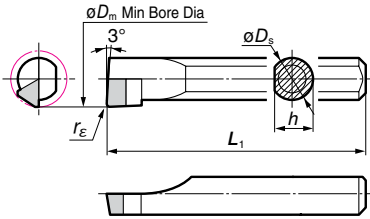


- Newly developed high rigidity slit-clamping system, excellent for small hole boring
 - Maximum overhang of L/D=5 possible.
 - Minimal bar deformation produces excellent boring accuracy.
 - Minimal vibration produces superior surface finish.
 - Easy bar indexing without sleeve removal.
- BN2000 for hardened steel and BN7000 for powdered metal are available

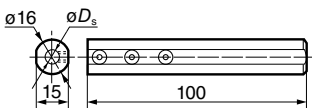
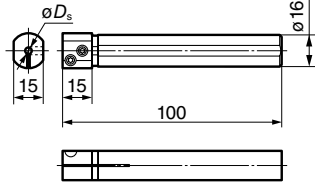
■ Brazed Boring Bar

Cat. No.	Stock				Min. Bore Dia.	Dimensions (mm)					Applicable Sleeve
	BN2000	BN250	BN7000	BN700	ϕD_m	ϕD_s	h	L_1	r_ϵ		
BNBX 020R	●	▲	●	●	2.5	2.0	1.8	40	0.2	HBX 2016	
025R	●	▲	●	●	3.0	2.5	2.2	40	0.2	HBX 2516	
030R	●	▲	●	●	3.5	3.0	2.7	40	0.2	HBX 3016	
035R	●	▲	●	●	4.0	3.5	3.2	40	0.2	HBX 3516	
040R	●	▲	●	●	4.5	4.0	3.7	40	0.2	HBX 4016	
045R	●	▲	●	●	5.0	4.5	4.2	40	0.2	HBX 4516	
050R	●	▲	●	●	5.5	5.0	4.7	60	0.2	HBX 5016	
055R	●	▲	●	●	6.0	5.5	5.2	60	0.2	HBX 5516	
060R	●	▲	●	●	6.5	6.0	5.7	60	0.2	HBX 6016	
BNBX 065R	●	▲			7.0	6.5	6.2	60	0.2	HBB 6516	
070R	●	▲			7.5	7.0	6.7	80	0.2	HBB 716	
075R	●	▲			8.0	7.5	7.2	80	0.2	HBB 7516	
080R	●	▲			8.5	8.0	7.7	80	0.2	HBB 816	



■ Adaptor Sleeve

Cat. No.	Stock	Diameter (ϕD_s)	Applicable Bar
HBX 2016	●	2.0	BNBX 020R
2516	●	2.5	BNBX 025R
3016	●	3.0	BNBX 030R
3516	●	3.5	BNBX 035R
4016	●	4.0	BNBX 040R
4516	●	4.5	BNBX 045R
5016	●	5.0	BNBX 050R
5516	●	5.5	BNBX 055R
6016	●	6.0	BNBX 060R
HBB 6516	●	6.5	BNBX 065R
716	●	7.0	BNBX 070R
7516	●	7.5	BNBX 075R
816	●	8.0	BNBX 080R



■ Parts (For Sleeve)

Screw	Recommended Tightening Torque (N·m)	Set Screw	Wrench	Applicable Sleeve
BFTX 0409N	3.4	BT06035T	TRD15	HBX 0000
—	—	BT0404	TH020	HBB 0000

* BNBX bars can be use with HBB type sleeves, however, HBX type sleeves are recommended for bars below $\phi 6\text{mm}$.

■ Recommended Cutting Conditions

Spindle speed n	More than 2,000min ⁻¹	Low speed may cause chattering and chipping on the cutting edge.
Depth of cut a_p	0.01 to 0.2mm	Excessive depth of cut may cause larger tool deformation resulting in deterioration of bore accuracy.
Feed rate f	0.01 to 0.1mm/rev	—

■ Important notes

- (1) Shorten overhang as much as possible (Max. L/D=5).
- (2) Even minor workpiece run-out may affect tool life.
- (3) Select a boring bar with a diameter closest to the bore diameter.
- (4) Although it is difficult to increase the rotational speed in small diameter boring applications, higher speeds are recommended whenever possible.