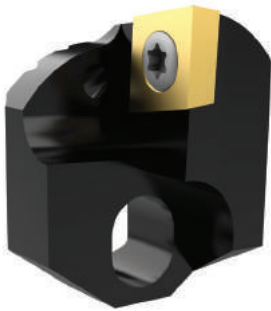
Diameter Range: 20.00 mm - 32.00 mm



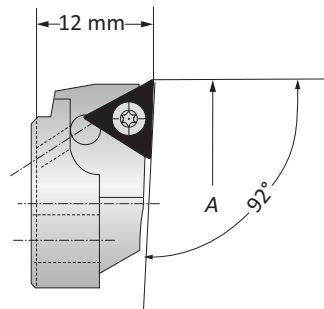
Serrated Tool Bodies

| Substrate | Boring Range A | Serrated Tool Body* | | | Weight | Part No. |
|-----------|-------------------|---------------------|-----------------|--------------------|-----------|---------------|
| | | X ₁ | X ₂ | X _{3 min} | | |
| Steel | 20.00 - 32.00 | 37.00 - 72.00 | 49.00 - 84.00 | 30.00 | 0.13 (kg) | 514029 |
| Carbide | 20.00 - 32.00 | 65.00 - 100.00 | 77.00 - 112.00 | 30.00 | 0.25 (kg) | 514030 |
| Carbide | 20.00 - 32.00 | 100.00 - 135.00 | 112.00 - 147.00 | 30.00 | 0.33 (kg) | 514031 |

*Fixture-through reducing sleeve (B10-A: 17)



Form 101

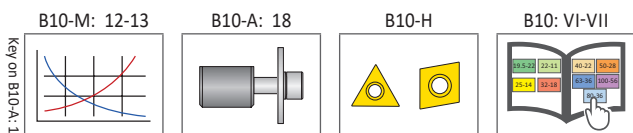


Form 20

Insert Holders

| Boring Range A | Weight | Insert Form | Part No. | Insert Form | Part No. |
|-------------------|-----------|-------------|---------------|-------------|---------------|
| | | | | | |
| 22.00 - 24.00 | 0.01 (kg) | 101 | 502053 | 20* | 502047 |
| 24.00 - 26.00 | 0.01 (kg) | 101 | 502054 | 20* | 502048 |
| 26.00 - 28.00 | 0.01 (kg) | 101 | 502055 | 20* | 502049 |
| 28.00 - 30.00 | 0.01 (kg) | 101 | 502056 | 20* | 502050 |
| 30.00 - 32.00 | 0.01 (kg) | 101 | 502057 | 20* | 502051 |

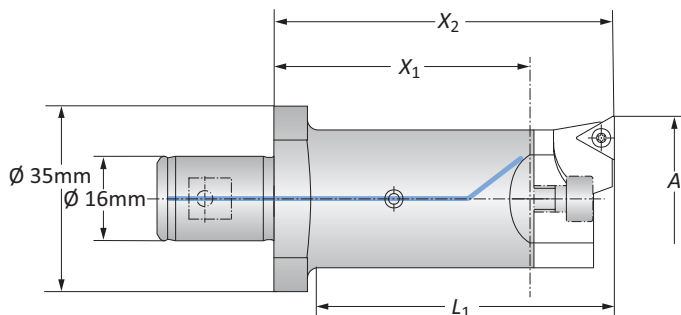
*Not suitable for indexable inserts with a radius of 0.80 mm



m = Metric (mm)
Inserts sold separately

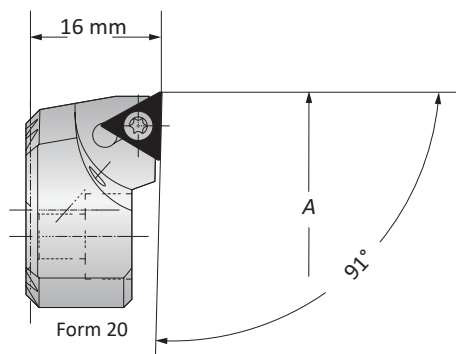
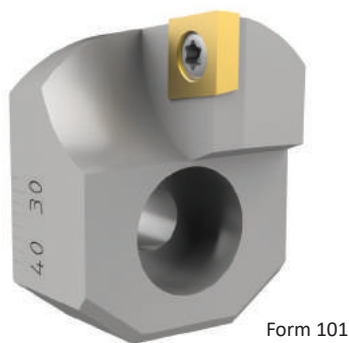
Serrated Tool Bodies | Insert Holders

Diameter Range: 29.00 mm - 53.00 mm



Serrated Tool Bodies

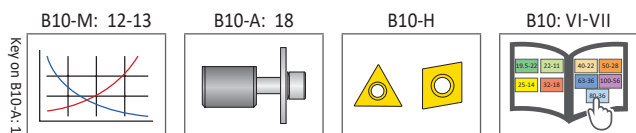
| | Boring Range | Serrated Tool Body | | | Weight | Part No. |
|---|---------------|--------------------|----------------|----------------|-----------|----------|
| | A | X ₁ | X ₂ | L ₁ | | |
| m | 29.00 - 53.00 | 48.00 | 64.00 | 56.00 | 0.20 (kg) | 236021 |
| | 29.00 - 53.00 | 84.00 | 100.00 | 92.00 | 0.30 (kg) | 236031 |



Insert Holders

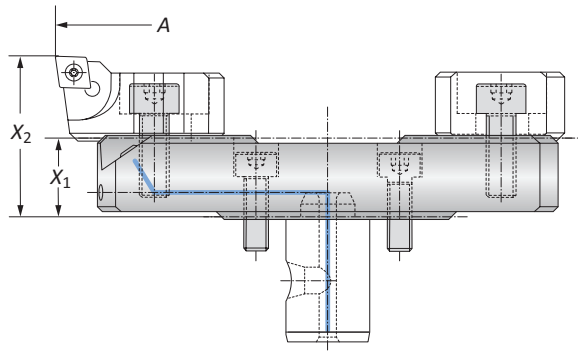
| | Boring Range | Weight | Insert Form | Part No. |
|---|---------------|-----------|-------------|----------|
| | A | | | |
| m | 29.00 - 41.00 | 0.04 (kg) | 101 | 236023 |
| | 29.00 - 41.00 | 0.04 (kg) | 20* | 236022 |
| | 40.00 - 53.00 | 0.06 (kg) | 101 | 236025 |
| | 40.00 - 53.00 | 0.06 (kg) | 20* | 236024 |

*Not suitable for indexable inserts with a radius of 0.80 mm




Alu-Line Serrated Slides | Insert Holders

Diameter Range: 68.00 mm - 152.00 mm



Alu-Line Serrated Slides

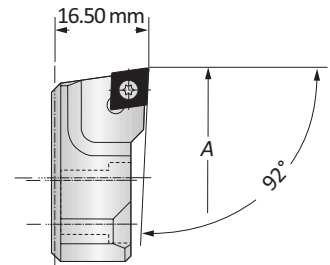
| | Boring Range | | Serrated Slide | | Weight | Part No. |
|---|-----------------|----------------|----------------|--|-----------|----------|
| | A | X ₁ | X ₂ | | | |
|  | 68.00 - 96.00 | 16.00 | 32.50 | | 0.10 (kg) | 501054 |
| | 96.00 - 124.00 | 16.00 | 32.50 | | 0.10 (kg) | 501055 |
| | 124.00 - 152.00 | 16.00 | 32.50 | | 0.20 (kg) | 501056 |

Insert Holders

| | Boring Range | | Weight | Insert Form | Part No. |
|---|----------------|-----------|--------|-------------|----------|
| | A | | | | |
|  | 68.00 - 152.00 | 0.05 (kg) | 101 | 502064 | |
| | 68.00 - 152.00 | 0.05 (kg) | 20 | 502069 | |




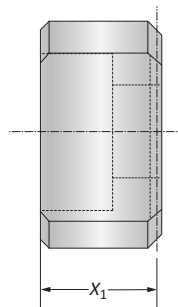
Form 20



Form 101

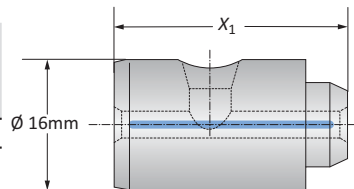
Counterweight

| | Counterweight | | Part No. |
|---|----------------|-----------|----------|
| | X ₁ | Weight | |
|  | 13.40 | 0.05 (kg) | 502165 |



Alu-Line Coolant Delivery Section

| | Coolant Delivery | | Part No. |
|---|------------------|-----------|----------|
| | X ₁ | Weight | |
|  | 25.50 | 0.01 (kg) | 450137 |




B10-M: 12-13
Key on B10-A-1

B10-A: 18

B10-H

B10: VI-VII

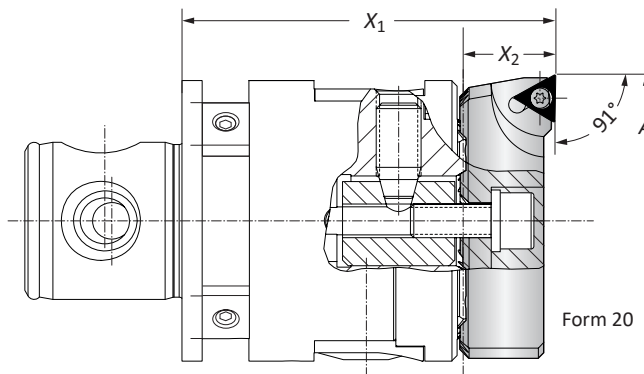
 = Metric (mm)
Inserts sold separately

Insert Holders for Boring Heads

Diameter Range: 52.00 mm - 102.00 mm



Form 101

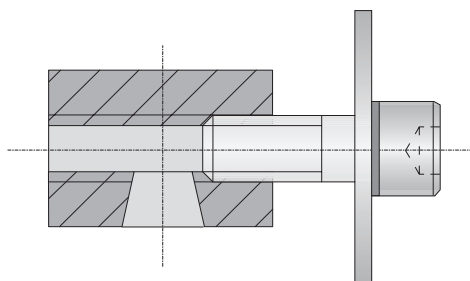


Insert Holders for Boring Heads

| | Boring Range | | Insert Holder | | Weight | Insert Form | Part No. |
|---|----------------|--|----------------|----------------|-----------|-------------|---------------|
| | A | | X ₁ | X ₂ | | | |
| Ⓜ | 52.00 - 77.00 | | 66.00 | 16.50 | 0.06 (kg) | 101 | 236027 |
| | 52.00 - 77.00 | | 66.00 | 16.50 | 0.06 (kg) | 20 | 236026 |
| | 76.00 - 102.00 | | 66.00 | 16.50 | 0.10 (kg) | 101 | 236029 |
| | 76.00 - 102.00 | | 66.00 | 16.50 | 0.10 (kg) | 20 | 236028 |

Clamping Piece for Insert Holder for Boring Heads

| | Boring Range | Service Key | Complete Part No. |
|---|----------------|-------------|-------------------|
| Ⓜ | 52.00 - 102.00 | s5 | 236020 |

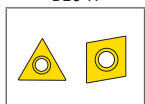
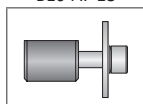
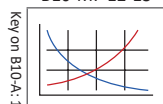


B10-M: 12-13

B10-A: 18

B10-H

B10: VI-VII



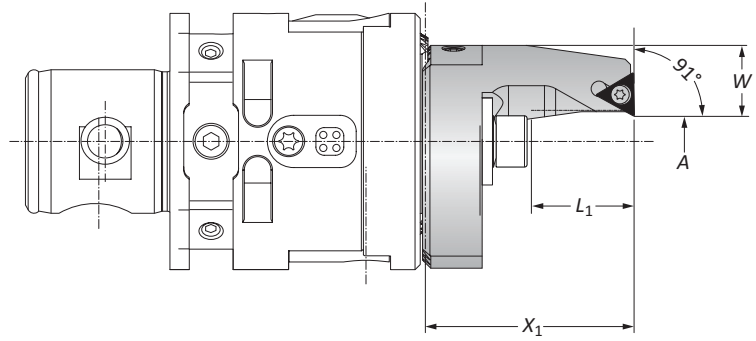
B10-A: 14

www.alliedmachine.com | +44 (0) 1384 400 900 | enquiries.eu@alliedmachine.com

Ⓜ = Metric (mm)
Inserts sold separately

Outside Turning Insert Holders for Boring Heads

Outside Turning | Diameter Range: 4.00 mm - 66.00 mm

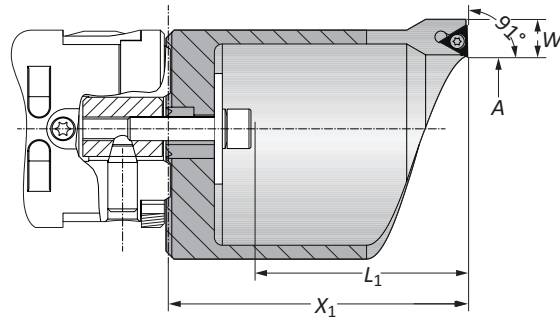


Type A Insert Holders

| | Boring Range | | Insert Holder | | | Weight | Type | Insert Form | Part No. |
|---|---------------|----------------|----------------|-------|------|--------|------|-------------|----------|
| | A | X ₁ | L ₁ | W | | | | | |
| m | 4.00 - 17.50 | 40.50 | 20.00 | 16.60 | 0.10 | A | 20* | 236081 | |
| | 16.50 - 30.00 | 50.50 | 30.00 | 11.10 | 0.10 | A | 20* | 236082 | |

NOTE: Clockwise and neutral execution

*Not suitable for indexable inserts with a radius of 0.80 mm



Type B Insert Holders

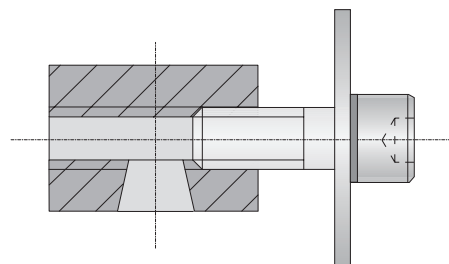
| | Boring Range | | Insert Holder | | | Weight | Type | Insert Form | Part No. |
|---|---------------|----------------|----------------|------|-----------|--------|------|-------------|----------|
| | A | X ₁ | L ₁ | W | | | | | |
| m | 29.00 - 44.00 | 75.50 | 54.00 | 9.60 | 0.30 (kg) | B | 20* | 236083 | |
| | 43.00 - 66.00 | 100.50 | 79.00 | 9.60 | 0.40 (kg) | B | 20* | 236084 | |

NOTE: Clockwise and neutral execution

*Not suitable for indexable inserts with a radius of 0.80 mm

Clamping Pieces for Outside Turning Insert Holders

| Insert Holder Type | Boring Range | Service Key | Complete Part No. |
|--------------------|---------------|-------------|-------------------|
| A | 4.00 - 30.00 | s5 | 236088 |
| B | 29.00 - 66.00 | s5 | 236089 |



Key on B10-A-1

B10-M: 12-13

B10-A: 18

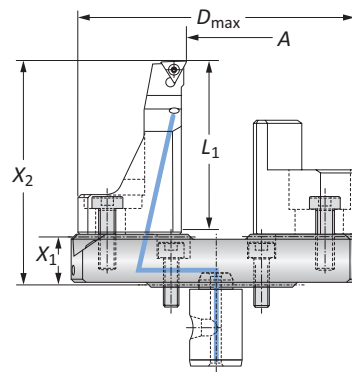
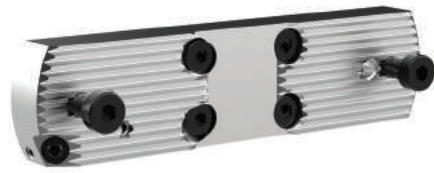
B10-H

B10: VI-VII

m = Metric (mm)
Inserts sold separately

Outside Turning Serrated Slides | Insert Holders

Diameter Range: 2.00 mm - 58.00 mm



Serrated Slides

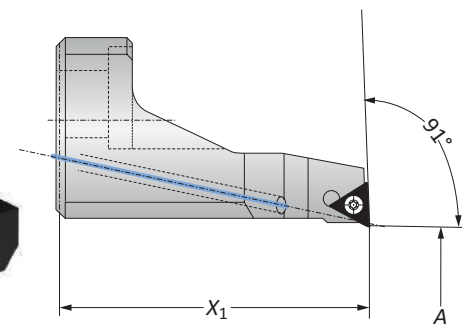
| | Outside Turning Range | Serrated Slide | | | Weight | Interfering Diameter | Part No. |
|---|-----------------------|----------------|----------------|----------------|-----------|----------------------|----------|
| | A | X ₁ | X ₂ | L ₁ | | D _{max} | |
| Ⓜ | 2.00 - 30.00 | 16.00 | 73.00 | 55.00 | 0.35 (kg) | 101.00 | 501064 |
| | 30.00 - 58.00 | 16.00 | 73.00 | 55.00 | 0.44 (kg) | 129.00 | 501065 |



Insert Holder

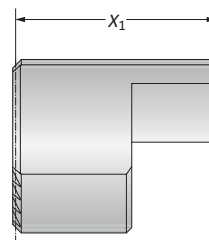
| | Boring Range | Insert Holder | Weight | Insert Form | Part No. |
|---|--------------|----------------|-----------|-------------|----------|
| | A | X ₁ | | | |
| Ⓜ | 2.00 - 58.00 | 57.00 | 0.15 (kg) | 20* | 502082 |

*Clockwise and neutral execution



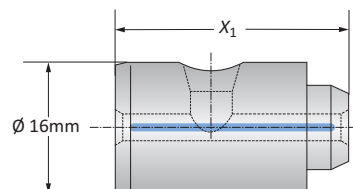
Counterweight

| | Counterweight | Weight | Part No. |
|---|----------------|-----------|----------|
| | X ₁ | | |
| Ⓜ | 37.75 | 0.16 (kg) | 502183 |



Alu-Line Coolant Delivery Section

| | Coolant Delivery Section | Weight | Part No. |
|---|--------------------------|-----------|----------|
| | X ₁ | | |
| Ⓜ | 25.50 | 0.01 (kg) | 450137 |

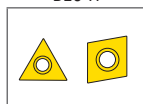
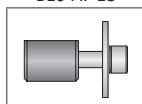
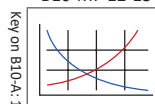


B10-M: 12-13

B10-A: 18

B10-H

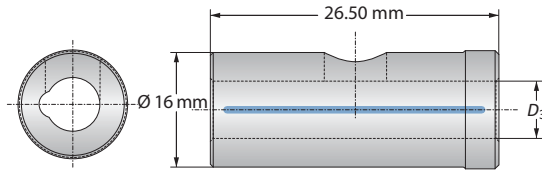
B10: VI-VII



Ⓜ = Metric (mm)
Inserts sold separately

Accessories

Metric Reducing Sleeves



Reducing Sleeves

| Reducing Sleeve | | Weight | Part No. |
|-----------------|-------|-----------|----------|
| | D_3 | | |
| m | 4.00 | 0.05 (kg) | 450129 |
| | 5.00 | 0.04 (kg) | 450130 |
| | 7.00 | 0.04 (kg) | 450132 |
| | 8.00 | 0.04 (kg) | 450133 |
| | 10.00 | 0.03 (kg) | 450134 |
| | 12.00 | 0.02 (kg) | 450135 |
| | 14.00 | 0.01 (kg) | 450136 |

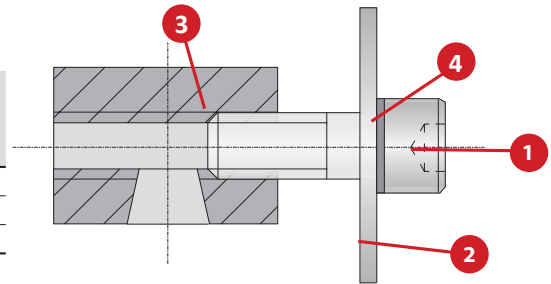
 = Metric (mm)

Accessories

Clamping Elements | Thread Pin | Balancing Element | 3E^{TECH} Accessories

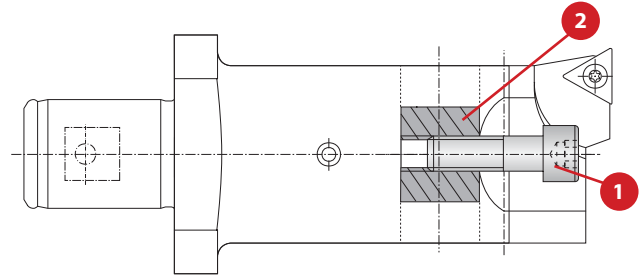
Clamping Elements for Insert Holders

| Boring Range | 1 Cap Screw | Hex Size | 2 Washer | 3 Clamping Nut | 4 Locking Washer | Complete Part No. |
|--------------|----------------|----------|-------------|-------------------|---------------------|-------------------|
| 4 - 30 | 070153 | s5 | 315155 | 236120 | 215254 | 236088 |
| 29 - 66 | 070153 | s5 | 315156 | 236120 | 215254 | 236089 |
| 52 - 102 | 115147 | s5 | 115725 | 236120 | - | 236020 |



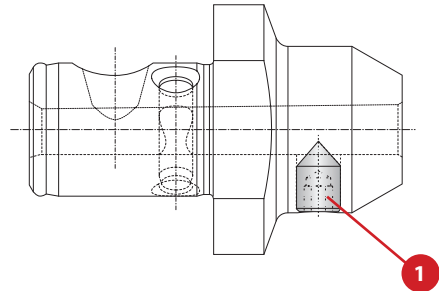
Clamping Elements for Serrated Tool Body

| 1 Cap Screw | Hex Size | 2 Clamping Piece |
|----------------|----------|---------------------|
| 027154 | s4 | 145184 |



Thread Pin

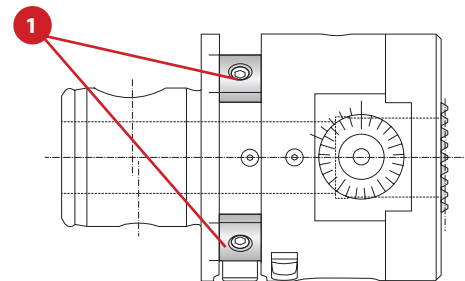
| Service Key | 1 Part No. |
|-------------|---------------|
| S3 / A | 415244 |



Balancing Element

| Nominal Size | Key Size / Type | 1 Part No. |
|---------------|-----------------|---------------|
| M8 x 1.25 x 8 | s2 / A | 536005 |

NOTE: Balancing elements sold separately



3E^{TECH+} Accessories

| 1 Charging Unit |
|--------------------|
| Part No. |
| 536016 |

NOTE: Charging unit sold separately from 3E^{TECH+}

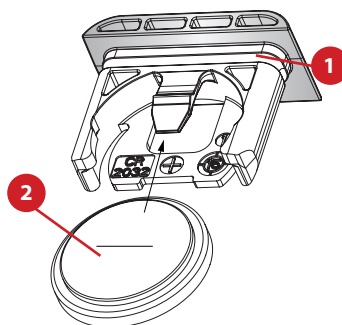


NOTE: 3E^{TECH+} adjustment accuracy of 0.001 mm on diameter

3E^{TECH} Accessories (Old Display)

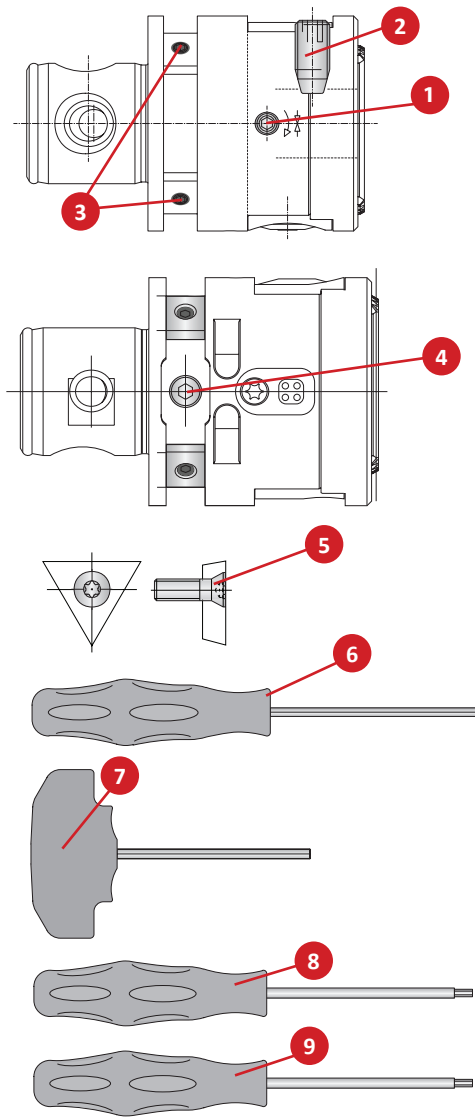
| 1 Sealing Ring | 2 Battery CR2032 |
|-------------------|---------------------|
| Part No. | Part No. |
| 215483 | 515491 |

NOTE: Not required for 3E^{TECH+} (New Display)

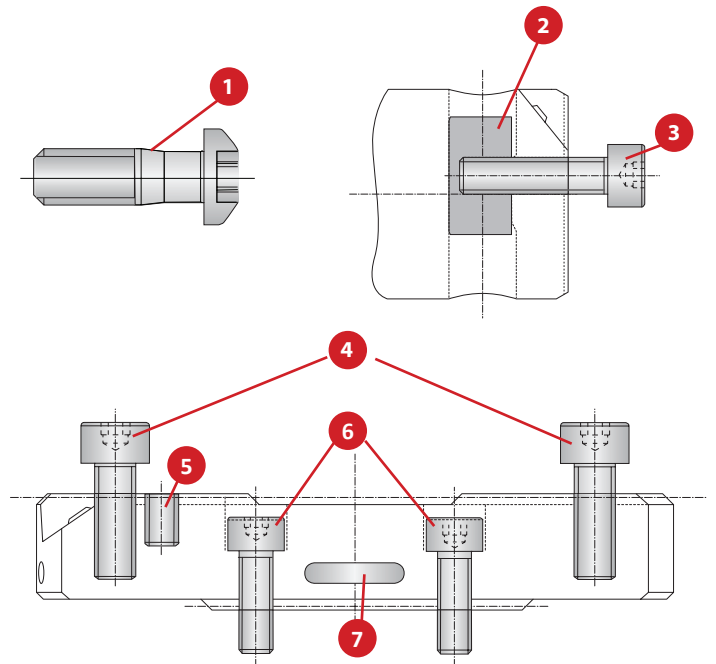


Accessories

| No. | Part | Insert Form | Size | Part No. |
|-----|-----------------------------------|---------------------------------|----------------|----------------------------|
| 1 | Clamping screw | - | - | 070333 |
| 2 | Thread pin for tool clamping | - | - | 215674 |
| 3 | Clamping screw for balance weight | - | - | 115470 |
| 4 | Balancing screw plug | - | - | 115119 |
| 5 | Insert screws | Form 20 Form 101 Form 211 | T7 T8 T6 | 115535 115676 215377 |
| 6 | Hex wrench | - | s2.5 s2 | 115575 215473 |
| 7 | Hex wrench | - | s4 | 115576 |
| 8 | Torx driver | - | T6 T7 T8 | 115537 115591 115590 |
| 9 | Torx screwdriver | Form 211 Form 20 Form 101 | T6 T7 T8 | 415507 415508 415514 |

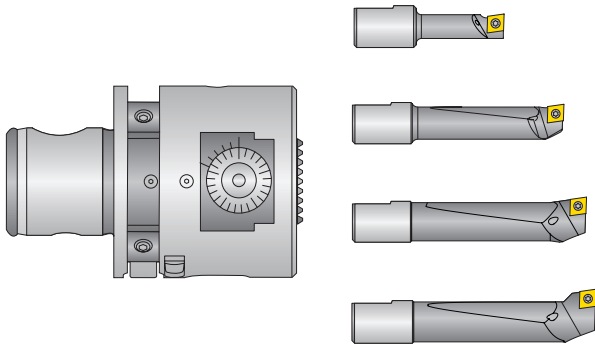


| No. | Part | Size | Part No. |
|-----|--|------|----------|
| 1 | Screw for securing insert holder | T25 | 415112 |
| 2 | Clamping piece | - | 145184 |
| 3 | Cap screw for securing insert holders | s4 | 027154 |
| 4 | Cap screw for securing insert holder/counterweight | s4 | 315248 |
| 5 | Set screw - coolant | s1.5 | 114224 |
| 6 | Cap screw for securing serrated slide | s3 | 116289 |
| 8 | Sealing ring for coolant delivery | - | 415386 |



Kit Components

3E^{TECH+} | Insert Form 101 | Diameter Range: 10.00 mm - 30.00 mm



Diameter Range: 10.00 mm - 30.00 mm

| Kit Components | | | | | |
|----------------|-------------|------------------|-------------|---------------|---------|
| | Boring Head | Boring Bar Range | Boring Bars | Service Keys | Kit No. |
| m | 536002 | 10.00 - 15.00 | 218048 | 115575 (s2.5) | 103046 |
| | | 15.00 - 20.00 | 081041 | 215403 (s4) | |
| | | 20.00 - 25.00 | 081042 | 115590 (T8) | |
| | | 25.00 - 30.00 | 081043 | | |

NOTE: Balancing elements and inserts sold separately

NOTE: 3E^{TECH+} digital readout module and charging station sold separately



3E^{TECH+} Digital Readout Module

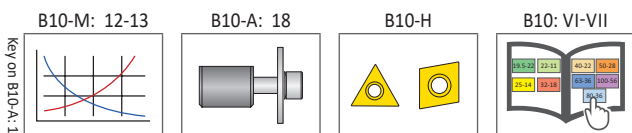
| Part No. | Charging Unit* |
|----------|----------------|
| 536015 | 536016 |

NOTE: WEEE-Reg.-Nr. DE 15820388

*Charging unit sold separately



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



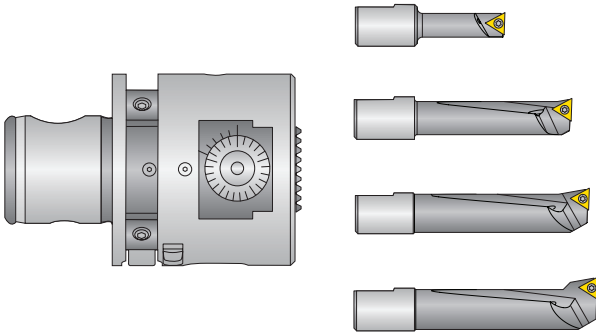
m = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com

Kit Components

3E^{TECH+} | Insert Form 20 | Diameter Range: 10.00 mm - 30.00 mm



Diameter Range: 10.00 mm - 30.00 mm

| Kit Components | | | | | |
|----------------|-------------|------------------|-------------|---------------|---------|
| | Boring Head | Boring Bar Range | Boring Bars | Service Keys | Kit No. |
| m | 536002 | 10.00 - 15.00 | 218059 | 115575 (s2.5) | 103045 |
| | | 15.00 - 20.00 | 081045 | 215403 (s4) | |
| | | 20.00 - 25.00 | 081046 | 115591 (T7) | |
| | | 25.00 - 30.00 | 081047 | | |

NOTE: Balancing elements and inserts sold separately

NOTE: 3E^{TECH+} digital readout module and charging station sold separately



3E^{TECH+} Digital Readout Module

| Part No. | Charging Unit* |
|----------|----------------|
| 536015 | 536016 |

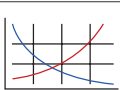
NOTE: WEEE-Reg.-Nr. DE 15820388

*Charging unit sold separately

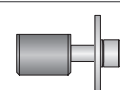


NOTE: 3E^{TECH+} adjustment accuracy of 0.001 mm on diameter

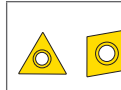
B10-M: 12-13




B10-A: 18



B10-H



B10: VI-VII



Key on B10-A: 1

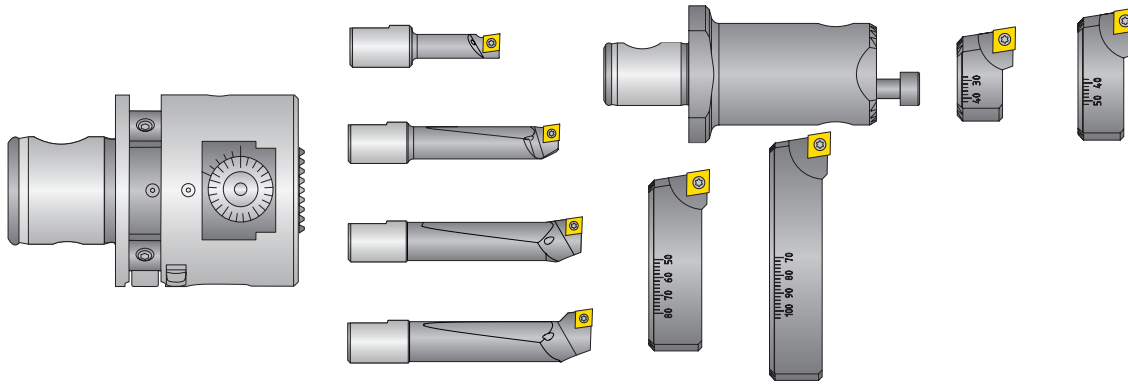
m = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

Kit Components

3E^{TECH+} | Insert Form 101 | Diameter Range: 10.00 mm - 102.00 mm



Diameter Range: 10.00 mm - 102.00 mm

| Kit Components | | | | | | | | | | | |
|----------------|------------------|----------|-------------------------------------|---------------------|----------|--------------------------------|----------|--------|----------------|--------------|---------|
| Boring Head | Boring Bars | | Serrated Tool Body & Insert Holders | | | Insert Holders for Boring Head | | | Clamping Piece | Service Keys | Kit No. |
| | Boring Bar Range | Part No. | Serrated Tool Body | Insert Holder Range | Part No. | Insert Holder Range | Part No. | | | | |
| m | 10.00 - 15.00 | 218048 | 236021 | 29.00 - 41.00 | 236023 | 52.00 - 77.00 | 236027 | 236020 | 115575 (s2.5) | 103048 | |
| | 15.00 - 20.00 | 081041 | | 40.00 - 53.00 | 236025 | 76.00 - 102.00 | 236029 | | 215403 (s4) | | |
| | 20.00 - 25.00 | 081042 | | | | | | | 215521 (s5) | | |
| | 25.00 - 30.00 | 081043 | | | | | | | 115590 (T8) | | |

NOTE: Balancing elements and inserts sold separately
 NOTE: 3E^{TECH+} digital readout module and charging station sold separately



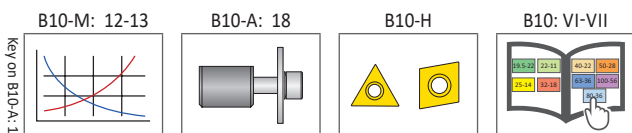
3E^{TECH+} Digital Readout Module

| Part No. | Charging Unit* |
|----------|----------------|
| 536015 | 536016 |

NOTE: WEEE-Reg.-Nr. DE 15820388
 *Charging unit sold separately



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



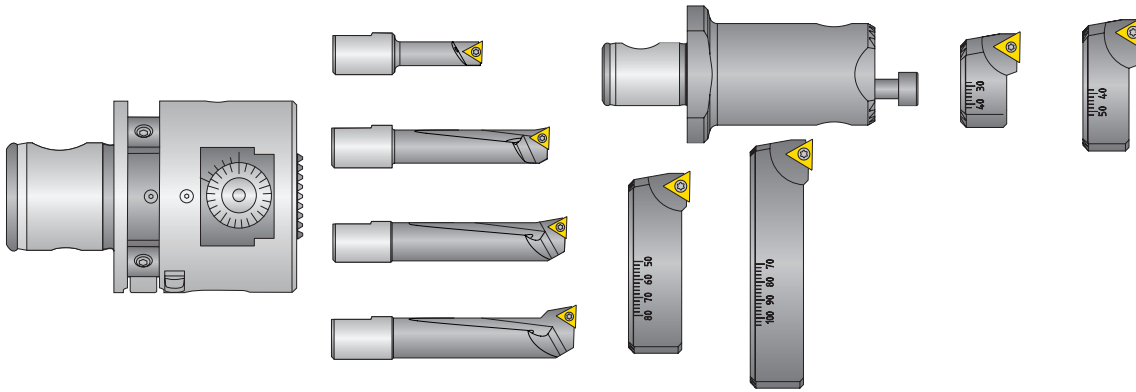
m = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

Kit Components

3E^{TECH+} | Insert Form 20 | Diameter Range: 10.00 mm - 102.00 mm



Diameter Range: 10.00 mm - 102.00 mm

| Kit Components | | | | | | | | | | |
|----------------|------------------|----------|-------------------------------------|---------------------|----------|--------------------------------|----------|----------------|---------------|---------|
| Boring Head | Boring Bars | | Serrated Tool Body & Insert Holders | | | Insert Holders for Boring Head | | | Service Keys | Kit No. |
| | Boring Bar Range | Part No. | Serrated Tool Body | Insert Holder Range | Part No. | Insert Holder Range | Part No. | Clamping Piece | | |
| m | 10.00 - 15.00 | 218059 | 236021 | 29.00 - 41.00 | 236026 | 52.00 - 77.00 | 236022 | 236020 | 115575 (s2.5) | 103047 |
| | 15.00 - 20.00 | 081045 | | 40.00 - 53.00 | 236028 | 76.00 - 102.00 | 236024 | | 215403 (s4) | |
| | 20.00 - 25.00 | 081046 | | | | | | | 215521 (s5) | |
| | 25.00 - 30.00 | 081047 | | | | | | | 115591 (T7) | |

NOTE: Balancing elements and inserts sold separately

NOTE: 3E^{TECH+} digital readout module and charging station 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 0.001 mm on diameter

Key on B10-A-1

B10-M: 12-13

B10-A: 18

B10-H

B10: VI-VII

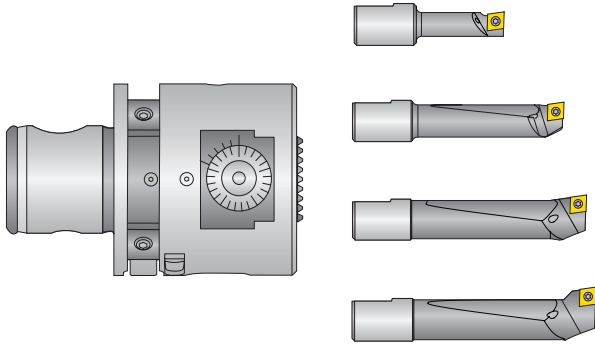
m = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

Kit Components

Non-Digital | Insert Form 101 | Diameter Range: 10.00 mm - 30.00 mm



Diameter Range: 10.00 mm - 30.00 mm

| Kit Components | | | | | |
|----------------|-------------|------------------|-------------|---------------|---------|
| | Boring Head | Boring Bar Range | Boring Bars | Service Keys | Kit No. |
| m | 536001 | 10.00 - 15.00 | 218048 | 115575 (s2.5) | 103050 |
| | | 15.00 - 20.00 | 081041 | 215403 (s4) | |
| | | 20.00 - 25.00 | 081042 | 115590 (T8) | |
| | | 25.00 - 30.00 | 081043 | | |

NOTE: Balancing elements and inserts sold separately



Key on B10-A-1

B10-M: 12-13

B10-A: 18

B10-H

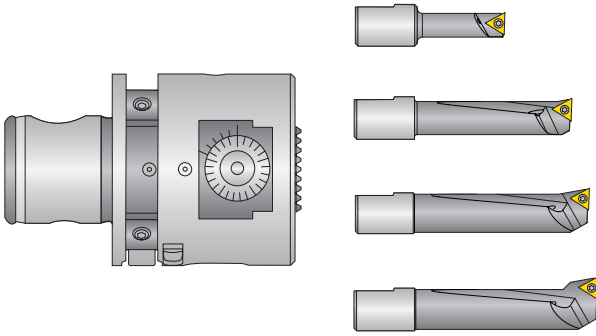
B10: VI-VII

m = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com

Kit Components

Non-Digital | Insert Form 20 | Diameter Range: 10.00 mm - 30.00 mm



Diameter Range: 10.00 mm - 30.00 mm

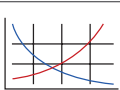
| Kit Components | | | | | |
|----------------|-------------|------------------|-------------|---------------|---------|
| | Boring Head | Boring Bar Range | Boring Bars | Service Keys | Kit No. |
| m | 536001 | 10.00 - 15.00 | 218059 | 115575 (s2.5) | 103049 |
| | | 15.00 - 20.00 | 081045 | 215403 (s4) | |
| | | 20.00 - 25.00 | 081046 | 115591 (T7) | |
| | | 25.00 - 30.00 | 081047 | | |

NOTE: Balancing elements and inserts sold separately

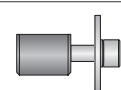


Key on B10-A-1:

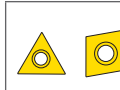
B10-M: 12-13



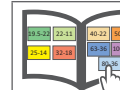
B10-A: 18



B10-H



B10: VI-VII

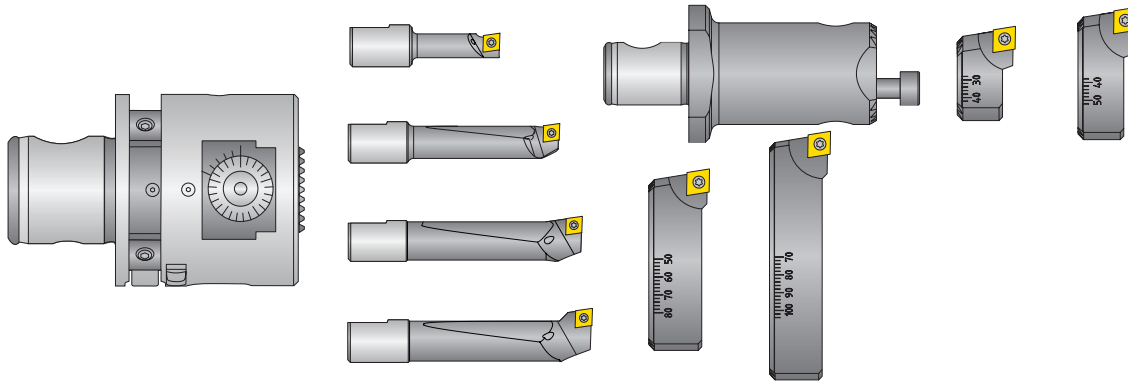


m = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com

Kit Components

Non-Digital | Insert Form 101 | Diameter Range: 10.00 mm - 102.00 mm



Diameter Range: 10.00 mm - 102.00 mm

| Kit Components | | | | | | | | | | |
|----------------|------------------|----------|-------------------------------------|---------------------|----------|--------------------------------|----------|----------------|---------------|---------|
| Boring Head | Boring Bars | | Serrated Tool Body & Insert Holders | | | Insert Holders for Boring Head | | | Service Keys | Kit No. |
| | Boring Bar Range | Part No. | Serrated Tool Body | Insert Holder Range | Part No. | Insert Holder Range | Part No. | Clamping Piece | | |
| m | 10.00 - 15.00 | 218048 | 236021 | 29.00 - 41.00 | 236023 | 52.00 - 77.00 | 236027 | 236020 | 115575 (s2.5) | 103052 |
| | 15.00 - 20.00 | 081041 | | 40.00 - 53.00 | 236025 | 76.00 - 102.00 | 236029 | | 215403 (s4) | |
| | 20.00 - 25.00 | 081042 | | | | | | | 215521 (s5) | |
| | 25.00 - 30.00 | 081043 | | | | | | | 115590 (T8) | |

NOTE: Balancing elements and inserts sold separately



Key on B10-A-1

B10-M: 12-13

B10-A: 18

B10-H

B10: VI-VII

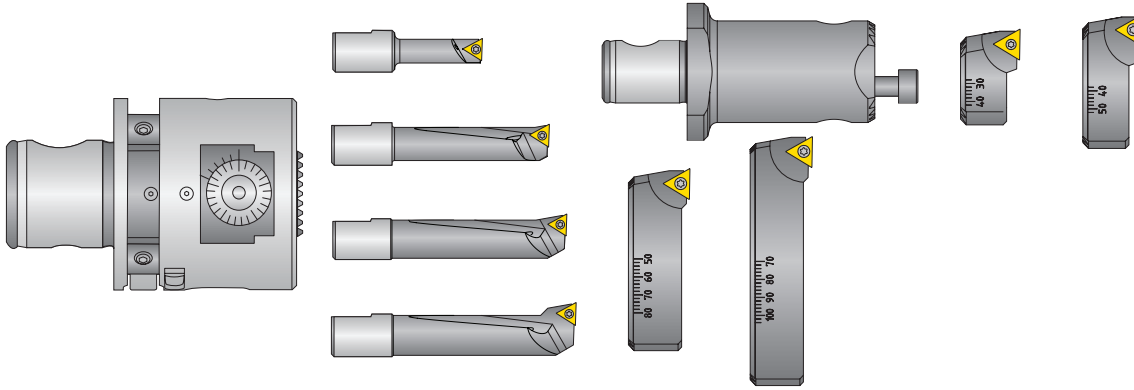
m = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

Kit Components

Non-Digital | Insert Form 20 | Diameter Range: 10.00 mm - 102.00 mm



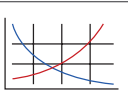
Diameter Range: 10.00 mm - 102.00 mm

| Kit Components | | | | | | | | | | |
|----------------|------------------|----------|-------------------------------------|---------------------|----------|--------------------------------|----------|----------------|----------------|---------|
| Boring Head | Boring Bars | | Serrated Tool Body & Insert Holders | | | Insert Holders for Boring Head | | | Service Keys | Kit No. |
| | Boring Bar Range | Part No. | Serrated Tool Body | Insert Holder Range | Part No. | Insert Holder Range | Part No. | Clamping Piece | | |
| Ⓜ | 10.00 - 15.00 | 218059 | 236021 | 29.00 - 41.00 | 236022 | 52.00 - 77.00 | 236026 | 236020 | 115575 (s2.5) | 103051 |
| | 15.00 - 20.00 | 081045 | | 40.00 - 53.00 | | 236024 | | | 76.00 - 102.00 | |
| | 20.00 - 25.00 | 081046 | | | | | | 215521 (s5) | | |
| | 25.00 - 30.00 | 081047 | | | | | | 115591 (T7) | | |

NOTE: Balancing elements and inserts sold separately

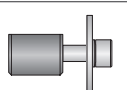


B10-M: 12-13

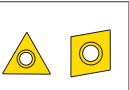


Key on B10-A-1

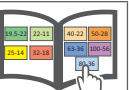
B10-A: 18



B10-H



B10: VI-VII



Ⓜ = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

248 Product Overview

248 VERSATILE FINE BORING

Compact design. Precision boring.

The Wohlhaupter® 248 compact boring head allows for higher spindle speeds and achieves long-reach boring jobs. Its cylindrical shank provides variable length adjustments up to 10xD.

Test this *compact design* for finish machining today.

- Diameter range: 3.00 mm - 30.20 mm
- Length adjustment up to 10xD
- Through coolant boring tool
- 0.01 mm adjust on diameter
- Max spindle speed: 20,000 RPM



IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com



248 Head



Insert Holder
Ø 15.90 mm - 30.20 mm



Adapter



Adapter



Boring Bar
Ø 3.70 mm - 16.00 mm



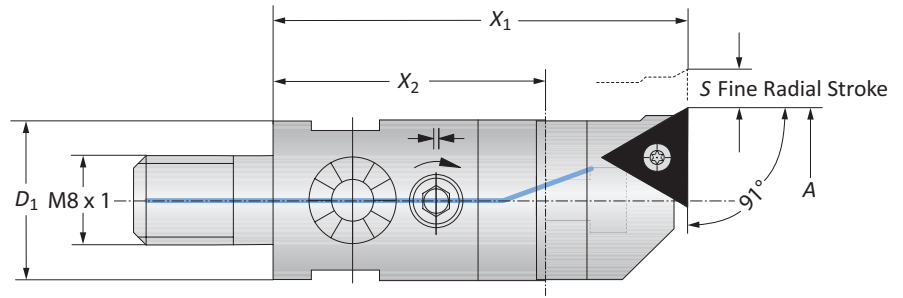
Mini Boring Bar
Ø 3.00 mm - 6.00 mm

OPERATION **VERSATILITY**

from **3.00 mm** to **30.20 mm**

Boring Heads

Diameter Range: 15.90 mm - 30.20 mm



| Boring Connection | Boring Range A | Boring Head | | | | Weight | Insert Form | Part No. | | |
|-------------------|-------------------|----------------|----------------|----------------|-------|--------|-------------|---------------|-------------|--------|
| | | X ₁ | X ₂ | D ₁ | S | | | Insert Holder | Boring Head | |
| Ⓜ | M8 x 1 | 15.90 - 20.10 | 42.00 | 26.00 | 15.00 | 1.40 | 0.06 (kg) | 20* | 248051 | 248001 |
| | M8 x 1 | 15.90 - 20.10 | 42.00 | 26.00 | 15.00 | 1.40 | 0.06 (kg) | 101 | 248054 | 248001 |
| | M8 x 1 | 19.90 - 24.80 | 46.00 | 30.00 | 18.00 | 1.80 | 0.09 (kg) | 20* | 248052 | 248002 |
| | M8 x 1 | 19.90 - 24.80 | 46.00 | 30.00 | 18.00 | 1.80 | 0.09 (kg) | 101 | 248055 | 248002 |
| | M8 x 1 | 24.50 - 30.20 | 46.00 | 30.00 | 23.00 | 2.30 | 0.13 (kg) | 20* | 248053 | 248003 |
| | M8 x 1 | 24.50 - 30.20 | 46.00 | 30.00 | 23.00 | 2.30 | 0.13 (kg) | 101 | 248056 | 248003 |

*Not suitable for indexable inserts with a radius of 0.80 mm

B10-M: 12-13

B10-A: 34

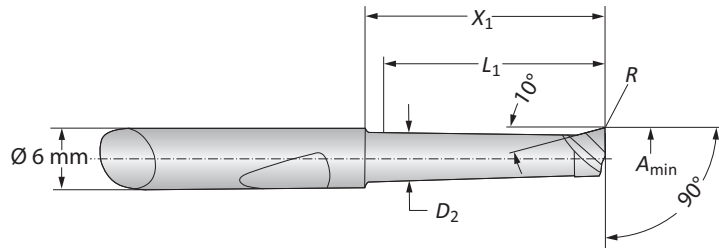
B10: VI-VII

Ⓜ = Metric (mm)

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

Mini Boring Bars

WHC05 | WHW04 | WBN150 | Diameter Range: 3.00 mm - 6.00 mm

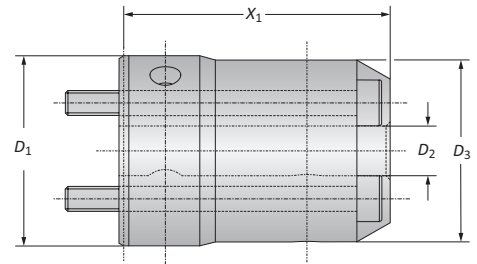


Mini Boring Bars

| Boring Range | Boring Bar | | | | | Part No. | | | |
|--------------|------------|-------|-------|-------|-------|-------------|----------------|------------------|--------------|
| | A_{min} | D_1 | D_2 | X_1 | L_1 | R | Coated Carbide | Uncoated Carbide | CBN |
| m | 3.00 | 6.00 | 2.60 | 11.50 | 10.00 | 0.10 | 081306WHC05 | – | 081322WBN150 |
| | 3.00 | 6.00 | 2.60 | 16.50 | 15.00 | 0.10 | 081307WHC05 | 081307WHW04 | – |
| | 4.00 | 6.00 | 3.60 | 12.00 | 10.00 | 0.20 | 081308WHC05 | – | 081317WBN150 |
| | 4.00 | 6.00 | 3.60 | 17.00 | 15.00 | 0.20 | 081309WHC05 | – | 081341WBN150 |
| | 4.00 | 6.00 | 3.60 | 22.00 | 20.00 | 0.20 | 081310WHC05 | 081310WHW04 | – |
| | 5.00 | 6.00 | 4.60 | 12.00 | 10.00 | 0.20 | 081311WHC05 | – | 081318WBN150 |
| | 5.00 | 6.00 | 4.60 | 22.00 | 20.00 | 0.20 | 081312WHC05 | – | 081319WBN150 |
| | 5.00 | 6.00 | 4.60 | 32.00 | 30.00 | 0.20 | 081313WHC05 | 081313WHW04 | – |
| | 6.00 | 6.00 | 5.60 | 22.00 | 20.00 | 0.20 | 081314WHC05 | – | 081320WBN150 |
| | 6.00 | 6.00 | 5.60 | 32.00 | 30.00 | 0.20 | 081315WHC05 | – | 081321WBN150 |
| 6.00 | 6.00 | 5.60 | 42.00 | 40.00 | 0.20 | 081316WHC05 | 081316WHW04 | – | |

Adapter

| Boring Head | Adapter | | | | Part No. |
|-------------|---------|-------|-------|-------|----------|
| | X_1 | D_1 | D_2 | D_3 | |
| m 248003 | 32.00 | 23.00 | 6.00 | 22.00 | 248071 |



Key on B10-A: 1

B10-M: 12-13

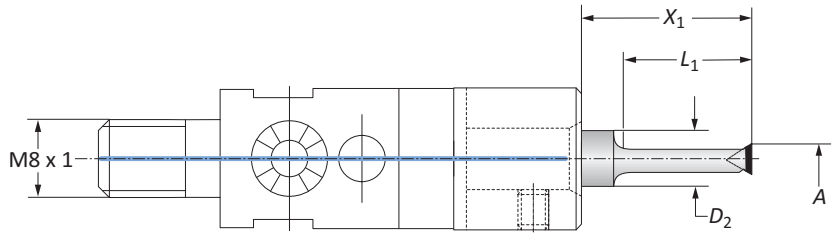
B10-A: 34

B10: VI-VII

m = Metric (mm)

Boring Bars

Diameter Range: 3.70 mm - 16.00 mm



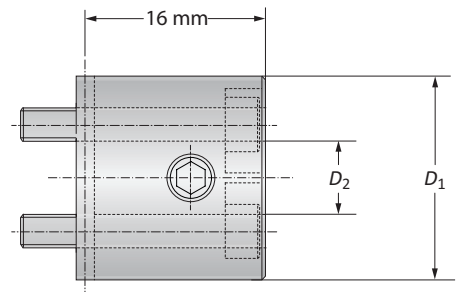
Boring Bars

| Boring Range | Boring Bar | | | | Insert Form | Part No. |
|---------------|---------------|----------------|----------------|----------------|-------------|----------|
| | A | D ₂ | X ₁ | L ₁ | | |
| Ⓜ | 3.70 - 5.00 | 8.00 | 20.80 | 18.00 | 325* | 218074 |
| | 4.90 - 6.00 | 8.00 | 26.00 | 23.00 | 47* | 218075 |
| | 5.90 - 8.00 | 8.00 | 27.00 | 25.00 | 211* | 218076 |
| | 7.90 - 10.00 | 8.00 | 30.50 | 30.00 | 211* | 218077 |
| | 9.90 - 12.00 | 8.00 | 35.00 | 35.00 | 20* | 218079 |
| | 9.90 - 12.00 | 8.00 | 35.00 | 35.00 | 101 | 218082 |
| | 11.90 - 14.00 | 10.00 | 45.00 | 45.00 | 20* | 218080 |
| | 11.90 - 14.00 | 10.00 | 45.00 | 45.00 | 101 | 218083 |
| 13.90 - 16.00 | 10.00 | 50.00 | 50.00 | 20* | 218081 | |
| 13.90 - 16.00 | 10.00 | 50.00 | 50.00 | 101 | 218084 | |

*Not suitable for indexable inserts with a radius of 0.80 mm

Adapters

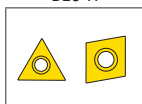
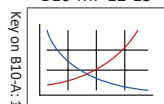
| Boring Head | Adapter | | Part No. |
|-------------|----------------|----------------|----------|
| | D ₁ | D ₂ | |
| 248002 | 18.00 | 8.00 | 248063 |
| 248003 | 23.00 | 8.00 | 248064 |
| 248003 | 23.00 | 10.00 | 248065 |



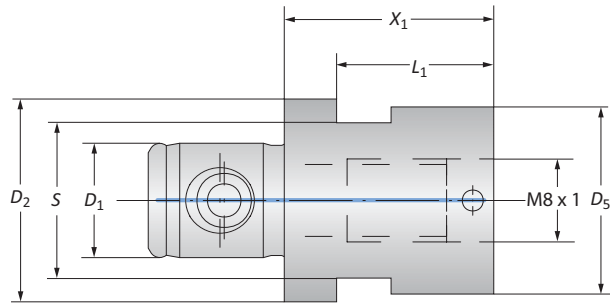
B10-M: 12-13

B10-H

B10: VI-VII

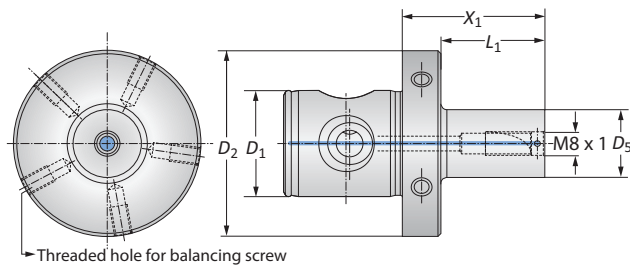


Adapters



Adapters

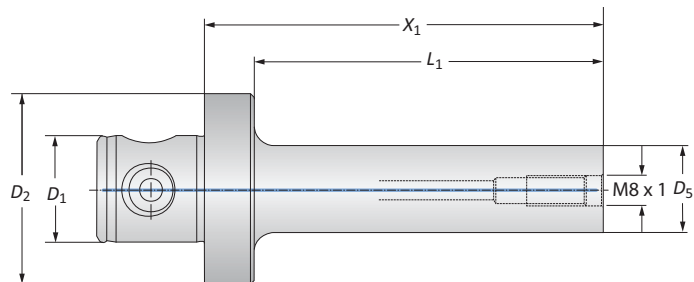
| MVS Connection | Boring Connection | Adapter | | | | Weight | Service Key | Part No. |
|--------------------|-------------------|-------------|-------|-------|-------|-----------|-------------|----------|
| | | $D_2 D_1$ | X_1 | L_1 | S | | | |
| m 19.5 - 11 | M8 x 1 | 20.00 | 15.00 | 15/P | 18.00 | 0.05 (kg) | 15 S / P | 219168 |
| 23 - 11 | M8 x 1 | 20.00 | - | 19/P | 23.00 | 0.07 (kg) | 19 S / P | 219169 |



Balanced Adapters

| MVS Connection | Boring Connection | Adapter | | | Weight | Balancing Screw | Part No. |
|------------------|-------------------|-------------|-------|-------|-----------|-----------------|----------|
| | | $D_2 D_1$ | X_1 | L_1 | | | |
| m 50 - 28 | M8 x 1 | 32.00 | 19.00 | 15.00 | 0.35 (kg) | M6 x 1 x 10 | 219185 |
| 50 - 28 | M8 x 1 | 48.00 | 35.00 | 18.00 | 0.40 (kg) | M6 x 1 x 10 | 219176 |
| 50 - 28 | M8 x 1 | 48.00 | 35.00 | 23.00 | 0.45 (kg) | M6 x 1 x 10 | 219177 |

NOTE: Balance refers to a specific residual imbalance of ≤ 10 g mm/kg

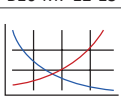


Vibration Reducing Heavy Metal Adapters

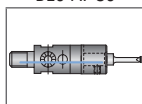
| MVS Connection | Boring Connection | Adapter | | | Weight | Part No. |
|------------------|-------------------|-------------|-------|-------|-----------|----------|
| | | $D_2 D_1$ | X_1 | L_1 | | |
| m 50 - 28 | M8 x 1 | 68.00 | 55.00 | 15.00 | 0.80 (kg) | 248147 |
| 50 - 28 | M8 x 1 | 84.00 | 71.00 | 19.00 | 1.00 (kg) | 248148 |
| 50 - 28 | M8 x 1 | 104.00 | 91.00 | 23.00 | 1.30 (kg) | 248149 |

Key on B10-A: 1

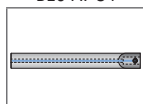
B10-M: 12-13



B10-A: 30



B10-A: 34



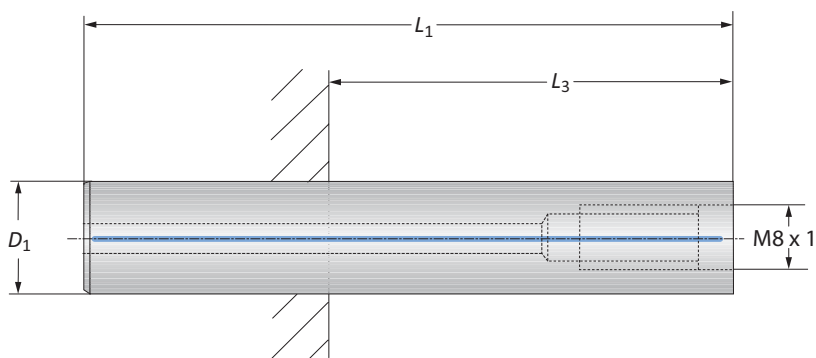
B10: VI-VII



m = Metric (mm)

Shanks

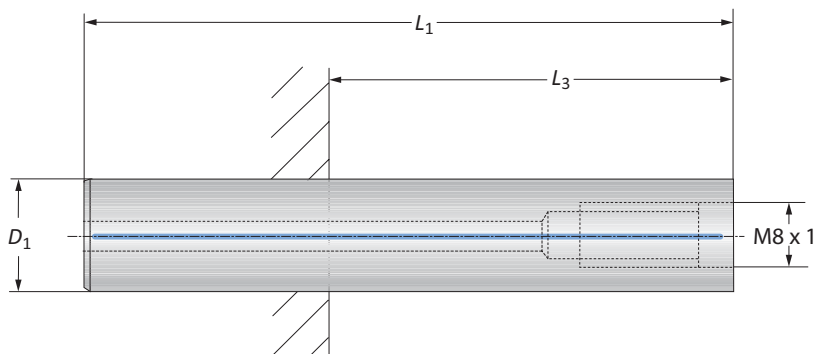
Steel | Carbide



Steel Shanks

| Connection | Shank | | | L_3 min* | | | Weight | Part No. |
|------------|-------|--------|------------|------------|----------|-----------|-----------|----------|
| | D_1 | L_1 | L_3 max* | SK 40+50 | HSK-A 63 | HSK-A 100 | | |
| M8 x 1 | 15.00 | 85.00 | 37.00 | – | – | – | 0.10 (kg) | 248136 |
| M8 x 1 | 18.00 | 100.00 | 52.00 | – | 5.00 | 12.00 | 0.20 (kg) | 248137 |
| M8 x 1 | 23.00 | 117.00 | 69.00 | – | 22.00 | 29.00 | 0.40 (kg) | 248138 |

* L_3 dimensions apply to collet chucks



Carbide Shanks

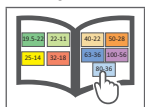
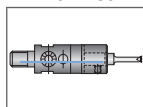
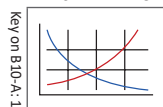
| Connection | Shank | | | L_3 min* | | | | Weight | Part No. |
|------------|-------|--------|------------|------------|--------|----------|-----------|-----------|----------|
| | D_1 | L_1 | L_3 max* | SK 40 | SK 50 | HSK-A 63 | HSK-A 100 | | |
| M8 x 1 | 15.00 | 130.00 | 82.00 | 20.00 | 20.00 | 35.00 | 42.00 | 0.30 (kg) | 248142 |
| M8 x 1 | 18.00 | 155.00 | 107.00 | 39.00 | 21.00 | 60.00 | 67.00 | 0.60 (kg) | 248143 |
| M8 x 1 | 23.00 | 180.00 | 132.00 | 64.00 | 46.00 | 85.00 | 92.00 | 1.10 (kg) | 248144 |
| M8 x 1 | 23.00 | 242.00 | 194.00 | 126.00 | 108.00 | 147.00 | 154.00 | 1.40 (kg) | 248145 |

* L_3 dimensions apply to collet chucks

B10-M: 12-13

B10-A: 30

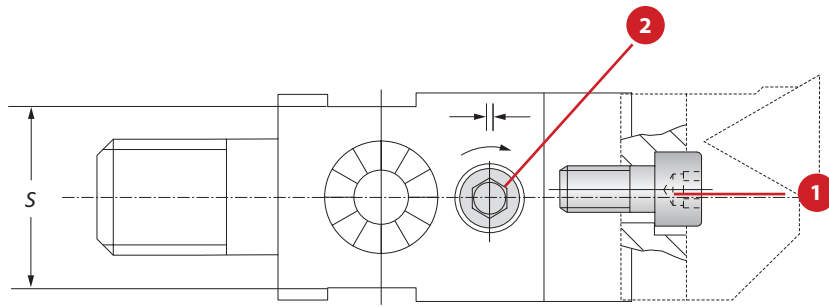
B10: vi-vii




m = Metric (mm)

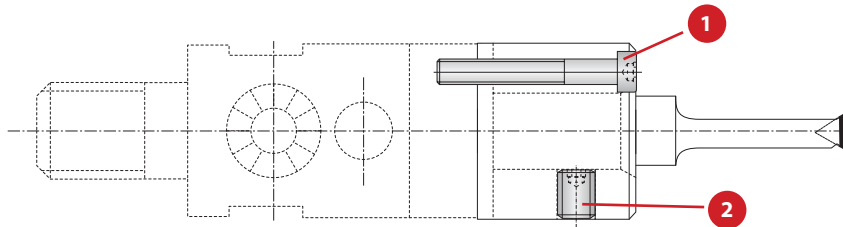
Accessories

Clamping Elements




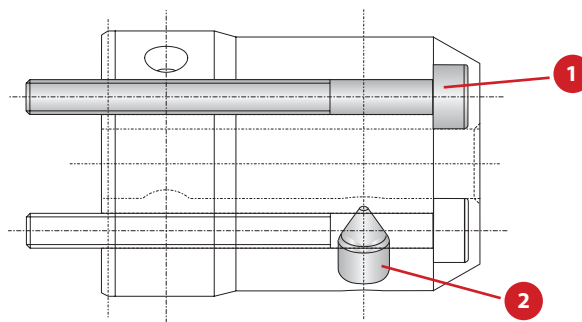
Clamping Elements for Boring Heads

| Boring Head | Service Key | 1 Cap Screw | | 2 Set Screw | |
|--|-------------|-------------|-------------|-------------|-------------|
| | S / Type | Part No. | Service Key | Part No. | Service Key |
|  248001 | 13 S / P | 315631 | s3 / A | 315629 | s2 / A |
| 248002 | 15 S / P | 315631 | s3 / A | 315684 | s2 / A |
| 248003 | 19 S / P | 315631 | s3 / A | 315687 | s2 / A |




Clamping Elements for Adapters

| Adapters | 1 Cap Screw | | 2 Set Screw | |
|--|-------------|-------------|-------------|-------------|
| | Part No. | Service Key | Part No. | Service Key |
|  248063 | 315801 | S 2.5 / A | 115136 | S 2.5 / A |
| 248064 | 315801 | S 2.5 / A | 031141 | S 2.5 / A |
| 248065 | 315801 | S 2.5 / A | 031141 | S 2.5 / A |



Screws for Adapter

| Adapters | 1 Cap Screw | | 2 Set Screw | |
|--|-------------|-------------|-------------|-------------|
| | Part No. | Service Key | Part No. | Service Key |
|  248071 | 515166 | S 2.5 / A | 415244 | S 3 / A |

 = Metric (mm)

PrimeBore Product Overview

PrimeBore VERSATILE FINE BORING

Advancing versatile technology.

With over 30 years of development, the Wohlhaupter® PrimeBore boring head offers versatility and precision. The PrimeBore head can bore multiple hole sizes ranging from 3.00 mm - 208.00 mm with our broad range of compatible boring bars.

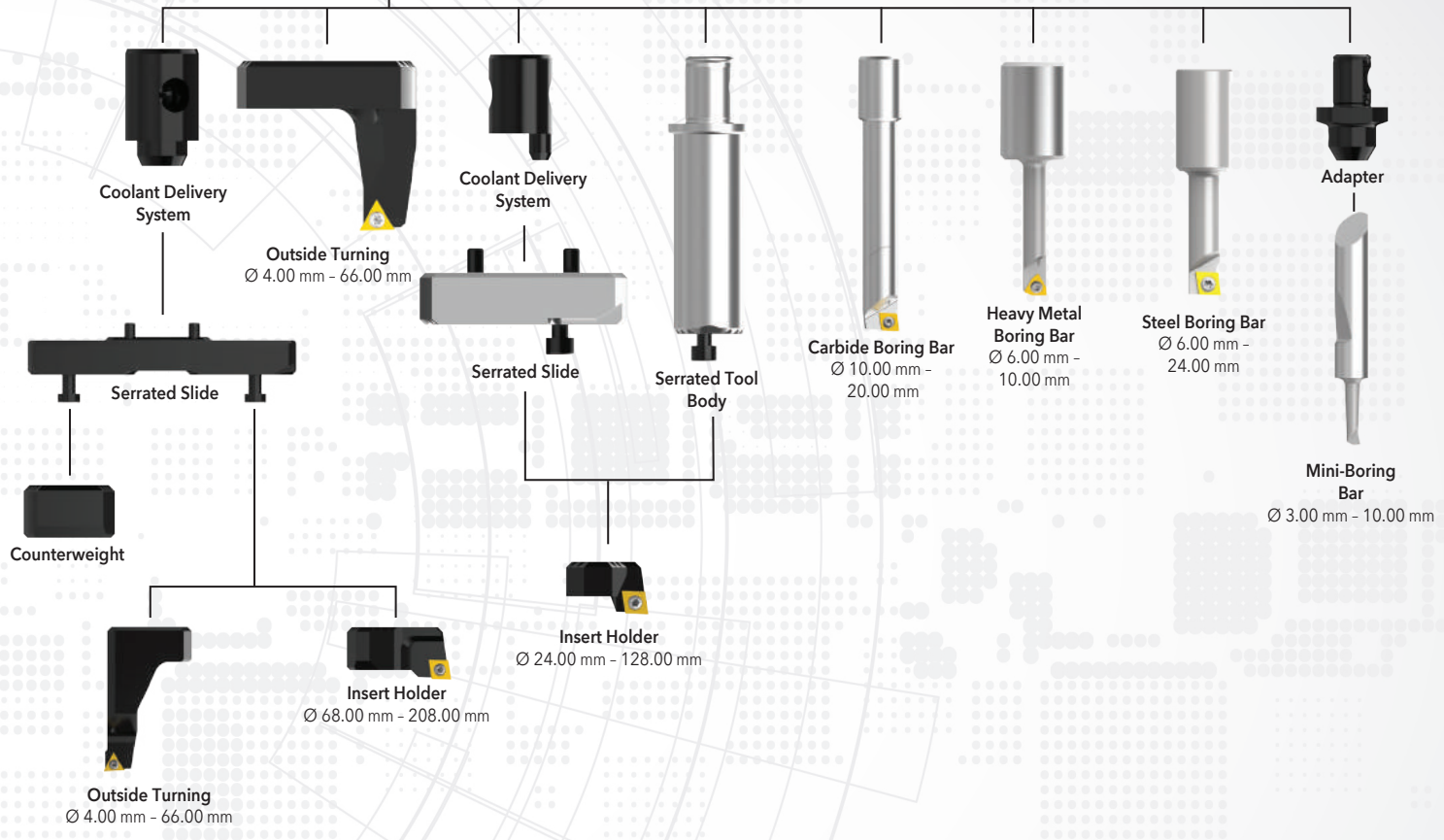
Complete your boring job with *technology that continues to advance.*

- Diameter range: 3.00 mm - 208.00 mm
- Ease the stress of working on different day-to-day projects with boring kits
- 0.002 mm adjust on diameter
- Economical precision and versatility
- Max spindle speed: 12,000 RPM
- Through coolant



IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com

PRIME BORE



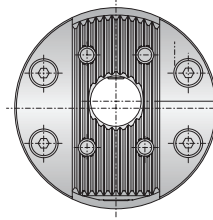
OPERATION **VERSATILITY**

from **3.00 mm** to **208.00 mm**
plus outside turning

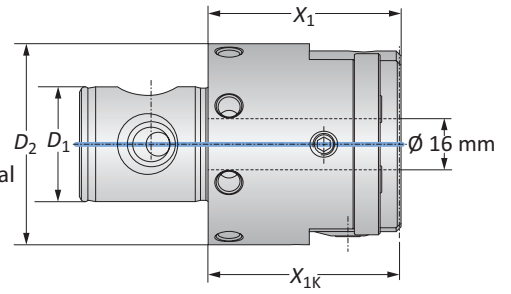


Boring Heads

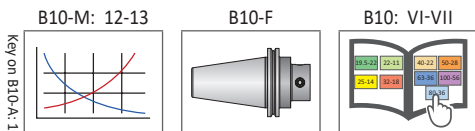
Diameter Range: 3.00 mm - 208.00 mm



+ 4.5 mm
- 0.1 mm
Fine Radial Stroke



| MVS Connection | Boring Head | | Weight | Part No. | |
|----------------|---------------|--------------|--------|-----------|--------|
| | $D_2 D_1$ | Boring Range | | | X_1 |
| 63 - 36 | 3.00 - 208.00 | 60.00 | 59.50 | 1.30 (kg) | 450001 |

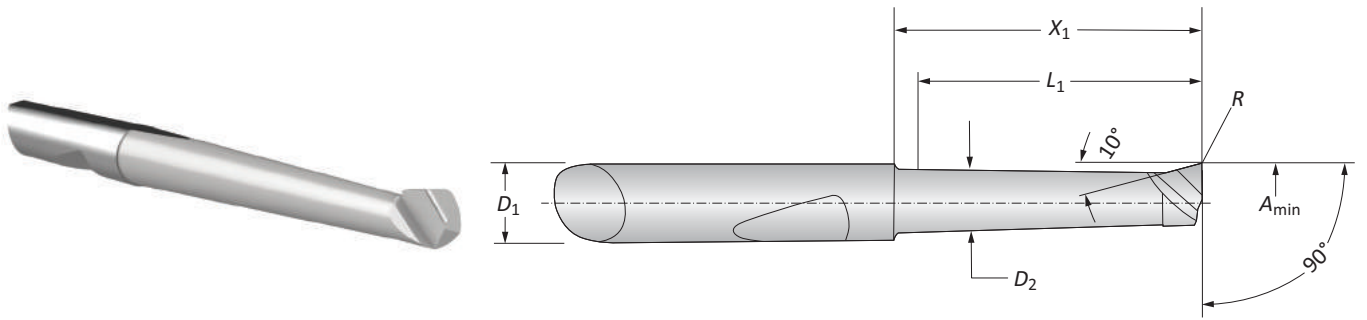


= Metric (mm)

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com

Mini Boring Bars

WHC05 | WHW04 | WBN150 | Diameter Range: 3.00 mm - 10.00 mm



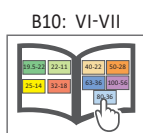
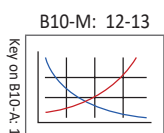
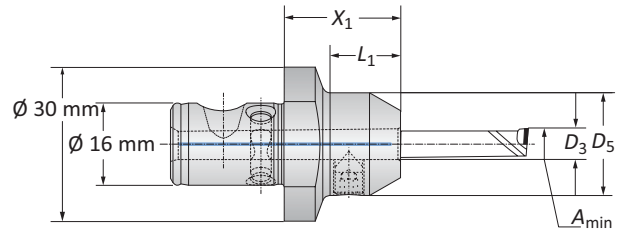
Mini Boring Bars

| Boring Range | Boring Bar | | | | | Part No. | | | |
|--------------|------------|-------|-------|-------|-------|----------|----------------|------------------|--------------|
| | A_{min} | D_1 | D_2 | X_1 | L_1 | R | Coated Carbide | Uncoated Carbide | CBN |
| m | 3.00 | 6.00 | 2.60 | 11.50 | 10.00 | 0.10 | 081306WHC05 | - | 081322WBN150 |
| | 3.00 | 6.00 | 2.60 | 16.50 | 15.00 | 0.10 | 081307WHC05 | 081307WHW04 | - |
| | 4.00 | 6.00 | 3.60 | 12.00 | 10.00 | 0.20 | 081308WHC05 | - | 081317WBN150 |
| | 4.00 | 6.00 | 3.60 | 17.00 | 15.00 | 0.20 | 081309WHC05 | - | 081341WBN150 |
| | 4.00 | 6.00 | 3.60 | 22.00 | 20.00 | 0.20 | 081310WHC05 | 081310WHW04 | - |
| | 5.00 | 6.00 | 4.60 | 12.00 | 10.00 | 0.20 | 081311WHC05 | - | 081318WBN150 |
| | 5.00 | 6.00 | 4.60 | 22.00 | 20.00 | 0.20 | 081312WHC05 | - | 081319WBN150 |
| | 5.00 | 6.00 | 4.60 | 32.00 | 30.00 | 0.20 | 081313WHC05 | 081313WHW04 | - |
| | 6.00 | 6.00 | 5.60 | 22.00 | 20.00 | 0.20 | 081314WHC05 | - | 081320WBN150 |
| | 6.00 | 6.00 | 5.60 | 32.00 | 30.00 | 0.20 | 081315WHC05 | - | 081321WBN150 |
| | 6.00 | 6.00 | 5.60 | 42.00 | 40.00 | 0.20 | 081316WHC05 | 081316WHW04 | - |
| | 8.00 | 8.00 | 7.60 | 25.00 | 23.00 | 0.20 | 081323WHC05 | - | - |
| | 8.00 | 8.00 | 7.60 | 50.00 | 48.00 | 0.20 | 081324WHC05 | - | - |



Adapters

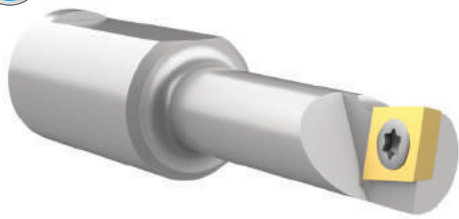
| Adapter | Adapter | | | | Part No. |
|---------|---------|-------|-------|-------|----------|
| | D_3 | D_5 | X_1 | L_1 | |
| m | 6.00 | 20.00 | 22.50 | 14.00 | 319010 |
| | 8.00 | 22.00 | 22.50 | 14.00 | 236071 |



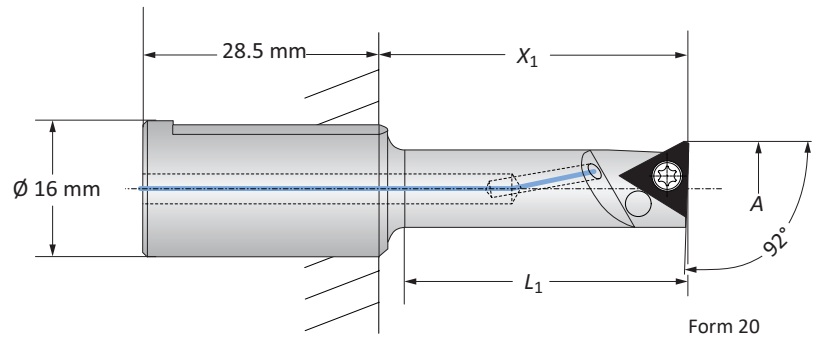
m = Metric (mm)

Boring Bars

Steel | Heavy Metal



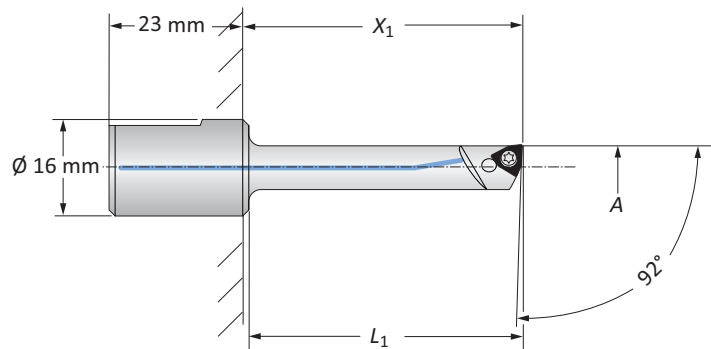
Form 101



Steel Boring Bars | Diameter Range: 6.00 mm - 24.00 mm

| | Boring Range | | Boring Bar | | | Weight | Insert Form | Part No. |
|---|---------------|----------------|----------------|--|--|-----------|-------------|----------|
| | A | X ₁ | L ₁ | | | | | |
| m | 6.00 - 10.00 | 22.00 - 32.00 | 20.00 | | | 0.04 (kg) | 211* | 450026 |
| | 10.00 - 16.00 | 35.00 - 45.00 | 33.00 | | | 0.06 (kg) | 101 | 450027 |
| | 10.00 - 16.00 | 35.00 - 45.00 | 33.00 | | | 0.06 (kg) | 20* | 450038 |
| | 16.00 - 24.00 | 60.00 - 70.00 | 58.00 | | | 0.10 (kg) | 101 | 450028 |
| | 16.00 - 24.00 | 60.00 - 70.00 | 58.00 | | | 0.10 (kg) | 20* | 450039 |

*Not suitable for indexable inserts with a radius of 0.80 mm



Heavy Metal Boring Bars | Diameter Range: 6.00 mm - 10.00 mm

| | Boring Range | | Boring Bar | | | Weight | Insert Form | Part No. |
|---|--------------|----------------|----------------|--|--|-----------|-------------|----------|
| | A | X ₁ | L ₁ | | | | | |
| m | 6.00 - 8.00 | 32.00 | 29.00 | | | 0.08 (kg) | 211* | 081055 |
| | 8.00 - 10.00 | 45.00 | 42.00 | | | 0.09 (kg) | 211* | 218072 |

*Not suitable for indexable inserts with a radius of 0.80 mm

B10-M: 12-13 B10-H B10: VI-VII

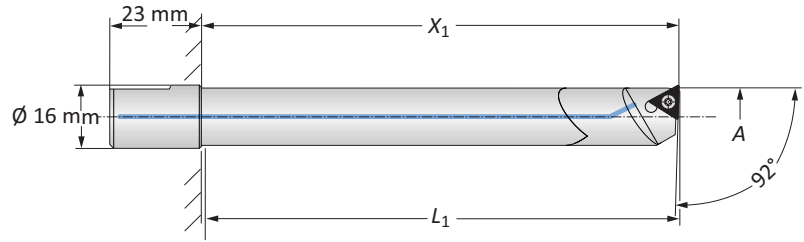
m = Metric (mm)
Inserts sold separately

Boring Bars

Carbide | Diameter Range: 10.00 mm - 20.00 mm



Form 101



Form 20

Carbide Boring Bars

| | Boring Range | | Boring Bar | | Weight | Insert Form | Part No. | Insert Form | Part No. |
|----------|---------------|----------------|----------------|-----------|--------|---------------|----------|---------------|----------|
| | A | X ₁ | L ₁ | | | | | | |
| m | 10.00 - 12.00 | 55.00 | 52.00 | 0.07 (kg) | 101 | 218042 | 20* | 218037 | |
| | 10.00 - 12.00 | 75.00 | 72.00 | 0.09 (kg) | 101 | 218032 | 20* | 218029 | |
| | 12.00 - 14.00 | 70.00 | 67.00 | 0.10 (kg) | 101 | 218043 | 20* | 218038 | |
| | 12.00 - 14.00 | 90.00 | 87.00 | 0.15 (kg) | 101 | 218033 | 20* | 218030 | |
| | 14.00 - 16.00 | 75.00 | 72.00 | 0.16 (kg) | 101 | 218044 | 20* | 218039 | |
| | 14.00 - 16.00 | 100.00 | 97.00 | 0.20 (kg) | 101 | 218045 | 20* | 218040 | |
| | 16.00 - 20.00 | 90.00 | 87.00 | 0.26 (kg) | 101 | 218046 | 20* | 218041 | |
| | 16.00 - 20.00 | 120.00 | 117.00 | 0.33 (kg) | 101 | 218034 | 20* | 218031 | |

*Not suitable for indexable inserts with a radius of 0.80 mm

B10-M: 12-13

Key on B10-A: 1

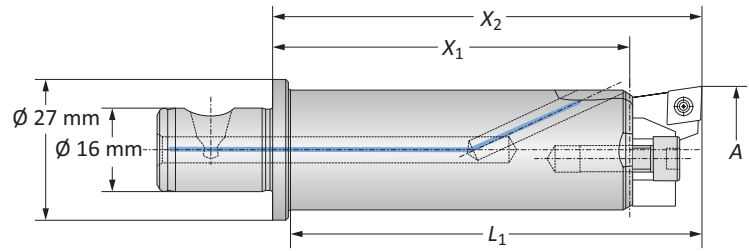
B10-H

B10: VI-VII

m = Metric (mm)
Inserts sold separately

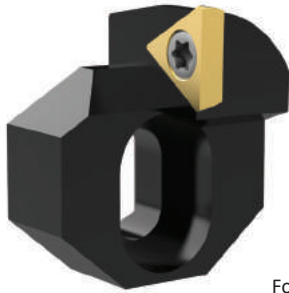
Serrated Tool Bodies | Insert Holders

Diameter Range: 24.00 mm - 65.00 mm

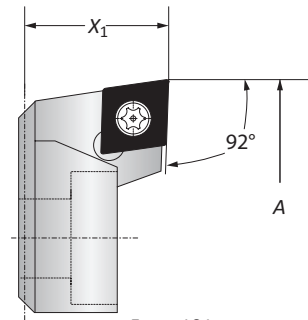


Serrated Tool Body

| Boring Range | Serrated Tool Body | | | | Weight | Part No. |
|---------------|--------------------|----------------|----------------|----------------|--------|----------|
| | A | X ₁ | X ₂ | L ₁ | | |
| 24.00 - 65.00 | 68.00 | 82.00 | 79.00 | 0.20 (kg) | 450021 | |



Form 20

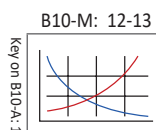


Form 101

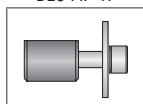
Insert Holders

| Boring Range | Insert Holder | Weight | Insert Form | Part No. |
|---------------|---------------|-----------|-------------|----------|
| | | | | |
| 24.00 - 40.00 | 14.00 | 0.02 (kg) | 101 | 450022 |
| 24.00 - 40.00 | 14.00 | 0.02 (kg) | 20* | 450040 |
| 40.00 - 65.00 | 14.00 | 0.03 (kg) | 101 | 450023 |
| 40.00 - 65.00 | 14.00 | 0.03 (kg) | 20* | 450041 |

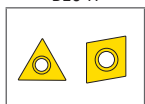
*Not suitable for indexable inserts with a radius of 0.80 mm



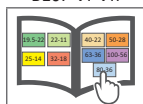
B10-A: 47



B10-H



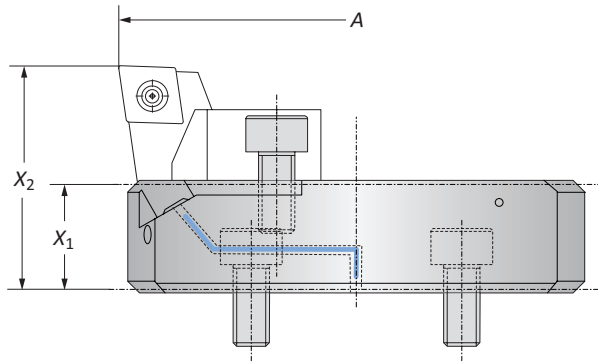
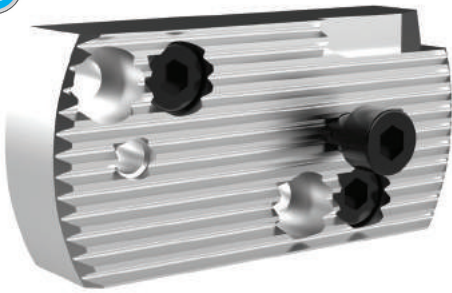
B10: VI-VII



m = Metric (mm)
Inserts sold separately

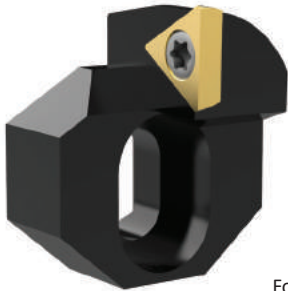
Serrated Slides | Insert Holders

Diameter Range: 65.00 mm - 128.00 mm

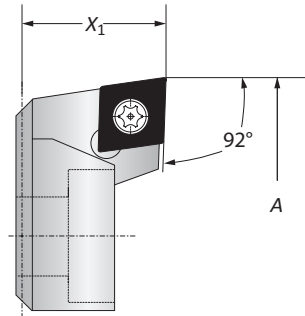


Serrated Slides

| Boring Range | Serrated Slide | | Weight | Part No. |
|----------------|----------------|----------------|-----------|----------|
| | A | X ₁ | | |
| 65.00 - 128.00 | 14.50 | 29.50 | 0.08 (kg) | 450024 |



Form 20



Form 101

Insert Holders

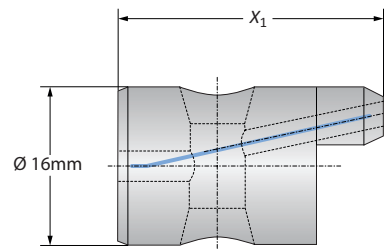
| Boring Range | Insert Holder | Weight | Insert Form | Part No. |
|----------------|----------------|-----------|-------------|----------|
| A | X ₁ | | | |
| 65.00 - 128.00 | 14.00 | 0.03 (kg) | 101 | 450023 |
| 65.00 - 128.00 | 14.00 | 0.03 (kg) | 20* | 450041 |

*Not suitable for indexable inserts with a radius of 0.80 mm

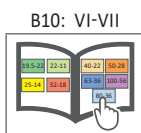
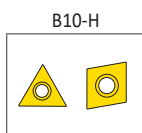
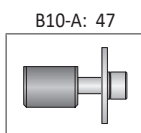


Alu-Line Coolant Delivery Section

| Coolant Delivery Section | | |
|--------------------------|-----------|----------|
| X ₁ | Weight | Part No. |
| 26.75 | 0.01 (kg) | 450125 |



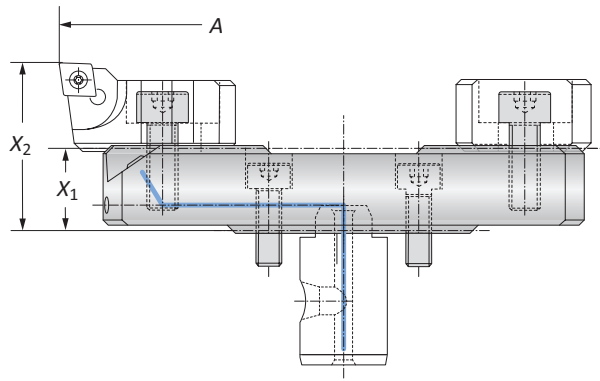
B10-M: 12-13
Key on B10-A-1



= Metric (mm)
Inserts sold separately

Alu-Line Serrated Slides | Insert Holders

Diameter Range: 68.00 mm - 208.00 mm



Alu-Line Serrated Slides

| | Boring Range | | Serrated Slide | | Weight | Part No. |
|----------|-----------------|----------------|----------------|--|-----------|----------|
| | A | X ₁ | X ₂ | | | |
| | 68.00 - 96.00 | 16.00 | 32.50 | | 0.10 (kg) | 501054 |
| | 96.00 - 124.00 | 16.00 | 32.50 | | 0.10 (kg) | 501055 |
| m | 124.00 - 152.00 | 16.00 | 32.50 | | 0.20 (kg) | 501056 |
| | 152.00 - 180.00 | 22.00 | 38.50 | | 0.25 (kg) | 501058 |
| | 180.00 - 208.00 | 22.00 | 38.50 | | 0.30 (kg) | 501059 |

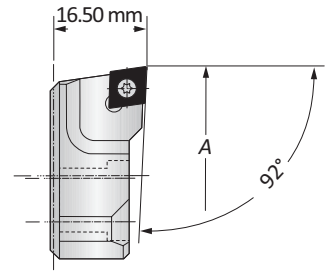
Insert Holders

| | Boring Range | | Insert Form | Part No. |
|----------|----------------|-----------|-------------|----------|
| | A | Weight | | |
| m | 68.00 - 208.00 | 0.05 (kg) | 101 | 502064 |
| | 68.00 - 208.00 | 0.05 (kg) | 20 | 502069 |

NOTE: Other insert holders available upon request



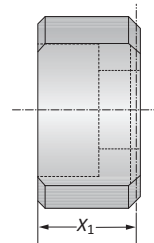
Form 20



Form 101

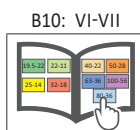
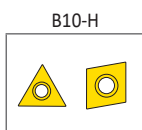
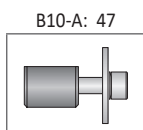
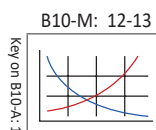
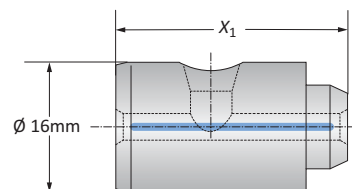
Counterweight

| | Counterweight | | Part No. |
|----------|----------------|-----------|----------|
| | X ₁ | Weight | |
| m | 13.40 | 0.05 (kg) | 502165 |



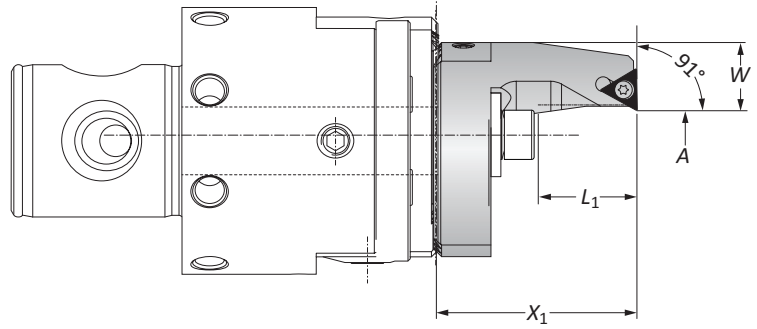
Alu-Line Coolant Delivery Section

| | Coolant Delivery Section | | Part No. |
|----------|--------------------------|-----------|----------|
| | X ₁ | Weight | |
| m | 25.50 | 0.01 (kg) | 450137 |



Outside Turning Insert Holders for Boring Heads

Diameter Range: 4.00 mm - 66.00 mm

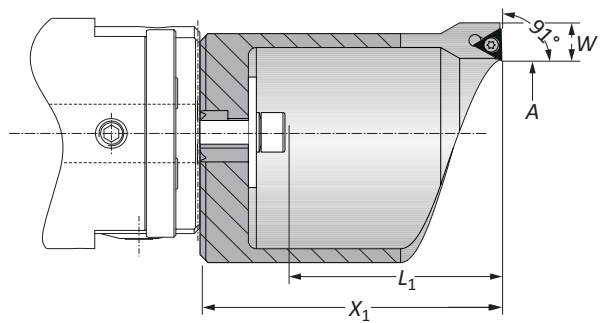


Type A Insert Holders | Diameter Range: 4.00 mm - 30.00 mm

| Boring Range | Insert Holder | | | Weight | Type | Insert Form | Part No. |
|--------------|---------------|----------------|----------------|--------|------|-------------|----------|
| | A | X ₁ | L ₁ | | | | |
| Ⓜ | 4.00 - 17.50 | 40.50 | 20.00 | 16.60 | A | 20* | 236081 |
| | 16.50 - 30.00 | 50.50 | 30.00 | 11.10 | A | 20* | 236082 |

NOTE: Clockwise and neutral execution

*Not suitable for indexable inserts with a radius of 0.80 mm



Type B Insert Holders | Diameter Range: 29.00 mm - 66.00 mm

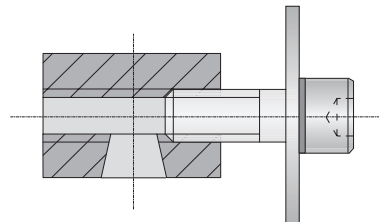
| Boring Range | Insert Holder | | | Weight | Type | Insert Form | Part No. |
|--------------|---------------|----------------|----------------|--------|------|-------------|----------|
| | A | X ₁ | L ₁ | | | | |
| Ⓜ | 29.00 - 44.00 | 75.50 | 54.00 | 9.60 | B | 20* | 236083 |
| | 43.00 - 66.00 | 100.50 | 79.00 | 9.60 | B | 20* | 236084 |

NOTE: Clockwise and neutral execution

*Not suitable for indexable inserts with a radius of 0.80 mm

Clamping Pieces for Outside Turning Insert Holders

| Insert Holder Type | Boring Range | Service Key | Complete Part No. |
|--------------------|---------------|-------------|-------------------|
| Ⓜ A | 4.00 - 30.00 | s5 | 236088 |
| B | 29.00 - 66.00 | s5 | 236089 |



Key on B10-A-1

B10-M: 12-13

B10-A: 47

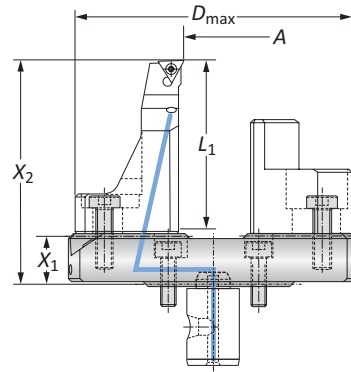
B10-H

B10: VI-VII

Ⓜ = Metric (mm)
Inserts sold separately

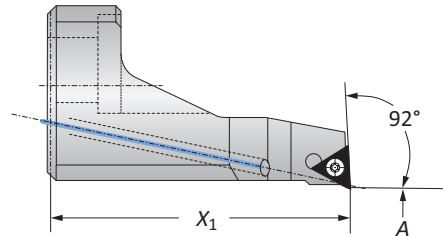
Outside Turning Serrated Slides | Insert Holders

Diameter Range: 2.00 mm - 114.00 mm



Outside Turning Serrated Slides

| | Boring Range | Serrated Slide | | | | Weight | Part No. |
|---|----------------|----------------|----------------|----------------|------------------|-----------|----------|
| | A | X ₁ | X ₂ | L ₁ | D _{max} | | |
| m | 2.00 - 30.00 | 16.00 | 73.00 | 55.00 | 101.00 | 0.35 (kg) | 501064 |
| | 30.00 - 58.00 | 16.00 | 73.00 | 55.00 | 129.00 | 0.44 (kg) | 501065 |
| | 58.00 - 86.00 | 22.00 | 79.00 | 55.00 | 157.00 | 0.60 (kg) | 501066 |
| | 86.00 - 114.00 | 22.00 | 79.00 | 55.00 | 185.00 | 0.73 (kg) | 501067 |



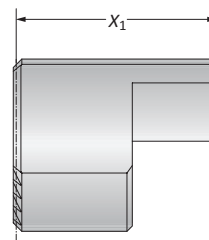
Insert Holder

| | Outside Turning Range | Insert Holder | Weight | Insert Form | Part No. |
|---|-----------------------|----------------|-----------|-------------|----------|
| | A | X ₁ | | | |
| m | 2.00 - 114.00 | 57.00 | 0.15 (kg) | 20 | 502082 |

NOTE: clockwise and neutral execution

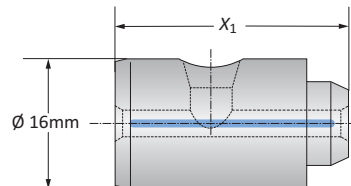
Counterweight

| | Counterweight | Weight | Part No. |
|---|----------------|-----------|----------|
| | X ₁ | | |
| m | 37.75 | 0.16 (kg) | 502183 |



Coolant Delivery Section

| | Coolant Delivery Section | Weight | Part No. |
|---|--------------------------|-----------|----------|
| | X ₁ | | |
| m | 25.50 | 0.01 (kg) | 450137 |

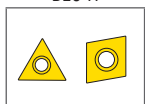
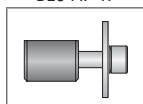
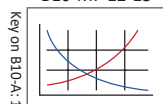


B10-M: 12-13

B10-A: 47

B10-H

B10: VI-VII



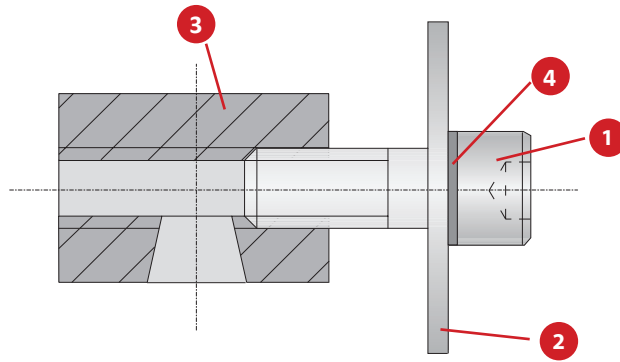
B10-A: 46

www.alliedmachine.com | +44 (0) 1384 400 900 | enquiries.eu@alliedmachine.com

m = Metric (mm)
Inserts sold separately

Accessories

Clamping Elements

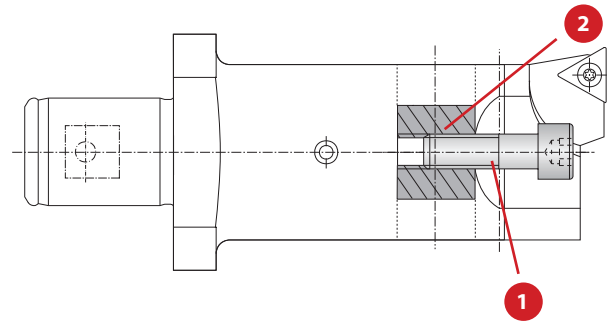


Clamping Elements for Insert Holders

| | 1 | | 2 | 3 | 4 | |
|-----------------------|---------------|----------|---------------|---------------|----------------|-------------------|
| Boring Range | Cap Screw | Hex Size | Washer | Clamping Nut | Locking Washer | Complete Part No. |
| m 4.00 - 30.00 | 070153 | s5 | 315155 | 236120 | 215254 | 236088 |
| 29.00 - 66.00 | 070153 | s5 | 315156 | 236120 | 215254 | 236089 |

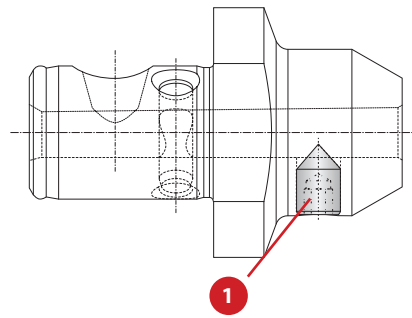
Clamping Elements for Serrated Tool Body

| 1 | | 2 |
|---------------|----------|----------------|
| Cap Screw | Hex Size | Clamping Piece |
| 027154 | s4 | 145184 |



Thread Pin

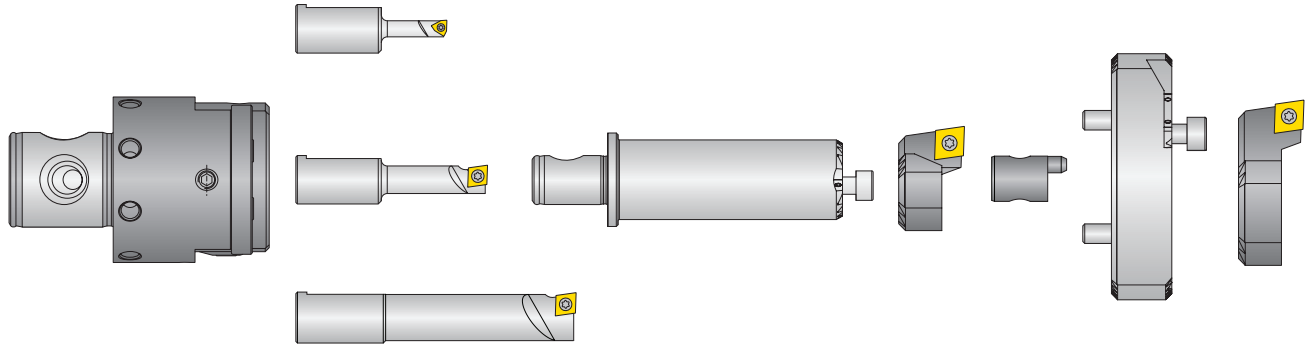
| | 1 |
|-------------|---------------|
| Service Key | Part No. |
| S3 / A | 415244 |



m = Metric (mm)

Kit Components

Form 101 | Diameter Range: 6.00 mm - 128.00 mm



Diameter Range: 6.00 mm - 128.00 mm

| Kit Components | | | | | | | | | | |
|----------------|---------------|-------------------|----------------|----------|--------------------|----------------|--------------------------|---|---------|--|
| Boring Head | Boring Bars | | Insert Holders | | Serrated Tool Body | Serrated Slide | Coolant Delivery Section | Service Keys | Kit No. | |
| | Boring Range | Part No. | Boring Range | Part No. | | | | | | |
| Ⓜ 450001 | 6.00 - 10.00 | 450026 (Form 211) | 24.00 - 40.00 | 450022 | 450021 | 450024 | 450125 | 003195 (s4) 515451 (T6) 515452 (T8) | 103088 | |
| | 10.00 - 16.00 | 450027 (Form 101) | 40.00 - 65.00 | 450023 | | | | | | |
| | 16.00 - 24.00 | 450028 (Form 101) | | | | | | | | |

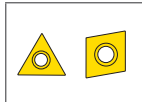
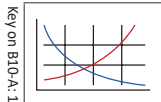
NOTE: Inserts sold separately



B10-M: 12-13

B10-H

B10: VI-VII



| | | | |
|-------|-------|-------|-------|
| 10-22 | 22-11 | 40-22 | 50-28 |
| 25-14 | 10-18 | 18-10 | 10-15 |

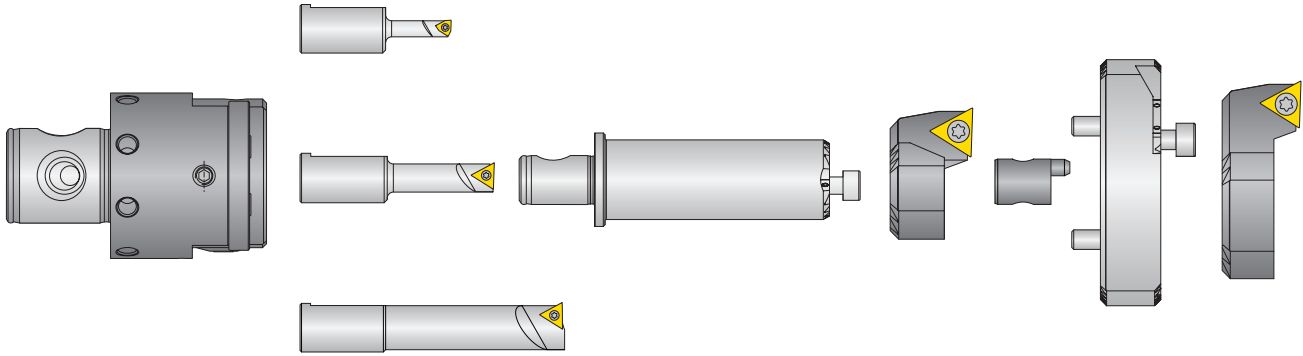
Ⓜ = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com

Kit Components

Form 20 | Diameter Range: 6.00 mm - 128.00 mm



Diameter Range: 6.00 mm - 128.00 mm

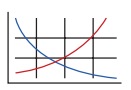
| Kit Components | | | | | | | | | | |
|----------------|--------------|---------------|-------------------|---------------|--------------------|----------------|--------------------------|--------------|---|--------|
| Boring Head | Boring Bars | | Insert Holders | | Serrated Tool Body | Serrated Slide | Coolant Delivery Section | Service Keys | Kit No. | |
| | Boring Range | Part No. | Boring Range | Part No. | | | | | | |
| Ⓜ | 450001 | 6.00 - 10.00 | 450026 (Form 211) | 24.00 - 40.00 | 450040 | 450021 | 450024 | 450125 | 003195 (s4) 515451 (T6) 515453 (T7) | 103089 |
| | | 10.00 - 16.00 | 450038 (Form 20) | 40.00 - 65.00 | 450041 | | | | | |
| | | 16.00 - 24.00 | 450039 (Form 20) | | | | | | | |

NOTE: Inserts sold separately

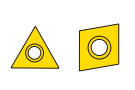


Key on B10-A-1


B10-M: 12-13



B10-H



B10: VI-VII



Ⓜ = Metric (mm)
Inserts sold separately

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email: engineering.eu@alliedmachine.com

Digital 510 Product Overview

Digital 510 VERSATILE FINE BORING

Improve your boring job with the Digital 510 boring head.

The Wohlhaupter® Digital 510 boring head offers precision, quality, and efficiency. Our integrated digital display makes the 510 the smallest precision boring tool available and allows for easy optoelectronic adjusting.

Experience *precision boring* for yourself.

- Diameter range: 0.40 mm - 12.00 mm
- Easy-to-read digital display
- Through coolant
- External counterweight for balancing
- Protected against coolant and dust according to IP65
- Fine adjustments of 0.002 mm
- Ideal for CAT40, BT30, HSK40
- Max spindle speed: 35,000 RPM



NOTE: Adjustment accuracy of 0.002 mm on diameter

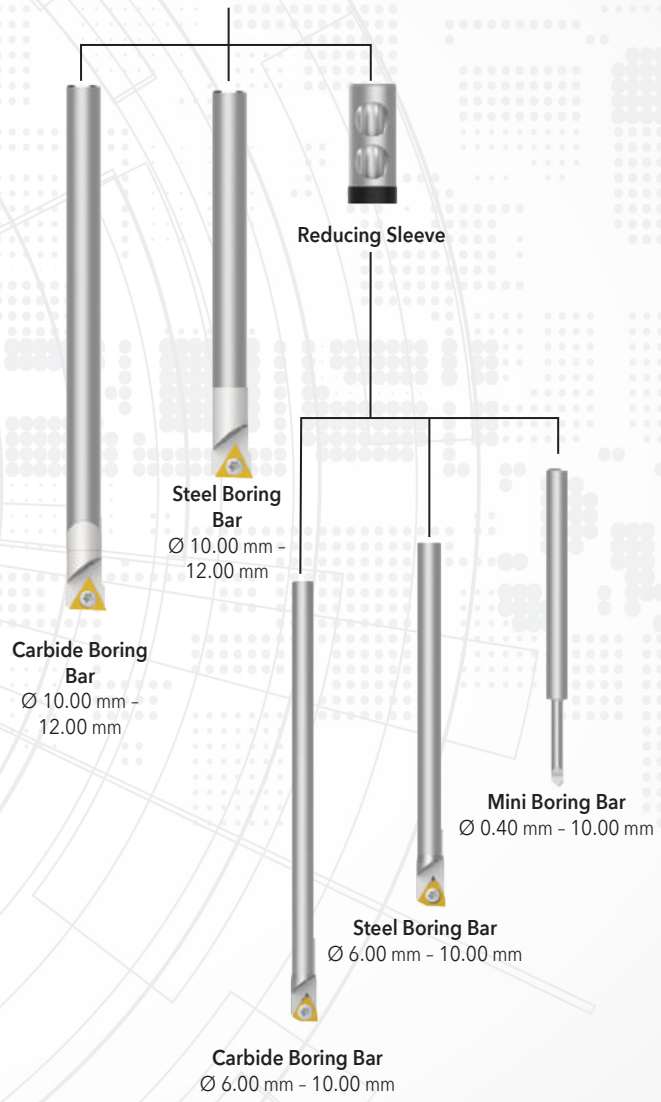
IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com

DIGITAL



NOTE: Adjustment accuracy of 0.002 mm on diameter

Digital 510001 Boring Head
0.40 mm - 12.00 mm

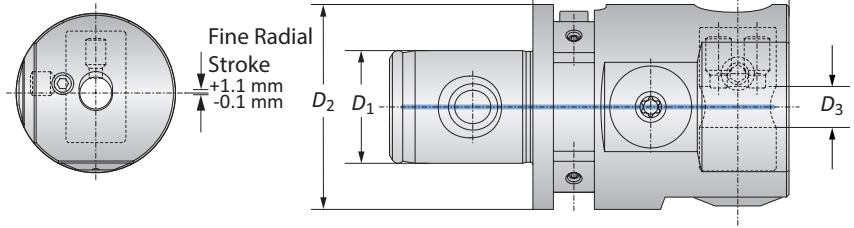


OPERATION VERSATILITY

from **0.40 mm** to **12.00 mm**

Boring Heads

Diameter Range: 0.40 mm - 12.00 mm

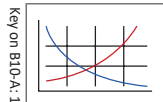


NOTE: Adjustment accuracy of 0.002 mm on diameter

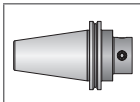
Boring Heads

| MVS Connection | Boring Range | Boring Head | | Weight | Part No. |
|----------------|--------------|---------------|-------|-----------|----------|
| | | D_2 D_1 | D_3 | | |
| 40 - 22 | 0.40 - 12.00 | 8.00 | 50.00 | 0.42 (kg) | 510001 |

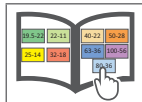
B10-M: 12-13



B10-F



B10: VI-VII



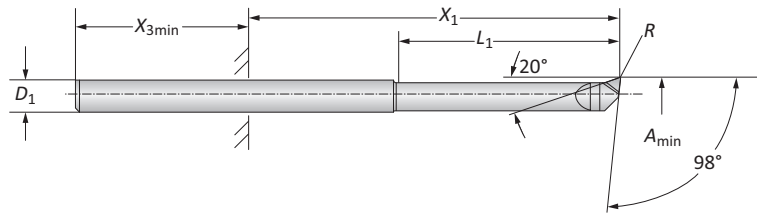
Key on B10-A:1

= Metric (mm)

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

Mini Boring Bars

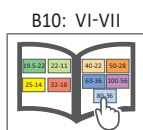
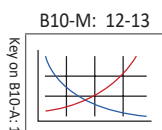
Diameter Range: 0.40 mm - 5.00 mm



Mini Boring Bars

| | Boring Range | | Boring Bar | | | | Part No. |
|---|--------------|-------|---------------|--------------|-------|------|--------------|
| | A_{min} | D_1 | X_1 | $X_{3\ min}$ | L_1 | R | |
| m | 0.40 | 4.00* | 3.00 - 26.00 | 16.00 | 2.00 | 0.03 | 081401WHC126 |
| | 0.60 | 4.00* | 4.00 - 27.00 | 16.00 | 3.00 | 0.04 | 081402WHC126 |
| | 0.80 | 4.00* | 5.00 - 28.00 | 16.00 | 4.00 | 0.04 | 081403WHC126 |
| | 1.00 | 4.00* | 6.00 - 29.00 | 16.00 | 5.00 | 0.05 | 081404WHC126 |
| | 1.50 | 4.00* | 8.50 - 31.50 | 16.00 | 7.50 | 0.05 | 081405WHC126 |
| | 2.00 | 4.00* | 11.00 - 34.00 | 16.00 | 10.00 | 0.05 | 081406WHC126 |
| | 2.50 | 4.00* | 13.50 - 36.50 | 16.00 | 12.50 | 0.05 | 081407WHC126 |
| | 2.80 | 4.00* | 15.00 - 38.00 | 16.00 | 14.00 | 0.07 | 081408WHC126 |

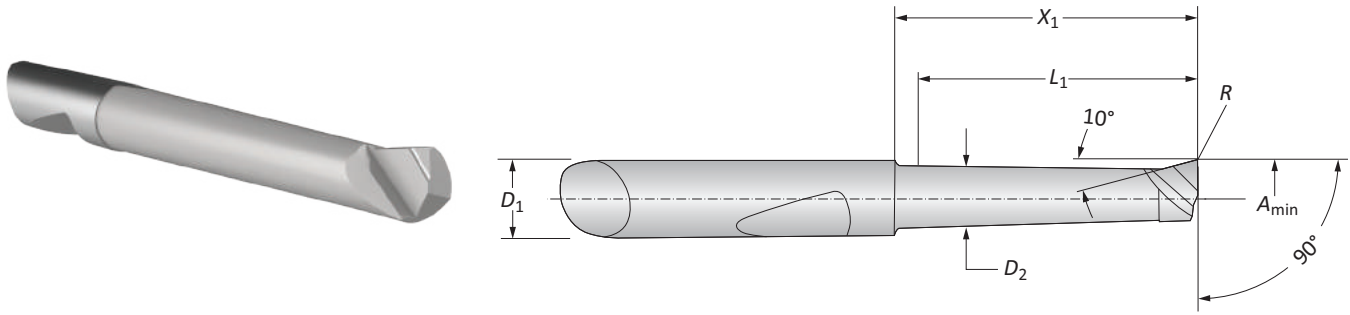
*Fixture-through reducing sleeve required (B10-A: 58)



m = Metric (mm)

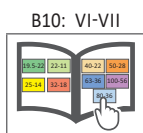
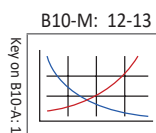
Mini Boring Bars

WHC05 | WHW04 | WBN150 | Diameter Range: 3.00 mm - 10.00 mm



| | Boring Range | | Boring Bar | | | | Part No. | | |
|---|--------------|-------|------------|-------|-------|------|----------------|------------------|--------------|
| | A_{min} | D_1 | D_2 | X_1 | L_1 | R | Coated Carbide | Uncoated Carbide | CBN |
| E | 3.00 | 6.00* | 2.60 | 11.50 | 10.00 | 0.10 | 081306WHC05 | - | 081322WBN150 |
| | 3.00 | 6.00* | 2.60 | 16.50 | 15.00 | 0.10 | 081307WHC05 | 081307WHW04 | - |
| | 4.00 | 6.00* | 3.60 | 12.00 | 10.00 | 0.20 | 081308WHC05 | - | 081317WBN150 |
| F | 4.00 | 6.00* | 3.60 | 17.00 | 15.00 | 0.20 | 081309WHC05 | - | 081341WBN150 |
| | 4.00 | 6.00* | 3.60 | 22.00 | 20.00 | 0.20 | 081310WHC05 | 081310WHW04 | - |
| | 5.00 | 6.00* | 4.60 | 12.00 | 10.00 | 0.20 | 081311WHC05 | - | 081318WBN150 |
| G | 5.00 | 6.00* | 4.60 | 22.00 | 20.00 | 0.20 | 081312WHC05 | - | 081319WBN150 |
| | 5.00 | 6.00* | 4.60 | 32.00 | 30.00 | 0.20 | 081313WHC05 | 081313WHW04 | - |
| | 6.00 | 6.00* | 5.60 | 22.00 | 20.00 | 0.20 | 081314WHC05 | - | 081320WBN150 |
| H | 6.00 | 6.00* | 5.60 | 32.00 | 30.00 | 0.20 | 081315WHC05 | - | 081321WBN150 |
| | 6.00 | 6.00* | 5.60 | 42.00 | 40.00 | 0.20 | 081316WHC05 | 081316WHW04 | - |
| | 8.00 | 8.00* | 7.60 | 25.00 | 23.00 | 0.20 | 081323WHC05 | - | - |
| I | 8.00 | 8.00* | 7.60 | 50.00 | 48.00 | 0.20 | 081324WHC05 | - | - |

*Fixture-through reducing sleeve required (B10-A: 58)



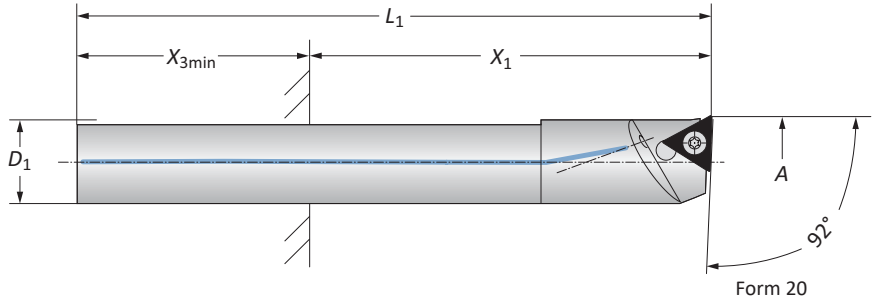
Ⓜ = Metric (mm)


Boring Bars

Steel | Diameter Range: 6.00 mm - 12.00 mm



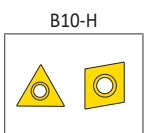
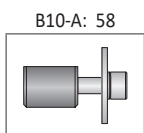
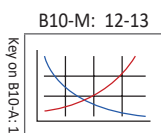
Form 101




| | Boring Range | | Boring Bar | | | | Part No. | | | |
|---|---------------|----------------|----------------|--------------------|----------------|-----------|-------------|---------------|-------------|---------------|
| | A | D ₁ | X ₁ | X _{3 min} | L ₁ | Weight | Insert Form | Boring Bar | Insert Form | Boring Bar |
|  | 6.00 - 8.00 | 5.00* | 12.50 - 25.00 | 16.00 | 70.00 | 0.01 (kg) | 211** | 514032 | - | - |
| | 8.00 - 10.00 | 7.00* | 17.50 - 35.00 | 16.00 | 81.00 | 0.02 (kg) | 211** | 514033 | - | - |
| | 10.00 - 12.00 | 8.00 | 20.00 - 40.00 | 19.00 | 85.00 | 0.03 (kg) | 101 | 514003 | 20** | 514004 |

*Fixture-through reducing sleeve required (B10-A: 58)

**Not suitable for indexable inserts with a radius of 0.8 mm



Key on B10-A: 1

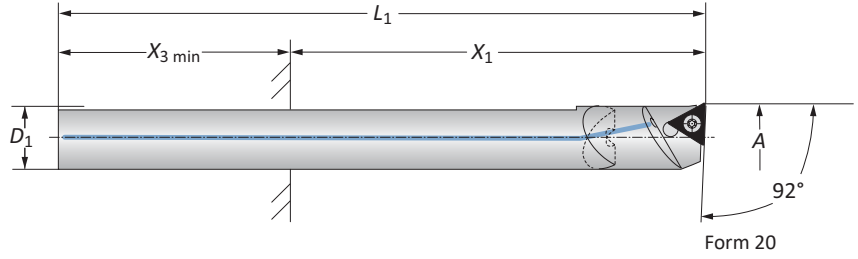
 = Metric (mm)
Inserts sold separately

Boring Bars

Carbide | Diameter Range: 6.00 mm - 12.00 mm



Form 101

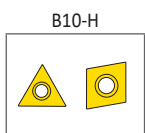
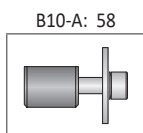
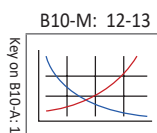


Form 20

| Boring Range | Boring Bar | | | | Weight | Part No. | | | |
|---------------|------------|----------------|----------------|--------------------|-----------|----------------|---------------|------------|---------------|
| | A | D ₁ | X ₁ | X _{3 min} | | L ₁ | Insert Form | Boring Bar | Insert Form |
| 6.00 - 8.00 | 5.00* | 12.50 - 40.00 | 16.00 | 90.00 | 0.02 (kg) | 211** | 514034 | - | - |
| 8.00 - 10.00 | 7.00* | 21.00 - 56.00 | 16.00 | 109.00 | 0.05 (kg) | 211** | 514035 | - | - |
| 10.00 - 12.00 | 8.00 | 22.00 - 64.00 | 19.00 | 117.00 | 0.07 (kg) | 101 | 514015 | 20** | 514016 |

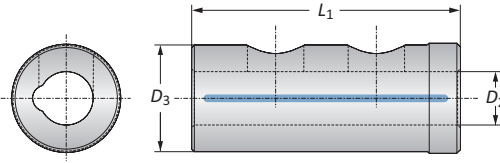
*Fixture-through reducing sleeve required (B10-A: 58)

**Not suitable for indexable inserts with a radius of 0.80 mm



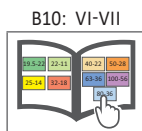
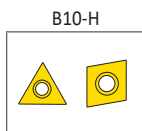
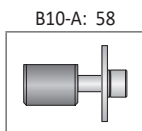
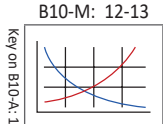
m = Metric (mm)
Inserts sold separately

Reducing Sleeves



| Reducing Sleeve | | | | Part No. |
|-----------------|-------|-------|--|----------|
| D_3 | D_2 | L_1 | | |
| 8.00 | 4.00 | 20.00 | | 514201 |
| 8.00 | 5.00 | 20.00 | | 514202 |
| 8.00 | 6.00 | 20.00 | | 514210 |
| 8.00 | 7.00 | 20.00 | | 514203 |

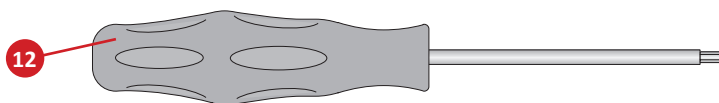
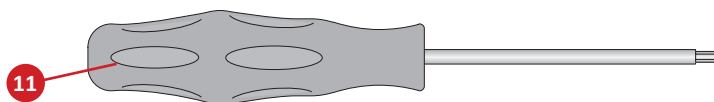
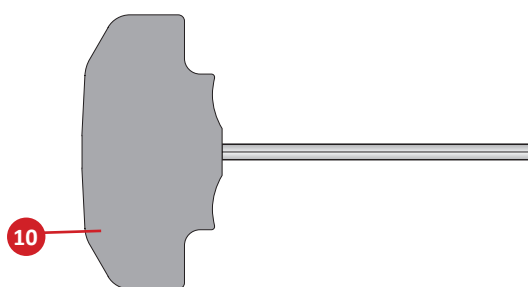
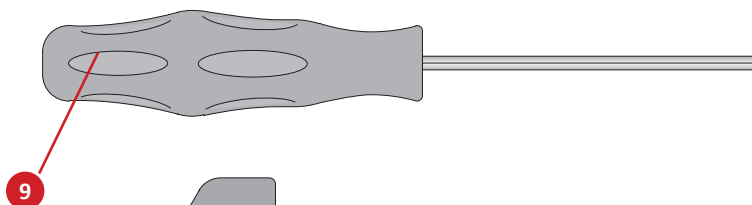
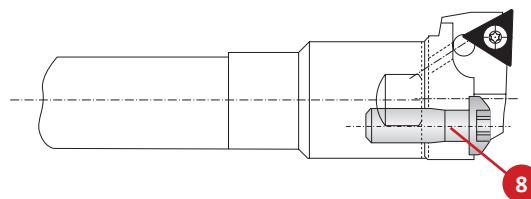
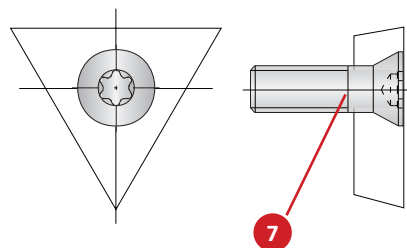
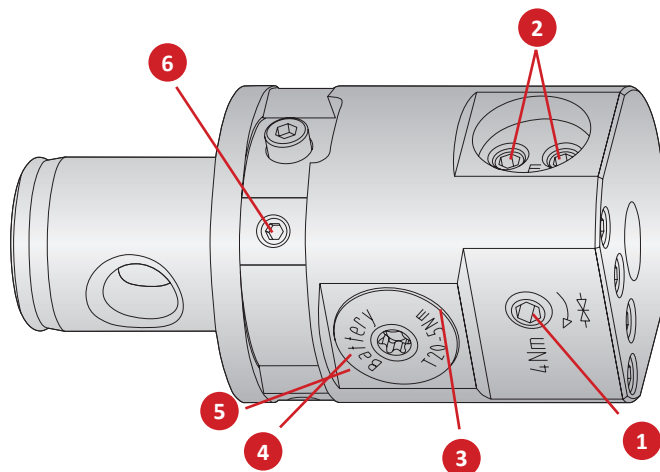
Ⓜ



Ⓜ = Metric (mm)
Inserts sold separately

Boring Head Accessories

| No. | Part | Insert Form | Size | Part No. |
|-----|---------------------------------|---------------------------------|-----------------------|--|
| | | | | 510001 |
| 1 | Clamping screw | - | - | 115985 |
| 2 | Thread pin for tool clamping | - | - | 070333 |
| 3 | Sealing ring for battery cover | - | - | 415895 |
| 4 | Battery* | - | - | 415896 |
| 5 | Battery cover with sealing ring | - | - | 501016 |
| 6 | Thread pin | - | - | 510114 |
| 7 | Insert screws | Form 20 Form 101 Form 211 | T7 T8 T6 | 115535 115676 515286 |
| 8 | Clamping Screw | - | T25 | 415112 |
| 9 | Hex wrench | - | s2 | 215473 |
| 10 | Hex wrench | - | s2.5 s3.0 s4.0 | 415577 415578 115576 |
| 11 | Torx driver | - | T6 T7 T8 T20 | 115537 115591 115590 215150 |
| 12 | Torx screw-driver | Form 211 Form 20 Form 101 | T6 T7 T8 | 415507 415508 415514 |



*Always change two batteries
NOTE: Please use VARTA batteries

DigiBore Product Overview



DigiBore VERSATILE FINE BORING

Advanced versatile technology.

The Wohlhaupter® DigiBore boring head provides internal balancing, which makes this tool the stress-free choice to meet your required surface finish. Its digital display allows for quick and accurate diameter corrections at the machine.

Engineered with the *future in mind*.

- Diameter range: 3.00 mm - 208.00 mm
- Offers outside turning capabilities: 4.00 mm - 114.00 mm
- Digital readout for simple 0.002 mm diameter adjustments
- Ease the stress of working on different day-to-day projects with boring kits
- Automatic internal balancing improves surface finish, tool life, and accuracy
- Max spindle speed: 16,000 RPM
- Max coolant pressure: 40 bar



NOTE: Adjustment accuracy of 0.002 mm on diameter

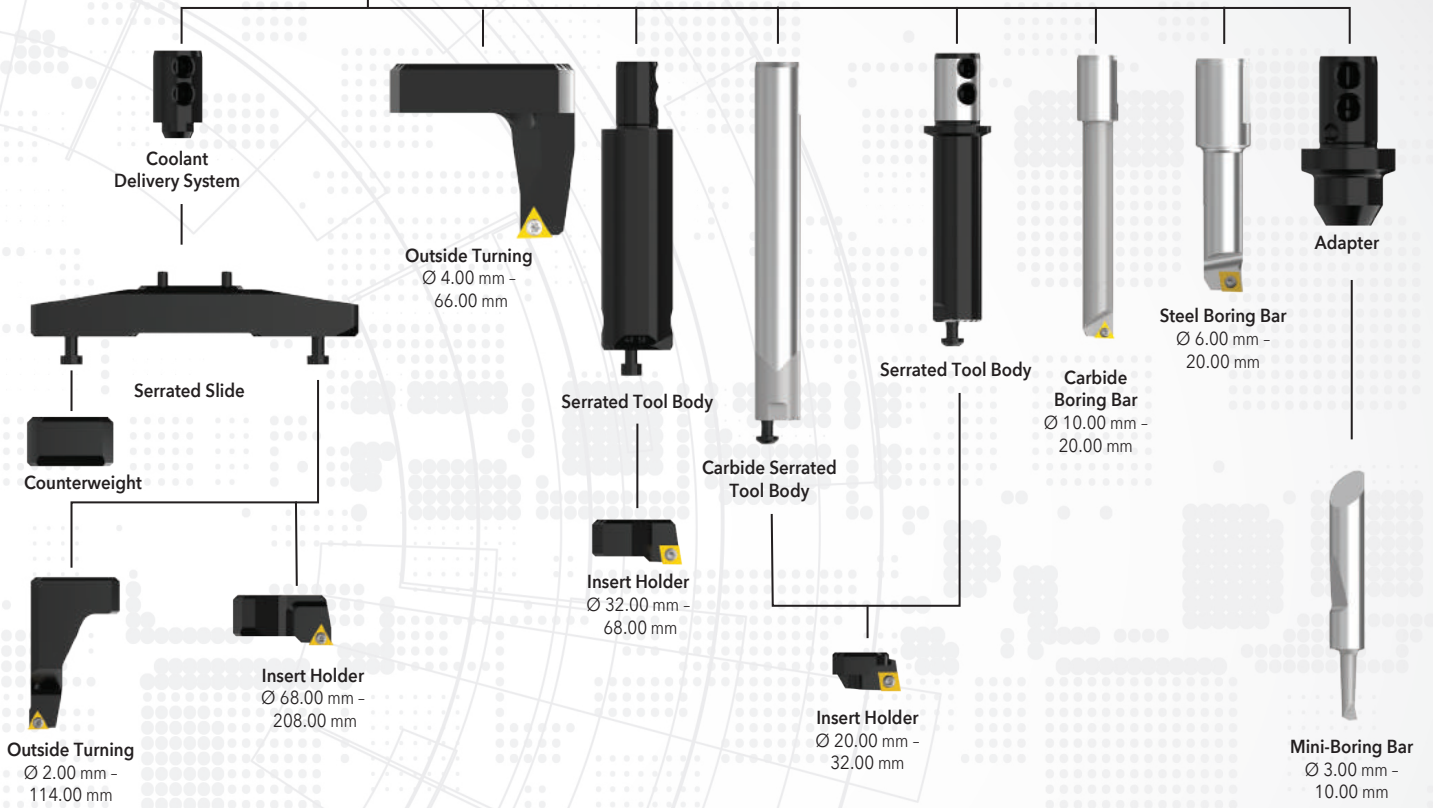
IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com

DIGI BORE



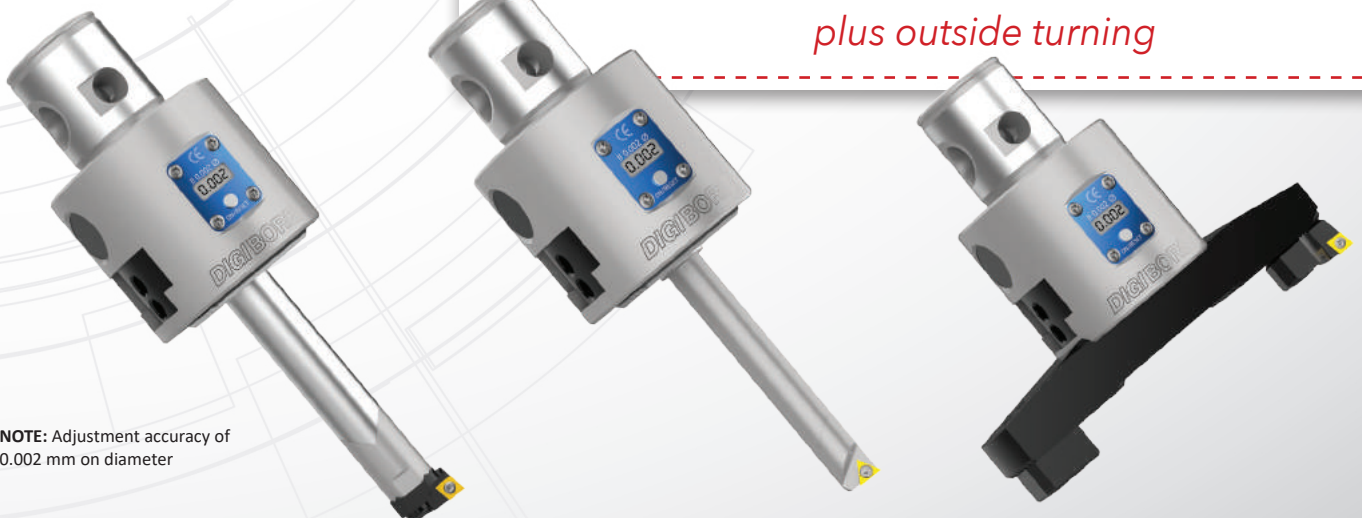
DigiBore Head

NOTE: Adjustment accuracy of 0.002 mm on diameter



OPERATION **VERSATILITY**

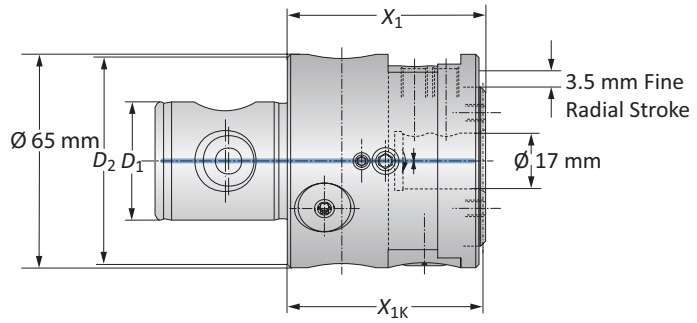
from **3.00 mm** to **208.00 mm**
plus outside turning



NOTE: Adjustment accuracy of 0.002 mm on diameter

Boring Heads

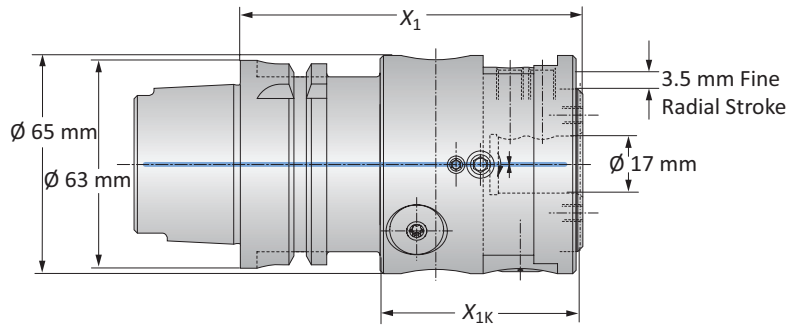
Diameter Range: 3.00 mm - 208.00 mm



NOTE: Adjustment accuracy of 0.002 mm on diameter

DigiBore Boring Heads

| | MVS Connection | | Boring Head | | Weight | Part No. |
|--|----------------|---------------|-------------|----------|-----------|----------|
| | D_2 D_1 | Boring Range | X_1 | X_{1K} | | |
| | 50 - 28 | 3.00 - 208.00 | 60.00 | 59.50 | 1.30 (kg) | 501005 |
| | 63 - 36 | 3.00 - 208.00 | 60.00 | 59.50 | 1.50 (kg) | 501001 |



NOTE: Adjustment accuracy of 0.002 mm on diameter

DigiBore Boring Heads

| | Connection | | Boring Head | | Weight | Part No. |
|--|------------------------|---------------|-------------|----------|-----------|----------|
| | Connection | Boring Range | X_1 | X_{1K} | | |
| | HSK-A 63 | 3.00 - 208.00 | 102.00 | 59.50 | 2.10 (kg) | 501004 |
| | PSC 63 (Polygon Shank) | 3.00 - 208.00 | 102.00 | 59.50 | 2.10 (kg) | 501019 |

B10-M: 12-13 B10-F B10: VI-VII

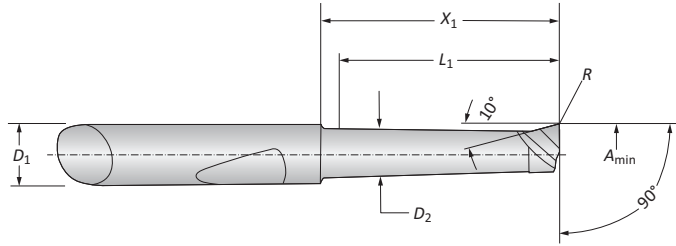
Key on B10-A:1

= Metric (mm)

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

Mini Boring Bars

WHC05 | WHW04 | WBN150 | Diameter Range: 3.00 mm - 10.00 mm



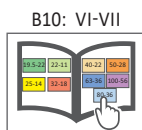
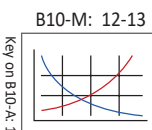
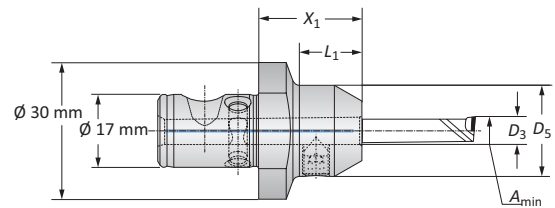
Mini Boring Bars

| Boring Range | Boring Bar | | | | | | Part No. | | |
|--------------|------------|-------|-------|-------|-------|------|----------------|------------------|--------------|
| | A_{min} | D_1 | D_2 | X_1 | L_1 | R | Coated Carbide | Uncoated Carbide | CBN |
| m | 3.00 | 6.00 | 2.60 | 11.50 | 10.00 | 0.10 | 081306WHC05 | - | 081322WBN150 |
| | 3.00 | 6.00 | 2.60 | 16.50 | 15.00 | 0.10 | 081307WHC05 | 081307WHW04 | - |
| | 4.00 | 6.00 | 3.60 | 12.00 | 10.00 | 0.20 | 081308WHC05 | - | 081317WBN150 |
| | 4.00 | 6.00 | 3.60 | 17.00 | 15.00 | 0.20 | 081309WHC05 | - | 081341WBN150 |
| | 4.00 | 6.00 | 3.60 | 22.00 | 20.00 | 0.20 | 081310WHC05 | 081310WHW04 | - |
| | 5.00 | 6.00 | 4.60 | 12.00 | 10.00 | 0.20 | 081311WHC05 | - | 081318WBN150 |
| | 5.00 | 6.00 | 4.60 | 22.00 | 20.00 | 0.20 | 081312WHC05 | - | 081319WBN150 |
| | 5.00 | 6.00 | 4.60 | 32.00 | 30.00 | 0.20 | 081313WHC05 | 081313WHW04 | - |
| | 6.00 | 6.00 | 5.60 | 22.00 | 20.00 | 0.20 | 081314WHC05 | - | 081320WBN150 |
| | 6.00 | 6.00 | 5.60 | 32.00 | 30.00 | 0.20 | 081315WHC05 | - | 081321WBN150 |
| | 6.00 | 6.00 | 5.60 | 42.00 | 40.00 | 0.20 | 081316WHC05 | 081316WHW04 | - |
| | 8.00 | 8.00 | 7.60 | 25.00 | 23.00 | 0.20 | 081323WHC05 | - | - |
| | 8.00 | 8.00 | 7.60 | 50.00 | 48.00 | 0.20 | 081324WHC05 | - | - |



Adapters

| Boring Range | Adapter | | | | | Weight | Part No. |
|--------------|--------------|-------|-------|-------|-------|-----------|----------|
| | A_{min} | X_1 | L_1 | D_3 | D_5 | | |
| m | 3.00 - 8.00 | 22.50 | 14.00 | 6.00 | 20.00 | 0.04 (kg) | 501050 |
| | 8.00 - 10.00 | 22.50 | 14.00 | 8.00 | 22.00 | 0.04 (kg) | 501051 |



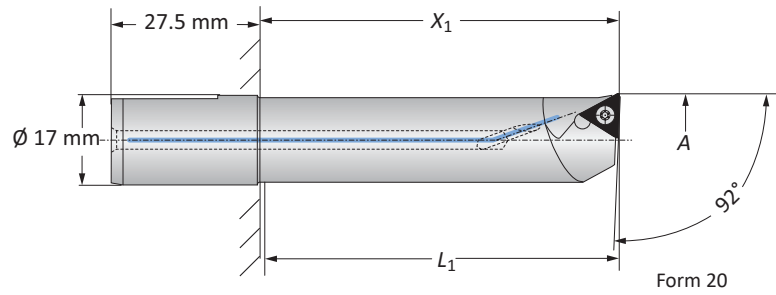
m = Metric (mm)

Boring Bars

Steel | Diameter Range: 6.00 mm - 20.00 mm



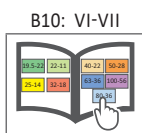
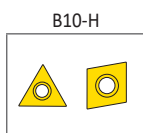
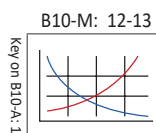
Form 101



Form 20

| | Boring Range | | Boring Bar | | Weight | Insert Form | Part No. | Insert Form | Part No. |
|---|---------------|----------------|----------------|--|-----------|-------------|----------|-------------|----------|
| | A | X ₁ | L ₁ | | | | | | |
| m | 6.00 - 8.00 | 22.00 | 19.00 | | 0.05 (kg) | 211* | 502068 | - | - |
| | 8.00 - 10.00 | 30.00 | 27.00 | | 0.05 (kg) | 211* | 502066 | - | - |
| | 10.00 - 11.00 | 30.00 | 27.00 | | 0.06 (kg) | 101 | 502012 | 20* | 502001 |
| | 11.00 - 12.00 | 30.00 | 27.00 | | 0.06 (kg) | 101 | 502075 | 20* | 502070 |
| | 12.00 - 13.00 | 45.00 | 42.00 | | 0.07 (kg) | 101 | 502013 | 20* | 502002 |
| | 13.00 - 14.00 | 45.00 | 42.00 | | 0.08 (kg) | 101 | 502076 | 20* | 502071 |
| | 14.00 - 15.00 | 50.00 | 47.00 | | 0.08 (kg) | 101 | 502014 | 20* | 502003 |
| | 15.00 - 16.00 | 50.00 | 47.00 | | 0.09 (kg) | 101 | 502077 | 20* | 502072 |
| | 16.00 - 17.00 | 60.00 | 57.00 | | 0.10 (kg) | 101 | 502015 | 20* | 502004 |
| | 17.00 - 18.00 | 60.00 | 57.00 | | 0.12 (kg) | 101 | 502078 | 20* | 502073 |
| | 18.00 - 19.00 | 68.00 | 65.00 | | 0.13 (kg) | 101 | 502016 | 20* | 502005 |
| | 19.00 - 20.00 | 68.00 | 65.00 | | 0.14 (kg) | 101 | 502079 | 20* | 502074 |

*Not suitable for indexable inserts with a radius of 0.80 mm

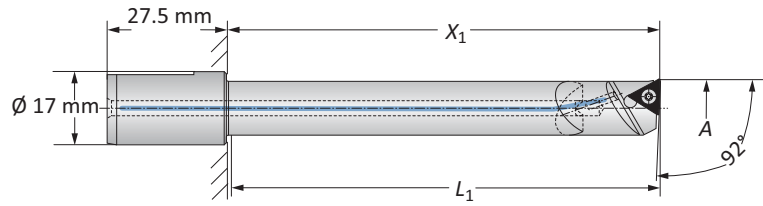


Boring Bars

Carbide | Diameter Range: 10.00 mm - 20.00 mm



Form 101



Form 20

| Boring Range | Boring Bar | | Weight | Insert Form | Part No. | Insert Form | Part No. | |
|---------------|---------------|----------------|-----------|-------------|----------|-------------|----------|----------------|
| | A | X ₁ | | | | | | L ₁ |
| m | 10.00 - 12.00 | 55.00 | 52.00 | 0.12 (kg) | 101 | 502093 | 20* | 502088 |
| | 10.00 - 12.00 | 70.00 | 67.00 | 0.14 (kg) | 101 | 502034 | 20* | 502023 |
| | 12.00 - 14.00 | 65.00 | 62.00 | 0.13 (kg) | 101 | 502094 | 20* | 502089 |
| | 12.00 - 14.00 | 85.00 | 82.00 | 0.18 (kg) | 101 | 502035 | 20* | 502024 |
| | 14.00 - 16.00 | 75.00 | 72.00 | 0.17 (kg) | 101 | 502095 | 20* | 502090 |
| | 14.00 - 16.00 | 90.00 | 87.00 | 0.22 (kg) | 101 | 502036 | 20* | 502025 |
| | 16.00 - 18.00 | 85.00 | 82.00 | 0.26 (kg) | 101 | 502096 | 20* | 502091 |
| | 16.00 - 18.00 | 110.00 | 107.00 | 0.32 (kg) | 101 | 502037 | 20* | 502026 |
| | 18.00 - 20.00 | 95.00 | 92.00 | 0.28 (kg) | 101 | 502097 | 20* | 502092 |
| 18.00 - 20.00 | 120.00 | 117.00 | 0.40 (kg) | 101 | 502038 | 20* | 502027 | |

*Not suitable for indexable inserts with a radius of 0.80 mm

Key on B10-A: 1

B10-M: 12-13

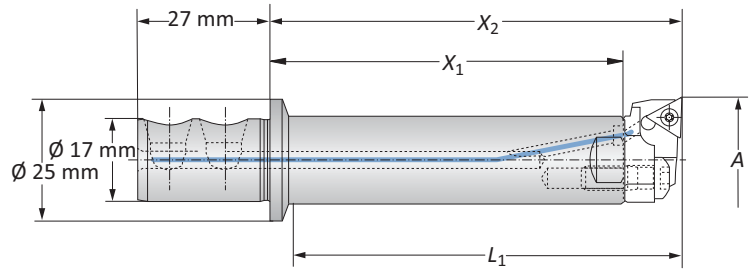
B10-H

B10: VI-VII

m = Metric (mm)
Inserts sold separately

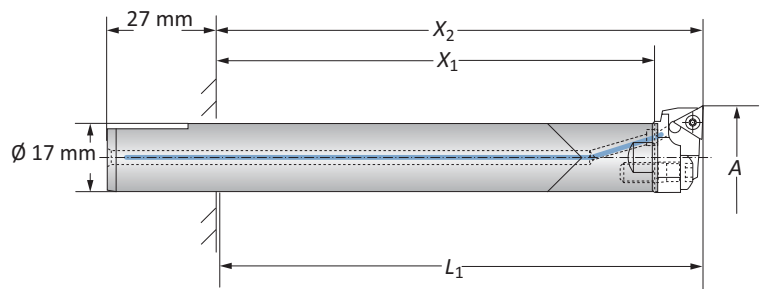
Serrated Tool Bodies | Insert Holders

Steel | Carbide | Diameter Range: 20.00 mm - 32.00 mm



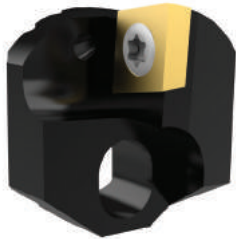
Steel Serrated Tool Body

| Boring Range | Serrated Tool Body | | | Weight | Part No. |
|---------------|--------------------|----------------|----------------|-----------|----------|
| A | X ₁ | X ₂ | L ₁ | | |
| 20.00 - 32.00 | 72.00 | 84.00 | 77.00 | 0.20 (kg) | 502045 |

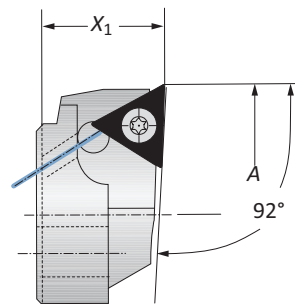


Carbide Serrated Tool Body

| Boring Range | Serrated Tool Body | | | Weight | Part No. |
|---------------|--------------------|----------------|----------------|-----------|----------|
| A | X ₁ | X ₂ | L ₁ | | |
| 20.00 - 32.00 | 108.00 | 120.00 | 117.00 | 0.40 (kg) | 502062 |



Form 101

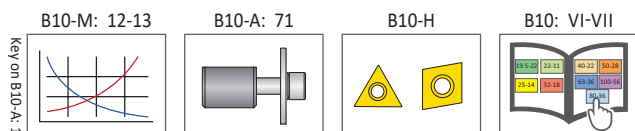


Form 20

Insert Holders

| Boring Range | Insert Holder | Weight | Insert Form | Part No. | Insert Form | Part No. |
|---------------|----------------|-----------|-------------|----------|-------------|----------|
| A | X ₁ | | | | | |
| 20.00 - 22.00 | 12.00 | 0.01 (kg) | 101 | 502052 | 20* | 502046 |
| 22.00 - 24.00 | 12.00 | 0.01 (kg) | 101 | 502053 | 20* | 502047 |
| 24.00 - 26.00 | 12.00 | 0.01 (kg) | 101 | 502054 | 20* | 502048 |
| 26.00 - 28.00 | 12.00 | 0.01 (kg) | 101 | 502055 | 20* | 502049 |
| 28.00 - 30.00 | 12.00 | 0.01 (kg) | 101 | 502056 | 20* | 502050 |
| 30.00 - 32.00 | 12.00 | 0.01 (kg) | 101 | 502057 | 20* | 502051 |

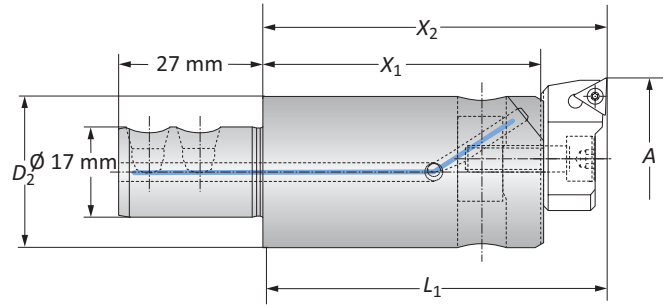
*Not suitable for indexable inserts with a radius of 0.80 mm



m = Metric (mm)
Inserts sold separately

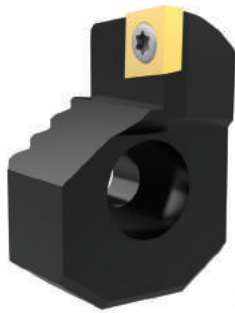
Alu-Line Serrated Tool Bodies | Insert Holders

Diameter Range: 32.00 mm - 68.00 mm

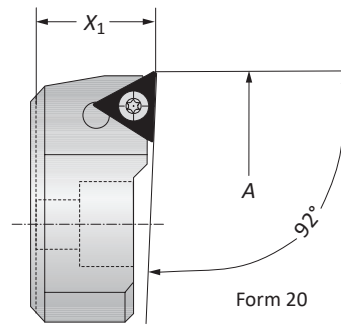


Alu-Line Serrated Tool Bodies

| Boring Range | Serrated Tool Body | | | | | Weight | Part No. |
|--------------|--------------------|----------------|----------------|----------------|----------------|-----------|----------|
| | A | D ₂ | X ₁ | X ₂ | L ₁ | | |
| m | 32.00 - 50.00 | 28.50 | 52.00 | 66.00 | 63.00 | 0.10 (kg) | 501052 |
| | 32.00 - 50.00 | 28.50 | 88.00 | 102.00 | 99.00 | 0.20 (kg) | 501060 |
| | 50.00 - 68.00 | 46.00 | 61.00 | 75.00 | 72.00 | 0.20 (kg) | 501053 |
| | 50.00 - 68.00 | 46.00 | 106.00 | 120.00 | 117.00 | 0.30 (kg) | 501061 |



Form 101

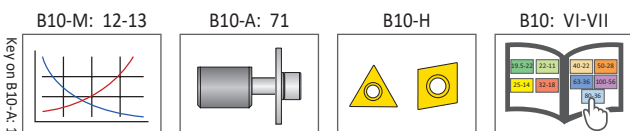


Form 20

Insert Holders

| Serrated Tool Body | Boring Range | Insert Holder | Weight | Insert Form | Part No. | | |
|--------------------|-----------------|-----------------|---------------|-------------|-----------|--------|--------|
| | A | X ₁ | | | | | |
| m | 501052 / 501060 | 32.00 - 41.00 | 14.00 | 0.03 (kg) | 20* | 502060 | |
| | | 41.00 - 50.00 | 14.00 | 0.04 (kg) | 20* | 502061 | |
| | 501053 / 501061 | 501052 / 501060 | 32.00 - 41.00 | 14.00 | 0.03 (kg) | 101 | 502058 |
| | | | 41.00 - 50.00 | 14.00 | 0.04 (kg) | 101 | 502059 |
| 501053 / 501061 | | 50.00 - 59.00 | 14.00 | 0.03 (kg) | 20* | 502060 | |
| | | 59.00 - 68.00 | 14.00 | 0.04 (kg) | 20* | 502061 | |
| 501053 / 501061 | 501053 / 501061 | 50.00 - 59.00 | 14.00 | 0.03 (kg) | 101 | 502058 | |
| | | 59.00 - 68.00 | 14.00 | 0.04 (kg) | 101 | 502059 | |

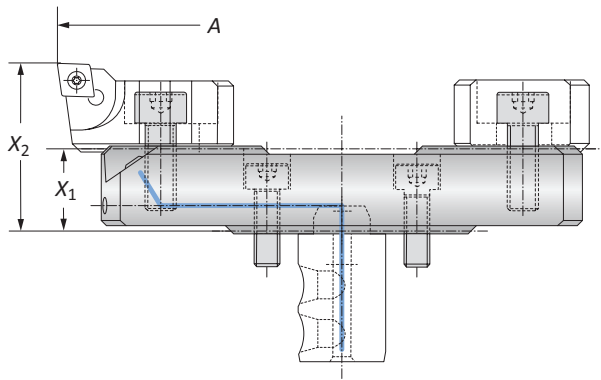
*Not suitable for indexable inserts with a radius of 0.80 mm



m = Metric (mm)
Inserts sold separately

Alu-Line Serrated Slides | Insert Holders

Diameter Range: 68.00 mm - 208.00 mm



Alu-Line Serrated Slides

| | Boring Range | | Serrated Slide | | Weight | Part No. |
|---|-----------------|----------------|----------------|--|-----------|----------|
| | A | X ₁ | X ₂ | | | |
| m | 68.00 - 96.00 | 16.00 | 32.50 | | 0.10 (kg) | 501054 |
| | 96.00 - 124.00 | 16.00 | 32.50 | | 0.10 (kg) | 501055 |
| | 124.00 - 152.00 | 16.00 | 32.50 | | 0.20 (kg) | 501056 |
| | 152.00 - 180.00 | 22.00 | 38.50 | | 0.25 (kg) | 501058 |
| | 180.00 - 208.00 | 22.00 | 38.50 | | 0.30 (kg) | 501059 |

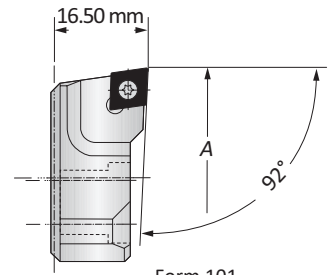
Insert Holders

| | Boring Range | | | |
|---|----------------|-----------|-------------|----------|
| | A | Weight | Insert Form | Part No. |
| m | 68.00 - 208.00 | 0.05 (kg) | 101 | 502064 |
| | 68.00 - 208.00 | 0.05 (kg) | 20 | 502069 |

NOTE: Other insert holders available upon request



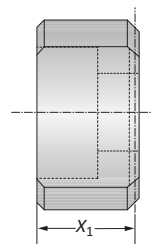
Form 20



Form 101

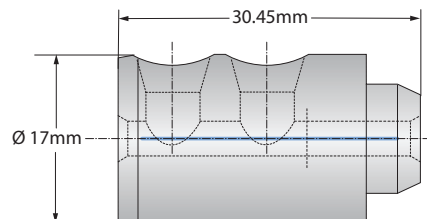
Counterweight

| Counterweight | | | |
|----------------|-----------|----------|--|
| X ₁ | Weight | Part No. | |
| m 13.40 | 0.05 (kg) | 502165 | |



Coolant Delivery System

| Coolant Delivery System | |
|-------------------------|----------|
| Weight | Part No. |
| m 0.02 (kg) | 501157 |

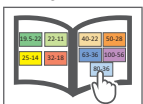
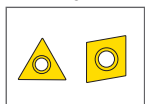
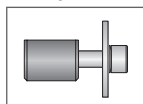
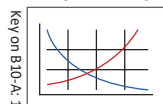


B10-M: 12-13

B10-A: 71

B10-H

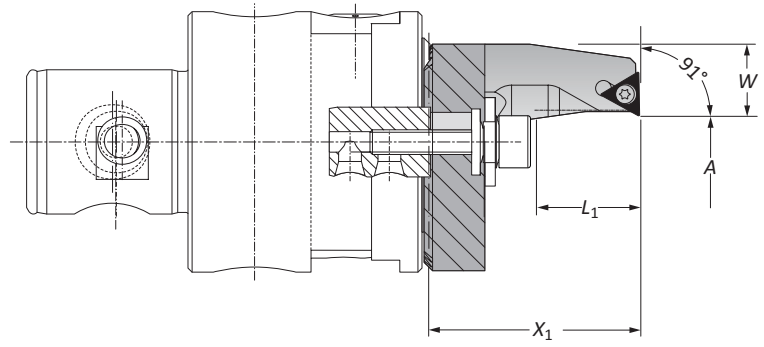
B10: VI-VII




m = Metric (mm)
Inserts sold separately

Outside Turning Insert Holders for Boring Heads

Diameter Range: 4.00 mm - 66.00 mm

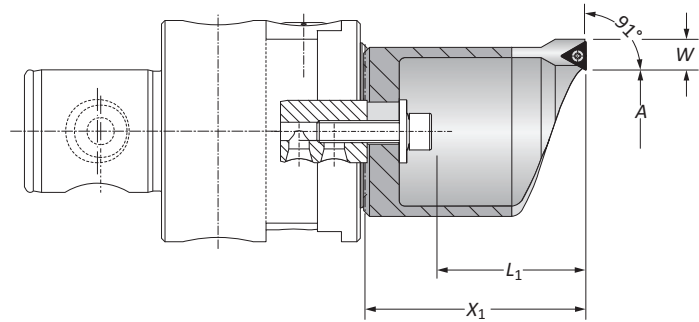


Type A Insert Holders | Diameter Range: 4.00 mm - 30.00 mm


| Boring Range | Insert Holder | | | | Weight | Insert Form | Part No. |
|---|---------------|----------------|----------------|-----------|--------|-------------|----------|
| | A | X ₁ | L ₁ | W | | | |
|  4.00 - 17.50 16.50 - 30.00 | 40.50 | 20.00 | 16.60 | 0.10 (kg) | 20* | 236081 | |
| | 50.50 | 30.00 | 11.10 | 0.10 (kg) | 20* | 236082 | |

NOTE: Clockwise and neutral execution

*Not suitable for indexable inserts with a radius of 0.80 mm




Type B Insert Holders | Diameter Range: 29.00 mm - 66.00 mm

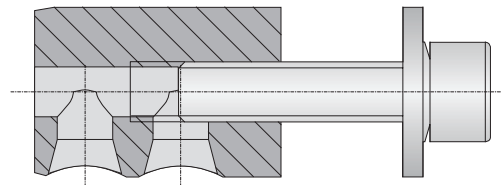
| Boring Range | Insert Holder | | | | Weight | Insert Form | Part No. |
|--|---------------|----------------|----------------|-----------|--------|-------------|----------|
| | A | X ₁ | L ₁ | W | | | |
|  29.00 - 44.00 43.00 - 66.00 | 75.50 | 54.00 | 9.60 | 0.30 (kg) | 20* | 236083 | |
| | 100.50 | 79.00 | 9.60 | 0.40 (kg) | 20* | 236084 | |

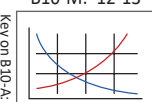
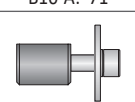
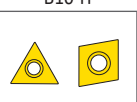

NOTE: Clockwise and neutral execution


*Not suitable for indexable inserts with a radius of 0.80 mm

Clamping Pieces for Outside Turning Insert Holders

| Insert Holder Type | Boring Range | Service Key | Complete Part No. |
|---|---------------|-------------|-------------------|
|  A | 4.00 - 30.00 | s5 | 502080 |
| B | 29.00 - 66.00 | s5 | 502081 |



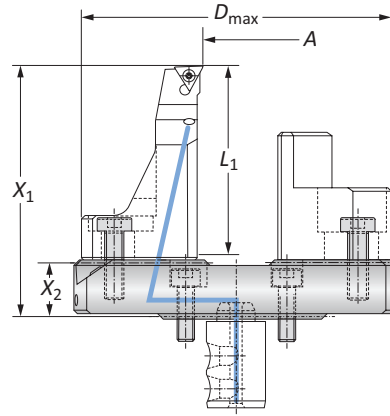
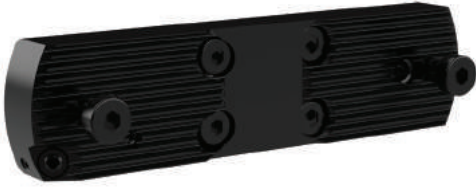
 B10-M: 12-13
 B10-A: 71
 B10-H
 B10: VI-VII
Key on B10-A-1

 = Metric (mm)
 Inserts sold separately

A
B
C
D
E
F
G
H
I
J
K
L
M
INDEX

Outside Turning Serrated Slides | Insert Holders

Diameter Range: 2.00 mm - 114.00 mm



Outside Turning Serrated Slides

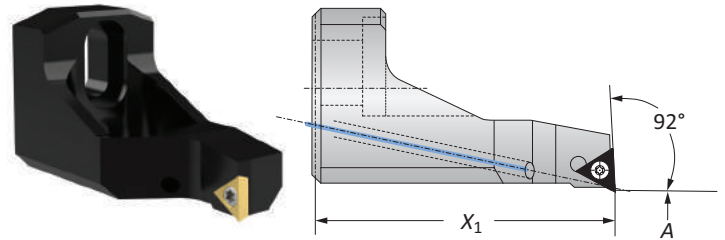
| | Boring Range | | Serrated Slide | | | | Weight | Part No. |
|---|----------------|----------------|----------------|----------------|------------------|-----------|--------|----------|
| | A | X ₁ | X ₂ | L ₁ | D _{max} | | | |
| m | 2.00 - 30.00 | 73.00 | 16.00 | 55.00 | 101.00 | 0.35 (kg) | 501064 | |
| | 30.00 - 58.00 | 73.00 | 16.00 | 55.00 | 129.00 | 0.44 (kg) | 501065 | |
| | 58.00 - 86.00 | 79.00 | 22.00 | 55.00 | 157.00 | 0.60 (kg) | 501066 | |
| | 86.00 - 114.00 | 79.00 | 22.00 | 55.00 | 185.00 | 0.73 (kg) | 501067 | |



Outside Turning Insert Holder

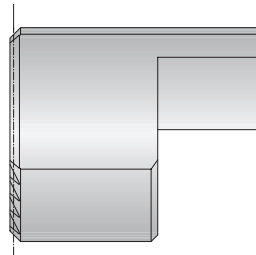
| | Outside Turning Range | | Insert Holder | Weight | Insert Form | Part No. |
|---|-----------------------|----------------|---------------|--------|-------------|----------|
| | A | X ₁ | | | | |
| m | 2.00 - 114.00 | 57.00 | 0.15 (kg) | 20 | 502082 | |

NOTE: Clockwise and neutral execution



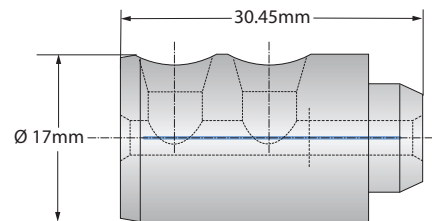
Counterweight

| | Counterweight | | Part No. |
|---|----------------|-----------|----------|
| | X ₁ | Weight | |
| m | 37.75 | 0.16 (kg) | 502183 |



Coolant Delivery System

| | Coolant Delivery System | |
|---|-------------------------|----------|
| | Weight | Part No. |
| m | 0.02 (kg) | 501157 |



Key on B10-A: 1

B10-M: 12-13

B10-A: 71

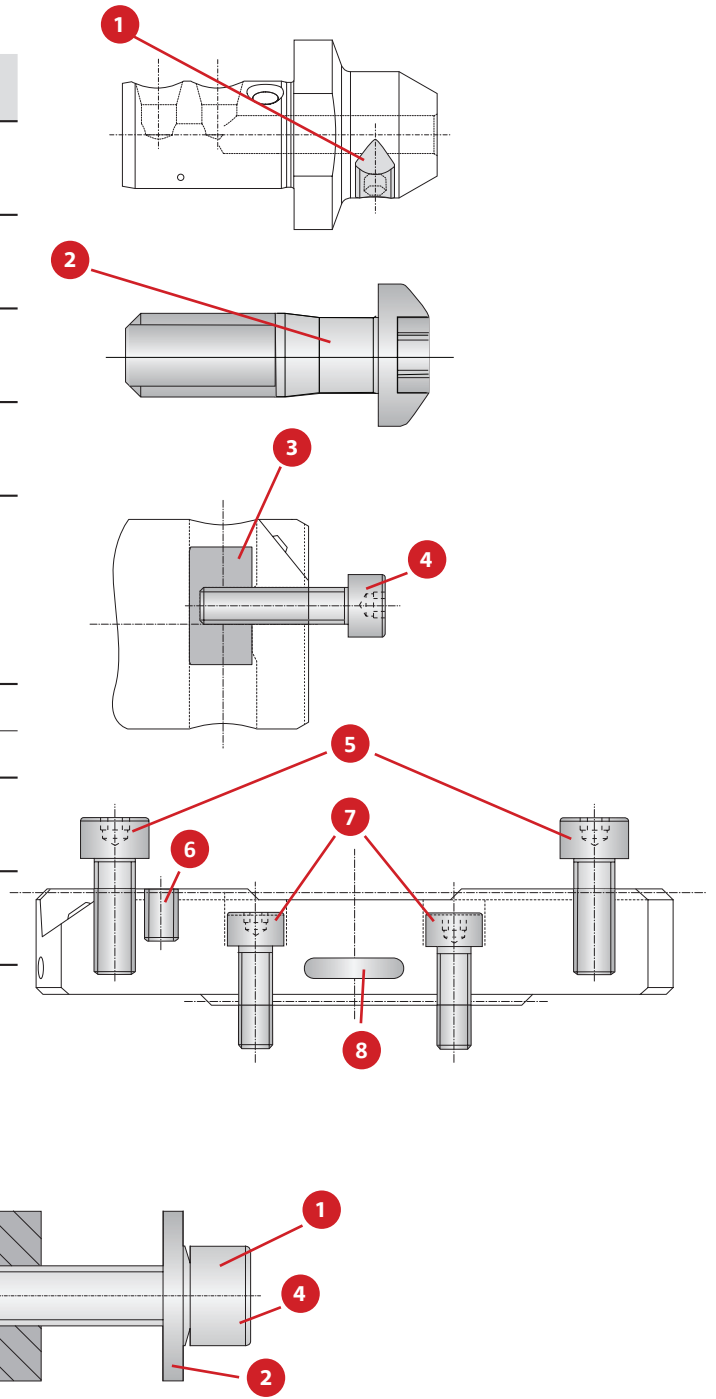
B10-H

B10: VI-VII

m = Metric (mm)
Inserts sold separately

Accessories

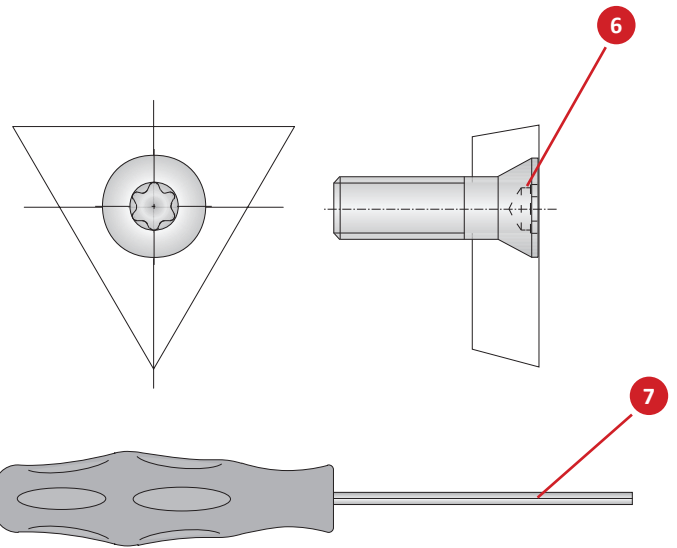
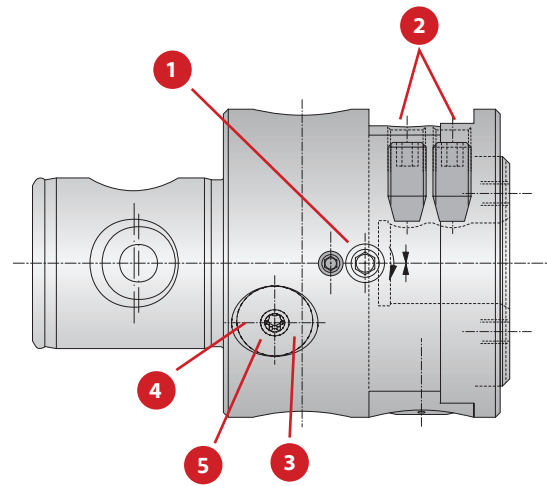
| No. | Part | Size | Part No. |
|-----|--|------------------------|-------------|
| 1 | Set screw | s3 | 415244 |
| 2 | Screw for securing insert holder | T25 | 415112 |
| 3 | Clamping piece | - | 145184 |
| 4 | Cap screw for securing insert holders | s4 | 027154 |
| 5 | Cap screw for securing insert holder/ counterweight | s4 | 315248 |
| 6 | Set screw - coolant | 501054, 501055, 501056 | s1.5 114224 |
| | | 501058, 501059 | s1.5 115303 |
| 7 | Cap screw for securing serrated slide | s4 | 115166 |
| 8 | Sealing ring for coolant delivery | - | 415386 |



| Boring Range | Type | Hex Size | Clamping Screw Parts | | | | Complete Part No. |
|----------------|------|----------|----------------------|----------|------------------|------------------|-------------------|
| | | | 1 Cap Screw | 2 Washer | 3 Clamping Piece | 4 Locking Washer | |
| m 4.00 - 30.00 | A | s5 | 070153 | 315155 | 502180 | 215254 | 502080 |
| | B | s5 | 070153 | 315156 | 502180 | 215254 | 502081 |

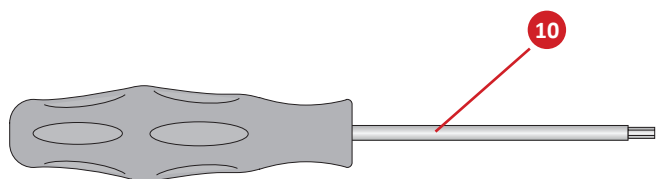
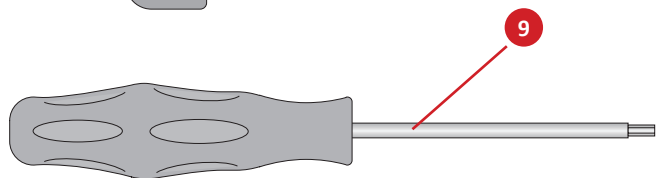
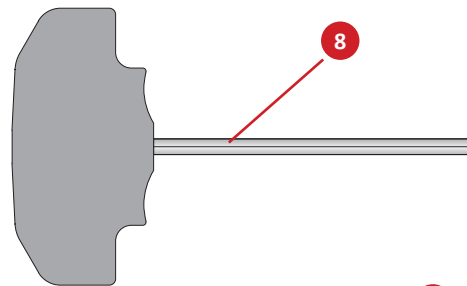
Accessories

| No. | Part | Insert Form | Size | Part No. |
|-----|--|--|-----------------------|--------------------------------------|
| 1 | Clamping screw | - | - | 415353 |
| 2 | Set screw for clamping tool | - | - | 215674 |
| 3 | Battery cover | - | - | 415895 |
| 4 | Battery* | - | - | 415896 |
| 5 | Battery access cover with sealing ring | - | - | 501016 |
| 6 | Insert screws | Form 211 Form 20 Form 101 | T6 T7 T8 | 215377 115535 115676 |
| 7 | Hex driver | - | s1.5 s3 | 215472 115630 |
| 8 | Hex driver | - | s4 | 115576 |
| 9 | Torx® driver | - | T6 T7 T8 T20 | 115537 115591 115590 215150 |
| 10 | Torque screwdriver, Torx | (0.6 Nm) Form 211 (0.9 Nm) Form 20 (1.2 Nm) Form 101 | T6 T7 T8 | 415507 415508 415514 |



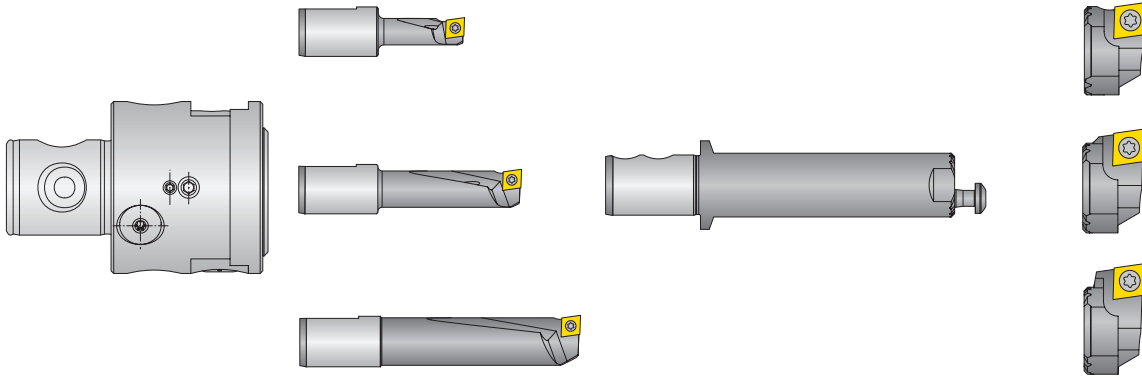
*Always change two batteries

NOTE: Please use VARTA batteries (V392 SR41)




Kit Components

Insert Form 101 | Diameter Range: 10.00 mm - 32.00 mm



Diameter Range: 10.00 mm - 32.00 mm

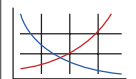
| | Kit Components | | | | | | | Kit No. |
|---|----------------|---|----------------------------|---------------|--------------------|----------------------------|--|---------------|
| | Boring Head | Boring Range | Boring Bars | Boring Range | Serrated Tool Body | Insert Holders | Service Keys | |
|  | 501001 | 10.00 - 11.00 14.00 - 15.00 18.00 - 19.00 | 502012 502014 502016 | 20.00 - 32.00 | 502045 | 502052 502054 502056 | 115576 (s4) 415121 (T25) 115590 (T8) | 103061 |

NOTE: Inserts sold separately

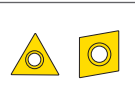


Key on B10-A-1

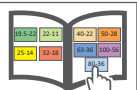
B10-M: 12-13




B10-H



B10: VI-VII

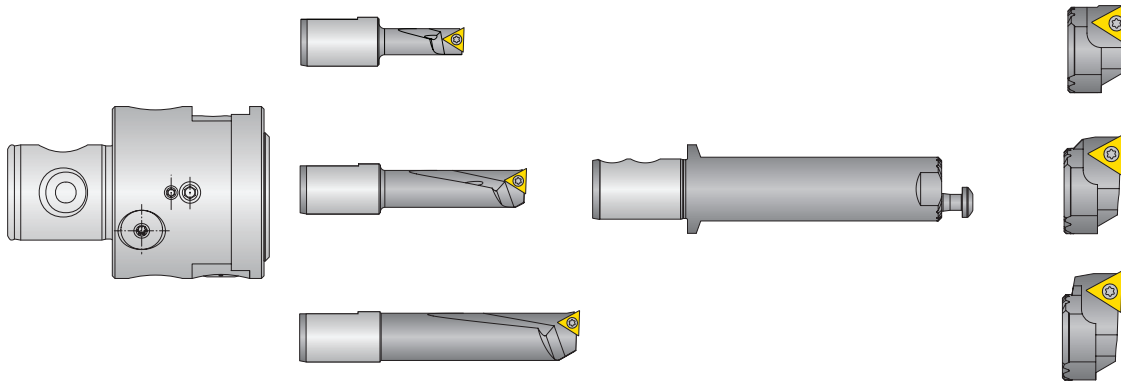


 = Metric (mm)
Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com

Kit Components

Insert Form 20 | Diameter Range: 10.00 mm - 32.00 mm



Diameter Range: 10.00 mm - 32.00 mm

| | | Kit Components | | | | | | |
|---|-------------|----------------|-------------|---------------|--------------------|----------------|--------------|---------|
| | Boring Head | Boring Range | Boring Bars | Boring Range | Serrated Tool Body | Insert Holders | Service Keys | Kit No. |
| m | 501001 | 10.00 - 11.00 | 502001 | 20.00 - 32.00 | 502045 | 502046 | 115576 (s4) | 103062 |
| | | 14.00 - 15.00 | 502003 | | | 502048 | 415121 (T25) | |
| | | 18.00 - 19.00 | 502005 | | | 502050 | 115591 (T7) | |

NOTE: Inserts sold separately



Key on B10-A-1

B10-M: 12-13

B10-H

B10: VI-VII

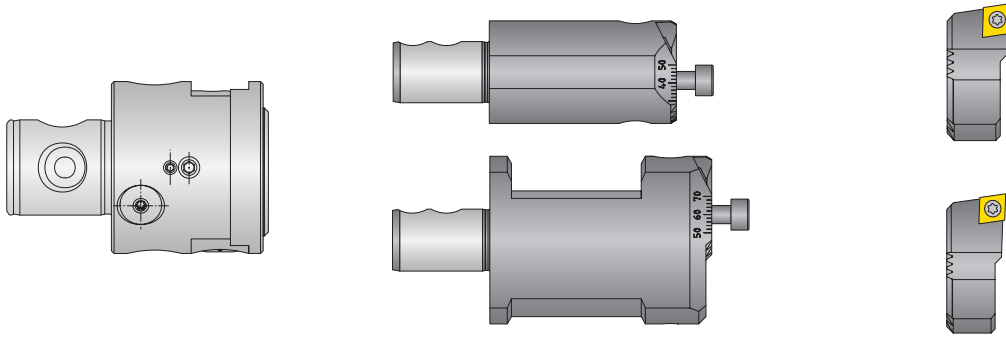
m = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

Kit Components

Insert Form 101 | Diameter Range: 32.00 mm - 68.00 mm



Diameter Range: 32.00 mm - 68.00 mm

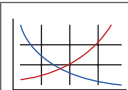
| | Boring Head | Kit Components | | | | Kit No. |
|---|-------------|----------------|--------------------|----------------|--------------|---------|
| | | Boring Range | Serrated Tool Body | Insert Holders | Service Keys | |
| Ⓜ | 501001 | 32.00 - 50.00 | 501052 | 502058 | 115576 (s4) | 103063 |
| | | 50.00 - 68.00 | 501053 | 502059 | 115590 (T8) | |

NOTE: Inserts sold separately

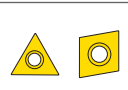


Key on B10-A-1

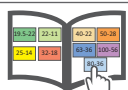
B10-M: 12-13



B10-H



B10: VI-VII

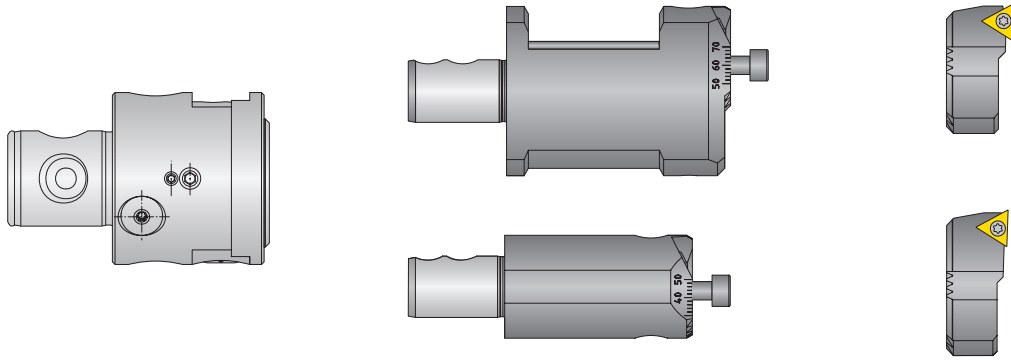


Ⓜ = Metric (mm)
Inserts sold separately

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email: engineering.eu@alliedmachine.com

Kit Components

Insert Form 20 | Diameter Range: 32.00 mm - 68.00 mm



Diameter Range: 32.00 mm - 68.00 mm

| | | Kit Components | | | | |
|---|-------------|----------------|--------------------|----------------|--------------|---------|
| | Boring Head | Boring Range | Serrated Tool Body | Insert Holders | Service Keys | Kit No. |
| m | 501001 | 32.00 - 50.00 | 501052 | 502060 | 115576 (s4) | 103064 |
| | | 50.00 - 68.00 | 501053 | 502061 | 115591 (T7) | |

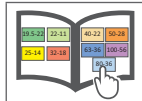
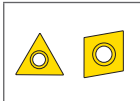
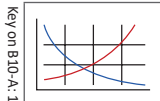
NOTE: Inserts sold separately



B10-M: 12-13

B10-H

B10: VI-VII



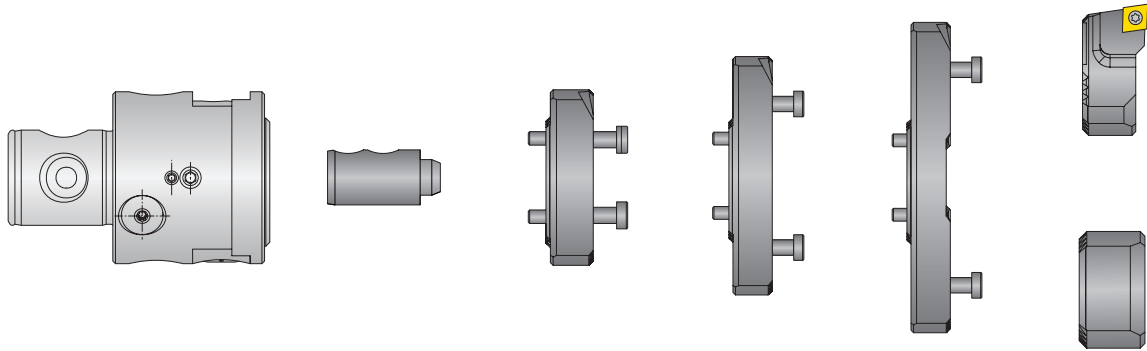
m = Metric (mm)

Inserts sold separately


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 email: engineering.eu@alliedmachine.com

Kit Components

Insert Form 101 | Diameter Range: 68.00 mm - 152.00 mm



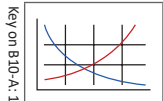
Diameter Range: 68.00 mm - 152.00 mm

| | | Kit Components | | | | | | |
|---|-------------|--|----------------------------|---------------|---------------|------------------|----------------------------|---------------|
| | Boring Head | Boring Range | Serrated Slides | Insert Holder | Counterweight | Coolant Delivery | Service Keys | Kit No. |
|  | 501001 | 68.00 - 96.00 96.00 - 124.00 124.00 - 152.00 | 501054 501055 501056 | 502064 | 502165 | 501157 | 115576 (s4) 115590 (T8) | 103065 |

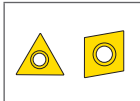
NOTE: Inserts sold separately



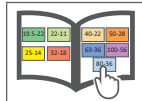
B10-M: 12-13



B10-H



B10: VI-VII



Key on B10-A-1

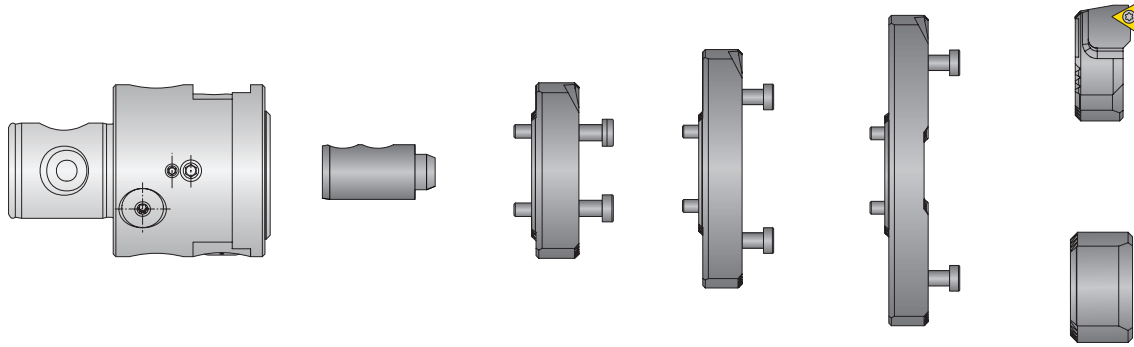
 = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
email: engineering.eu@alliedmachine.com

Kit Components

Insert Form 20 | Diameter Range: 68.00 mm - 152.00 mm



Diameter Range: 68.00 mm - 152.00 mm

| | | Kit Components | | | | | | |
|---|-------------|-----------------|-----------------|---------------|---------------|------------------|--------------|---------|
| | Boring Head | Boring Range | Serrated Slides | Insert Holder | Counterweight | Coolant Delivery | Service Keys | Kit No. |
| m | 501001 | 68.00 - 96.00 | 501054 | 502069 | 502165 | 501157 | 115576 (s4) | 103066 |
| | | 96.00 - 124.00 | 501055 | | | | 115591 (T7) | |
| | | 124.00 - 152.00 | 501056 | | | | | |

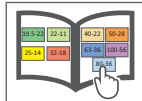
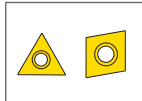
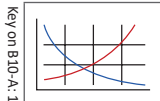
NOTE: Inserts sold separately



B10-M: 12-13

B10-H

B10: VI-VII



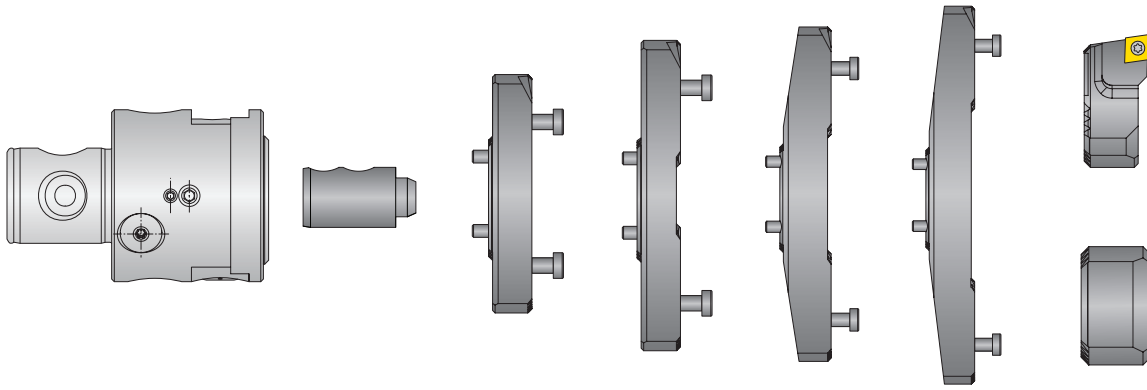
m = Metric (mm)

Inserts sold separately

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 email: engineering.eu@alliedmachine.com

Kit Components

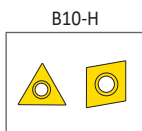
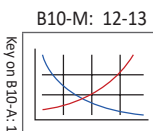
Insert Form 101 | Diameter Range: 96.00 mm - 208.00 mm



Diameter Range: 96.00 mm - 208.00 mm

| | | Kit Components | | | | | | |
|---|-------------|-----------------|-----------------|---------------|---------------|------------------|----------------------------|---------|
| | Boring Head | Boring Range | Serrated Slides | Insert Holder | Counterweight | Coolant Delivery | Service Keys | Kit No. |
| m | 501001 | 96.00 - 124.00 | 501055 | 502064 | 502165 | 501157 | 115576 (s4) 115590 (T8) | 103081 |
| | | 124.00 - 152.00 | 501056 | | | | | |
| | | 152.00 - 180.00 | 501058 | | | | | |
| | | 180.00 - 208.00 | 501059 | | | | | |

NOTE: Inserts sold separately



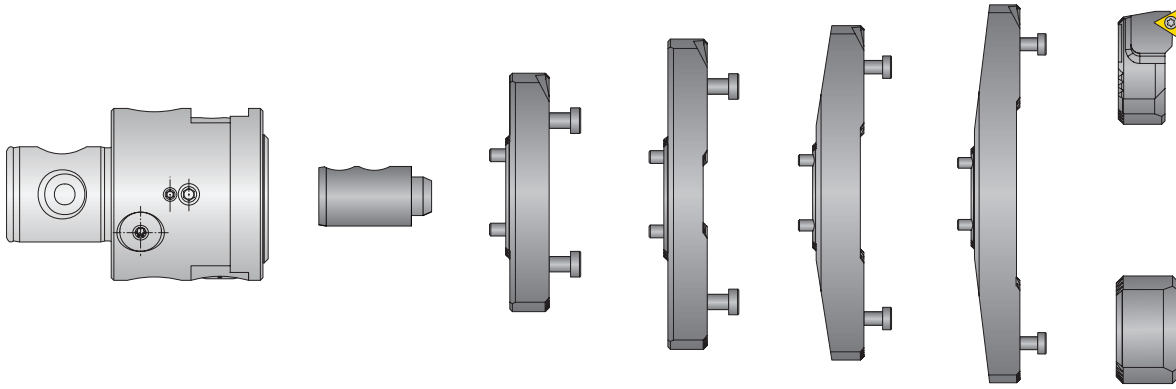
m = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

Kit Components

Insert Form 20 | Diameter Range: 96.00 mm - 208.00 mm



Diameter Range: 96.00 mm - 208.00 mm

| | | Kit Components | | | | | | |
|---|-------------|-----------------|-----------------|---------------|---------------|------------------|--------------|---------|
| | Boring Head | Boring Range | Serrated Slides | Insert Holder | Counterweight | Coolant Delivery | Service Keys | Kit No. |
| m | 501001 | 96.00 - 124.00 | 501055 | 502069 | 502165 | 501157 | 115576 (s4) | 103080 |
| | | 124.00 - 152.00 | 501056 | | | | 115591 (T7) | |
| | | 152.00 - 180.00 | 501058 | | | | | |
| | | 180.00 - 208.00 | 501059 | | | | | |

NOTE: Inserts sold separately

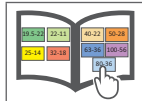
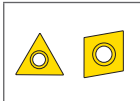
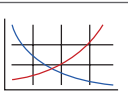


B10-M: 12-13

B10-H

B10: VI-VII

Key on B10-A-1



m = Metric (mm)

Inserts sold separately

IMPORTANT: Max spindle speed refers to maximum possible speed for an individual boring head and is not a recommended parameter. Refer to page B10-M: 12 for recommended application-specific parameters. Factory technical assistance is available for your specific applications through our Application Engineering department.
 email: engineering.eu@alliedmachine.com

Guaranteed Test / Demo Application Form

| | |
|------------------|--|
| Distributor PO # | |
|------------------|--|

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

IMPORTANT: For processing, send Purchase Order to your Allied Field Sales Engineer (FSE). Please clearly mark the paperwork as "Test Order."

Distributor Information

Company Name: _____
 Contact: _____
 Account Number: _____
 Phone: _____
 Email: _____

End User Information

Company Name: _____
 Contact: _____
 Industry: _____
 Phone: _____
 Email: _____

Current Process List all tooling, coatings, substrates, speeds and feeds, tool life, and any problems you are experiencing

Test Objective List what would make this a successful test (i.e. penetration rate, finish, tool life, hole size, etc.)

Application Information

| | | |
|------------------------------------|---------------------------|--|
| Hole Diameter: _____ in/mm | Tolerance: _____ | Material: _____ (4150 / A36 / Cast Iron / etc.) |
| Pre-existing Diameter: _____ in/mm | Depth of Cut: _____ in/mm | Hardness: _____ (BHN / Rc) |
| Required Finish: _____ RMS | | State: _____ (Casting / Hot rolled / Forging) |

Machine Information

| | | |
|--|--|------------------------------|
| Machine Type: _____ (Lathe / Screw machine / Machine center / etc.) | Builder: _____ (Haas, Mori Seiki, etc.) | Model #: _____ |
| Shank Required: _____ (CAT50 / Morse taper, etc.) | | Power: _____ HP/KW |
| Rigidity: _____ | Orientation: _____ | Tool Rotating: _____ |
| <input type="checkbox"/> Excellent | <input type="checkbox"/> Vertical | <input type="checkbox"/> Yes |
| <input type="checkbox"/> Good | <input type="checkbox"/> Horizontal | <input type="checkbox"/> No |
| <input type="checkbox"/> Poor | | Thrust: _____ lbs/N |

Coolant Information

| | |
|--|-----------------------------------|
| Coolant Delivery: _____ (Through tool / Flood) | Coolant Pressure: _____ PSI / bar |
| Coolant Type: _____ (Air mist, oil, synthetic, water soluble, etc.) | Coolant Volume: _____ GPM / LPM |

Requested Tooling

| QTY | Item Number |
|-----|-------------|
| | |
| | |
| | |

| QTY | Item Number |
|-----|-------------|
| | |
| | |
| | |

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ALLIED MACHINE & ENGINEERING



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Allied Machine’s sole and exclusive obligation under this warranty is limited to, at its option, without additional charge, replacing or repairing this product or issuing a credit. For this warranty to be applied, the product must be returned freight prepaid to the plant designated by an Allied Machine representative and which, upon inspection, is determined by Allied Machine to be defective in material and workmanship.

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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