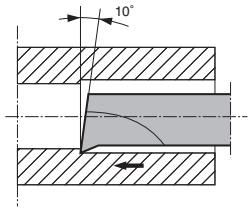
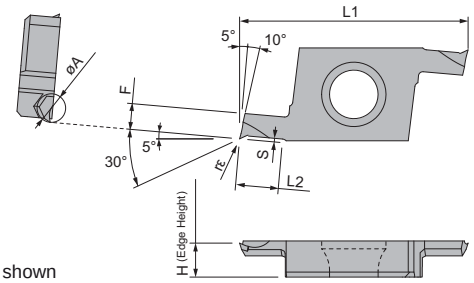
TWB (Micro Boring : Lay-down type) [Corner-R (rε) Tolerance: +0/−0.02mm, +0/−0.03mm]

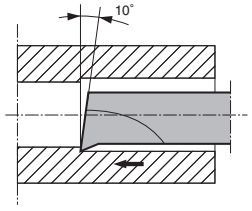


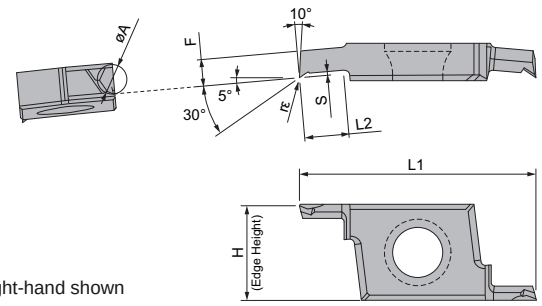


• Right-hand shown

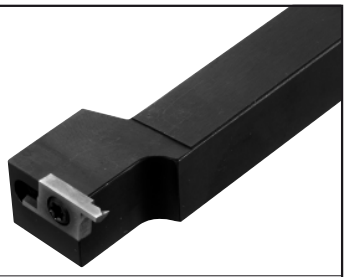
Example of installing insert for straight square shank

TWBT (Micro Boring : Up-right type) [Corner-R (rε) Tolerance: +0/−0.02mm, +0/−0.03mm]





• Right-hand shown



Example of installing insert for L-shape square shank

Insert Dimensions

Description		Min. Bore Dia.	Dimension (mm)								Insert Grade			Ref. Page for Toolholder
											PVD Coated Carbide		Carbide	
		øA	H	L1	L2	F	S	rε			PR1025		KW10	
TWBR	01003-005	1.0	2.38	16	3	0.85	0.2	+0 -0.02 0.05			●		●	F9
	01503-005	1.5				1.30					●		●	
	02003-005	2.0				1.75	0.25				●		●	
	02503-005	2.5				2.10	0.3				●		●	
	03003-005	3.0				2.40	0.4				●		●	
TWBR	01503-010	1.5	2.38	16	3	1.30	0.2	+0 -0.03 0.1			●		●	
	02003-010	2.0				1.75	0.25				●		●	
	02503-010	2.5				2.10	0.3				●		●	
	03003-010	3.0				2.30	0.4				●		●	
TWBTR	01003-005	1.0	6.4	16	3	0.85	0.2	+0 -0.02 0.05			●		●	F9
	01503-005	1.5				1.30					●		●	
	02003-005	2.0				1.75	0.25				●		●	
	02503-005	2.5				2.10	0.3				●		●	
	03003-005	3.0				2.30	0.4				●		●	
TWBTR	01503-010	1.5	6.4	16	3	1.30	0.2	+0 -0.03 0.1			●		●	
	02003-010	2.0				1.75	0.25				●		●	
	02503-010	2.5				2.10	0.3				●		●	
	03003-010	3.0				2.30	0.4				●		●	

Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade (Cutting Speed: m/min)		TWBR01003 Type TWBR01503 Type TWBTR01003 Type TWBTR01503 Type		TWBR02003 Type TWBR02503 Type TWBR03003 Type TWBTR02003 Type TWBTR02503 Type TWBTR03003 Type		Remarks
	PVD Coated Carbide	Carbide	Cut: ap (mm), Feed: f (mm/rev)				
	PR1025	KW10	ap	f	ap	f	
Carbon Steel Alloy Steel	★ 30~100		~0.1	~0.01	~0.2	~0.03	Coolant
Stainless Steel	★ 30~80		~0.1	~0.01	~0.2	~0.02	
Non-ferrous Metals		★ ~100	~0.1	~0.02	~0.2	~0.05	

★ : 1st Recommendation

Twin Bars are sold in 5 piece boxes.

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)