

# Type R Tool Application: Cylindrical bores

Through holes, diameters 201 – 450 mm

Blind holes, diameters 201 – 450 mm

## Features

- For bore tolerances up to class IT8
- Suitable for metals with tensile strength up to 1400 N/mm<sup>2</sup> and maximum hardness HRC ≤ 45
- Tools achieve a surface quality of  $R_z < 1 \mu\text{m}$  ( $R_a \leq 0.2 \mu\text{m}$ )
- For use on CNC-controlled lathes, drills, mills, and machining centers as well as manual machines
- Right hand rotation

## Advantages

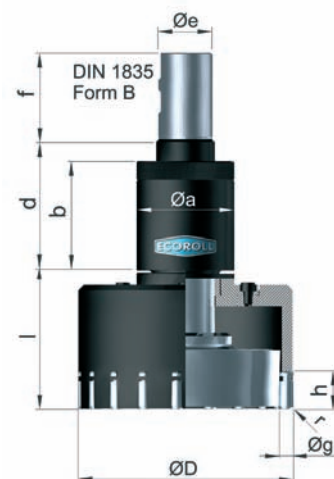
- Short cycle time
- Convenient diameter adjustment
- Minimal lubrication required (oil or emulsion)
- Tool automatically collapses when retracted to prevent surface damage
- Easy to change wear parts

## Basic tool design

- Type R tools consist of a tool body and roller head.
- Tool body includes shank and diameter adjustment assembly.
- Adjustment assembly accommodates any size within the setting range.
- Specially designed rollers for bores with wide ring grooves or with cross holes. These rollers guarantee smooth tool operation and retraction.

## Parameters

- Circumferential speed: up to 250 m/min.
- Feed rate: 0.10 - 0.4 mm/rev./roller



Tool body	Diameter range D	Setting range through blind hole <sup>1)</sup>	Tool shank: Morse taper or cylindrical shank Ø e x f	Number of rollers <sup>2)</sup>	Roller diameter Ø g x h	Roller radius r	a	b	c	d	i	l
							mm					
R5	≥ 201 < 255	-0.05 / +0.8	MK5	16	14 x 35	4	90	100	5	125	156	134
	≥ 255 < 320	-0.05 / +0.1	Ø 50 h6 x 80	20								
	≥ 320 < 450			28								

**NOTE: 1)** Depending on the application, blind hole tools may allow a larger range of settings than shown in the table.

**2)** Please exchange only complete sets of rollers. When ordering rollers, specify through or blind hole.