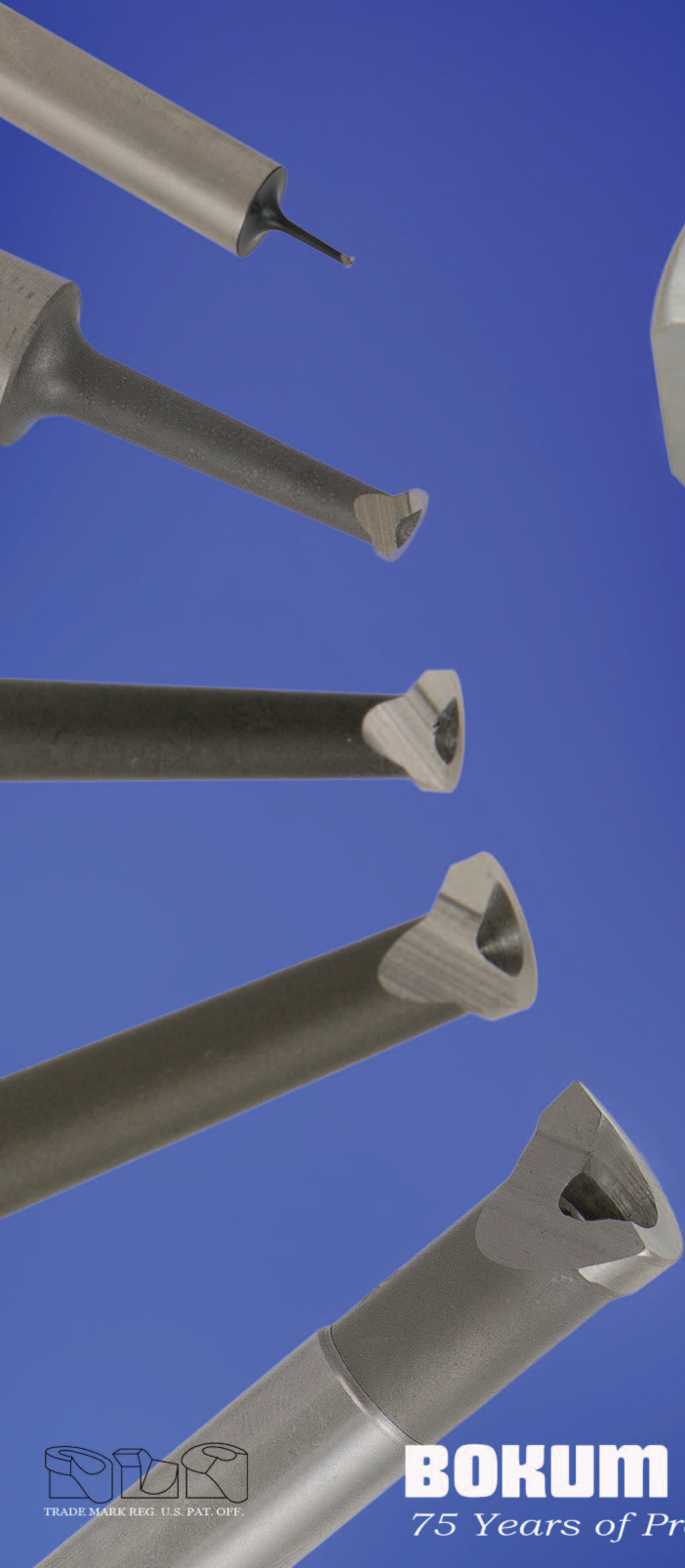


# BORING TOOLS

Solid Carbide  
Carbide Tipped  
High Speed Steel



**BOKUM TOOL COMPANY**



TRADE MARK REG. U.S. PAT. OFF.

**BOKUM TOOL COMPANY** Inc.

*75 Years of Precision Manufacturing*

# Introduction



Since 1937, Bokum has manufactured the finest cutting tools in the world. As industries have changed, Bokum's principals have remained the same; Always meet or exceed our customer's expectations. We manufacture a standard line of Boring, Recessing and Threading tools as well as Automatic Recessing heads, special grooving tools, and special boring bars.

We also work with OEM partners to provide precise and cost effective solutions allowing the end user to produce superior parts. If our extensive stock of standards does not offer a solution, our experienced team of engineers will work with you to design and manufacture a special in our plant.

As of this printing, Bokum Tool Company is entering its 75th year of manufacturing. We are proud to offer solutions which are more precise and cost effective compared with other machining methods. Whether utilized in the machining of the common products you see daily, or the creation of a unique prototype, it is likely a Bokum tool was involved.

Our cutting tools are available direct or offered through knowledgeable distributors. Please contact us today to assist you.



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32301 Dequindre Road • Madison Heights, MI 48071 • 248-585-0222 phone • 248-585-4855 fax  
• [www.bokumtoolco.com](http://www.bokumtoolco.com) • [sales@bokumtoolco.com](mailto:sales@bokumtoolco.com)

# BORING TOOLS

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**Boring Tool sets** are available upon request. Typical sets cover a particular Minimum Boring range and are offered at a discount. You may also create your own "Boring Tool Set" of 6 separate tools and receive a 10% discount off the total price.

**In addition,** Bokum will design and manufacture special Boring tools at your request. Please contact us for price and delivery.



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# The Bokum Principle

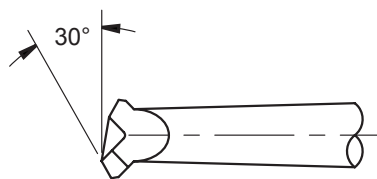
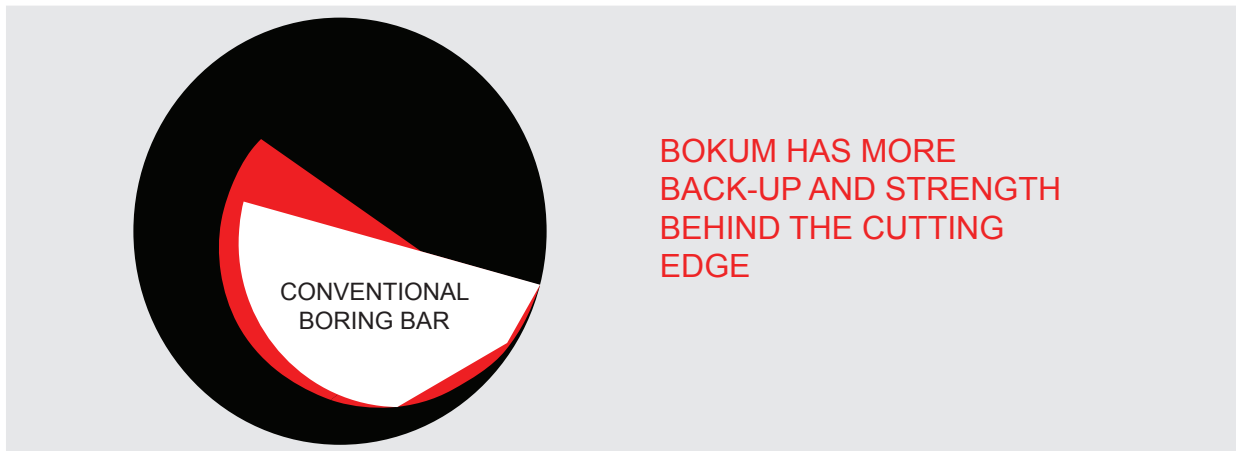
Bokum Boring tools cover a minimum bore diameter range from 1/16" to 2", with 19 sizes offered in small fractional increments. Each tool for any given size is the largest cross section that will enter that hole. Effective boring range is from 1/16" to 6" hole .

- Constant radial and helical relief
- Our Boring tools are made from the highest quality HSS, C2(Micrograin) and C7 Carbide
- Maximum rigidity - Produces round, straight holes
- Free cutting - minimum deflection
- Short Stubby tools - minimum overhang
- Superior finish - May eliminate need for grinding operation
- Lowest cost per cutting edge - Offers many regrinds
- Two Styles of tool offered
  - Style "A" - Heavier Cuts, Thru Boring, Quality Finish
  - Style "B" - Best Possible Finish, Boring/Facing/Bottoming, light to medium cuts
- All offered from stock in a full range of sizes and types
- Bokum Cutter type tools offer a wide range of interchangeable shanks

## Advantages - Radial and Helical Relief

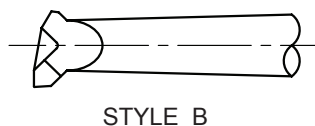
The drawing below shows a typical boring tool superimposed on a Bokum boring tool of the same relative size. The areas in red show the greater back up strength of the Bokum Principle - which results in longer tool life and superior finish.

The radial angle on a Bokum Tool is the relief on the outside diameter of the cutting head. We believe this angle should be held constant to a tolerance of +/- 3 minutes of one degree. Each Bokum boring tool is ground within this specification for precise machining throughout its long life.



### STYLE "A"

- Heavier cuts
- Thru Boring
- Quality finish



### STYLE "B"

- Light to Medium cuts
- Boring, facing, bottoming
- Best possible finish



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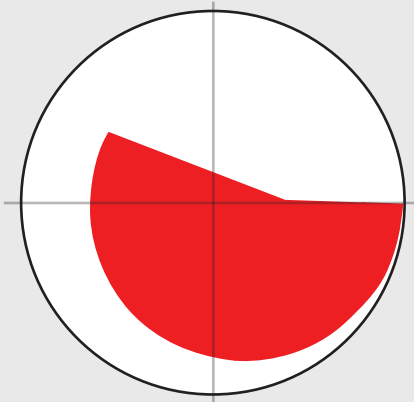
# Select the Correct Boring Tool

## Type of Tool

For best accuracy and finish, select largest tool that will enter the bore. When possible, select the shortest, stubbiest tool that will accommodate the length of the bore.

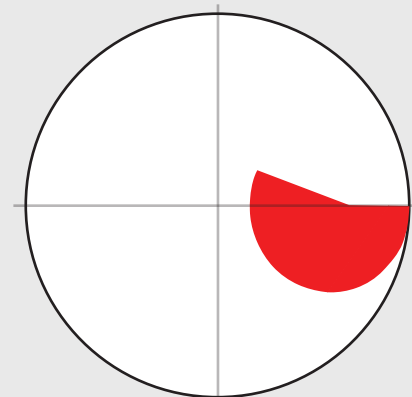
## High Speed Steel or Carbide?

- Average Finish - Select High Speed Steel for work with non-heat-treated material
- Better/Best Finish - Select Carbide tipped/Head or Solid Carbide. A must with heat-treated or exotic materials



**CORRECT SELECTION**

- Select largest tool that will enter the previously drilled hole
- Eliminates Chatter
- Produces best possible finish
- Rigidity. Eliminates deflection, produces straight, round holes



**WRONG SELECTION**

- Tool too small for hole to be bored
- Will Chatter
- Produce inferior finish
- Lacks rigidity. Possible deflection will cause lack of straightness and roundness



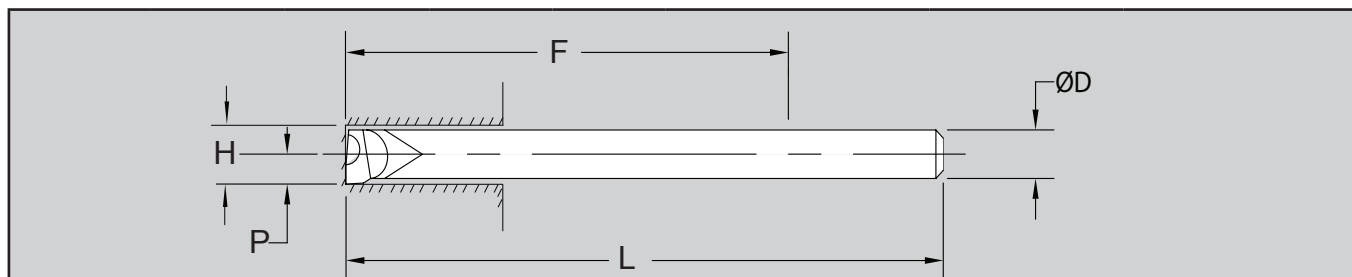
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# BORING TOOLS One-Piece Construction

## SOLID CARBIDE



H	F	L	D	P	S	R	CATALOG NUMBER
MIN BORE DIA	MAX BORE DEPTH	OVERALL LENGTH	SHANK DIA	CUTTING EDGE TO $\text{C}$	WIDTH OF CUTTING EDGE	RADIUS AT POINT	
.115	.750	1 1/2	3/32	.057	.022	.002	BSC35
.115	2.000	3	3/32	.057	.022	.002	BSC3
.146	.875	1 5/8	1/8	.073	.047	.002	BSC45
.146	2.250	3 1/4	1/8	.073	.047	.002	BSC4
.188	1.000	1 3/4	5/32	.094	.061	.003	BSC55
.188	2.500	3 1/2	5/32	.094	.061	.003	BSC5
.231	1.375	1 7/8	3/16	.115	.075	.003	BSC65
.231	2.750	3 3/4	3/16	.115	.075	.003	BSC6
.261	1.250	2 1/16	7/32	.130	.085	.004	BSC75
.261	3.375	4 1/8	7/32	.130	.085	.004	BSC7
.305	1.500	2 1/4	1/4	.152	.099	.004	BSC85
.305	3.500	4 1/2	1/4	.152	.099	.004	BSC8
.367	1.750	2 1/2	5/16	.183	.120	.004	BSC105
.367	4.000	5	5/16	.183	.120	.004	BSC10
.452	2.125	2 7/8	3/8	.226	.147	.005	BSC125
.452	4.750	5 3/4	3/8	.226	.147	.005	BSC12
.537	2.500	3 1/4	7/16	.268	.175	.005	BSC145
.537	5.500	6 1/2	7/16	.268	.175	.005	BSC14
.600	2.875	3 5/8	1/2	.300	.195	.005	BSC165
.600	3.250	4 1/4	1/2	.300	.195	.005	BSC167
.600	6.000	7 1/4	1/2	.300	.195	.005	BSC16

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2 (Micrograin)
- C7

**Optional:**

- TiAlN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

**Possible Modifications of Bokum Standard Boring Tools**

- The "L" dimension may be shortened
- The "F" dimension may be lengthened
- The "P" dimension may be reduced 10% maximum
- Change lead angle or width
- Any radius may be furnished on point of tool

The cutting heads are made of Carbide (C2 or C7). The shanks are made from a tough grade of carbide for maximum strength that has 2.8 times the rigidity of heat treated high speed steel of the same dimensions. This construction is of great help in securing that last tenth (.0001) of accuracy when the depth of bore is more than three times its diameter. You can see what a problem it is to bore a 1/8" diameter hole 1 1/2" deep. The BSC-3 tool is ideal for this job.

**Replacing cutting heads** - When cutting heads are used up after many regrinds, the tools may be returned to Bokum to have the heads replaced at a fraction of the cost of a new boring tool.



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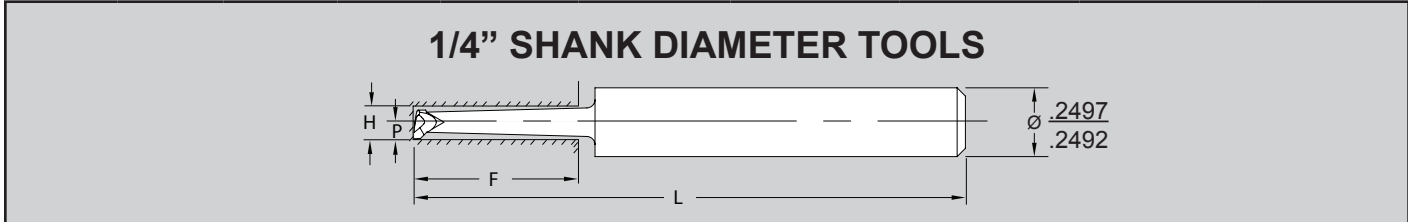
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# BORING TOOLS One-Piece Construction

## HSS, CARBIDE NECK, CARBIDE TIPPED

BORING TOOLS



H	F	L	P	HSS		CARBIDE NECK TOOLS		CARBIDE TIPPED TOOLS	
				STYLE A	STYLE B	STYLE A	STYLE B	STYLE A	STYLE B
.063	.125	1 1/2	.036	25H500A	25H500B	25CN500A	25CN500B		
.063	.188	1 1/2	.036	25H501A	25H501B	25CN501A	25CN501B		
.063	.250	2	.036	25H50A	25H50B	25CN50A	25CN50B		
.063	.375	4 1/2	.036	25H50LA	25H50LB	25CN50LA	25CN50LB		
.094	.188	1 1/2	.054	25H502A	25H502B	25CN502A	25CN502B		
.094	.250	1 1/2	.054	25H503A	25H503B	25CN503A	25CN503B		
.094	.312	1 9/16	.054	25H504A	25H504B	25CN504A	25CN504B		
.094	.375	2	.054	25H40A	25H40B	25CN40A	25CN40B		
.094	.563	4 1/2	.054	25H40LA	25H40LB	25CN40LA	25CN40LB		
.125	.188	1 1/2	.060	25H505A	25H505B	25CN505A	25CN505B	25CT505A	25CT505B
.125	.250	1 1/2	.060	25H506A	25H506B	25CN506A	25CN506B	25CT506A	25CT506B
.125	.375	1 5/8	.060	25H507A	25H507B	25CN507A	25CN507B	25CT507A	25CT507B
.125	.500	2	.060	25H30A	25H30B	25CN30A	25CN30B	25CT30A	25CT30B
.125	.750	4 1/2	.060	25H30LA	25H30LB	25CN30LA	25CN30LB	25CT30LA	25CT30LB
.188	.250	1 1/2	.090	25H508A	25H508B			25CT508A	25CT508B
.188	.312	1 9/16	.090	25H509A	25H509B			25CT509A	25CT509B
.188	.375	1 5/8	.090	25H510A	25H510B			25CT510A	25CT510B
.188	.500	1 3/4	.090	25H511A	25H511B			25CT511A	25CT511B
.188	.625	1 7/8	.090	25H512A	25H512B			25CT512A	25CT512B
.188	.750	2	.090	25H20A	25H20B			25CT20A	25CT20B
.188	1.125	4 1/2	.090	25H20LA	25H20LB			25CT20LA	25CT20LB
.250	.250	1 1/2	.122	25H513A	25H513B			25CT513A	25CT513B
.250	.375	1 5/8	.122	25H514A	25H514B			25CT514A	25CT514B
.250	.500	1 3/4	.122	25H515A	25H515B			25CT515A	25CT515B
.250	.625	1 7/8	.122	25H516A	25H516B			25CT516A	25CT516B
.250	.750	2	.122	25H517A	25H517B			25CT517A	25CT517B
.250	1.000	2 3/16	.122	25H0A	25H0B			25CT0A	25CT0B
.250	1.500	4 1/2	.122	25H0LA	25H0LB			25CT0LA	25CT0LB
.312	.500	1 3/4	.156	25H518A	25H518B			25CT518A	25CT518B
.312	.750	2	.156	25H519A	25H519B			25CT519A	25CT519B
.312	1.000	2 1/4	.156	25H520A	25H520B			25CT520A	25CT520B
.312	1.250	2 9/16	.156	25H1A	25H1B			25CT1A	25CT1B
.312	1.875	4 1/2	.156	25H1LA	25H1LB			25CT1LA	25CT1LB
.375	.500	1 3/4	.186	25H526A	25H526B			25CT526A	25CT526B
.375	.750	2	.186	25H527A	25H527B			25CT527A	25CT527B
.375	1.000	2 1/4	.186	25H528A	25H528B			25CT528A	25CT528B
.375	1.500	2 5/8	.186	25H15A	25H15B			25CT15A	25CT15B
.375	2.250	4 1/2	.186	25H15LA	25H15LB			25CT15LA	25CT15LB

**NOT AVAILABLE  
USE CT  
TOOLS**

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2 (Micrograin)
- C7

**Optional:**

- TiAlN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

**Possible Modifications of Bokum Standard Boring Tools**

- The "L" dimension may be shortened
- The "F" dimension may be lengthened
- The "P" dimension may be reduced 10% maximum
- Change lead angle or width
- Any radius may be furnished on point of tool



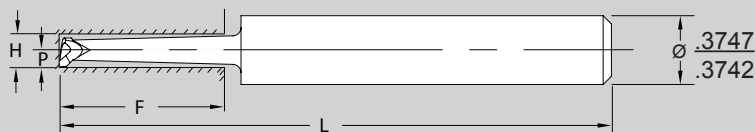
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# BORING TOOLS One-Piece Construction

## HSS, CARBIDE NECK, CARBIDE TIPPED

### 3/8" SHANK DIAMETER TOOLS



H	F	L	P	HSS		CARBIDE NECK TOOLS		CARBIDE TIPPED TOOLS	
MIN BORE DIA	MAX BORE DEPTH	OVERALL LENGTH	CUTTING EDGE TO $\downarrow$	STYLE A	STYLE B	STYLE A	STYLE B	STYLE A	STYLE B
.063	.125	1 1/2	.030	H500A	H500B	CN500A	CN500B		
.063	.188	1 1/2	.030	H501A	H501B	CN501A	CN501B		
.063	.250	2	.030	H50A	H50B	CN50A	CN50B		
.063	.375	4 1/2	.030	H50LA	H50LB	CN50LA	CN50LB		
.094	.188	1 1/2	.045	H502A	H502B	CN502A	CN502B		
.094	.250	1 1/2	.045	H503A	H503B	CN503A	CN503B		
.094	.312	1 9/16	.045	H504A	H504B	CN504A	CN504B		
.094	.375	2	.045	H40A	H40B	CN40A	CN40B		
.094	.563	4 1/2	.045	H40LA	H40LB	CN40LA	CN40LB		
.125	.188	1 1/2	.060	H505A	H505B	CN505A	CN505B	CT505A	CT505B
.125	.250	1 1/2	.060	H506A	H506B	CN506A	CN506B	CT506A	CT506B
.125	.375	1 5/8	.060	H507A	H507B	CN507A	CN507B	CT507A	CT507B
.125	.500	2	.060	H30A	H30B	CN30A	CN30B	CT30A	CT30B
.125	.750	4 1/2	.060	H30LA	H30LB	CN30LA	CN30LB	CT30LA	CT30LB
.188	.250	1 1/2	.090	H508A	H508B			CT508A	CT508B
.188	.312	1 9/16	.090	H509A	H509B			CT509A	CT509B
.188	.375	1 5/8	.090	H510A	H510B			CT510A	CT510B
.188	.500	1 3/4	.090	H511A	H511B			CT511A	CT511B
.188	.625	1 7/8	.090	H512A	H512B			CT512A	CT512B
.188	.750	2	.090	H20A	H20B			CT20A	CT20B
.188	1.125	4 1/2	.090	H20LA	H20LB			CT20LA	CT20LB
.250	.250	1 1/2	.122	H513A	H513B			CT513A	CT513B
.250	.375	1 5/8	.122	H514A	H514B			CT514A	CT514B
.250	.500	1 3/4	.122	H515A	H515B			CT515A	CT515B
.250	.625	1 7/8	.122	H516A	H516B			CT516A	CT516B
.250	.750	2	.122	H517A	H517B			CT517A	CT517B
.250	1.000	2 3/16	.122	H0A	H0B			CT0A	CT0B
.250	1.500	4 1/2	.122	H0LA	H0LB			CT0LA	CT0LB

**NOT AVAILABLE  
USE CT  
TOOLS**

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2(Micrograin)
- C7

**Optional:**

- TiAlN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

**Possible Modifications of Bokum Standard Boring Tools**

- The "L" dimension may be shortened
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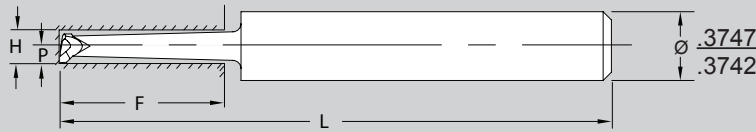
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# BORING TOOLS One-Piece Construction

## HSS AND CARBIDE TIPPED

### 3/8" SHANK DIAMETER TOOLS



H	F	L	P	HSS		CARBIDE NECK TOOLS		CARBIDE TIPPED TOOLS	
				STYLE A	STYLE B			STYLE A	STYLE B
.312	.500	1 3/4	.156	H518A	H518B	<b>NOT AVAILABLE USE CT TOOLS</b>		CT518A	CT518B
.312	.750	2	.156	H519A	H519B			CT519A	CT519B
.312	1.000	2 1/4	.156	H520A	H520B			CT520A	CT520B
.312	1.250	2 9/16	.156	H1A	H1B			CT1A	CT1B
.312	1.875	4 1/2	.156	H1LA	H1LB			CT1LA	CT1LB
.375	.500	1 3/4	.186	H526A	H526B			CT526A	CT526B
.375	.750	2	.186	H527A	H527B			CT527A	CT527B
.375	1.000	2 1/4	.186	H528A	H528B			CT528A	CT528B
.375	1.500	2 5/8	.186	H15A	H15B			CT15A	CT15B
.375	2.250	4 1/2	.186	H15LA	H15LB			CT15LA	CT15LB
.438	.500	1 3/4	.218	H521A	H521B			CT521A	CT521B
.438	.750	2	.218	H522A	H522B			CT522A	CT522B
.438	1.000	2 1/4	.218	H523A	H523B			CT523A	CT523B
.438	1.750	2 3/4	.218	H2A	H2B			CT2A	CT2B
.438	2.625	4 1/2	.218	H2LA	H2LB			CT2LA	CT2LB
.500	.750	2	.249	H529A	H529B			CT529A	CT529B
.500	1.000	2 1/4	.249	H530A	H530B			CT530A	CT530B
.500	2.000	3 1/4	.249	H25A	H25B			CT25A	CT25B
.500	2.750	4 1/2	.249	H25LA	H25LB			CT25LA	CT25LB
.563	1.062	2 5/16	.280	H524A	H524B			CT524A	CT524B
.563	1.563	2 13/16	.280	H525A	H525B			CT525A	CT525B
.563	2.250	3 3/8	.280	H3A	H3B			CT3A	CT3B
.563	3.250	4 1/2	.280	H3LA	H3LB			CT3LA	CT3LB

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2(Micrograin)
- C7

**Optional:**

- TiALN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

**Possible Modifications of Bokum Standard Boring Tools**

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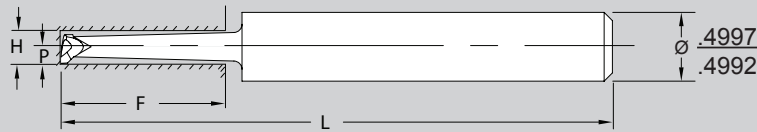
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# BORING TOOLS One-Piece Construction

## HSS, CARBIDE NECK, CARBIDE TIPPED

### 1/2" SHANK DIAMETER TOOLS



H	F	L	P	HSS		CARBIDE NECK TOOLS		CARBIDE TIPPED TOOLS	
MIN BORE DIA	MAX BORE DEPTH	OVERALL LENGTH	CUTTING EDGE TO $\phi$	STYLE A	STYLE B	STYLE A	STYLE B	STYLE A	STYLE B
.063	.125	1 1/2	.030	50H500A	50H500B	50CN500A	50CN500B		
.063	.188	1 1/2	.030	50H501A	50H501B	50CN501A	50CN501B		
.063	.250	2	.030	50H50A	50H50B	50CN50A	50CN50B		
.063	.375	4 1/2	.030	50H50LA	50H50LB	50CN50LA	50CN50LB		
.094	.188	1 1/2	.045	50H502A	50H502B	50CN502A	50CN502B		
.094	.250	1 1/2	.045	50H503A	50H503B	50CN503A	50CN503B		
.094	.312	1 9/16	.045	50H504A	50H504B	50CN504A	50CN504B		
.094	.375	2	.045	50H40A	50H40B	50CN40A	50CN40B		
.094	.563	4 1/2	.045	50H40LA	50H40LB	50CN40LA	50CN40LB		
.125	.188	1 1/2	.060	50H505A	50H505B	50CN505A	50CN505B	50CT505A	50CT505B
.125	.250	1 1/2	.060	50H506A	50H506B	50CN506A	50CN506B	50CT506A	50CT506B
.125	.375	1 5/8	.060	50H507A	50H507B	50CN507A	50CN507B	50CT507A	50CT507B
.125	.500	2	.060	50H30A	50H30B	50CN30A	50CN30B	50CT30A	50CT30B
.125	.750	4 1/2	.060	50H30LA	50H30LB	50CN30LA	50CN30LB	50CT30LA	50CT30LB
.188	.250	1 1/2	.090	50H508A	50H508B	<b>NOT AVAILABLE USE CT TOOLS</b>		50CT508A	50CT508B
.188	.312	1 9/16	.090	50H509A	50H509B			50CT509A	50CT509B
.188	.375	1 5/8	.090	50H510A	50H510B			50CT510A	50CT510B
.188	.500	1 3/4	.090	50H511A	50H511B			50CT511A	50CT511B
.188	.625	1 7/8	.090	50H512A	50H512B			50CT512A	50CT512B
.188	.750	2	.090	50H20A	50H20B			50CT20A	50CT20B
.188	1.125	4 1/2	.090	50H20LA	50H20LB			50CT20LA	50CT20LB
.250	.250	1 1/2	.122	50H513A	50H513B			50CT513A	50CT513B
.250	.375	1 5/8	.122	50H514A	50H514B			50CT514A	50CT514B
.250	.500	1 3/4	.122	50H515A	50H515B			50CT515A	50CT515B
.250	.625	1 7/8	.122	50H516A	50H516B			50CT516A	50CT516B
.250	.750	2	.122	50H517A	50H517B			50CT517A	50CT517B
.250	1.000	2 3/16	.122	50H0A	50H0B			50CT0A	50CT0B
.250	1.500	4 1/2	.122	50H0LA	50H0LB			50CT0LA	50CT0LB

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2(Micrograin)
- C7

**Optional:**

- TiALN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

**Possible Modifications of Bokum Standard Boring Tools**

- The "L" dimension may be shortened
- The "F" dimension may be lengthened
- The "P" dimension may be reduced 10% maximum
- Change lead angle or width
- Any radius may be furnished on point of tool



**BOKUM TOOL COMPANY inc**

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# BORING TOOLS One & Two-Piece Construction

## HSS, CARBIDE TIPPED

BORING TOOLS

1/2" SHANK DIAMETER TOOLS								
H	F	L	P	HSS		CARBIDE NECK TOOLS	CARBIDE TIPPED TOOLS	
MIN BORE DIA	MAX BORE DEPTH	OVERALL LENGTH	CUTTING EDGE TO $\perp$	STYLE A	STYLE B		STYLE A	STYLE B
.312	.500	1 3/4	.156	50H518A	50H518B	<b>NOT AVAILABLE USE CT TOOLS</b>	50CT518A	50CT518B
.312	.750	2	.156	50H519A	50H519B		50CT519A	50CT519B
.312	1.000	2 1/4	.156	50H520A	50H520B		50CT520A	50CT520B
.312	1.250	2 9/16	.156	50H1A	50H1B		50CT1A	50CT1B
.312	1.875	4 1/2	.156	50H1LA	50H1LB		50CT1LA	50CT1LB
.375	.500	1 3/4	.186	50H526A	50H526B		50CT526A	50CT526B
.375	.750	2	.186	50H527A	50H527B		50CT527A	50CT527B
.375	1.000	2 1/4	.186	50H528A	50H528B		50CT528A	50CT528B
.375	1.500	2 5/8	.186	50H15A	50H15B		50CT15A	50CT15B
.375	2.250	4 1/2	.186	50H15LA	50H15LB		50CT15LA	50CT15LB
.438	.500	1 3/4	.218	50H521A	50H521B		50CT521A	50CT521B
.438	.750	2	.218	50H522A	50H522B		50CT522A	50CT522B
.438	1.000	2 1/4	.218	50H523A	50H523B		50CT523A	50CT523B
.438	1.500	2 3/4	.218	50H2A	50H2B		50CT2A	50CT2B
.438	2.625	4 1/2	.218	50H2LA	50H2LB		50CT2LA	50CT2LB
.500	.750	2	.249	50H529A	50H529B		50CT529A	50CT529B
.500	1.000	2 1/4	.249	50H530A	50H530B		50CT530A	50CT530B
.500	2.000	3 1/4	.249	50H25A	50H25B		50CT25A	50CT25B
.500	2.750	4 1/2	.249	50H25LA	50H25LB		50CT25LA	50CT25LB
.563	1.062	2 5/16	.280	50H524A	50H524B		50CT524A	50CT524B
.563	1.563	2 13/16	.280	50H525A	50H525B		50CT525A	50CT525B
.563	2.250	3 3/8	.280	50H3A	50H3B		50CT3A	50CT3B
.563	3.250	4 1/2	.280	50H3LA	50H3LB		50CT3LA	50CT3LB

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2(Micrograin)
- C7

**Optional:**

- TiAlN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

1/2" SHANK DIAMETER TOOLS								
H	F	L	P	HSS CUTTER		CUTTER SHANK	CARBIDE TIPPED CUTTER	
MIN BORE DIA	MAX BORE DEPTH	OVERALL LENGTH	CUTTING EDGE TO $\perp$	STYLE A	STYLE B	STYLE S	STYLE A	STYLE B
.687	2.375	3 3/8	.340	H4A	H4B	50SU4	CT4A	CT4B
.687	3.500	4 1/2	.340			50SS4		
.687	6.750	8 3/4	.340			50SL4		



**BOKUM TOOL COMPANY inc**

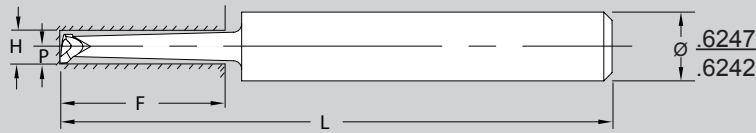
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# BORING TOOLS One-Piece Construction

## HSS, CARBIDE NECK, CARBIDE TIPPED

### 5/8" SHANK DIAMETER TOOLS



H	F	L	P	HSS		CARBIDE NECK TOOLS		CARBIDE TIPPED TOOLS	
				STYLE A	STYLE B	STYLE A	STYLE B	STYLE A	STYLE B
.125	.500	2	.060	62H30A	62H30B	62CN30A	62CN30B	62CT30A	62CT30B
.125	.750	4 1/2	.060	62H30LA	62H30LB	62CN30LA	62CN30LB	62CT30LA	62CT30LB
.188	.750	2	.090	62H20A	62H20B	<b>NOT AVAILABLE USE CT TOOLS</b>		62CT20A	62CT20B
.188	1.125	4 1/2	.090	62H20LA	62H20LB			62CT20LA	62CT20LB
.250	1.000	2 3/16	.122	62H0A	62H0B			62CT0A	62CT0B
.250	1.500	4 1/2	.122	62H0LA	62H0LB			62CT0LA	62CT0LB
.312	1.250	2 9/16	.156	62H1A	62H1B			62CT1A	62CT1B
.312	1.875	4 1/2	.156	62H1LA	62H1LB			62CT1LA	62CT1LB
.375	1.500	2 5/8	.186	62H15A	62H15B			62CT15A	62CT15B
.375	2.250	4 1/2	.186	62H15LA	62H15LB			62CT15LA	62CT15LB
.438	1.500	2 3/4	.218	62H2A	62H2B			62CT2A	62CT2B
.438	2.625	4 1/2	.218	62H2LA	62H2LB			62CT2LA	62CT2LB
.500	2.000	3 1/4	.249	62H25A	62H25B			62CT25A	62CT25B
.500	2.750	4 1/2	.249	62H25LA	62H25LB			62CT25LA	62CT25LB
.563	2.250	3 3/8	.280	62H3A	62H3B			62CT3A	62CT3B
.563	3.250	4 1/2	.280	62H3LA	62H3LB			62CT3LA	62CT3LB

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2(Micrograin)
- C7

**Optional:**

- TiALN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

**Possible Modifications of Bokum Standard Boring Tools**

- The "L" dimension may be shortened
- The "F" dimension may be lengthened
- The "P" dimension may be reduced 10% maximum
- Change lead angle or width
- Any radius may be furnished on point of tool



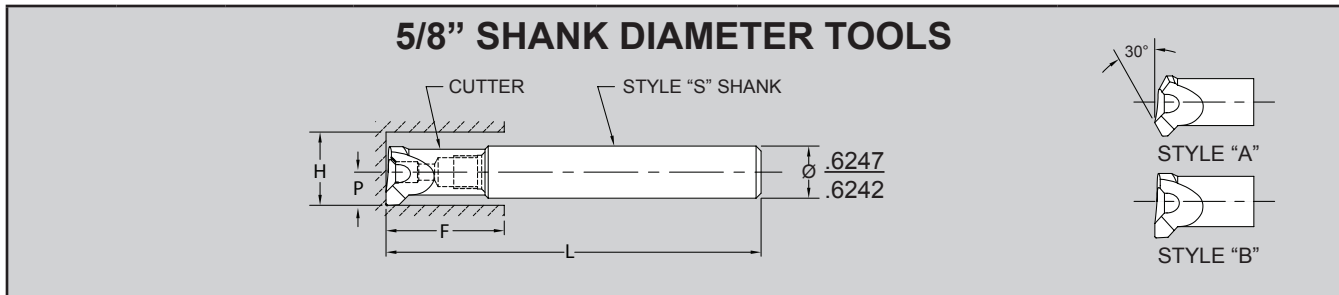
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# BORING TOOLS Two-Piece Construction

## HSS AND CARBIDE TIPPED



H	F	L	P	HSS CUTTER		CUTTER SHANK	CARBIDE TIPPED CUTTER	
				STYLE A	STYLE B	STYLE S	STYLE A	STYLE B
.687	2.750	3 11/16	.340	H4A	H4B	62SH4	CT4A	CT4B
.687	2.750	3 11/16	.340			62SS4		
.812	2.625	3 7/8	.398	H5A	H5B	62SH5	CT5A	CT5B
.812	3.500	4 1/2	.398			62SS5		
.812	7.750	9 3/4	.398			62SL5		

*When ordering Carbide Tools, please specify grade of carbide desired or material being machined.*

**Stocked Grades of Carbide**

- C2(Micrograin)
- C7

**Optional:**

- TiALN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

**Possible Modifications of Bokum Standard Boring Tools**

- The "L" dimension may be shortened
- The "F" dimension may be lengthened
- The "P" dimension may be reduced 10% maximum
- Change lead angle or width
- Any radius may be furnished on point of tool



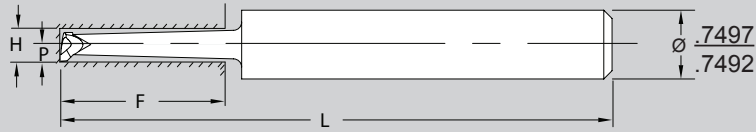
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# BORING TOOLS One-Piece Construction

## HSS, CARBIDE NECK, CARBIDE TIPPED

### 3/4" SHANK DIAMETER TOOLS



H	F	L	P	HSS		CARBIDE NECK TOOLS		CARBIDE TIPPED TOOLS	
				STYLE A	STYLE B	STYLE A	STYLE B	STYLE A	STYLE B
.125	.500	2	.060	75H30A	75H30B	75CN30A	75CN30B	75CT30A	75CT30B
.125	.750	4 1/2	.060	75H30LA	75H30LB	75CN30LA	75CN30LB	75CT30LA	75CT30LB
.188	.750	2	.090	75H20A	75H20B	<b>NOT AVAILABLE USE CT TOOLS</b>		75CT20A	75CT20B
.188	1.125	4 1/2	.090	75H20LA	75H20LB			75CT20LA	75CT20LB
.250	1.000	2 3/16	.122	75H0A	75H0B			75CT0A	75CT0B
.250	1.500	4 1/2	.122	75H0LA	75H0LB			75CT0LA	75CT0LB
.312	1.250	2 9/16	.156	75H1A	75H1B			75CT1A	75CT1B
.312	1.875	4 1/2	.156	75H1LA	75H1LB			75CT1LA	75CT1LB
.375	1.500	2 5/8	.186	75H15A	75H15B			75CT15A	75CT15B
.375	2.250	4 1/2	.186	75H15LA	75H15LB			75CT15LA	75CT15LB
.438	1.500	2 3/4	.218	75H2A	75H2B			75CT2A	75CT2B
.438	2.625	4 1/2	.218	75H2LA	75H2LB			75CT2LA	75CT2LB
.500	2.000	3 1/4	.249	75H25A	75H25B			75CT25A	75CT25B
.500	2.750	4 1/2	.249	75H25LA	75H25LB			75CT25LA	75CT25LB
.563	2.250	3 3/8	.280	75H3A	75H3B			75CT3A	75CT3B
.563	3.250	4 1/2	.280	75H3LA	75H3LB			75CT3LA	75CT3LB

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2(Micrograin)
- C7

**Optional:**

- TiALN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

**Possible Modifications of Bokum Standard Boring Tools**

- The "L" dimension may be shortened
- The "F" dimension may be lengthened
- The "P" dimension may be reduced 10% maximum
- Change lead angle or width
- Any radius may be furnished on point of tool



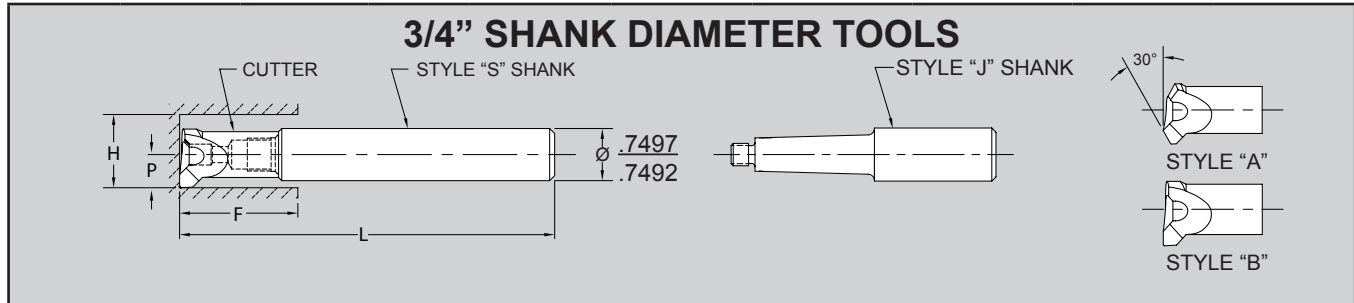
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# BORING TOOLS Two-Piece Construction

## HSS, CARBIDE TIPPED



H	F	L	P	HSS CUTTER		CUTTER SHANK		CARBIDE TIPPED CUTTER	
				STYLE A	STYLE B	STYLE S	STYLE J	STYLE A	STYLE B
MIN BORE DIA	MAX BORE DEPTH	OVERALL LENGTH	CUTTING EDGE TO $\phi$						
.687	1.125	3 11/16	.340	H4A	H4B	75SH4		CT4A	CT4B
.687	2.625	4 1/2	.340				75JS4		
.687	2.500	4 1/2	.340				75JD4		
.687	2.375	4 1/2	.340				75JP4		
.687	4.375	6 1/4	.340				75JL4		
.812	2.875	3 7/8	.398	H5A	H5B	75SH5		CT5A	CT5B
.812	2.625	4 1/2	.398				75JS5		
.812	2.750	4 1/2	.398				75JD5		
.812	5.125	7	.398				75JL5		
.937	3.500	4 1/2	.467	H6A	H6B	75SS6		CT6A	CT6B
.937	9.000	11	.467				75SL6		
.937	2.625	4 1/2	.467				75JS6		
.937	2.625	4 3/4	.467				75JP6		
.937	6.000	7 7/8	.467				75JL6		
1.062	3.500	4 1/2	.541	H7A	H7B	75SS7		CT7A	CT7B
1.062	10.000	12	.541				75SL7		
1.062	2.625	4 1/2	.541				75JS7		
1.062	2.625	4 1/2	.541				75JD7		
1.062	7.000	8 7/8	.541				75JL7		
1.187	2.625	4 1/2	.585	H8A	H8B		75JS8	CT8A	CT8B
1.187	2.500	5	.585				75JP8		
1.187	7.250	9	.585				75JL8		

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2(Micrograin)
- C7

**Optional:**

- TiALN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

**Possible Modifications of Bokum Standard Boring Tools**

- The "L" dimension may be shortened
- The "F" dimension may be lengthened
- The "P" dimension may be reduced 10% maximum
- Change lead angle or width
- Any radius may be furnished on point of tool



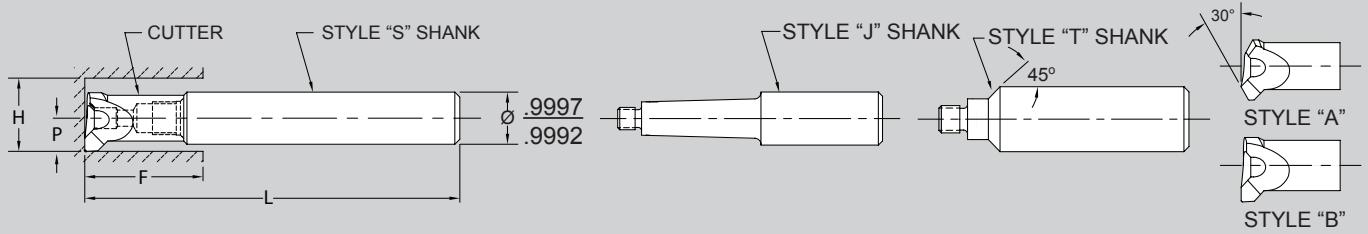
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# BORING TOOLS Two-Piece Construction

## HSS, CARBIDE TIPPED

### 1" SHANK DIAMETER TOOLS



H	F	L	P	HSS CUTTER		CUTTER SHANK			CARBIDE TIPPED CUTTER	
				STYLE A	STYLE B	STYLE S	STYLE J	STYLE T	STYLE A	STYLE B
.687	2.625	4 1/2	.340				100JS4			
.687	4.375	6 1/4	.340	H4A	H4B		100JL4		CT4A	CT4B
.687	1.250	7 1/32	.340					100TL4		
.812	2.625	4 1/2	.398				100JS5			
.812	5.125	7	.398	H5A	H5B		100JL5		CT5A	CT5B
.812	1.437	7 3/16	.398					100TL5		
.937	2.625	4 1/2	.467				100JS6			
.937	6.000	7 7/8	.467	H6A	H6B		100JL6		CT6A	CT6B
.937	1.625	7 3/8	.467					100TL6		
1.062	2.625	4 1/2	.541				100JS7			
1.062	3.250	5 3/4	.541	H7A	H7B		100JH7		CT7A	CT7B
1.062	7.000	8 7/8	.541				100JL7			
1.187	2.625	4 1/2	.585				100JS8			
1.187	3.250	6	.585				100JH8			
1.187	3.250	5 3/4	.585	H8A	H8B		100JP8		CT8A	CT8B
1.187	7.250	9	.585				100JL8			
1.312	3.250	5 1/8	.632				100JS9			
1.312	3.500	6	.632				100JH9			
1.312	3.500	6	.632	H9A	H9B		100JP9		CT9A	CT9B
1.312	7.250	9	.632				100JL9			
1.500	4.000	6	.730				100SS10			
1.500	11.750	14 3/4	.730				100SL10			
1.500	3.750	5 1/2	.730				100JS10			
1.500	4.750	7 1/4	.730	H10A	H10B		100JH10		CT10A	CT10B
1.500	3.750	6 1/4	.730				100JP10			
1.500	7.500	9 1/4	.730				100JL10			
1.750	4.000	6 1/2	.860	H11A	H11B		100JP11		CT11A	CT11B
2.000	4.500	7	1.000	H12A	H12B		100JP12		CT12A	CT12B

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2(Micrograin)
- C7

**Optional:**

- TiALN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

**Possible Modifications of Bokum Standard Boring Tools**

- The "L" dimension may be shortened
- The "F" dimension may be lengthened
- The "P" dimension may be reduced 10% maximum
- Change lead angle or width
- Any radius may be furnished on point of tool



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# BORING TOOLS Two-Piece Construction

## HSS, CARBIDE NECK, CARBIDE TIPPED

1 1/4" SHANK DIAMETER TOOLS									
H	F	L	P	HSS CUTTER		CUTTER SHANK		CARBIDE TIPPED CUTTER	
MIN BORE DIA	MAX BORE DEPTH	OVERALL LENGTH	CUTTING EDGE TO $\phi$	STYLE A	STYLE B	STYLE S	STYLE T	STYLE A	STYLE B
1.062	1.812	9 9/16	.541	H7A	H7B		125TL7	CT7A	CT7B
1.187	1.937	9 11/16	.585	H8A	H8B		125TL8	CT8A	CT8B
1.312	2.000	9 3/4	.632	H9A	H9B		125TL9	CT9A	CT9B
1.750	4.000	6	.860	H11A	H11B	125SS11		CT11A	CT11B
1.750	12.750	16 3/4	.860			125SL11			

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2 (Micrograin)
- C7

**Optional:**

- TiAlN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

1 1/2" SHANK DIAMETER TOOLS									
H	F	L	P	HSS CUTTER		CUTTER SHANK		CARBIDE TIPPED CUTTER	
MIN BORE DIA	MAX BORE DEPTH	OVERALL LENGTH	CUTTING EDGE TO $\phi$	STYLE A	STYLE B	STYLE S	STYLE T	STYLE A	STYLE B
1.500	2.250	12	.730	H10A	H10B		150TL10	CT10A	CT10B
1.750	6.000	12 11/32	.860	H11A	H11B		150TL11	CT11A	CT11B
2.000	4.000	6	1.000	H12A	H12B	150SS12		CT12A	CT12B
2.000	15.750	19 3/4	1.000			150SL12			
2.000	6.000	12 5/8	1.000				150TL12		

**Possible Modifications of Bokum Standard Boring Tools**

- The "L" dimension may be shortened
- The "F" dimension may be lengthened
- The "P" dimension may be reduced 10% maximum
- Change lead angle or width
- Any radius may be furnished on point of tool



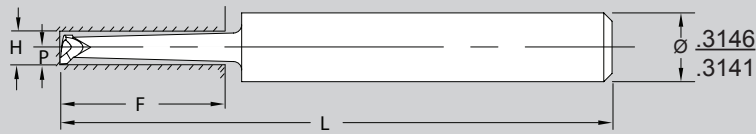
**BOKUM TOOL COMPANY inc**

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# BORING TOOLS One-Piece Construction

HSS, CARBIDE NECK, CARBIDE TIPPED

## 8mm SHANK DIAMETER TOOLS



H	F	L	P	HSS		CARBIDE NECK TOOLS		CARBIDE TIPPED TOOLS	
MIN BORE DIA	MAX BORE DEPTH	OVERALL LENGTH	CUTTING EDGE TO $\phi$	STYLE A	STYLE B	STYLE A	STYLE B	STYLE A	STYLE B
.063	.250	2	.030	8MH50A	8MH50B	8MCN50A	8MCN50B		
.063	.375	4 1/2	.030	8MH50LA	8MH50LB	8MCN50LA	8MCN50LB		
.094	.375	2	.045	8MH40A	8MH40B	8MCN40A	8MCN40B		
.094	.563	4 1/2	.045	8MH40LA	8MH40LB	8MCN40LA	8MCN40LB		
.125	.500	2	.060	8MH30A	8MH30B	8MCN30A	8MCN30B	8MCT30A	8MCT30B
.125	.750	4 1/2	.060	8MH30LA	8MH30LB	8MCN30LA	8MCN30LB	8MCT30LA	8MCT30LB
.188	.750	2	.090	8MH20A	8MH20B	<b>NOT AVAILABLE USE CT TOOLS</b>		8MCT20A	8MCT20B
.188	1.125	4 1/2	.090	8MH20LA	8MH20LB			8MCT20LA	8MCT20LB
.250	1.000	2 3/16	.122	8MH0A	8MH0B			8MCT0A	8MCT0B
.250	1.500	4 1/2	.122	8MH0LA	8MH0LB			8MCT0LA	8MCT0LB
.312	1.250	2 9/16	.156	8MH1A	8MH1B			8MCT1A	8MCT1B
.312	1.875	4 1/2	.156	8MH1LA	8MH1LB			8MCT1LA	8MCT1LB
.375	1.500	2 5/8	.186	8MH15A	8MH15B			8MCT15A	8MCT15B
.375	2.250	4 1/2	.186	8MH15LA	8MH15LB			8MCT15LA	8MCT15LB
.438	1.500	2 3/4	.218	8MH2A	8MH2B			8MCT2A	8MCT2B
.438	2.625	4 1/2	.218	8MH2LA	8MH2LB			8MCT2LA	8MCT2LB
.500	2.000	3 1/4	.249	8MH25A	8MH25B			8MCT25A	8MCT25B
.500	2.750	4 1/2	.249	8MH25LA	8MH25LB			8MCT25LA	8MCT25LB
.563	2.250	3 3/8	.280	8MH3A	8MH3B			8MCT3A	8MCT3B
.563	3.250	4 1/2	.280	8MH3LA	8MH3LB			8MCT3LA	8MCT3LB

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2(Micrograin)
- C7

**Optional:**

- TiALN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

**Possible Modifications of Bokum Standard Boring Tools**

- The "L" dimension may be shortened
- The "F" dimension may be lengthened
- The "P" dimension may be reduced 10% maximum
- Change lead angle or width
- Any radius may be furnished on point of tool



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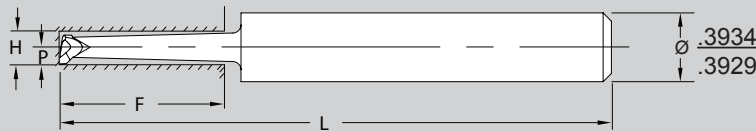
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# BORING TOOLS One-Piece Construction

HSS, CARBIDE NECK, CARBIDE TIPPED

BORING TOOLS

## 10mm SHANK DIAMETER TOOLS



H	F	L	P	HSS		CARBIDE NECK TOOLS		CARBIDE TIPPED TOOLS	
MIN BORE DIA	MAX BORE DEPTH	OVERALL LENGTH	CUTTING EDGE TO $\phi$	STYLE A	STYLE B	STYLE A	STYLE B	STYLE A	STYLE B
.063	.250	2	.030	10MH50A	10MH50B	10MCN50A	10MCN50B		
.063	.375	4 1/2	.030	10MH50LA	10MH50LB	10MCN50LA	10MCN50LB		
.094	.375	2	.045	10MH40A	10MH40B	10MCN40A	10MCN40B		
.094	.563	4 1/2	.045	10MH40LA	10MH40LB	10MCN40LA	10MCN40LB		
.125	.500	2	.060	10MH30A	10MH30B	10MCN30A	10MCN30B	10MCT30A	10MCT30B
.125	.750	4 1/2	.060	10MH30LA	10MH30LB	10MCN30LA	10MCN30LB	10MCT30LA	10MCT30LB
.188	.750	2	.090	10MH20A	10MH20B	<b>NOT AVAILABLE USE CT TOOLS</b>		10MCT20A	10MCT20B
.188	1.125	4 1/2	.090	10MH20LA	10MH20LB			10MCT20LA	10MCT20LB
.250	1.000	2 3/16	.122	10MH0A	10MH0B			10MCT0A	10MCT0B
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.312	1.250	2 9/16	.156	10MH1A	10MH1B			10MCT1A	10MCT1B
.312	1.875	4 1/2	.156	10MH1LA	10MH1LB			10MCT1LA	10MCT1LB
.375	1.500	2 5/8	.186	10MH15A	10MH15B			10MCT15A	10MCT15B
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.438	2.625	4 1/2	.218	10MH2LA	10MH2LB			10MCT2LA	10MCT2LB
.500	2.000	3 1/4	.249	10MH25A	10MH25B			10MCT25A	10MCT25B
.500	2.750	4 1/2	.249	10MH25LA	10MH25LB			10MCT25LA	10MCT25LB
.563	2.250	3 3/8	.280	10MH3A	10MH3B			10MCT3A	10MCT3B
.563	3.250	4 1/2	.280	10MH3LA	10MH3LB			10MCT3LA	10MCT3LB

When ordering Carbide Tools, please specify grade of carbide desired or material being machined.

**Stocked Grades of Carbide**

- C2(Micrograin)
- C7

**Optional:**

- TiAlN Coating
- TiN Coating
- TiCN Coating
- CBN Tipped

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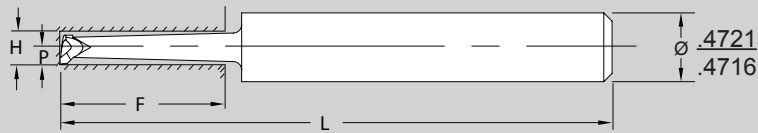
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# BORING TOOLS One-Piece Construction

## HSS, CARBIDE NECK, CARBIDE TIPPED

### 12mm SHANK DIAMETER TOOLS



H	F	L	P	HSS		CARBIDE NECK TOOLS		CARBIDE TIPPED TOOLS	
				STYLE A	STYLE B	STYLE A	STYLE B	STYLE A	STYLE B
.063	.250	2	.030	12MH50A	12MH50B	12MCN50A	12MCN50B		
.063	.375	4 1/2	.030	12MH50LA	12MH50LB	12MCN50LA	12MCN50LB		
.094	.375	2	.045	12MH40A	12MH40B	12MCN40A	12MCN40B		
.094	.563	4 1/2	.045	12MH40LA	12MH40LB	12MCN40LA	12MCN40LB		
.125	.500	2	.060	12MH30A	12MH30B	12MCN30A	12MCN30B	12MCT30A	12MCT30B
.125	.750	4 1/2	.060	12MH30LA	12MH30LB	12MCN30LA	12MCN30LB	12MCT30LA	12MCT30LB
.188	.750	2	.090	12MH20A	12MH20B	<b>NOT AVAILABLE USE CT TOOLS</b>		12MCT20A	12MCT20B
.188	1.125	4 1/2	.090	12MH20LA	12MH20LB			12MCT20LA	12MCT20LB
.250	1.000	2 3/16	.122	12MH0A	12MH0B			12MCT0A	12MCT0B
.250	1.500	4 1/2	.122	12MH0LA	12MH0LB			12MCT0LA	12MCT0LB
.312	1.250	2 9/16	.156	12MH1A	12MH1B			12MCT1A	12MCT1B
.312	1.875	4 1/2	.156	12MH1LA	12MH1LB			12MCT1LA	12MCT1LB
.375	1.500	2 5/8	.186	12MH15A	12MH15B			12MCT15A	12MCT15B
.375	2.250	4 1/2	.186	12MH15LA	12MH15LB			12MCT15LA	12MCT15LB
.438	1.500	2 3/4	.218	12MH2A	12MH2B			12MCT2A	12MCT2B
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# BORING TOOLS - Feeds and Speeds

## HSS, CARBIDE NECK, CARBIDE TIPPED

Bokum HSS Boring Tools Cutting Speeds		
Material Being Machined	Surface Feet Per Min (SFM)	Surface Meters Per Min (SMPM)
CAST IRON	65-100	20-30
BRASS	80-125	24-38
ALUMINUM	75-175	23-53
MILD STEEL	70-100	21-30
HARDENED STEEL	Not Recommended	Not Recommended
STAINLESS STEEL	40-60	12-18

Bokum Carbide Tipped Boring Tools Cutting Speeds		
Material Being Machined	Surface Feet Per Min (SFM)	Surface Meters Per Min (SMPM)
CAST IRON	180-300	55-91
BRASS	200-400	61-122
ALUMINUM	250-1000	76-305
MILD STEEL	175-250	53-76
HARDENED STEEL	50-150	15-46
STAINLESS STEEL	125-200	38-61

FEEDS FOR ROUGH BORING: .007" - .015" Per Revolution

FEEDS FOR FINISH BORING: .001" - .005" Per Revolution



TRADE MARK REG. U.S. PAT. OFF.

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# BORING TOOLS - Trouble Shooting Hints

## HSS, CARBIDE NECK, CARBIDE TIPPED

Over the years we have found that the Bokum regrinding fixtures normally will solve 90 percent of any problems a customer has to maintaining size, will help produce a better finish and make a tool last longer. The trouble shooting tips below are based on the assumption that the Boring Tool has been properly resharpend.

**PROBLEM:** Finish on part shows chatter marks. Not Acceptable.

- POSSIBLE CAUSES:**
1. Cutting tool head too small for hole.
  2. Length of tool excessively long.
  3. Loose Spindle, part is not chucked securely.
  4. Vibration through external source, i.e. a punch press operating nearby.
  5. Insufficient surface footage.
  6. Feed too coarse.

**PROBLEM:** High Speed Steel burning up.

- POSSIBLE CAUSES:**
1. Material being cut is too hard, over 28 Rockwell "C".
  2. Surface footage beyond recommendation.

**PROBLEM:** Carbide tip is chipping at cutting point.

- POSSIBLE CAUSES:**
1. Surface footage is too slow.
  2. Chip being removed by tool is entangling around carbide head and is rechipping tool.
  3. Too hard a grade of carbide is being used for application.
  4. Poor material quality or impurities may cause interrupted type cut.
  5. External vibration from other machines or from the machine itself.
  6. Machine has stopped while tool is still engaged in cut.



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