

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

	Description	Min. Bore Dia. øA	Dimension (mm)			Insert Grade	
			F	S	rε	PVD Coated Carbide	Carbide
						PR1025	KW10
	TWBR 01003-005	1.0	0.85	0.2	0.05	●	□
	01503-005	1.5	1.30	0.2		●	□
	02003-005	2.0	1.75	0.25		●	□
	02503-005	2.5	2.10	0.3		●	□
	03003-005	3.0	2.30	0.4		●	□
	TWBR 01503-010	1.5	1.30	0.2	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		●	□

● Right-hand shown

STWS (Square shank for Vertical type insert: L-shape type)

● Right-hand shown	

● Toolholder Dimensions

Description	Std.	Dimension (mm)										Drawing	Spare Parts		Applicable Insert	
		H1-h	B	L1	L2	L3	F1	F2	T	Clamp Screw	Wrench					
STWSR 1010JX-15T	●	10	10	120	16	-	10	9	3	-	SB-3080TR	LTW-10S	TWBTR ○○○○○ - ○○○ TWFGTR ○○○			
1212JX-15T	●	12	12				12	7								
1616JX-15T	●	16	16				20	3								
STWSR 1010F-15T	●	10	10	85	16	-	10	9	3	-	SB-3080TR	LTW-10S	TWBTR ○○○○○ - ○○○ TWFGTR ○○○			
1212F-15T	●	12	12				12	7								
1010K-15T	□	10	10				10	9								
1212K-15T	□	12	12	125	16	-	12	7	3	-	SB-3080TR	LTW-10S	TWBTR ○○○○○ - ○○○ TWFGTR ○○○			
1616K-15T	□	16	16				20	3								

◆ 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

● : Std. Item ○ : Check Availability □ : Deleted from the next catalogue

Twin Bars are sold in 5 piece boxes.

