

# TUNG<sup>ORE</sup>B<sup>MINI</sup>

www.tungaloy.com

Tungaloy Report No. 529S1-G

High reliability internal boring bar now offers low cutting force & high chip evacuation!!



**INDUSTRY 4.0**  
*FEED the SPEED!*



# XOMU inserts optimized for internal boring with high rake angle

**Existing: Multifunctional tool**

- Drilling
- Face turning
- Internal boring
- External turning

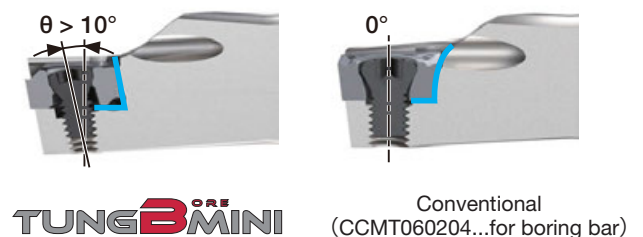
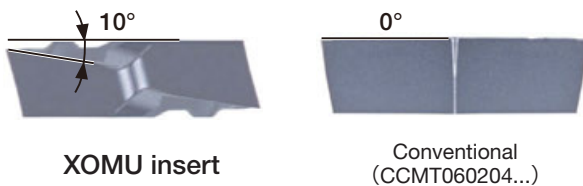
**New**

**For Internal boring**

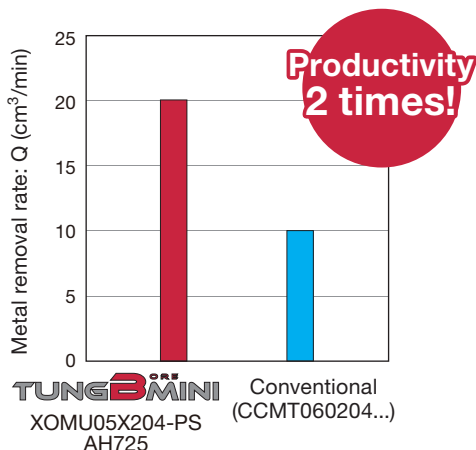
**High chip evacuation**  
Large pocket clearance

## Features

- 1. Low cutting force**  
Large inclination angle of XOMU insert
- 2. High reliability & high rigidity clamping**  
Dovetail clamping and slanted insert clamping screw



## CUTTING PERFORMANCE



**P** Machining : Internal turning  
Workpiece material : S45C / C45  
Coolant : Wet

	TUNGBOREMINI	Conventional
Cutting speed : Vc (m/min)	100	100
Feed : f (mm/rev)	0.08	0.08
Depth of cut : ap (mm)	2.5	1.25
Number of passes	1	2



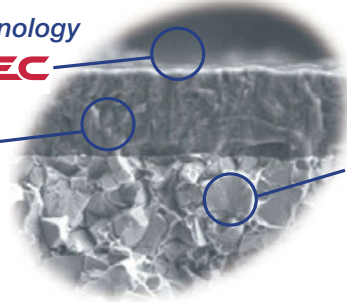
## PVD grade: AH725

AH725 features a super tough substrate with a new PVD coating layer.

Special surface technology

**PREMIUMTEC**  
TUNGALOY

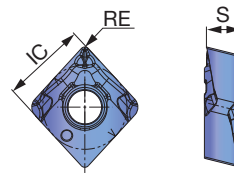
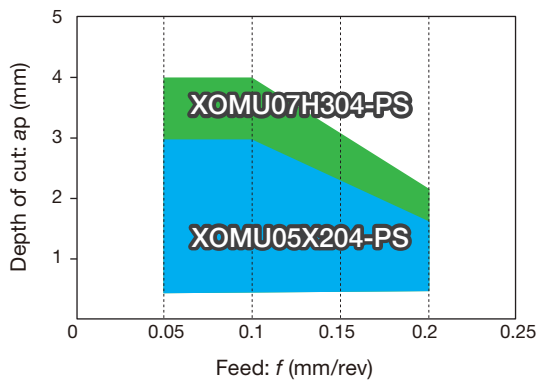
Coating layer with excellent adhesion strength  
**PVD coating**



Remarkable toughness  
**Fine grain carbide**

## Standard cutting conditions

DMIN	Description		Depth of cut: ap (mm)	Feed: f (mm/rev)	Cutting speed: Vc (m/min)	
	Holder	Insert			Carbon steel, Alloy steel	Stainless steel
ø10	A/E08*-SXUOR/L05-D100	XOMU05X204-PS	0.5 - 3	0.05 - 0.2	50 - 180	50 - 160
ø14	A/E12*-SXUOR/L07-D140	XOMU07H304-PS	0.5 - 4.5	0.05 - 0.2	50 - 180	50 - 160



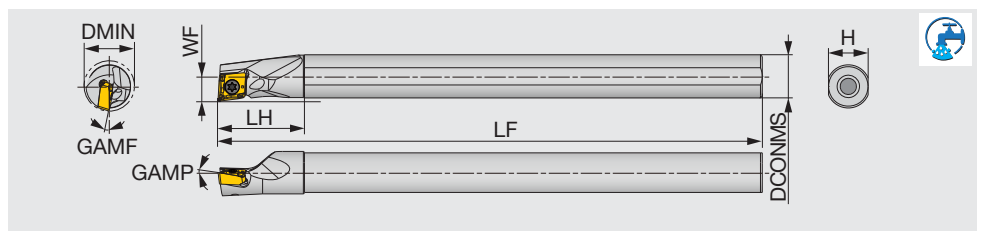
Designation	RE	Coated		
		AH725	S	IC
XOMU05X204-PS	0.4	●	2.3	5.56
XOMU07H304-PS	0.4	●	3.3	7.3

●: Line up

**New**

## A/E-SXUOR/L

Screw-on boring bar, for XOMU rhombic inserts



Designation	DMIN	DCONMS	WF	LF	LH	H	GAMP	GAMP	Insert
A08H-SXUOR/L05-D100	10	8	5	100	16	7.5	-7	-0.8	XOMU05X204-PS
A12M-SXUOR/L07-D140	14	12	7	150	24	11	-7.2	3.2	XOMU07H304-PS
E08K-SXUOR/L05-D100	10	8	5	125	22	7.5	-7	-0.8	XOMU05X204-PS
E12Q-SXUOR/L07-D140	14	12	7	180	27	11	-7.2	3.2	XOMU07H304-PS

## SPARE PARTS

Designation	Clamping screw	Wrench
A08H-SXUOR/L05-D100	CSTB-2L040	T-6F
A12M-SXUOR/L07-D140	CSPB-2.5	IP-8D
E08K-SXUOR/L05-D100	CSTB-2L040	T-6F
E12Q-SXUOR/L07-D140	CSPB-2.5	IP-8D

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