

DBP Finsih Boring



- Single bit finsih boring head.
- Easy to adjust boring diameter.
- Boring Range 20 ~ 202mm.
- 單刃精搪頭使用 1 片刀片
- 易於調整加工孔徑
- 精搪孔範圍 20~202mm

→ Page C083

DBR Rough Boring

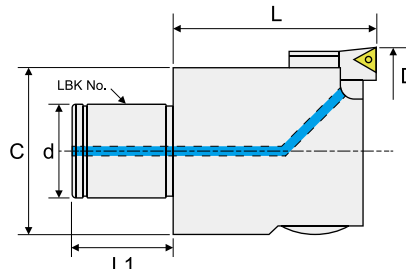


- Twin bit rough boring head.
- Easy to adjust boring diameter.
- Boring Range 25 ~ 204mm.
- 雙刃粗搪頭使用 2 片刀片
- 易於調整加工孔徑
- 粗搪孔範圍 25~204mm

→ Page C084

DBP Finsih Boring Head · Internal Coolant 捨棄式單刃精搪刀

- Finish boring head is suitable for finish boring
- Coolant nozzle easily cools the insert, elongating its working life.
- Boring diameter from 20mm to 202mm.

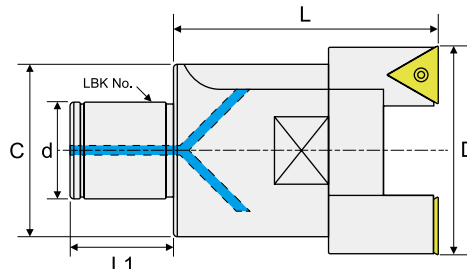


Order No.	LBK No.	D (Boring Range)	C	d	L1	L	Insert
IDBCBH20TC09	LBK1	20~26	19	11	13	35	TC..0902
IDBCBH25TC09	LBK2	25~33	24	14	16	40	
IDBCBH32TC09	LBK3	32~42	31	18	20	40	
IDBCBH40TC09	LBK4	40~55	39	22	24	50	
IDBCBH52TC11	LBK5	52~75	50	28	30	60	TC..1102
IDBCBH68TC11	LBK6	68~102	64	36	40	70	
IDBCBH100TC11	LBK6	100~152	90	36	40	70	
IDBCBH150TC11	LBK6	150~202	140	36	40	70	
IDBCBH100ATC11	LBK7	100~152	90	58	50	70	
IDBCBH150ATC11	LBK7	150~202	140	58	50	70	

※ For inserts, please refer to turning inserts 搭配刀片，請參考車刀片

DBR Rough Boring Head · Internal Coolant 捨棄式雙刀粗搪刀

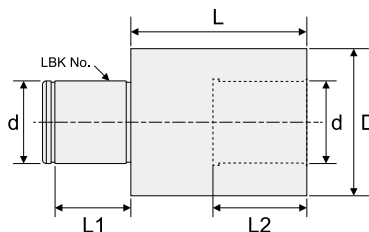
- Thickened cartridge with higher rigidity.
- Coolant nozzle easily cools the insert, elongating its working life.
- The design of chip pocket, improving chip flow of deep boring.
- Clamp plate solidifies cartridges and head, upgrading cutting rigidity.
- Patented step boring design; suitable for both level boring and step boring.



	Order No.	LBK No.	D (Boring Range)	C	d	L1	L	Insert
	IDBRBH25LACC06	LBK2	25~35	24	14	16	50	CC..06
	IDBRBH32LACC06	LBK3	32~45	31	18	20	60	CC..06
	IDBRBH32LATC11	LBK3	32~45	31	18	20	60	TC..11
	IDBRBH40LACC09	LBK4	40~55	39	22	24	74	CC..09
	IDBRBH40LATC16	LBK4	40~55	39	22	24	74	TC..16
	IDBRBH40LASC09	LBK4	40~55	39	22	24	74	SC..09
	IDBRBH52LACC09	LBK5	52~75	50	28	30	80	CC..09
	IDBRBH52LATC16	LBK5	52~75	50	28	30	80	TC..16
	IDBRBH52LASC09	LBK5	52~75	50	28	30	80	SC..09
	IDBRBH68LACC12	LBK6	68~100	66	36	40	90	CC..12
	IDBRBH68LATC16	LBK6	68~100	66	36	40	90	TC..16
	IDBRBH90LACC12	LBK6	90~130	88	36	40	100	CC..12
IDBRBH90LATC16	LBK6	90~130	88	36	40	100	TC..16	
	IDBRBH90ALACC12	LBK7	90~130	88	58	50	100	CC..12
	IDBRBH90ALATC16	LBK7	90~130	88	58	50	100	TC..16
	IDBRBH120ALACC12	LBK7	120~164	100	58	50	95	CC..12
	IDBRBH160ALACC12	LBK7	160~204	130	58	50	95	CC..12

※ For inserts, please refer to turning inserts 搭配刀片，請參考車刀片

DBE Constant Diameter Extension 等徑搪刀延長桿



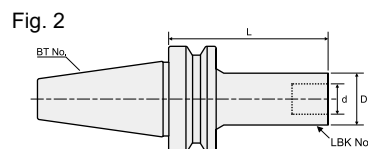
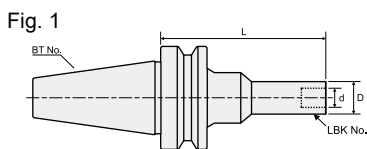
Order No.	LBK No.	d	D	L	L1	L2	Applicable Boring Heads
IDBELBK1130L	LBK1	11	19	30	13	15	IDBCBH20
IDBELBK2230L	LBK2	18	24	30	16	18	IDBCBH25; IDBRBH25
IDBELBK3330L	LBK3	22	31	30	20	22	IDBCBH32; IDBRBH32
IDBELBK4445L	LBK4	28	39	45	24	32	IDBCBH40; IDBRBH40
IDBELBK5560L	LBK5	36	50	60	30	42	IDBCBH52; IDBRBH52
IDBELBK6660L	LBK6	58	64	60	40	52	IDBCBH68; IDBCBH100; IDBCBH150; IDBRBH68; IDBRBH90
IDBELBK77105L	LBK7	14	88	105	50	26	IDBCBH100; IDBCBH150; IDBRBH90; IDBRBH120; IDBRBH160

Recommended Cutting Conditions 建議切削數據

Work Material		Hardness	Vc (m/min)	fr (mm/rev)
P	Mild Steel	(<180HB)	90~200	0.04~0.14
	Carbon Steel	(180~280HB)	60~180	0.04~0.15
	Alloy Steel	(280~350HB)	50~150	0.04~0.15
M	Stainless Steel	(<200HB)	60~230	0.07~0.12
K	Cast Iron	(<350Mpa)	120~230	0.04~0.13
	Ductile Cast Iron	(<450Mpa)	120~230	0.04~0.13
N	Aluminum <12% Si	-	120~700	0.04~0.25
	Aluminum >12% Si	-	120~700	0.04~0.25
S	Heat Resistant Alloy	-	20~80	0.04~0.05
H	Hardened Material	-	20~70	0.04~0.05

Holemaking

DBBT Boring Taper Shank for DBP, DB Heads 捨棄式搪刀刀柄



Order No.	Fig	LBK No.	L	D	d	Applicable Boring Heads
IDBBT30LBK1070L	2	LBK1	70	19	11	IDBCBH20
IDBBT30LBK2080L		LBK2	80	24	14	IDBCBH25; IDBRBH25
IDBBT30LBK3080L		LBK3	80	31	18	IDBCBH32; IDBRBH32
IDBBT30LBK4070L		LBK4	70	39	22	IDBCBH40; IDBRBH40
IDBBT30LBK5060L		LBK5	60	50	28	IDBCBH52; IDBRBH52
IDBBT30LBK6060L		LBK6	60	64	36	IDBCBH68; IDBRBH68; IDBRBH90
IDBBT40LBK1075L		LBK1	75	19	11	IDBCHB20
IDBBT40LBK1090L		LBK1	90			
IDBBT40LBK1105L		LBK1	105			
IDBBT40LBK2085L		LBK2	85	24	14	IDBCBH25; IDBRBH25
IDBBT40LBK2100L		LBK2	100			
IDBBT40LBK2115L		LBK2	115			
IDBBT40LBK3095L		LBK3	95	31	18	IDBCBH32; IDBRBH32
IDBBT40LBK3125L		LBK3	125			
IDBBT40LBK3155L		LBK3	155			
IDBBT40LBK4085L		LBK4	85	39	22	IDBCBH40; IDBRBH40
IDBBT40LBK4130L		LBK4	130			
IDBBT40LBK4175L		LBK4	175			
IDBBT40LBK5075L		LBK5	75	50	28	IDBCBH52; IDBRBH52
IDBBT40LBK5125L		LBK5	125			
IDBBT40LBK5175L	LBK5	175				
IDBBT40LBK6065L	LBK6	65	64	36	IDBCBH68; IDBCBH100; IDBCBH150; IDBRBH68; IDBRBH90	
IDBBT40LBK6115L	LBK6	115				
IDBBT40LBK6165L	LBK6	165				
IDBBT40LBK7100L	LBK7	100	88	58	IDBCBH100; IDBCBH150; IDBRBH90; IDBRBH120; IDBRBH160	
IDBBT50LBK1115L	1	LBK1	115	Ø31(L30) / Ø19	11	IDBCBH20
IDBBT50LBK1145L		LBK1	145			
IDBBT50LBK2125L		LBK2	125			
IDBBT50LBK2155L	LBK2	155	Ø39(L15) / Ø24	14	IDBCBH25; RBH25	
IDBBT50LBK3125L	LBK3	125				
IDBBT50LBK3155L	LBK3	155				
IDBBT50LBK4115L	2	LBK4	115	39	22	IDBCBH40; RBH40
IDBBT50LBK4145L		LBK4	145			
IDBBT50LBK4175L		LBK4	175			
IDBBT50LBK4215L	1	LBK4	215	Ø50(L10) / Ø39	28	IDBCBH52; RBH52
IDBBT50LBK5105L	2	LBK5	105	50		
IDBBT50LBK5180L		LBK5	180			
IDBBT50LBK5240L		LBK5	240			
IDBBT50LBK5300L	1	LBK5	300	Ø64(L60) / Ø50	36	IDBCBH68; IDBCBH100; IDBCBH150; IDBRBH68; IDBRBH90
IDBBT50LBK6095L	2	LBK6	95	64		
IDBBT50LBK6170L		LBK6	170			
IDBBT50LBK6230L		LBK6	230			
IDBBT50LBK6290L		LBK6	290			
IDBBT50LBK6350L	1	LBK6	350	Ø90(L120) / Ø64	58	IDBCBH100; IDBCBH150; IDBRBH90; IDBRBH120; IDBRBH160
IDBBT50LBK7100L	2	LBK7	100	88		
IDBBT50LBK7150L		LBK7	150			
IDBBT50LBK7200L		LBK7	200			
IDBBT50LBK7250L		LBK7	250			
IDBBT50LBK7300L		LBK7	300			
IDBBT50LBK7350L		LBK7	350			
IDBBT50LBK7400L		LBK7	400			
IDBBT50LBK7450L		LBK7	450			
IDBBT50LBK7500L		LBK7	500			
IDBBT50LBK7550L		LBK7	550			