

VHM - Bohrstangen

Carbide Boring Bars



Bohrstangen aus Voll-Hartmetall (VHM)

Carbide Boring Bars

- VHM-Bohrstangen mit Wendeschneidplatten, zur Innen- und Außenbearbeitung
- höchste Maßgenauigkeit und beste Oberflächengüte
- durch die Ausführung in VHM und durch Kühlmittelbohrungen zur Innenkühlung speziell für tiefe Bohrungen, punktgenaue Kühlmittelzufuhr
- Bohr-Ø ab 5mm, Bohrtiefe bis 10 x D
- sehr gute Schwingungsdämpfung
- angeschliffene Fläche - kein Ausrichten erforderlich

- Carbide boring bars with inserts for internal and external machining
- Highest precision and surface quality
- Especially for deep bores
- Bore Ø >5mm, drilling depth until 10xD
- Very good vibration damping
- Ground flat - no adjustment required

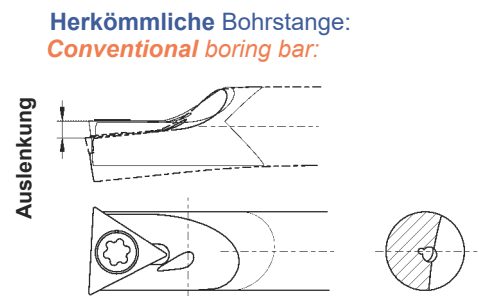
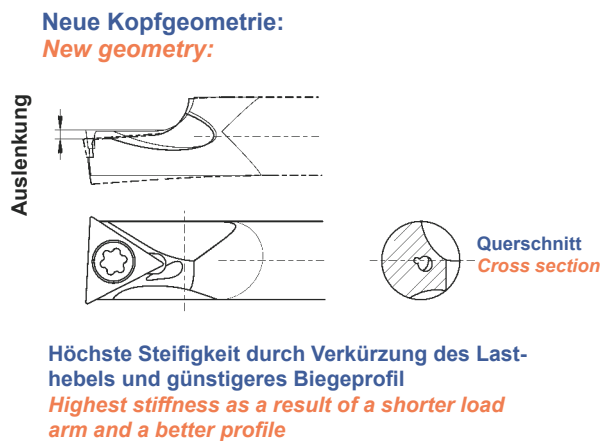
Neue Kopfgeometrie
für erhöhte Steifigkeit und bessere Spanabfuhr

New Design for highest stiffness
and a better removal of chips

Vergütete Köpfe!

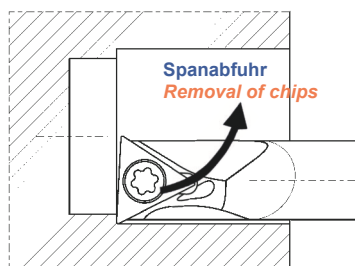
Tempered heads!

Stabilität und Präzision - Stability and precision



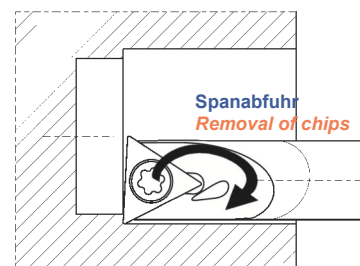
Oberflächenqualität und Sicherheit - Surface quality and safety

Neues Spankammerdesign
für verbesserte Spanabfuhr:
New chip space design for better removal of chips



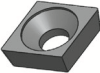
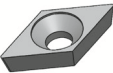
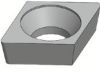

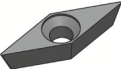

Ideale Spanabfuhr verbessert die Oberflächenqualität und reduziert den Werkzeugverschleiß
Perfect removal of chips effects a better surface quality and reduces tool wear

Herkömmliche Bohrstange:
Conventional boring bar



Übersicht: Halter für Platten . . .

Overview: Holders for Inserts . . .

Platten - Inserts		Seite - Page
	CC . . 0301 / 0401 / 0602 / 09T3 CP . . 04T1 / 05T1	269 - 270
	DC . . 0702 / 11T3	270 - 271
	JC . . 0301 (70° - Platte) (70° - Insert)	272
	TB . . 0601 TC . . 0902 / 1102 TP . . 07T1 / 0802 / 0902	272 - 273
	VC . . 0702 / 1103	274 - 276
	WB . . 0601 WC . . 0201	276 - 277

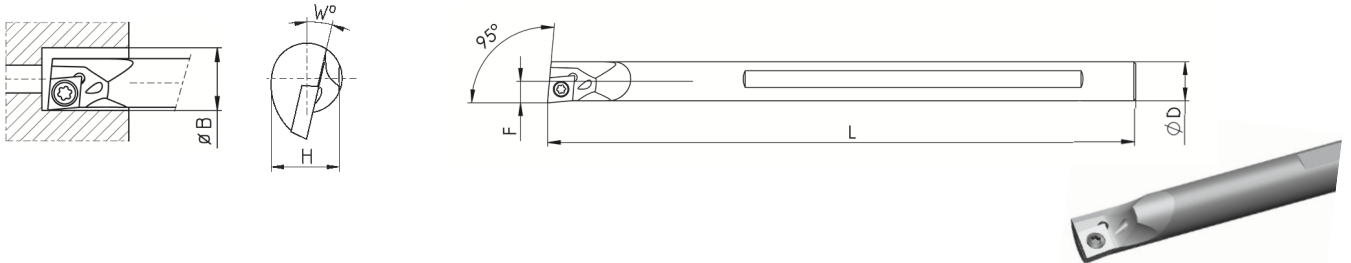
Alle Schrauben für Wendeplattenhalter s. S. 283
All screws for insert holders see page 283

VHM - Bohrstangen
mit Innenkühlung, für höchste Präzision

Carbide Boring Bars
also with inner coolant, for highest precision

C/E ...SCLC R/L ...SCLP R/L

Freiwinkel 7° / 11° Clearance angle 7° / 11°



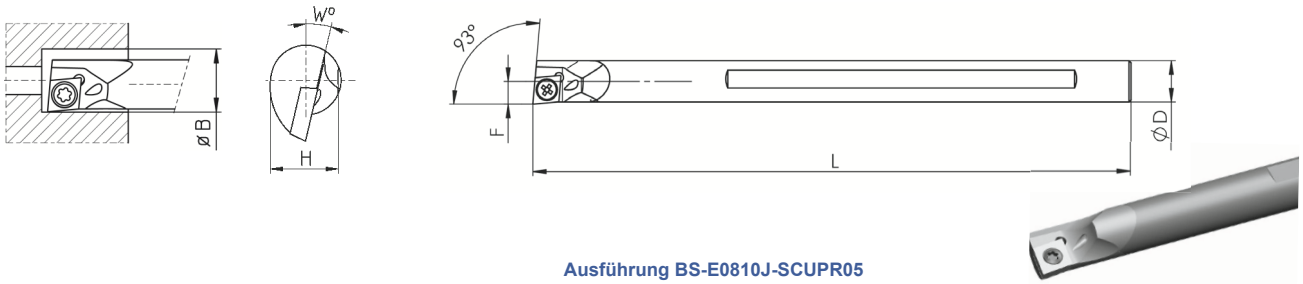
Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-C04G-SCLCR/L03	CC... 0301	4	90	2,5	14	3,6	4,8	--	A12-W6016024	T6
BS-C05H-SCLCR/L03	CC... 0301	5	100	3	11	4,5	5,8	--	A12-W6016024	T6
BS-E05H-SCLCR/L03	CC... 0301	5	100	3	11	4,5	5,8	✓*	A12-W6016024	T6
BS-E06J-SCLCR/L04	CC... 0401	6	110	3,5	7	5,5	6,9	✓	A12-W5420033	T6
BS-E06J-SCLPR/L04	CP... 04T1	6	110	3,5	7	5,5	6,9	✓	A12-W5420030	T6
* BS-E07K-SCLCR/L04	CC... 0401	7	125	4	7	6,5	7,9	✓*	A12-W5420033	T6
BS-E08K-SCLCR/L06	CC... 0602	8	125	4	10	7,5	8,9	✓	A12-W6025040	T8
BS-E08K-SCLPR/L04	CP... 04T1	8	125	4,5	7	7,5	8,9	✓	A12-W5420035	T6
BS-E10K-SCLCR/L06	CC... 0602	10	125	5,5	7	9,5	11	✓	A12-W6025040	T8
BS-E10M-SCLCR/L06	CC... 0602	10	150	5,5	7	9,5	11	✓	A12-W6025040	T8
BS-E12M-SCLCR/L06	CC... 0602	12	150	6,5	7	11,5	13	✓	A12-W6025049	T8
BS-E12Q-SCLCR/L06	CC... 0602	12	180	7,5	7	11,5	14	✓	A12-W6025049	T8
* BS-E12Q-SCLCR/L09	CC... 09T3	12	180	7,5	11	11,5	14	✓	A12-W6040060	T15
BS-E16J-SCLCR/L06	CC... 0602	16	110	9	7	15,5	17,5	✓	A12-W6025060	T8
BS-E16M-SCLCR/L06	CC... 0602	16	150	9	7	15,5	17,5	✓	A12-W6025060	T8
BS-E16R-SCLCR/L09	CC... 09T3	16	200	9	7	15,5	17,5	✓	A12-W6040070	T15
BS-E20S-SCLCR/L06	CC... 0602	20	250	11	7	19,5	21,7	✓	A12-W6025060	T8
BS-E20R-SCLCR/L09	CC... 09T3	20	200	12,5	7	19,5	23,2	✓	A12-W6040070	T15
BS-E20S-SCLCR/L09	CC... 09T3	20	250	11	7	19,5	21,7	✓	A12-W6040082	T15

* mit innerer Kühlmittelzufuhr auf Anfrage
* Ausverkaufsartikel

* with inner coolant on request
* sellout article

E...SCUC R/L ..SCUP R/L

Freiwinkel 7° Clearance angle 7°

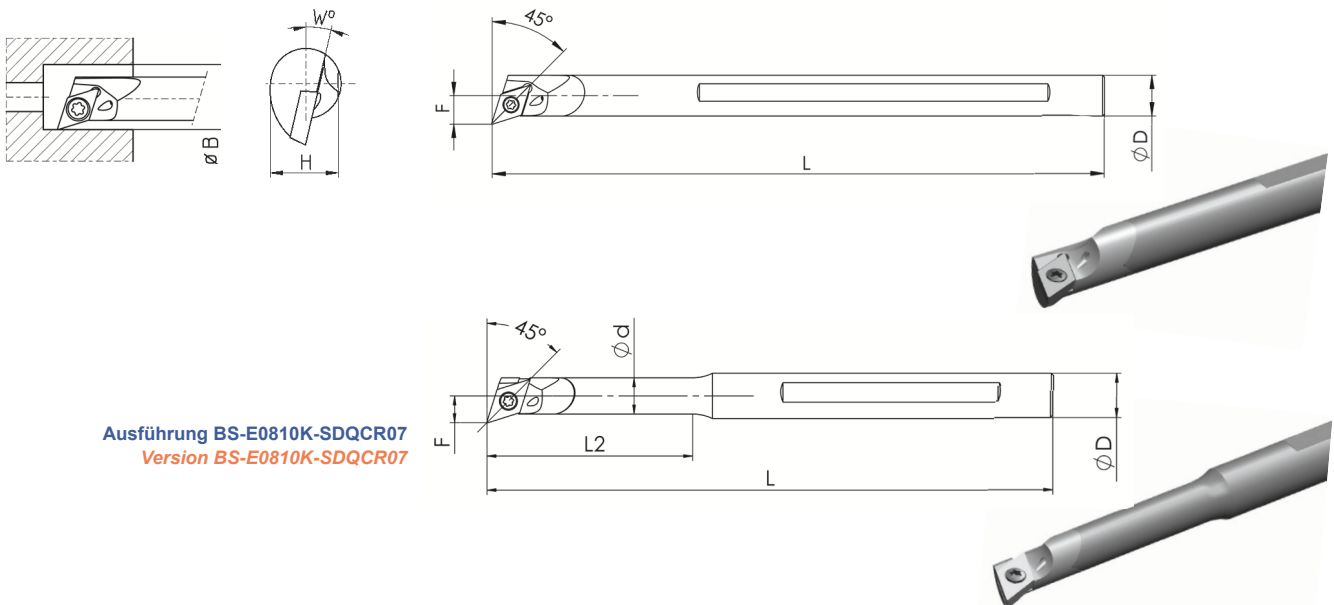


Ausführung BS-E0810J-SCUPR05
Version BS-E0810J-SCUPR05

Artikel-Nr. article-no.	Platte insert	D	d	L	L2	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E08K-SCUCR/L06	CC... 0602	8	--	125	--	4,8	10	7,5	9,2	✓	A12-W6025040	T8

E...SDQC R/L

Freiwinkel 7° Clearance angle 7°



Ausführung BS-E0810K-SDQCR07
Version BS-E0810K-SDQCR07

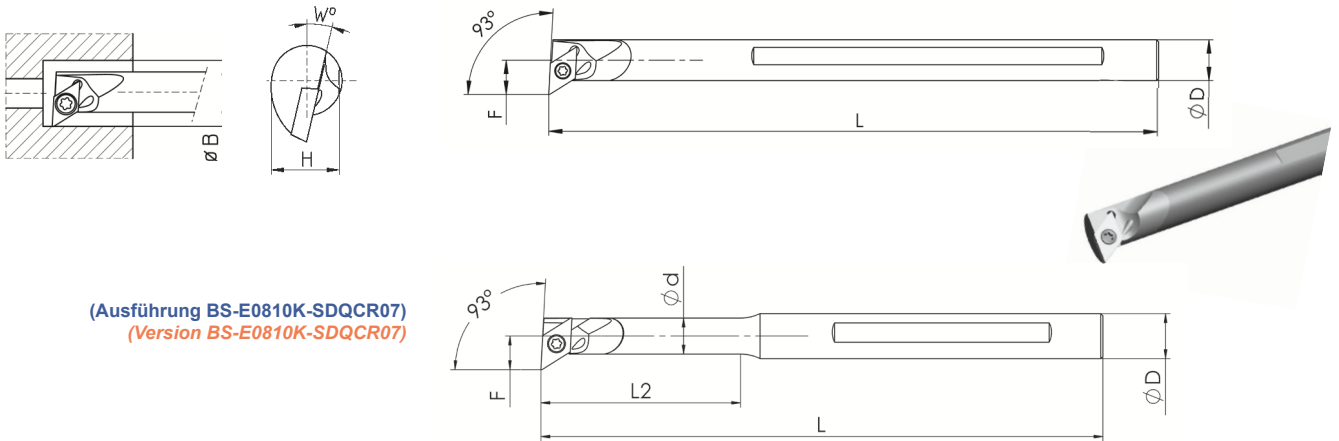
Artikel-Nr. article-no.	Platte insert	D	d	L	L2	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E0810K-SDQCR/L07	DC... 0702	10	8	125	45	7	10	9,5	10,4	✓	A12-W6025040	T8
BS-E10K-SDQCR/L07	DC... 0702	10	--	125	--	7	10	9,5	12,5	✓	A12-W6025049	T8
BS-E10M-SDQCR/L07	DC... 0702	10	--	150	--	7	10	9,5	12,5	✓	A12-W6025049	T8
BS-E12M-SDQCR/L07	DC... 0702	12	--	150	--	9	6	11,5	15,5	✓	A12-W6025049	T8
BS-E12Q-SDQCR/L07	DC... 0702	12	--	180	--	9	6	11,5	15,5	✓	A12-W6025049	T8
BS-E16R-SDQCR/L07	DC... 0702	16	--	200	--	11	6	15,5	19,5	✓	A12-W6025060	T8
BS-E16R-SDQCR/L11	DC... 11T3	16	--	200	--	11,5	8	15,5	20,2	✓	A12-W6040070	T15

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mit Innenkühlung, für höchste Präzision

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E...SDUC R/L

Freiwinkel 7° Clearance angle 7°



(Ausführung BS-E0810K-SDQCR07)
(Version BS-E0810K-SDQCR07)

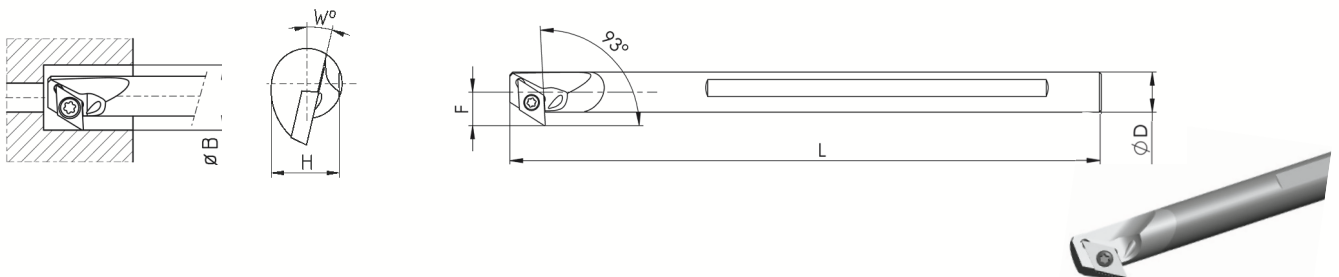
Artikel-Nr. article-no.	Platte insert	D	d	L	L2	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E08K-SDUCR/L07	DC... 0702	8	--	125	--	7,5	15	7,5	12,4	✓	A12-W6025049	T8
BS-E0810K-SDUCR/L07	DC... 0702	10	8	125	44	7,5	10	9,5	12,2	--*	A12-W6025049	T8
BS-E10K-SDUCR/L07	DC... 0702	10	--	125	--	7	10	9,5	12,5	✓	A12-W6025049	T8
BS-E10M-SDUCR/L07	DC... 0702	10	--	150	--	8,5	13	9,5	14	✓	A12-W6025060	T8
BS-E10M-SDUCR/L07-F	DC... 0702	10	--	150	--	7	13	9,5	12,5	✓	A12-W6025060	T8
BS-E12M-SDUCR/L07	DC... 0702	12	--	150	--	9,5	10	11,5	16	✓	A12-W6025060	T8
BS-E12Q-SDUCR/L07	DC... 0702	12	--	180	--	9	10	11,5	15,5	✓	A12-W6025060	T8
BS-E16R-SDUCR/L07	DC... 0702	16	--	200	--	11,5	10	15,5	20	✓	A12-W6025078	T8
BS-E16R-SDUCR/L07-F	DC... 0702	16	--	200	--	11	10	15,5	19,5	✓	A12-W6025078	T8
BS-E16R-SDUCR/L011	DC... 11T3	16	--	200	--	12	8	15,5	20,5	✓	A12-W6040078	T15
BS-E20R-SDUCR/L011	DC... 11T3	20	--	200	--	14	6	19,5	25,2	✓	A12-W6040078	T15

* mit innerer Kühlmittelzufuhr auf Anfrage

* with inner coolant on request

E...SDZC R/L

Freiwinkel 7° Clearance angle 7°



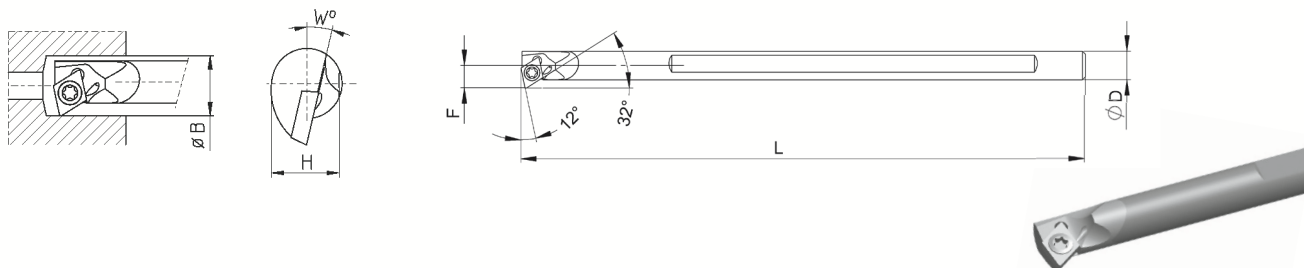
Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E08K-SDZCR/L07	DC... 0702	8	125	7,5	15	7,5	12,4	✓	A12-W6025049	T8
BS-E10M-SDZCR/L07	DC... 0702	10	150	8,5	13	9,5	14	✓	A12-W6025060	T8
BS-E12M-SDZCR/L07	DC... 0702	12	150	9,5	10	11,5	16	✓	A12-W6025060	T8
BS-E16R-SDZCR/L07	DC... 0702	16	200	11,5	10	15,5	20	✓	A12-W6025078	T8

E...SJXC R/L

Freiwinkel 7° Clearance angle 7°

Vorteil: Für außergewöhnlich tiefes Einstechmaß (vgl. F) bei sehr kleinem Bmin

Advantage: For exceptionally large recess depth (see F) at very low Bmin



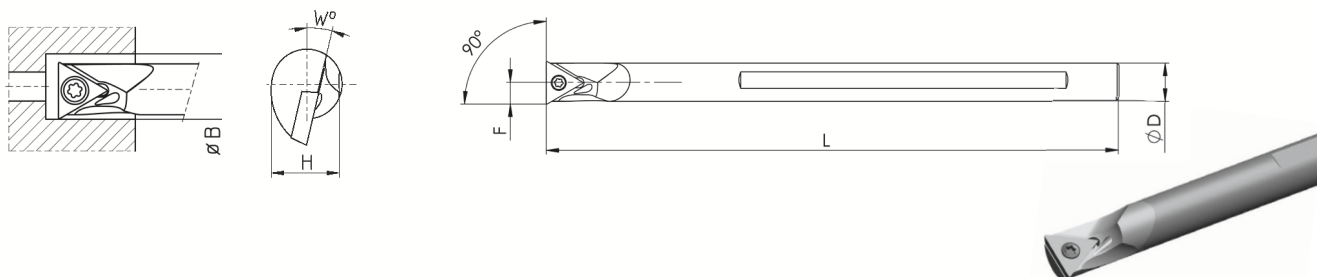
Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E04G-SJXCR/L03	JC... 0301	4	90	3,5	10	3,6	5,8	✓*	A12-W6016028	T6
BS-E05H-SJXCR/L03	JC... 0301	5	100	4	7	4,5	6,8	✓*	A12-W6016028	T6

* mit innerer Kühlmittelzufuhr auf Anfrage

* with inner coolant on request

E...STFC R/L

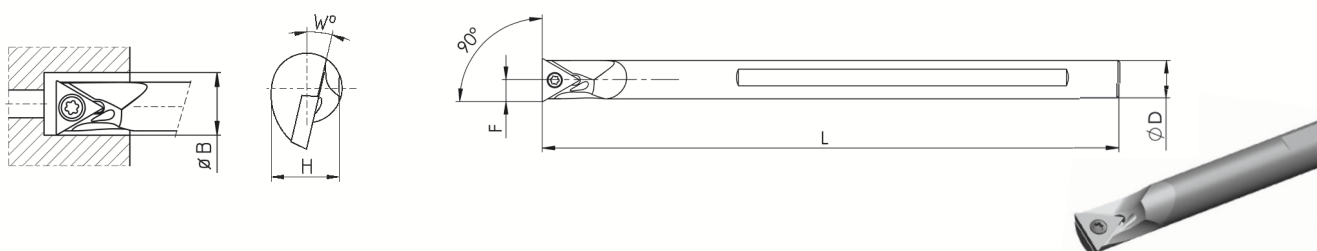
Freiwinkel 7° Clearance angle 7°



Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E08K-STFCR/L09	TC... 0902	8	125	5,5	11	7,5	9,4	✓	A12-W6022043	T7
BS-E10M-STFCR/L09	TC... 0902	10	150	6,5	9	4,5	12	✓	A12-W6022050	T7

E...STFP R/L

Freiwinkel 11° Clearance angle 11°



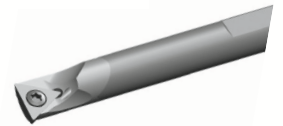
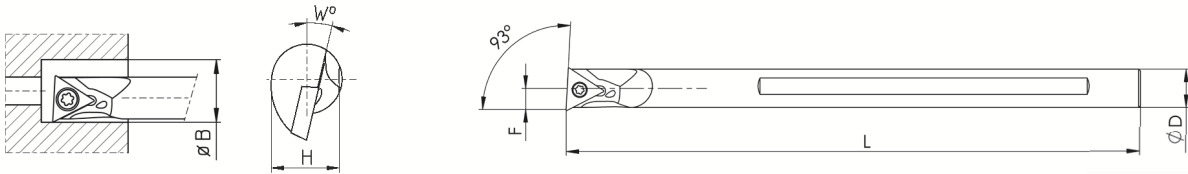
Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E08K-STFPR/L08	TP.. 0802	8	125	5	10	7,5	9,4	✓	A12-W6022043	T7
BS-E10K-STFPR/L09	TP.. 0902	10	150	6	7	9,5	11,5	✓	A12-W6025050	T8

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E...STUB R/L

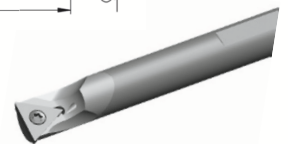
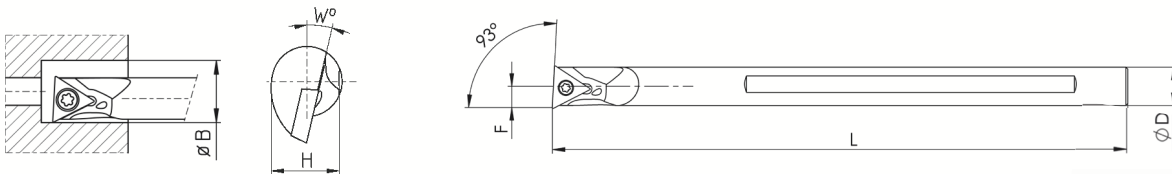
Freiwinkel 5° Clearance angle 5°



Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E06J-STUBR/L06	TB.. 0601	6	110	3,7	10	5,5	7,1	✓	A12-W5420030	T6
BS-E07K-STUBR/L06	TB.. 0601	7	125	4,2	10	6,5	8,1	✓	A12-W5420035	T6
BS-E08K-STUBR/L06	TB.. 0601	8	125	4,7	10	7,5	9,1	✓	A12-W5420040	T6

E...STUC R/L ...STUP R/L

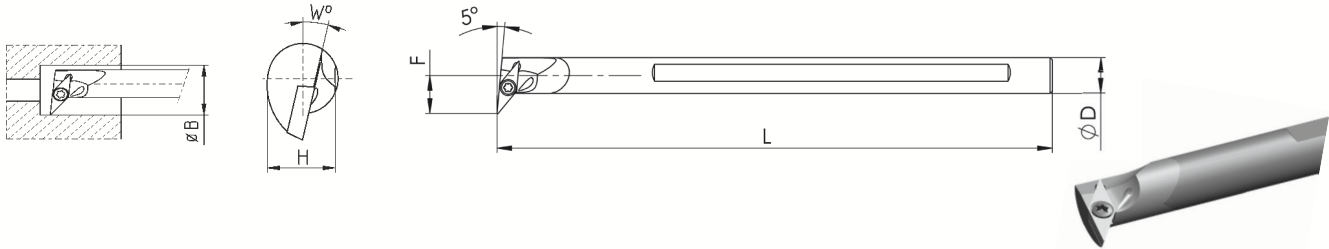
Freiwinkel 7° / 11° Clearance angle 7° / 11°



Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E06J-STUPR/L07	TP.. 07T1	6	110	3,6	7	5,5	7,1	✓	A12-W5420030	T6
BS-E08K-STUPR/L07	TP.. 07T1	8	125	4,6	7	7,5	9	✓	A12-W5420035	T6
BS-E08K-STUPR/L09	TP.. 0902	8	125	5,5	7	7,5	9,9	✓	A12-W6025040	T8
BS-E08K-STUCR/L09	TC.. 0902	8	125	5,5	11	7,5	9,9	✓	A12-W6022043	T7
BS-E10K-STUCR/L09	TC.. 0902	10	125	6,5	7	9,5	12	✓	A12-W6022050	T7
BS-E10M-STUCR/L11	TC.. 1102	10	150	5,5	7	9,5	11,3	✓	A12-W6025049	T8
BS-E12M-STUCR/L11	TC.. 1102	12	150	6,5	7	11,5	13	✓	A12-W6025060	T8
BS-E16R-STUCR/L11	TC.. 1102	16	200	8,5	7	15,5	17,2	✓	A12-W6025060	T8

E...SVLC R/L

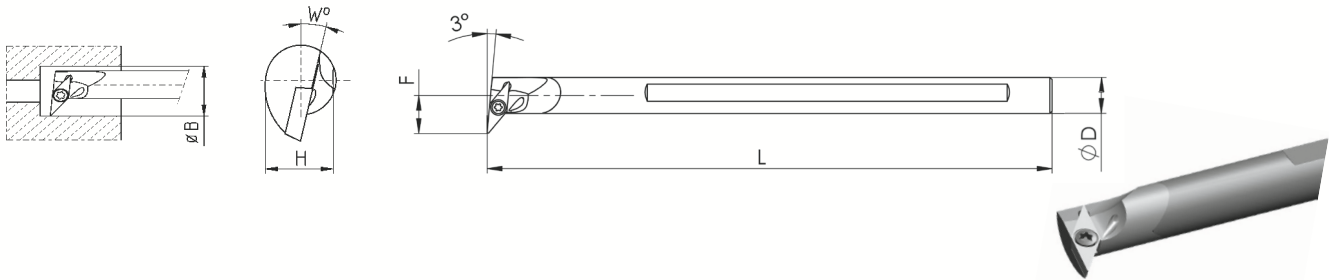
Freiwinkel 7° Clearance angle 7°



Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E08K-SVLCR/L07	VC.. 0702	8	125	8,5	10	7,5	12,9	✓	A12-W5420048	T6
BS-E10M-SVLCR/L07	VC.. 0702	10	150	8	8	9,5	15	✓	A12-W5420055	T6
BS-E12M-SVLCR/L07	VC.. 0702	12	150	9,5	6	11,5	17	✓	A12-W5420055	T6

E...SVUC R/L

Freiwinkel 7° Clearance angle 7°

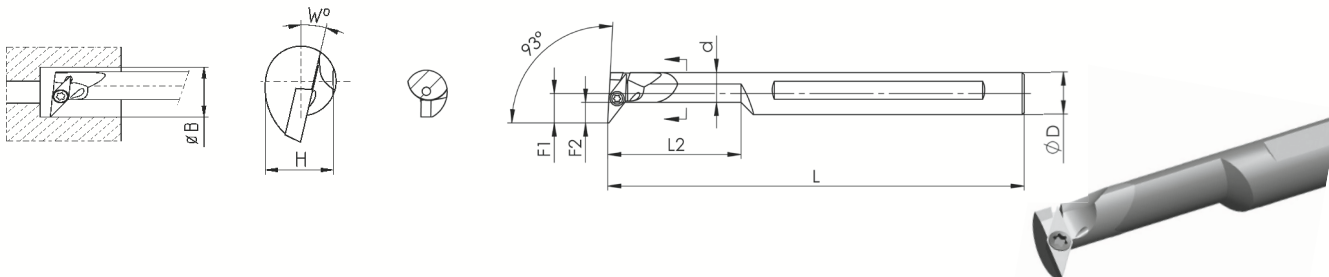


Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E12M-SVUCR/L11	VC.. 1103	12	150	13	6	11,5	19,5	✓	A12-W6025060	T7

E...SVLC R/L - EX ...SVUC R/L - EX

Freiwinkel 7° Clearance angle 7°

Vorteil: Sehr große Einstichtiefe bei hoher Schaftsteifigkeit
Advantage: Very large recess depth with high shaft rigidity



Artikel-Nr. article-no.	Platte insert	D	d	L	L ₂	F ₁	F ₂	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E10M-SVLCR/L07-EX *	VC.. 0702	10	7	150	32	7	5	10	9,5	12,5	✓	A12-W5420055	T6
BS-E10M-SVUCR/L07-EX	VC.. 0702	10	7	150	32	7	5	10	9,5	12,5	✓	A12-W5420055	T6
BS-E16M-SVUCR/L11-EX	VC.. 1103	16	11,5	150	60	12	8	6	15,5	20	✓	A12-W6025078	T6

* Anstellwinkel 95°

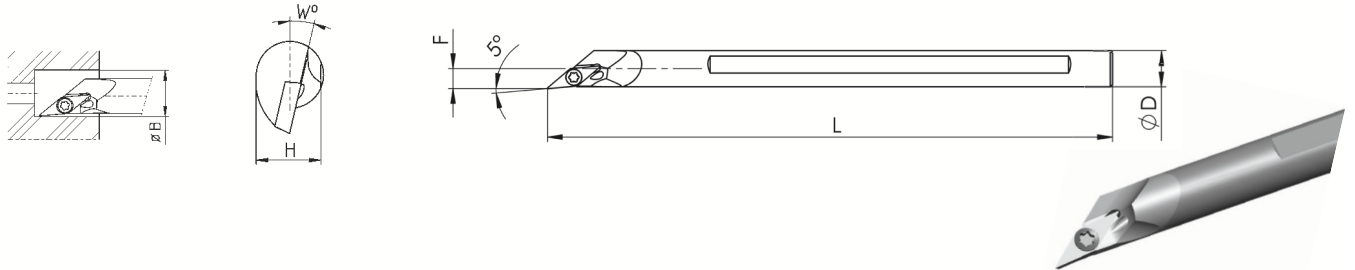
* work angle 95°

VHM - Bohrstangen mit Innenkühlung, für höchste Präzision

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E...SVOC R/L

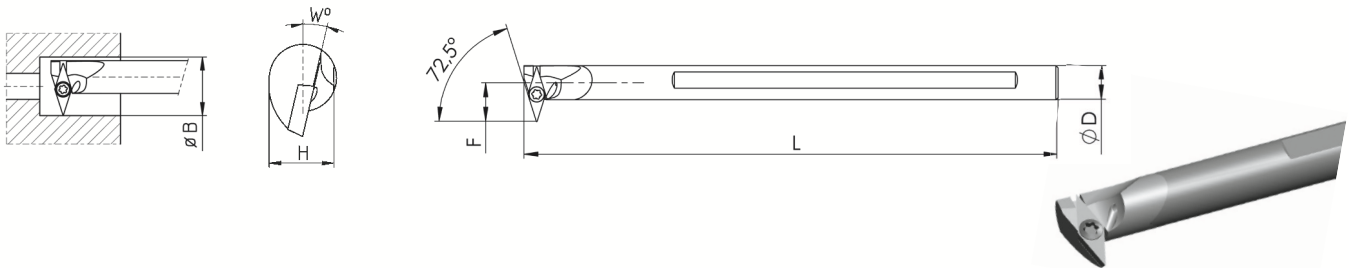
Freiwinkel 7° Clearance angle 7°



Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E08K-SVOCR/L07	VC.. 0702	8	125	4,5	10	7,5	8,9	✓	A12-W5420040	T6
BS-E10M-SVOCR/L07	VC.. 0702	10	150	5,5	8	9,5	11	✓	A12-W5420040	T6
BS-E12M-SVOCR/L07	VC.. 0702	12	150	6,5	6	11,5	13	✓	A12-W5420040	T6

E...SVVC R/L

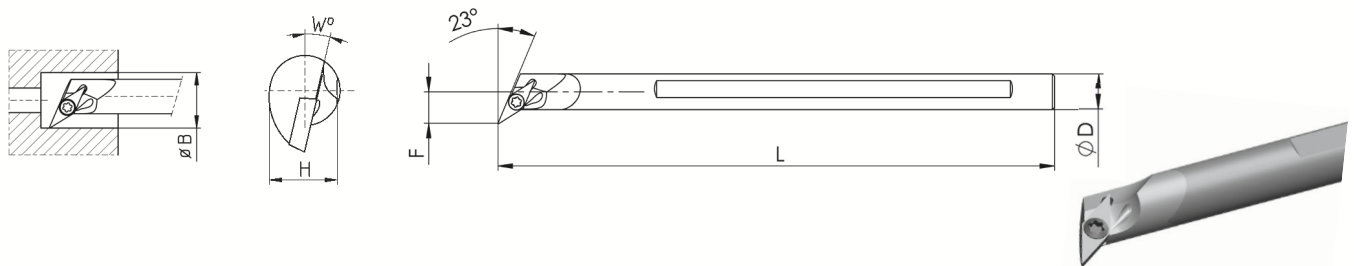
Freiwinkel 7° Clearance angle 7°



Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E08K-SVVCR/L07	VC.. 0702	8	125	9	10	7,5	13,5	✓	A12-W5420048	T6
BS-E10M-SVVCR/L07	VC.. 0702	10	150	10	8	9,5	15,5	✓	A12-W5420055	T6
BS-E12M-SVVCR/L07	VC.. 0702	12	150	11	6	11,5	17,5	✓	A12-W5420055	T6

E...SVXC R/L

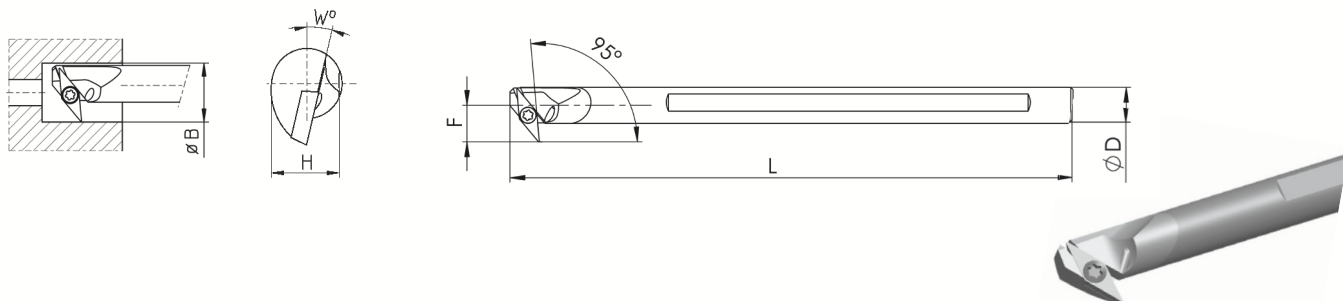
Freiwinkel 7° Clearance angle 7°



Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E08K-SVXCR/L07	VC.. 0702	8	125	7	10	7,5	11,4	✓	A12-W5420040	T6
BS-E10M-SVXCR/L07	VC.. 0702	10	150	8	8	9,5	13,5	✓	A12-W5420048	T6
BS-E12M-SVXCR/L07	VC.. 0702	12	150	9	6	11,5	15,5	✓	A12-W5420048	T6

E...SVZC R/L

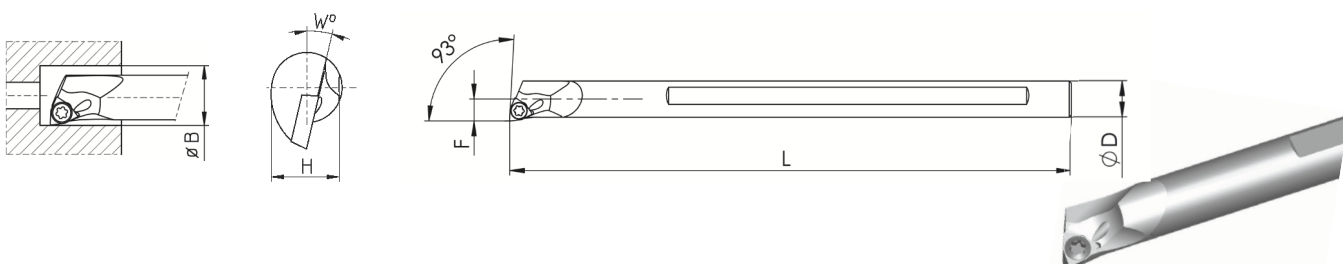
Freiwinkel 7° Clearance angle 7°



Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E08K-SVZCR/L07	VC.. 0702	8	125	8	10	7,5	12,4	✓	A12-W5420048	T6
BS-E10M-SVZCR/L07	VC.. 0702	10	150	9	8	9,5	14,5	✓	A12-W5420048	T6
BS-E12M-SVZCR/L07	VC.. 0702	12	150	10	6	11,5	16,5	✓	A12-W5420055	T6

C/E...SWUB R/L

Freiwinkel 5° Clearance angle 5°



Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E05F-SWUBR/L06	WBGT 0601	5	80	3	17	4,5	5,8	✓*	A12-W5420030	T6
BS-E055F-SWUBR/L06	WBGT 0601	5,5	80	3,25	15	5	6,4	--	A12-W5420030	T6
BS-E06F-SWUBR/L06	WBGT 0601	6	80	3,5	15	5,5	6,9	✓	A12-W5420030	T6
BS-E07F-SWUBR/L06	WBGT 0601	7	80	4	13	6,5	7,8	✓*	A12-W5420033	T6
BS-E08K-SWUBR/L06	WBGT 0601	8	125	4,5	12	6,5	9	✓	A12-W5420035	T6

* mit innerer Kühlmittelzufuhr auf Anfrage

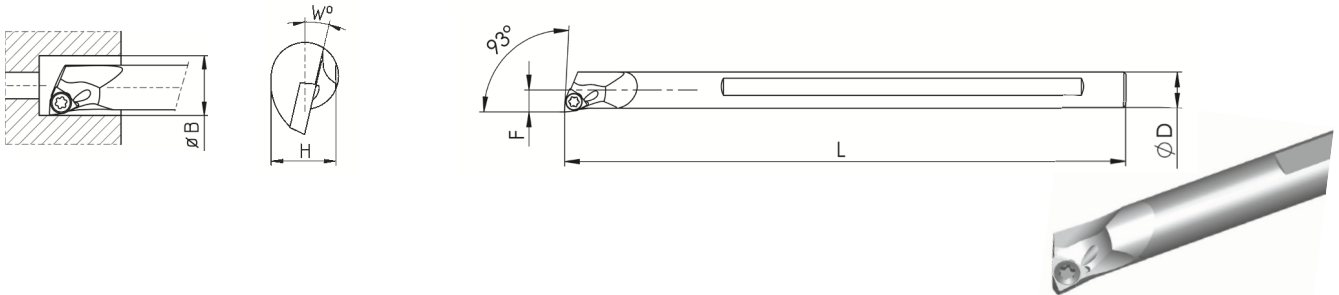
* with inner coolant on request

VHM - Bohrstangen
mit Innenkühlung, für höchste Präzision

Carbide Boring Bars
also with inner coolant, for highest precision

E...SWUC R/L

Freiwinkel 7° Clearance angle 7°



Artikel-Nr. article-no.	Platte insert	D	L	F	W [°]	H	Bmin	IK	Schraube screw	Schlüssel spanner
BS-E06J-SWUCR/L02	WCGX 0201	6	110	3,9	17	5,5	7,3	✓	A12-W5420030	T6
BS-E08K-SWUCR/L02	WCGX 0201	8	125	4,9	12	7,5	9,4	✓	A12-W5420033	T6
BS-E10M-SWUCR/L02	WCGX 0201	10	150	5,9	12	9,5	10,4	✓	A12-W5420040	T6

VHM - Bohrstangensatz

Carbide Boring Bars Set

E - SCLCR/L06 -

Satz in Plastik-Box, mit Schraubendreher
Set in plastic box incl. screwdriver

Artikel-Nr. article-no.	Satz bestehend aus set, includes	D	L
SET-E-SCLCR/L06	BS-E08K-SCLC R/L 06	8	125
	BS-E10K-SCLC R/L 06	10	125
	BS-E12M-SCLC R/L 06	12	150

E - SDUCR/L07 -

Satz in Plastik-Box, mit Schraubendreher
Set in plastic box incl. screwdriver

Artikel-Nr. article-no.	Satz bestehend aus set includes	D	L
SET-E-SDUCR/L07	BS-E0810H-SDUC R/L 07	8	100
	BS-E10K-SDUC R/L 07	10	125
	BS-E12M-SDUC R/L 07	12	150

