

ASR & Arbor

ASV & Arbor

ASR



BCF-S

BCF-L

ABPF-W

ABPF-WE

ARPF-WE

ARPF-W

ASF



regular

short

long

regular

extra long

long

extra long

R 10
R 12.5
R 16
R 20
R 25

R 4
R 5
R 6
R 8
R 10
R 12.5
R 16

R 0.3
R 0.5
R 1.0
R 1.5
R 2.0

Ø 8
Ø 10
Ø 12
Ø 16
Ø 20
Ø 25
Ø 32

Ø 63
Ø 80
Ø 100
Ø 125
Ø 160
Ø 200
Ø 250

Ø 50
Ø 63
Ø 80
Ø 100

R 3
Ø 20
Ø 25
Ø 32

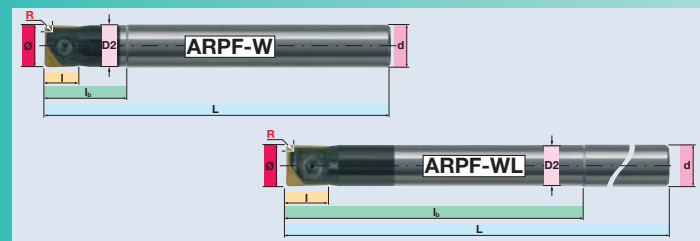
R 3
Ø 50
Ø 63
Ø 80
Ø 100

— Roughing
— Semi-Finishing
— Finishing

Diameter Tolerance of Indexable Tools with master insert (mm)		
Items		Ø Tolerance
ASR		0 / -0.2
ASV		0 / -0.2
BCF	Ø 20-32	0 / -0.15
BCF	Ø 40	+0.1 / -0.1
BCU		+0.1 / -0.1
ABPF		0 / -0.01
ARPF		0 / -0.01

Shank Tolerance all indexable Tools (mm)	
Ø	(mm)
6 ~ 10	- 0.005 ~ - 0.009
10 ~ 18	- 0.005 ~ - 0.011
18 ~ 30	- 0.005 ~ - 0.013
30 ~ 50	- 0.005 ~ - 0.016

Finishing

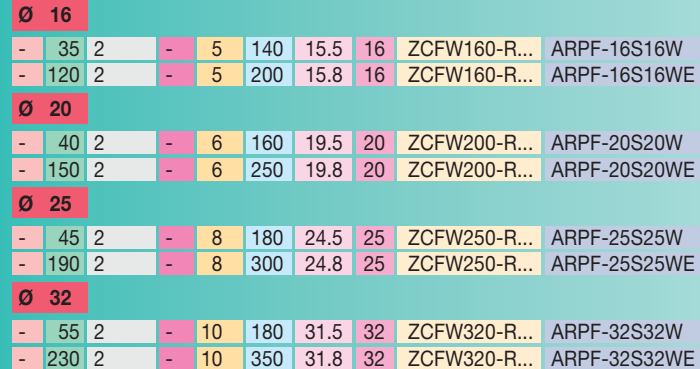


ARPF-W / ARPF-WL

R	lb	Flutes	D1	I	L	D2	d	Insert	Item-No.
Ø	8								
-	30	2	-	2.5	100	7.8	8	ZCFW080-R...	ARPF-08S08W
-	65	2	-	2.5	130	7.8	8	ZCFW080-R...	ARPF-08S08WL

Ø 10									
-	35	2	-	3	100	9.8	10	ZCFW100-R...	ARPF-10S10W
-	75	2	-	3	140	9.8	10	ZCFW100-R...	ARPF-10S10WL

Ø 12									
-	35	2	-	4	110	11.8	12	ZCFW120-R...	ARPF-12S12W
-	85	2	-	4	150	11.8	12	ZCFW120-R...	ARPF-12S12WL



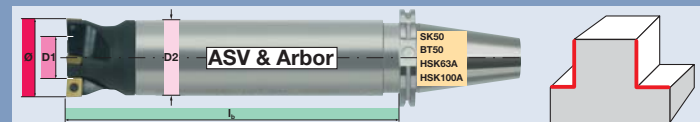
Ø 25

-	45	2	-	8	180	24.5	25	ZCFW250-R...	ARPF-25S25W
-	190	2	-	8	300	24.8	25	ZCFW250-R...	ARPF-25S25WE

Ø 32									
-	55	2	-	10	180	31.5	32	ZCFW320-R...	ARPF-32S32W
-	230	2	-	10	350	31.8	32	ZCFW320-R...	ARPF-32S32WE

Technical drawing illustrating a turning operation. The workpiece is a cylinder with diameter $D1$ and length L . It is being turned to a smaller diameter $D2$. The tool is labeled "ASV & Arbor". The tool holder is labeled "SK50 BT50 HSK63A HSK100A". A cross-section of the workpiece is shown on the right.

Plunging



ASV & Arbor

Ø 63						
100	3	-	46	1.6	MPHW12...	ASV-4063R + ...
200	3	-	46	1.6	MPHW12...	ASV-4063R + ...
300	3	-	46	1.6	MPHW12...	ASV-4063R + ...
400	3	-	46	1.6	MPHW12...	ASV-4063R + ...

Ø 80						
150	4	-	76	1.6	APHW19...	ASV-6080R + ...
250	4	-	76	1.6	APHW19...	ASV-6080R + ...
330	4	-	76	1.6	APHW19...	ASV-6080R + ...
400	4	-	76	1.6	APHW19...	ASV-6080R + ...

Ø 100						
150	5	-	76	1.6	APHW19...	ASV-6100R + ...
250	5	-	76	1.6	APHW19...	ASV-6100R + ...
330	5	-	76	1.6	APHW19...	ASV-6100R + ...
400	5	-	76	1.6	APHW19...	ASV-6100R + ...