

Fine Boring Head System with Easy-to-Use **Micro Adjustment Mechanism**





1345-01

S W S S
T O O L S

3 Nm

1mm
1mm
1mm
579
854
004

QJAF000

00.000mm

NO

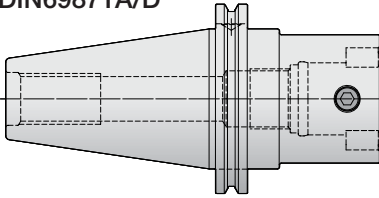
ACCELERATED MACHINING



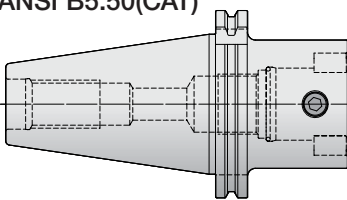
High accuracy diameter adjustment mechanism with no backlash. Easy-to-read digital display window.

Wide range of variation quick change system

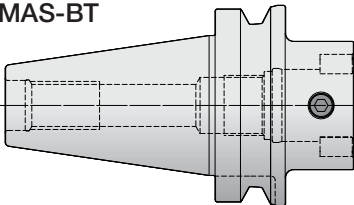
DIN69871A/D



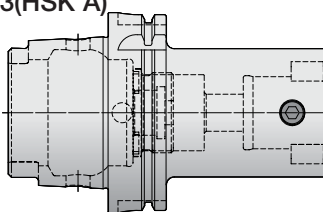
ANSI B5.50(CAT)



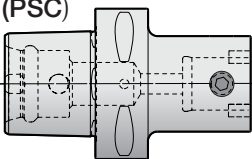
MAS-BT



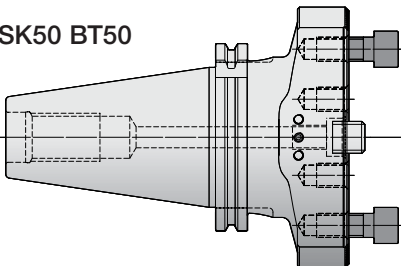
DIN69893(HSK A)



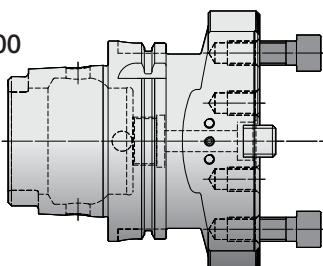
ISO26623-1(PSC)



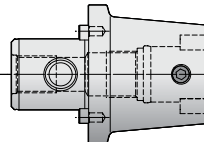
SK50 BT50



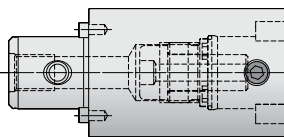
HSK-A100



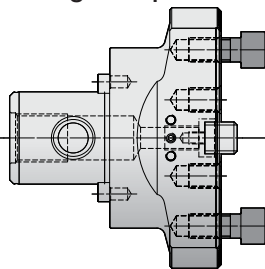
Reduction



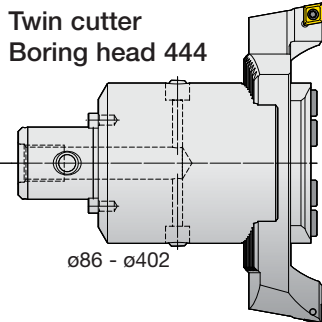
Extension



Bridge adaptor

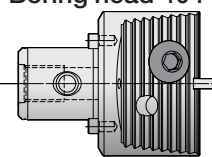


Twin cutter
Boring head 444



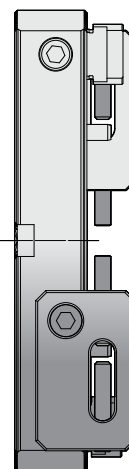
ø86 - ø402

Twin cutter
Boring head 404



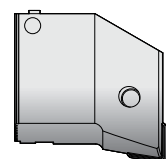
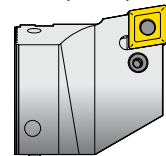
ø23.5 - ø153

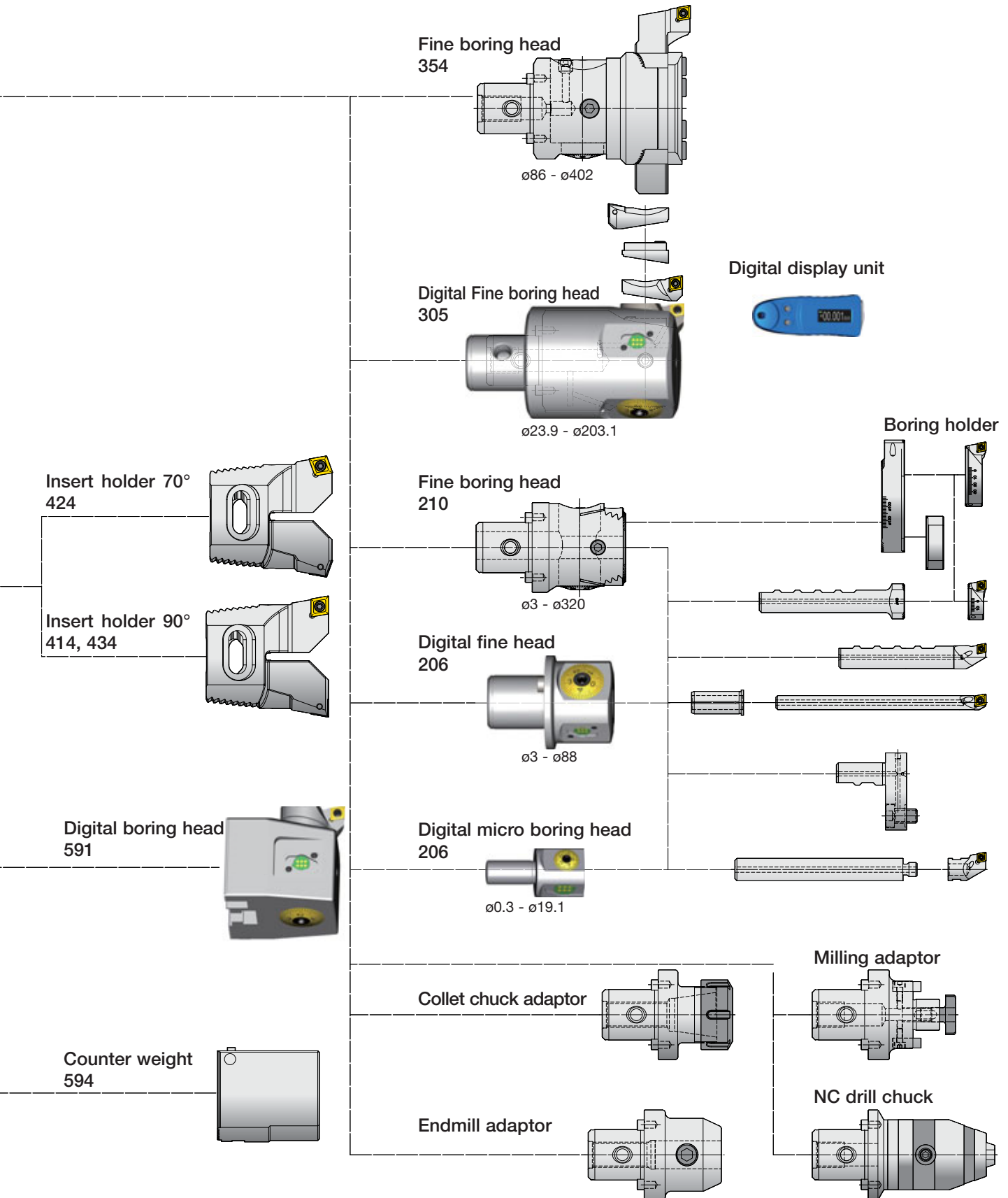
Extension Bridge



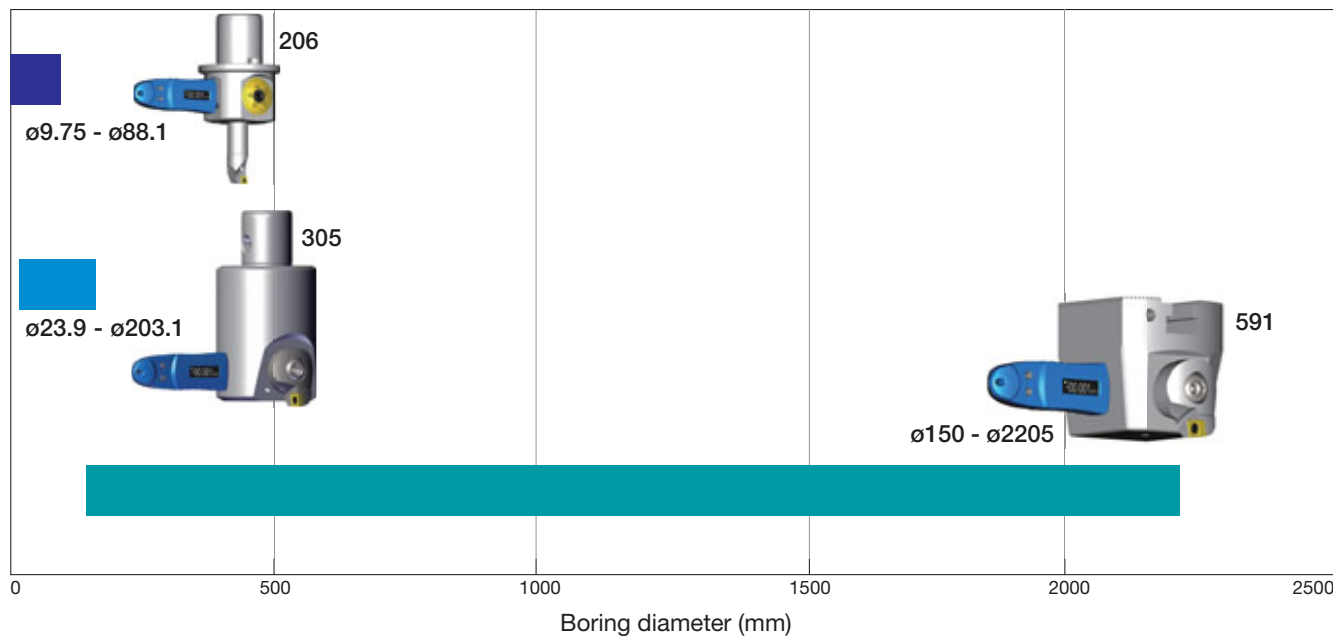
ø150 - ø2205

Boring head
570, 575, 580

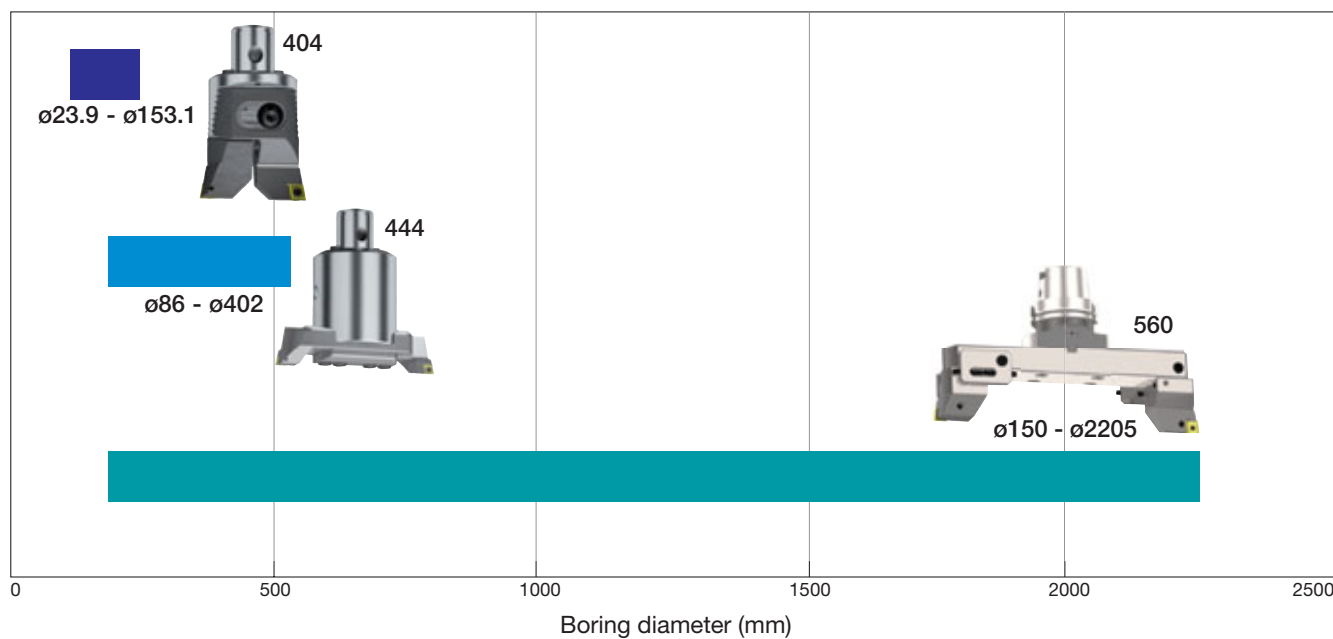




Digital fine boring head

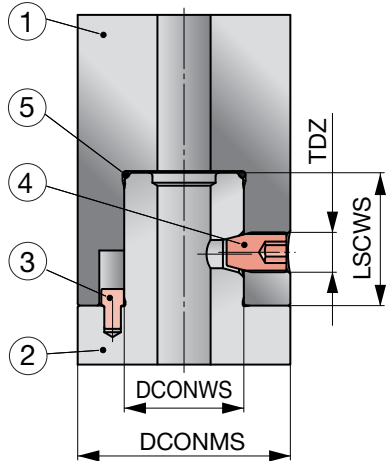


Roughing boring head



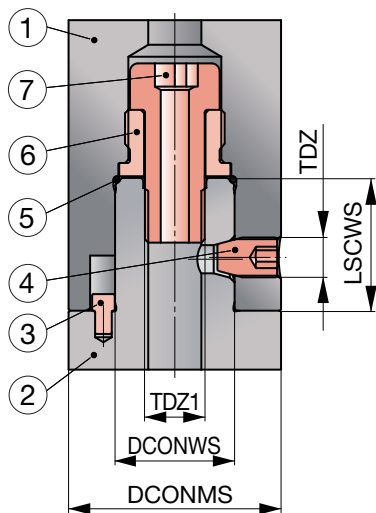
Highly rigid quick change coupling system

ST type



The male pilot ② is placed into the female receptacle ① and clamped with a radial clamping screw ④. Large contact surface and high prestress provide high rigidity. Two drive studs ③ ensure an accurate tip orientation and are used additionally for driving. On the female receptacle's base an O-ring ⑤ is fitted.

ST+ type for heavy cutting



ST+ provides an additional feature for heavy machining applications. By using a tension screw ⑦ a massive increase in prestress is achieved causing maximum in rigidity. The tension screw ⑦ is fitted in female receptacle by a threaded ring ⑥. Clamping of the system elements with the tension screw ⑦ is required only for extreme cutting conditions. Therefore the ST+-components are supplied without a tension screw ⑦ and threaded ring ⑥. These parts must be ordered separately and assembled by the user.

coupling size	Diameter (mm)			TDZ	Torque (N·m)	TDZ1
	DCONMS	DCONWS	LSCWS			
ST1	20	11	13	M4 x 0.5	2.5	-
ST2	25	14	16	M5 x 0.5	3	-
ST3	32	18	20	M6 x 0.75	5	-
ST4	39	22	24	M8 x 0.75	10	-
ST5	50	28	30	M10 x 1	20	-
ST6 / ST6+	64	36	40	M12 x 1	40	M18 x 2
ST7+	90	46	50	M20 x 1.5	60	M24 x 2

Fine boring head system makes **micron adjustment easy and simple in the machine**

Fine boring heads with digital display



206



ø9.75 - ø88.1

305



ø23.9 - ø203.1

591



ø150 - ø2205

- High setting accuracy adjustable in 0.001 mm in diameter.
- Easy-to-use digital display unit. Simply dock on the tool body to display an accurate tool diameter while mounted in the machine.
- Direct measurement system with no backlash.
- Economy-one digital unit can be used with all digital fine boring head.
- Internal coolant supply system for improved chip control.

GH1-DA

Digital display unit



Designation

GH1-DA2.BG0.077

High precision display unit with accuracy of 0.001 mm in diameter. Display unit features direct measurement system with no backlash. The illuminated display can be rotated 180 degrees to apply any measuring situation.

mm/inch switchable

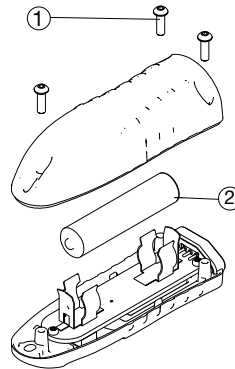
Standard AAA battery installed.

Magnet attachment

SPARE PARTS

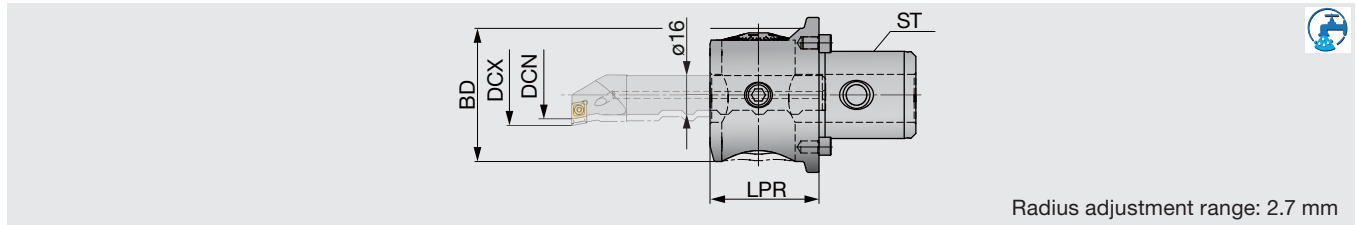


Designation	Clamping screw ①	Screw wrench	Battery ②
GH1-DA2.BG0.077	900.309.022.008	900.308.011.045	AAA



SwissBore206

Digital Fine boring heads $\varnothing 9.75 - \varnothing 88.1$

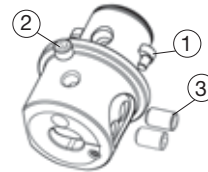


Radius adjustment range: 2.7 mm

Designation	ST	BD	DCN	DCX	LPR
206.064.025.045	ST6	55	9.75	88.1	45

SPARE PARTS

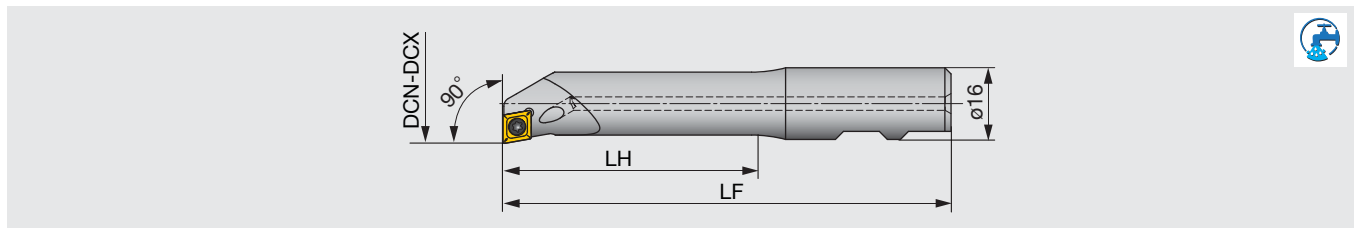
Designation	Drive pin ①	Clamping screw ②	Fastening screw ③
206.***.025.***	900.102.064.000	900.204.010.008	900.204.010.008



Boring bars 254,256
Option : Display unit GH1-DA2.BG0.077

SwissBore254

Boring bars $\varnothing 9.75 - \varnothing 30.1$



Designation	DCN	DCX	LH	LF	Insert
254.010.006.075	9.75	15.1	30	75	CC**0602...
254.015.006.090	14.75	20.1	51	90	CC**0602...
254.020.006.105	19.75	25.1	72	105	CC**0602...
254.025.006.115	24.75	30.1	82	115	CC**0602...

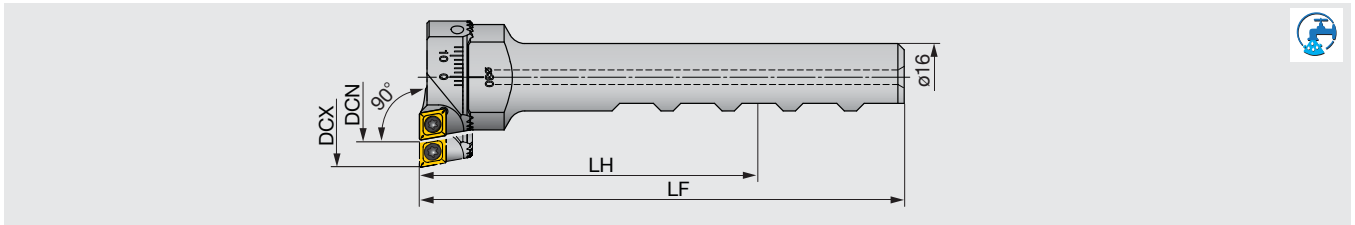
Applicable for 7 MPa pressure coolant

SPARE PARTS

Designation	Clamping screw	Wrench
254.0**006.**	CSTB-2.5S	T-8F

SwissBore256

Boring Bars $\varnothing 29.75 - \varnothing 88.1$

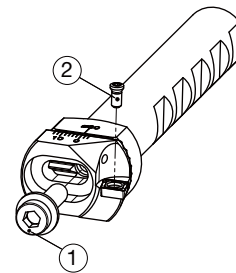


Designation (Shank)	Designation (Insert holder)	DCN	DCX	LH	LF	Insert
256.030.048.115	256.030.006.012	29.75	48.1	85	115	CC**0602...
256.048.088.115	256.048.006.014	47.75	88.1	85	115	CC**0602...

Applicable for 7 MPa pressure coolant

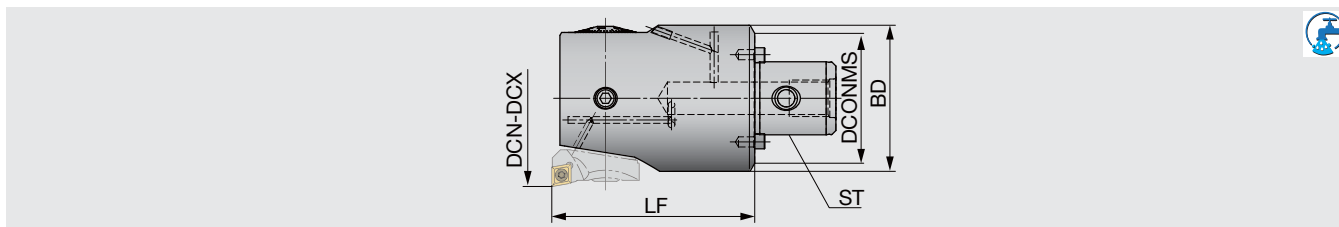
SPARE PARTS

Designation	Fastening screw ①	Clamping screw ②	Wrench ③
256.0**.006.0**	900.256, 005.016	CSTB-2.5S	T-8F



SwissBore305

Digital Fine boring heads $\varnothing 23.9 - \varnothing 203.1$

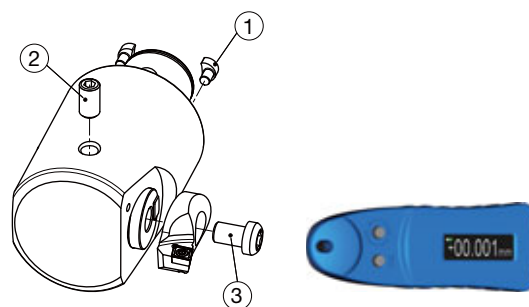


Designation	ST	DCN	DCX	DCNMS	BD	LF	Insert holder
305.020.024.035	ST1	23.9	31.1	20	20	35.5	314.011.024.006/007
305.020.024.035	ST1	29.9	37.1	20	20	35.5	314.011.030.006/007
305.025.031.040	ST2	30.9	40.1	25	25	40	314.013.031.006/007
305.025.031.040	ST2	30.9	47.1	25	25	40	314.013.038.006/007
305.032.040.047	ST3	39.9	51.1	32	32	47	314.017.040.006/007
305.032.040.047	ST3	47.9	59.1	32	32	47	314.017.048.006/007
305.039.051.057	ST4	50.9	67.1	39	42	57	314.022.051.006/007
305.039.051.057	ST4	64.9	81.1	39	42	57	314.022.065.006/007
305.050.067.080	ST5	66.9	87.1	50	55	80	314.030.067.009/011
305.050.067.080	ST5	84.9	105.1	50	55	80	314.030.085.009/011
305.064.087.100	ST6+	86.9	116.1	64	72	100	314.030.067.009/011
305.064.087.100	ST6+	104.9	134.1	64	72	100	314.030.085.009/011
305.090.116.130	ST7+	115.9	153.1	90	94	130	314.030.067.009/011
305.090.116.130	ST7+	133.9	171.1	90	94	130	314.030.085.009/011
305.090.116.130	ST7+	153.9	191.1	90	94	130	314.726.003.009/011
305.090.116.130	ST7+	165.9*	203.1*	90	94	130	-

*Option : insert holder (314.726.003.009 or 314.726.003.011) & adapter (900.803.001.006)
Applicable for 7 MPa pressure coolant

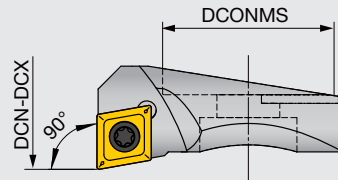
SPARE PARTS

Designation	Drive pin ①	Clamp screw ②	Clamp screw for tool ③
305.020.024.035	900.102.020.000	900.304.004.003	900.314.004.006
305.025.031.040	900.102.025.000	900.304.005.004	900.314.005.008
305.032.040.047	900.102.032.000	900.304.006.005	900.314.006.010
305.039.051.057	900.102.039.000	900.304.008.006	900.314.008.012
305.050.067.080	900.102.050.000	900.304.010.010	900.314.010.016
305.064.087.100	900.102.064.000	900.304.010.018	900.314.010.016
305.090.116.130	900.102.090.000	900.304.010.030	900.314.010.016



SwissBore314

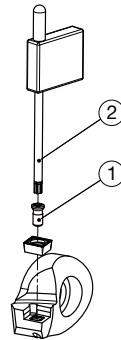
Insert holders 90° corner for CC**insert



Designation	DCN	DCX	DCONMS	Insert	Boring Head
314.011.024.006	23.9	31.1	11	CC**0602**	305.020.024.035
314.011.030.006	29.9	37.1	11	CC**0602**	305.020.024.035
314.013.031.006	30.9	40.1	13	CC**0602**	305.025.031.040
314.013.038.006	37.9	47.1	13	CC**0602**	305.025.031.040
314.017.040.006	39.9	51.1	17	CC**0602**	305.032.040.047
314.017.048.006	47.9	59.1	17	CC**0602**	305.032.040.047
314.022.051.006	50.9	67.1	22	CC**0602**	305.039.051.057
314.022.065.006	64.9	81.1	22	CC**0602**	305.039.051.057
314.030.067.009	66.9	87.1	30	CC**09T3**	305.050.067.080
314.030.085.009	84.9	105.1	30	CC**09T3**	305.050.067.080
314.030.067.009	86.9	116.1	30	CC**09T3**	305.064.087.100
314.030.085.009	104.9	134.1	30	CC**09T3**	305.064.087.100
314.030.067.009	115.9	153.1	30	CC**09T3**	305.090.116.130
314.030.085.009	133.9	171.1	30	CC**09T3**	305.090.116.130
314.726.003.009	153.9	191.1	30	CC**09T3**	305.090.116.130

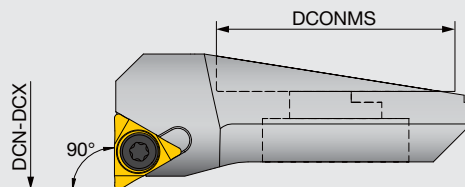
SPARE PARTS

Designation	Clamping screw ①	Wrench ②
314.***.***006	CSTB-2.5S	T-8F
314.***.***009	CSTB-4S	T-15F



SwissBore314

Insert holders 90° corner for TP**insert

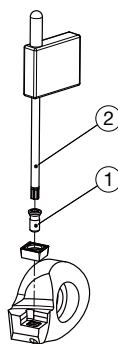


Designation	DCN	DCX	DCONMS	Insert	Boring Head
314.011.024.007	23.9	31.1	11	TP**0701**	305.020.024.035
314.011.030.007	29.9	37.1	11	TP**0701**	305.020.024.035
314.013.031.007	30.9	40.1	13	TP**0701**	305.025.031.040
314.013.038.007	37.9	47.1	13	TP**0701**	305.025.031.040
314.017.040.007	39.9	51.1	17	TP**0701**	305.032.040.047
314.017.048.007	47.9	59.1	17	TP**0701**	305.032.040.047
314.022.051.007	50.9	67.1	22	TP**0701**	305.039.051.057
314.022.065.007	64.9	81.1	22	TP**0701**	305.039.051.057
314.030.067.011	66.9	87.1	30	TP**1102**	305.050.067.080
314.030.085.011	84.9	105.1	30	TP**1102**	305.050.067.080
314.030.067.011	86.9	116.1	30	TP**1102**	305.064.087.100
314.030.085.011	104.9	134.1	30	TP**1102**	305.064.087.100
314.030.067.011	115.9	153.1	30	TP**1102**	305.090.116.130
314.030.085.011	133.9	171.1	30	TP**1102**	305.090.116.130
314.726.003.011	153.9	191.1	30	TP**1102**	305.090.116.130

SPARE PARTS

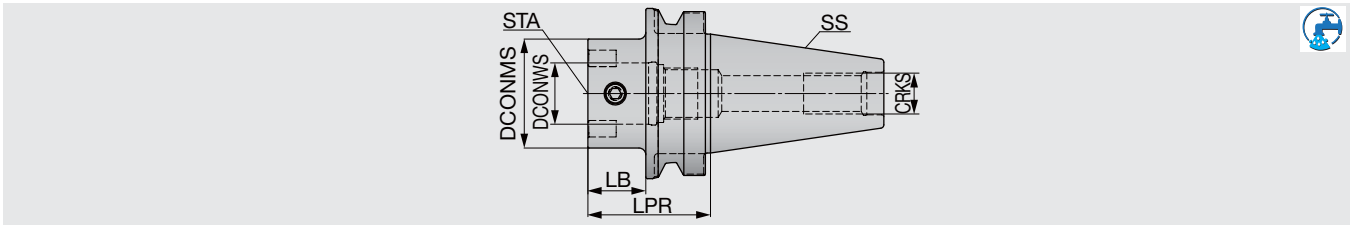


Designation	Clamping screw ①	Wrench ②
314.***.***007	CSTB-2.2L038	T-7F
314.***.***011	CSTB-2.5S	T-8F



SwissBore134

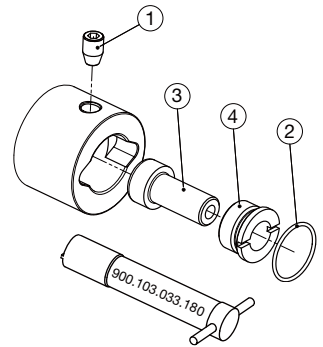
Master shank holders MAS-BT



Designation	SS	STA	DCONMS	DCONWS	LPR	LB	CRKS
134.530.050.038	BT30	ST5	50	28	38	16	M12
134.540.020.042	BT40	ST1	20	11	42	15	M16
134.540.025.042	BT40	ST2	25	14	42	15	M16
134.540.032.044	BT40	ST3	32	18	44	17	M16
134.540.039.048	BT40	ST4	39	22	48	21	M16
134.540.050.055	BT40	ST5	50	28	55	28	M16
134.540.064.046	BT40	ST6+	64	36	46	19	M16
134.550.020.063	BT50	ST1	20	11	63	25	M24
134.550.025.063	BT50	ST2	25	14	63	25	M24
134.550.032.065	BT50	ST3	32	18	65	27	M24
134.550.039.069	BT50	ST4	39	22	69	31	M24
134.550.050.072	BT50	ST5	50	28	72	34	M24
134.550.064.072	BT50	ST6+	64	36	72	34	M24
134.550.090.086	BT50	ST7+	90	46	86	48	M24

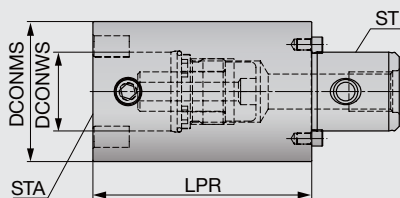
SPARE PARTS

Clamping size	Clamping screw ①	O-ring ②	Tension screw ③	Threaded ring ④
ST1	900.100.004.005	900.101.008.002	-	-
ST2	900.100.005.006	900.101.011.002	-	-
ST3	900.100.006.008	900.101.015.002	-	-
ST4	900.100.008.011	900.101.019.002	-	-
ST5	900.100.010.012	900.101.025.002	-	-
ST6	900.100.012.018	900.101.032.002	-	-
ST6+	900.100.012.018	900.101.032.002	900.102.018.040	900.103.030.020
ST7+	900.100.020.029	900.101.043.002	900.102.024.045	900.103.040.020



SwissBore164

Extension adapters



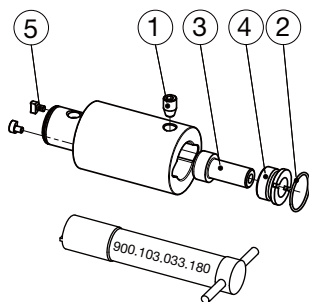
Designation	ST	STA	DCONMS	DCONWS	LPR
164.020.020.020	ST1	ST1	20	11	20
164.020.020.030	ST1	ST1	20	11	30
164.025.025.030	ST2	ST2	25	14	30
164.025.025.045	ST2	ST2	25	14	45
164.032.032.030	ST3	ST3	32	18	30
164.032.032.045	ST3	ST3	32	18	45
164.039.039.040	ST4	ST4	39	22	40
164.039.039.060	ST4	ST4	39	22	60
164.050.050.060	ST5	ST5	50	28	60
164.050.050.090	ST5	ST5	50	28	90
164.064.064.060	ST6+	ST6+	64	36	60
164.064.064.100	ST6+	ST6+	64	36	100
164.090.090.100	ST7+	ST7+	90	46	100
164.090.090.160	ST7+	ST7+	90	46	160

Option : Tension screw & Threading ring of ST+ type

SPARE PARTS

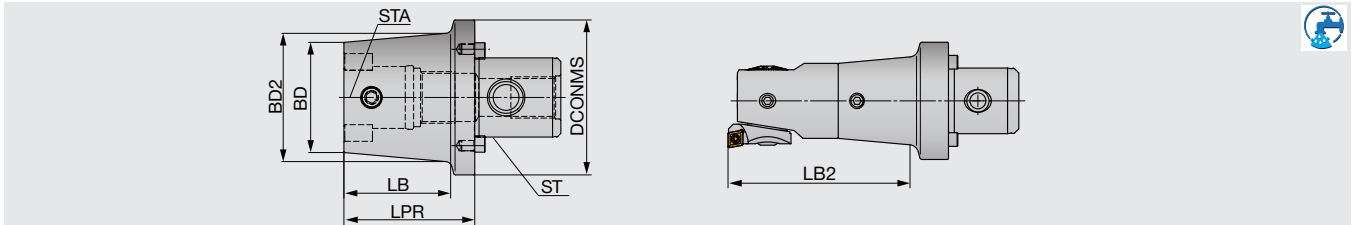


Clamping size	Clamping screw ①	O-ring ②	Tension screw ③	Threaded ring ④	Drive pin ⑤
ST1	900.100.004.005	900.101.008.002	-	-	900.102.020.000
ST2	900.100.005.006	900.101.011.002	-	-	900.102.025.000
ST3	900.100.006.008	900.101.015.002	-	-	900.102.032.000
ST4	900.100.008.011	900.101.019.002	-	-	900.102.039.000
ST5	900.100.010.012	900.101.025.002	-	-	900.102.050.000
ST6	900.100.012.018	900.101.032.002	-	-	900.102.064.000
ST6+	900.100.012.018	900.101.032.002	900.102.018.040	900.103.030.020	900.102.064.000
ST7+	900.100.020.029	900.101.043.002	900.102.024.045	900.103.040.020	900.102.090.000



SwissBore184

Reduction adapters

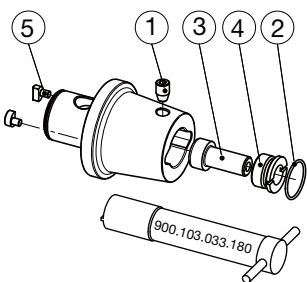


Designation	ST	STA	DCONMS	BD	BD2	LPR	LB	LB2
184.025.020.036	ST2	ST1	25	20	23	36	25	60.5
184.032.025.034	ST3	ST2	32	25	29	34.5	20	60
184.039.032.047	ST4	ST3	39	32	38	47	35	82
184.050.039.040	ST5	ST4	50	39	48	40	25.5	82.5
184.064.050.039	ST6+	ST5	64	50	60	39	24	104

LB2 : Max boring depth with twin cutter or fine boring head
 Option : Tension screw & Threading ring of ST+ type

SPARE PARTS

Clamping size	Clamping screw ①	O-ring ②	Tension screw ③	Threaded ring ④	Drive pin ⑤
ST1	900.100.004.005	900.101.008.002	-	-	900.102.020.000
ST2	900.100.005.006	900.101.011.002	-	-	900.102.025.000
ST3	900.100.006.008	900.101.015.002	-	-	900.102.032.000
ST4	900.100.008.011	900.101.019.002	-	-	900.102.039.000
ST5	900.100.010.012	900.101.025.002	-	-	900.102.050.000
ST6	900.100.012.018	900.101.032.002	-	-	900.102.064.000
ST6+	900.100.012.018	900.101.032.002	900.102.018.040	900.103.030.020	900.102.090.000

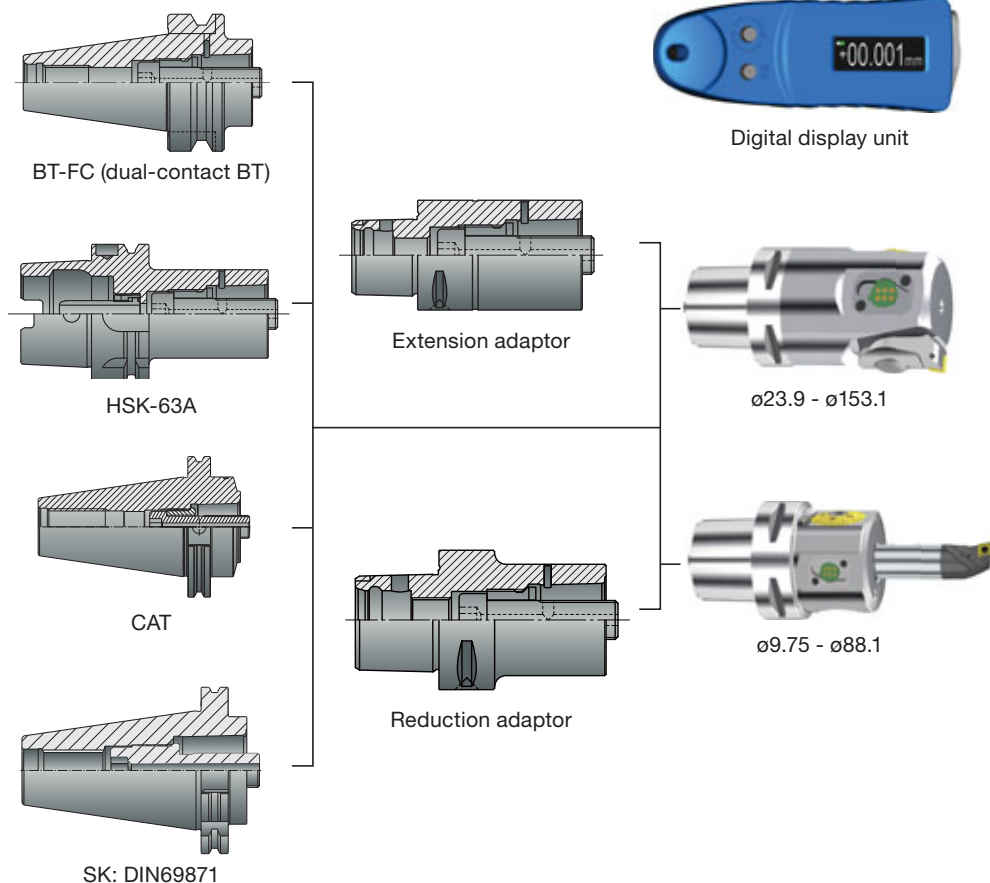


Fine boring heads with digital display



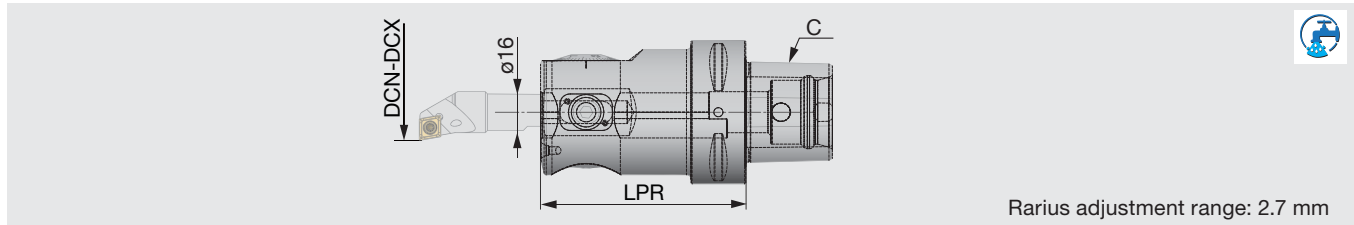
Fine boring head system with high precision adjustment mechanism

- Easy and accurate adjustment of 1 μ m in diameter is possible on the machine
- Digital display unit is docked on the boring head for micron adjustment
- Economy - one digital unit can be used with all fine boring heads
- Internal coolant for smooth chip control
- Also available with TungCap connection, allowing it for use in multi-tasking machines



TungCap FBHO-DE

Fine boring head with digital display $\varnothing 9.75 - \varnothing 88.1$



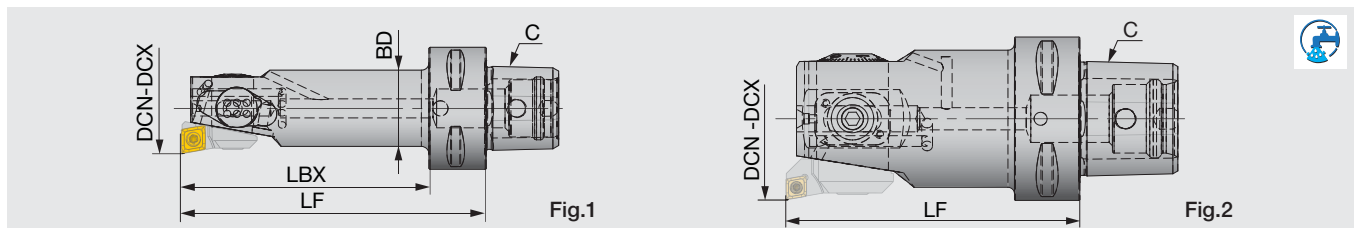
Radius adjustment range: 2.7 mm

Designation	C	DCN	DCX	LPR	Boring bar
BT4-FBHO-DE-1690	BT40	9.75	88.1	90	254.0**006... / 256...
HA6-FBHO-DE-1695	HSK-A63	9.75	88.1	95	254.0**006... / 256...
PSC63-FBHO-DE-1690	C6	9.75	88.1	90	254.0**006... / 256...
PSC50-FBHO-DE-1670	C5	9.75	88.1	70	254.0**006... / 256...
PSC40-FBHO-DE-1665	C4	9.75	88.1	65	254.0**006... / 256...

Applicable for 7 MPa pressure coolant

TungCap FBHS-DE

Fine boring head with digital display $\varnothing 23.9 - \varnothing 153.1$



Designation	C	DCN	DCX	LF	LBX	BD	Fig.	Insert holder
PSC32-FBHS-DE-24	C3	23.9	31.1	80	65	20	1	314.011.024.006/007
PSC32-FBHS-DE-24	C3	29.9	37.1	80	65	20	1	314.011.030.006/007
PSC32-FBHS-DE-31	C3	30.9	40.1	90	75	25	1	314.013.031.006/007
PSC32-FBHS-DE-31	C3	37.5	47.1	90	75	25	1	314.013.038.006/007
PSC40-FBHS-DE-40	C4	39.9	51.1	90	70	32	1	314.017.040.006/007
PSC40-FBHS-DE-40	C4	47.5	59.1	90	70	32	1	314.017.048.006/007
PSC50-FBHS-DE-51	C5	50.9	67.1	90	-	-	2	314.022.051.006/007
PSC50-FBHS-DE-51	C5	64.9	81.1	90	-	-	2	314.022.065.006/007
PSC50-FBHS-DE-67	C5	66.9	87.1	100	-	-	2	314.030.067.009/011
PSC50-FBHS-DE-67	C5	84.9	105.1	100	-	-	2	314.030.085.009/011
PSC63-FBHS-DE-87	C6	86.9	116.1	120	-	-	2	314.030.067.009/011
PSC63-FBHS-DE-87	C6	104.9	134.1	120	-	-	2	314.030.085.009/011
PSC63-FBHS-DE-116	C6	115.9	153.1	150	-	-	2	314.030.067.009/011
PSC63-FBHS-DE-116	C6	133.9	171.1	150	-	-	2	314.030.085.009/011

Insert holder is not included
Applicable for 7 MPa pressure coolant

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