SOLID CARBIDE FOR PRECISION BORING OF DEEP SMALL HOLES

AVAILABLE FROM STOCK

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

BOKUM TOOL COMPANY INC.

Advantages—

- Precision ground clearance throughout life of tool
- Shape of cross section remains constant.
- Only necessary to regrind top rake.
- Worn cutting heads can be retipped at our factory
- 180° of regrind life.
- Tin coating available upon request.

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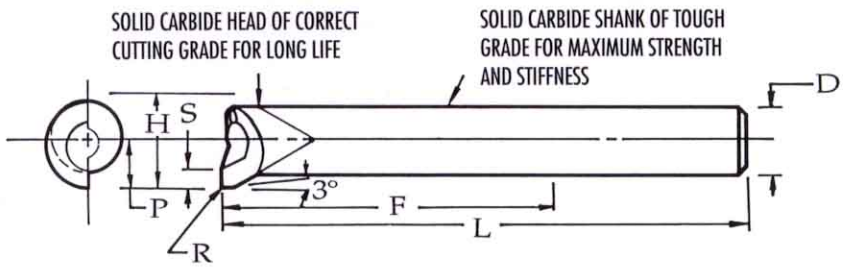
We have been making precision solid carbide boring tools for over 40 years. The cutting heads are ground to allow for very fine cuts with minimal build-up. The result: improved finish and closer tolerances. The shanks, made of a tough grade of carbide for maximum strength, have 2.8 times the rigidity 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 ⅛" diameter hole - 1½" deep. The BSC-3 tool is ideal for this job. The tool's greater rigidity permits higher speeds without chatter, resulting in finer finishes. Since the hole is so small and difficult to grind, this is often the only way parts can be produced within specifications for straightness, roundness, and size. When cutting heads are completely used after many regrinds, they can be removed and replaced with a new head at the factory; bringing the tool back to its' original dimensions and efficiency.

H	F	D										L	P	S	R	
MIN. BORING DIA.	MAX. BORING DEPTH	SHANK DIAMETERS STOCKED SHANK TOLERANCES										OVER ALL LENGTH	CUTTING EDGE TO ℄	WIDTH OF CUTTING EDGE	RADIUS AT POINT	CATALOG NUMBER
		.0935 .0930	.1247 .1242	.1560 .1555	.1872 .1867	.2185 .2180	.2497 .2492	.3122 .3117	.3747 .3742	.4372 .4367	.4997 .4992					
.115	¾	3/32										1½	.057	.022	.002	BSC 35
.115	2	3/32										3	.057	.022	.002	BSC 3
.146	⅞		⅛									1⅝	.073	.047	.002	BSC 45
.146	2¼		⅛									3¼	.073	.047	.002	BSC 4
.188	1			5/32								1¾	.094	.061	.003	BSC 55
.188	2½			5/32								3½	.094	.061	.003	BSC 5
.231	1⅛				3/16							1⅞	.115	.075	.003	BSC 65
.231	2¾				3/16							3¾	.115	.075	.003	BSC 6
.261	1¼					7/32						2 1/16	.130	.085	.004	BSC 75
.261	3⅛					7/32						4⅛	.130	.085	.004	BSC 7
.305	1½						¼					2¼	.152	.099	.004	BSC 85
.305	3½						¼					4½	.152	.099	.004	BSC 8
.367	1¾							5/16				2½	.183	.120	.004	BSC 105
.367	4							5/16				5	.183	.120	.004	BSC 10
.452	2⅛								3/8			2⅞	.226	.147	.005	BSC 125
.452	4¾								3/8			5¾	.226	.147	.005	BSC 12
.537	2½									7/16		3¼	.268	.175	.005	BSC 145
.537	5½									7/16		6½	.268	.175	.005	BSC 14
.600	2⅞										½	3⅜	.300	.195	.005	BSC 165
.600	3¼										½	4¼	.300	.195	.005	BSC 167
.600	6										½	7¼	.300	.195	.005	BSC 16



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